

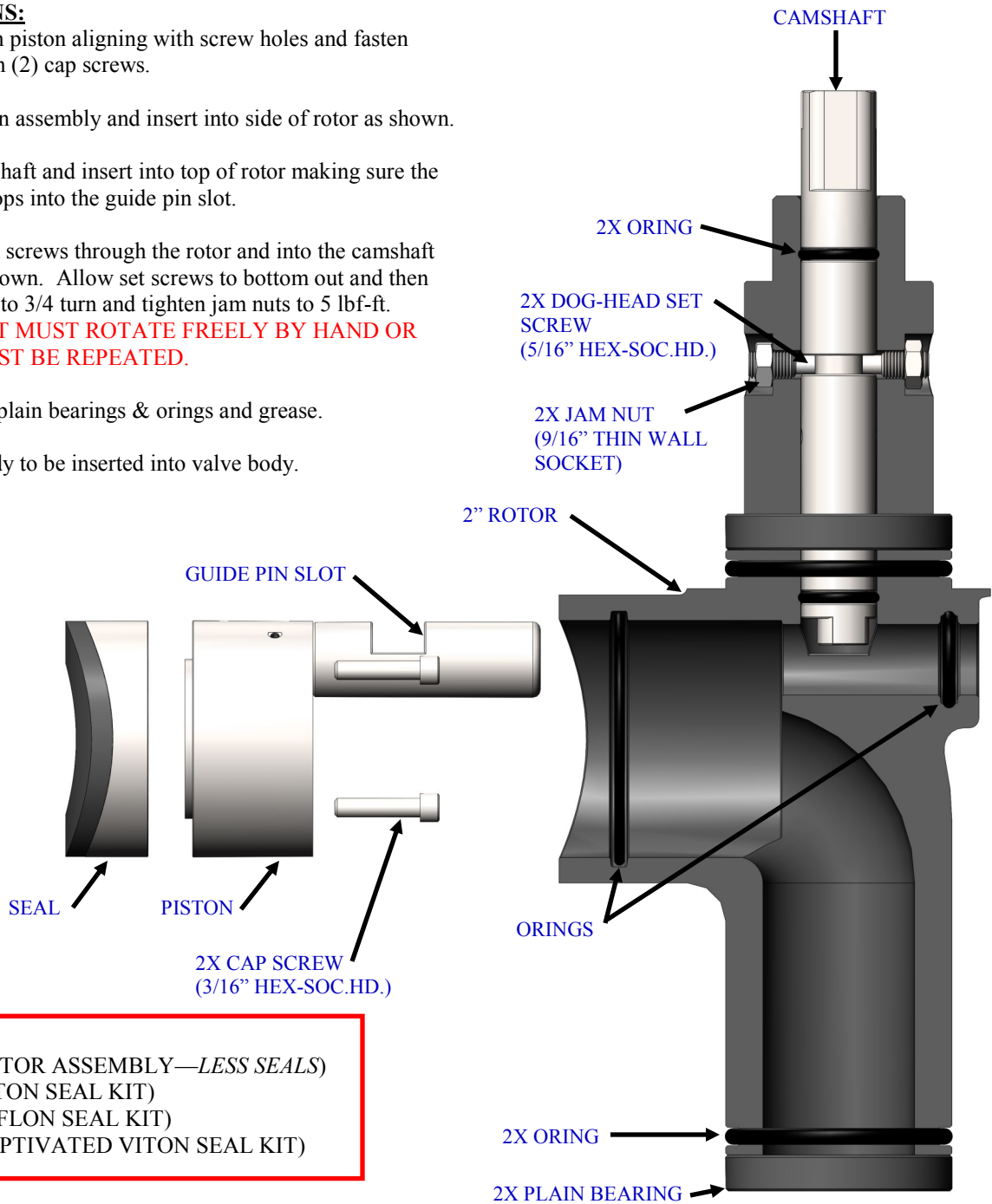
2" Rotor Assembly

REQUIREMENTS:

3/16 ALLEN WRENCH
5/16 ALLEN WRENCH
9/16 SOCKET WRENCH
LITIUM OR MOLYBDENUM GREASE

INSTRUCTIONS:

- 1.) Place seal on piston aligning with screw holes and fasten together with (2) cap screws.
- 2.) Grease piston assembly and insert into side of rotor as shown.
- 3.) Grease camshaft and insert into top of rotor making sure the camshaft drops into the guide pin slot.
- 4.) Insert (2) set screws through the rotor and into the camshaft groove as shown. Allow set screws to bottom out and then back off 1/2 to 3/4 turn and tighten jam nuts to 5 lbf-ft.
CAMSHAFT MUST ROTATE FREELY BY HAND OR STEP 4 MUST BE REPEATED.
- 5.) Replace (2) plain bearings & orings and grease.
- 6.) Rotor is ready to be inserted into valve body.



REFERENCE:

9643-35 (2" ROTOR ASSEMBLY—LESS SEALS)
9643-67 (2" VITON SEAL KIT)
9643-68 (2" TEFLON SEAL KIT)
9643-69 (2" CAPTIVATED VITON SEAL KIT)



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