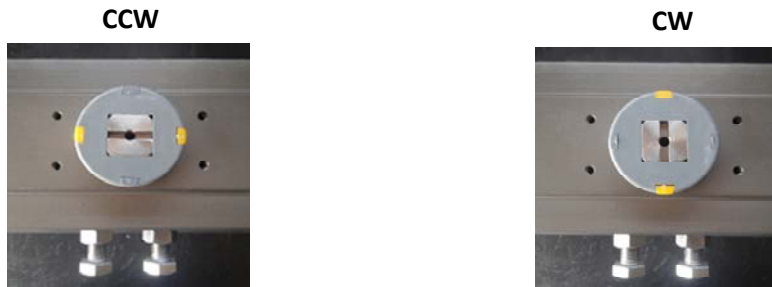


ONETORK

AT Series Special Service Instructions Service Issue No.: 90-AT-00001

Changing Fail Action on a AT Series Rack & Pinion Actuator

1. Note the actuator output shaft position, after the change, this position must be 90° apposed from the current setting. Factory rotation of actuator is Counter-Clockwise "CCW" to Open and Clockwise "CW" to Close. When the slot in the output shaft is perpendicular to the actuator cylinder, it is in the "Full CW" factory position. When the slot in the output shaft is parallel to the cylinder, it is in the "Full CCW" factory position.



2. Refer to second page, Drawing No. 30-00002

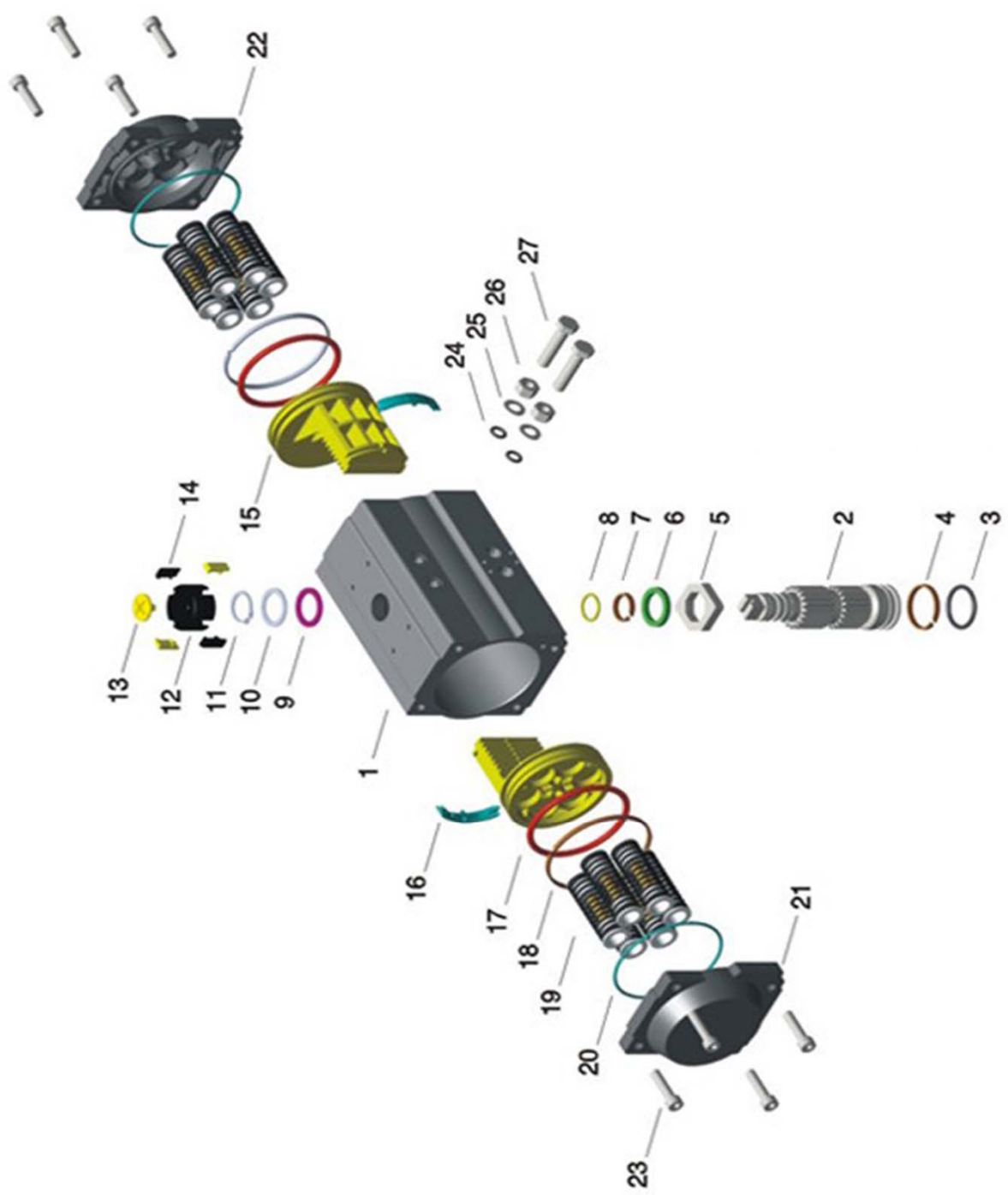
3. Begin by removing End Cap Bolts (#23), loosen diagonally to equalize bolt loading until spring preload is no longer present. Remove both End Caps (#21 & #22) along with Spring Assembly (#19). Springs may accompany End Caps during removal process.

4. Loosen both adjustment nuts (#26) and remove both adjusting bolts (#27). Rotate actuator output shaft (#2) until pistons (#15) come to end of cylinder.

5. Remove pistons (#15); realign actuator output shaft (#2) 180°, rotate pistons (#15) 180° from the position they came out of the cylinder and be sure that the pistons (#15), when reinserted into the cylinder are the same distance inside of cylinder when reassembling.

6. Push pistons all the way into the actuator to assure proper output shaft position. The shaft position should be 90° opposed to the position it was in before disassembly. If not remove the pistons and try again by repositioning the output shaft (#2) slightly and reinserting pistons until the shaft position has been properly achieved.

7. Reassemble the actuator by reversing order of disassembly above.



DWG#: 30-00002