

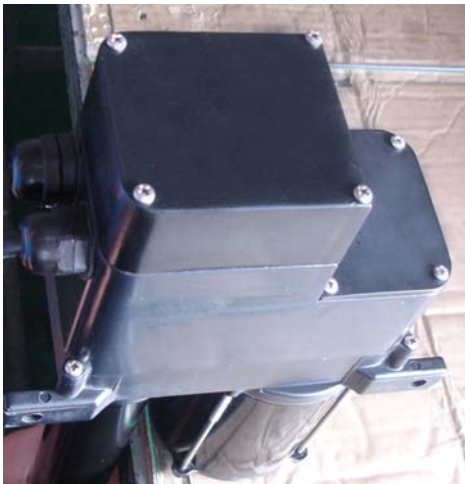
WORKING PROCESS OF REPLACEMENT

(VA ACTUATOR SERIES)

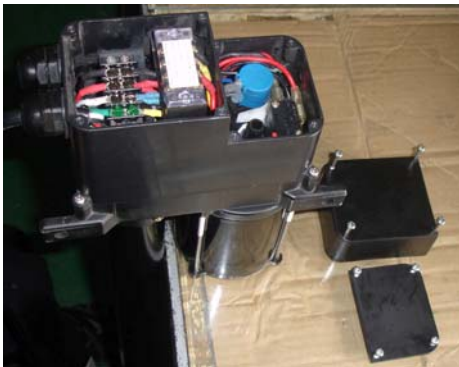
A: Spare Parts:

- 1) White Plastic Gear (steps: 1~12, 34)
- 2) Potentiometer (steps: 1~3, 13~19, 27~34)
- 3) Limit Switch (steps: 1~3, 13~14, 20~23, 34)
- 4) Capacitor (steps: 1~3, 13~15, 24~26, 34)

B: Working Process:



1. Original Unit



2. Disconnect Cam / Terminal Board Covers by Screwdriver.



3. Disconnect Plastic Housing.



4. Disconnect Metal Middle Board by Screwdriver.



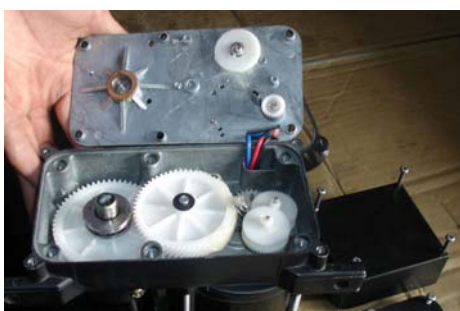
5. Open the Middle Board (pay attention to the rubber loop!).



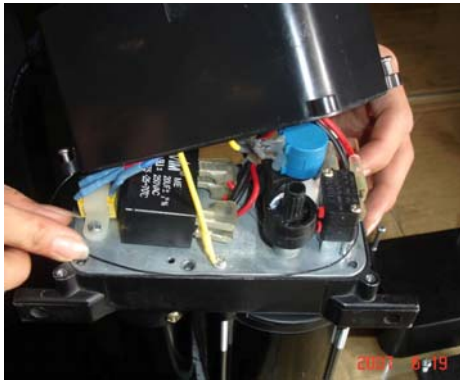
6. Take Away the Original Plastic Gear.



7. Install New Gear (gears teeth must be in mesh well, need grease).



8. Put on the washer of Plastic Gear.



9. Re-assembly the Middle Board



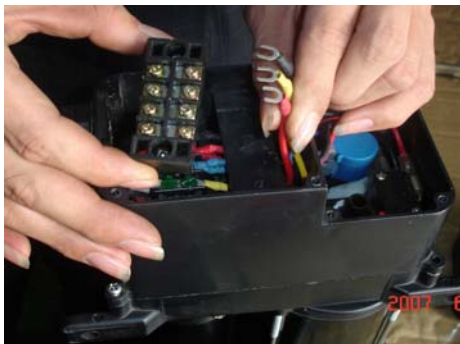
10. Lock the Screws of Middle Board.



