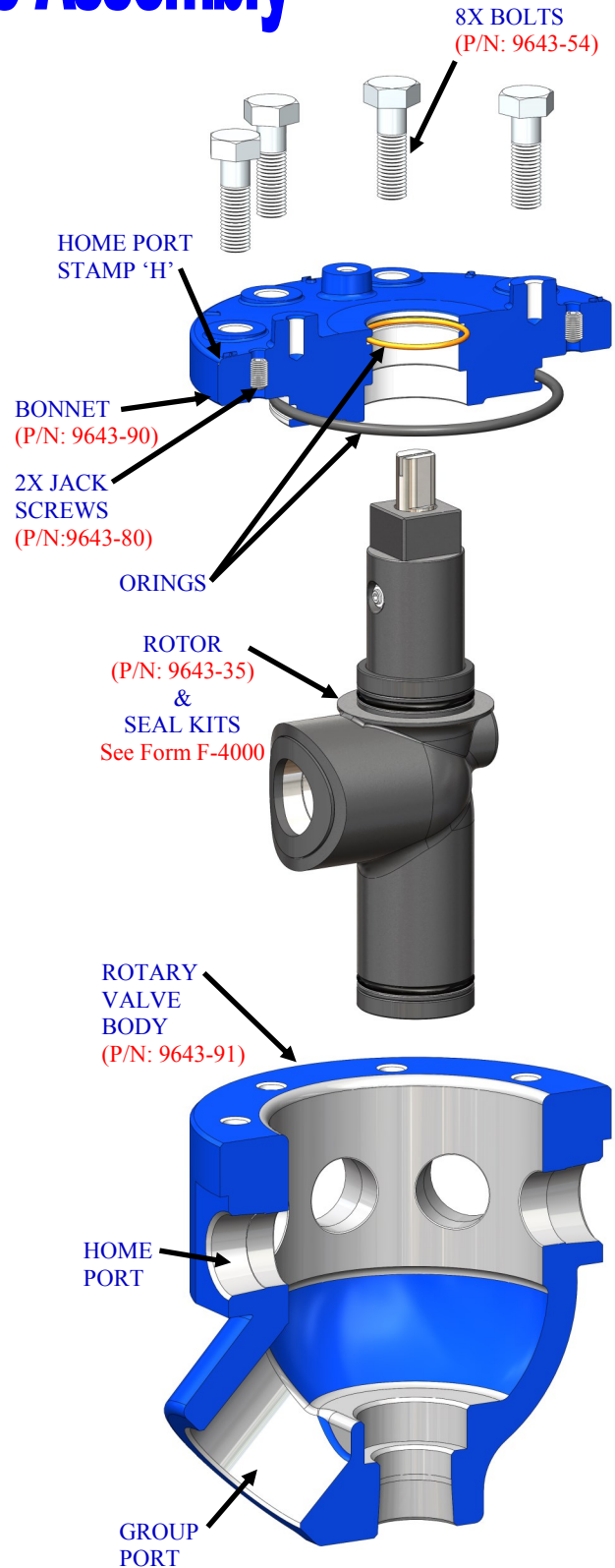


# 2" Rotary Valve Assembly

## INSTRUCTIONS:

- 1.) Insert rotor assembly into valve body as shown. Make sure that the rotor is fully seated at the bottom of the valve and aligned with the home port.
- 2.) Grease all orings to help make the assembly easy.
- 3.) Place bonnet over the rotor and align the (8) holes in order to bolt together. Align the 'H' letter on the bonnet with the home & group ports as shown. Apply approximately 100-200 lbf applied to the top of the bonnet will cause the orings to compress and the lid to set flush with the valve. If the bonnet does not seat and tightening of bolts requires excessive force, the plain bearings may be improperly seated and causing the rotor to bind. If this happens, take the rotor out of the valve body and start over. **DO NOT TIGHTEN BOLTS IN A SITUATION WHERE THE PLAIN BEARINGS ARE BINDING OR DAMAGE MAY OCCUR.**
- 4.) Tighten 3/4" bolts in a star pattern until they are at 100 lbf-ft.
- 5.) The valve is ready to receive the RSV actuator.



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