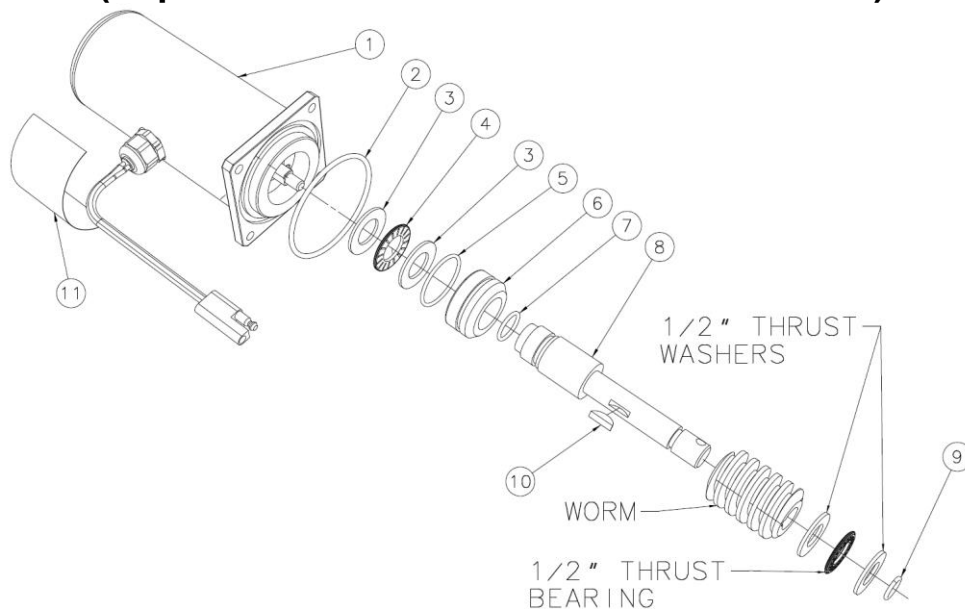


Valve Motor Replacement Kit P/N 81302001 (Replaces motors P/N 46035001 & 46042000)



No.	Part Number	Description	Qty.
1	81274001	12VDC Motor & Cover Assembly	1
2	57318000	O-Ring (AS568 - 142)	1
3	71513000	Washer - Thrust (0.625)	2
4	15699000	Bearing - Thrust (0.625)	1
5	57337000	O-Ring (AS568 - 025)	1
6	17707001	Bearing - Bushing	1
7	57295000	O-Ring (AS568 - 016)	1
8	63946001	Shaft - Gear (Valve)	1
9	57298000	O-Ring (AS568 - 012)	1
10	42002000	Key - Woodruff #404	1
11	25025000	Decal - Warning	1

Assembly Instructions: Use general purpose petroleum based grease.

1. Grease Thrust Bearing (4) and place between Thrust Washers (3) before inserting them all into the cavity in the Bushing (6).
2. Lightly grease O-ring (5) and place it in the outside groove on Bushing (6) and then install Bushing washer/bearing/washer end first into Motor Assembly (1). Push it in until the O-ring can no longer be seen and the Bushing contacts the bottom of the recess in the Motor Assembly.
3. Lightly grease O-ring (7) and place it in the outside groove on Gear Shaft (8). Align flats on shaft of Motor Assembly and slot in end of Gear Shaft and then insert Gear Shaft into Bushing as far as possible. The O-ring (7) should no longer be visible.
4. Remove original two 1/2" Thrust Washers, the one 1/2" Thrust Bearing, & the Worm from the old motor shaft. *(These are the only parts off of the original motor shaft that will be reused.)*
5. Assemble Woodruff Key (10), greased Worm, 1/2" thrust washer, greased 1/2" thrust bearing, and 1/2" thrust washer, and lightly greased O-ring (9) onto Gear Shaft (8).
6. Peel backer from Warning Decal (11) and attach it to Motor Assembly.
7. Insert O-ring (2) into face groove of Motor assembly flange and install entire assembly into valve gear case making sure O-ring (2) stays in place.

98255000 Rev-A