11. Re-assembly the Rubber Loop



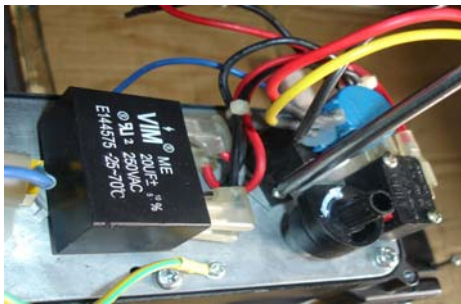
12. Re-assembly the Plastic Housing and Lock it by Screws.



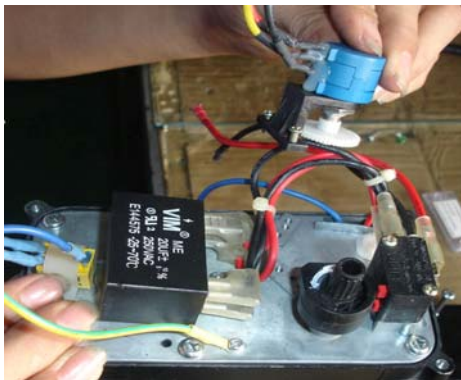
13. Loose the Screws of Potentiometer / Power Terminal Boards and Disconnect the leads.



14. Take Away Plastic Housing.



15. Disconnect the Screws of Potentiometer Bracket.



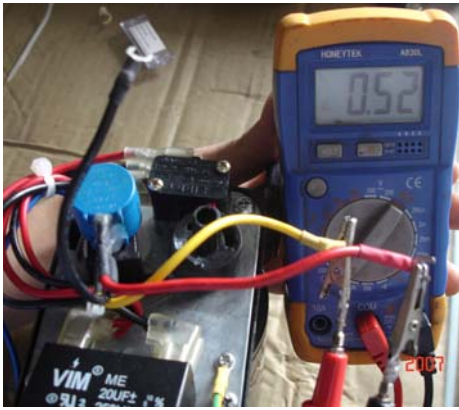
16. Take Away Original Potentiometer with Bracket.



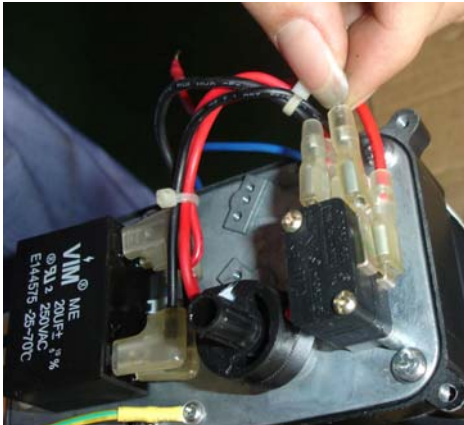
17. Adjust the resistance value of New Potentiometer to 0.50~0.60K ohm (rotate lightly the gear assembled on shaft of potentiometer).



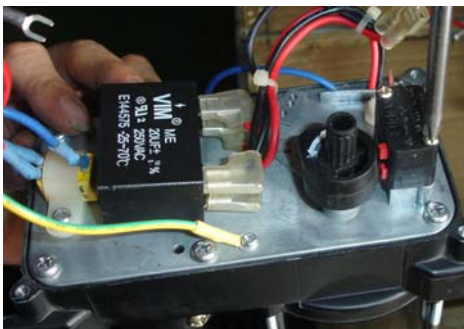
18. Lock the Bracket of New Potentiometer to the Holes on Middle Board. (3 sets holes for 18", 24", 36" Stroke Length, see marks beside the holes.)



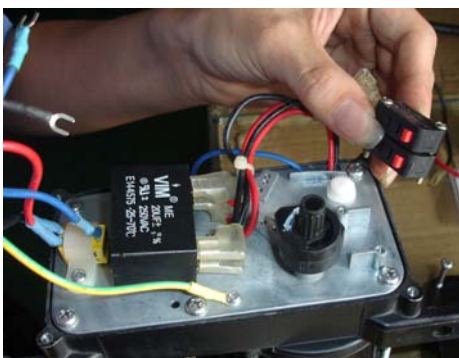
19. Retest the Value of the new potentiometer.



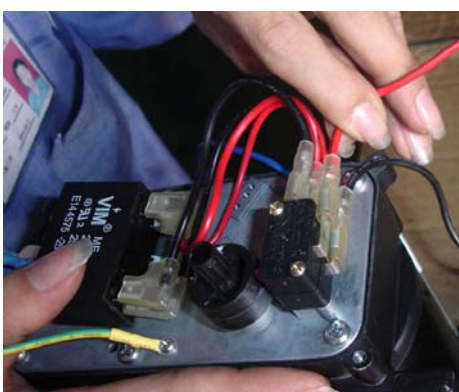
20. Disconnect the Leads of Limit Switch.



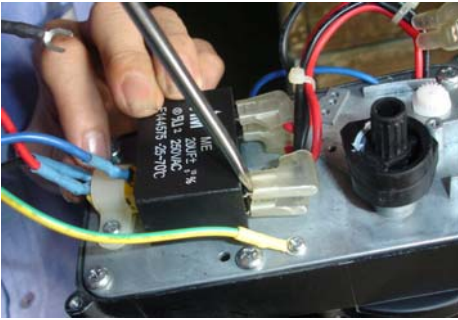
21. Loose the Screws of Limit Switch.



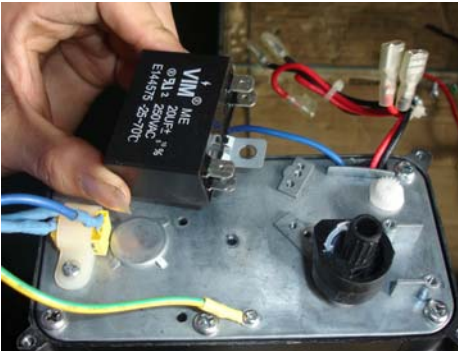
22. Take Away Original Limit Switch.



23. Change to New Limit Switch, Lock it and Reconnect all Leads Correctly.



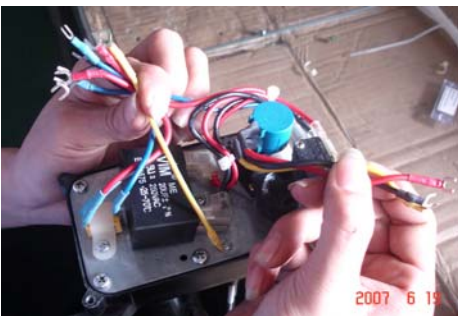
24. Disconnect all Leads of Capacitor.



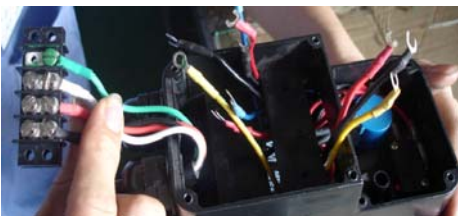
25. Loose the Screw of Capacitor, Take Away the Original One.



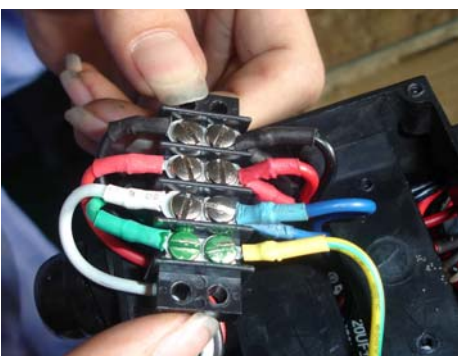
26. Change to New Capacitor, Lock it Tightly and Reconnect all Leads Correctly..



27. Bind the Leads by Tie Cable.



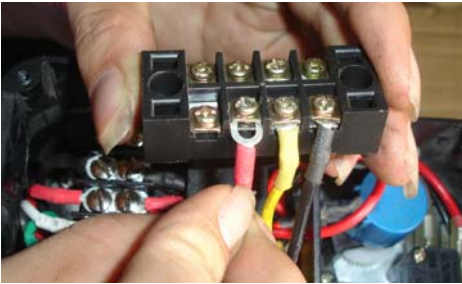
28. Pull Power Leads (7 leads) through the Gap of Plastic Housing.



29. Reconnect Power Leads with Power Terminal Board Correctly.



30. Lock the Power Terminal Board on Bracket of Plastic Housing.



31. Reconnect all Potentiometer Leads (3 leads) with Potentiometer Terminal Board Correctly.



32. Lock the Potentiometer Terminal Board on Bracket of Plastic Housing.



33. Put the Plastic Cover on Potentiometer Terminal Board.



34. Lock the Cam and Terminal Board Covers.

REMARK: The unit must be retested after exchanging new spare parts!!!