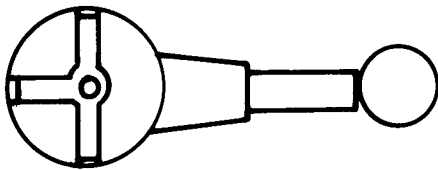
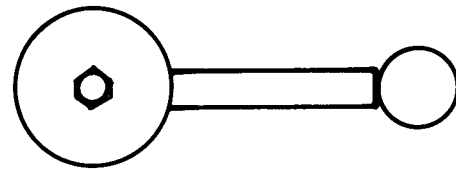


**CONVERSION OF OLD TORK-LOK<sup>®</sup> TO NEW TORK-LOK  
FOR STYLE 1581 WYE  
OPERATING INSTRUCTIONS**



Old Style Tork-Lok  
Handle Assembly  
Figure 1



Current Style New Tork-Lok  
Handle Assembly  
Figure 2

These instructions are written to assist in converting the old style Tork-Lok handle assembly to the current design as shown in Figure 2.

**I. TOOLS REQUIRED**

- $\frac{9}{64}$ " (3.57 mm) allen wrench
- $\frac{5}{32}$ " (3.97 mm) allen wrench
- $\frac{3}{4}$ " (19.05 mm) socket wrench or an adjustable type wrench
- Heavy-duty snap ring wrench for I.D. ring.

**CAUTION: EYE PROTECTION SHOULD BE USED DURING SSSEMBLE AND DISASSEMBLY.**

**II. DISASSEMBLY OF OLD TORK-LOK**

1. Using  $\frac{5}{32}$ " (3.97 mm) allen wrench, remove socket head cap screw from handle housing.
2. Lift off handle housing, rod and ball.
3. Using snap ring wrench remove large I.D. snap ring. Care must be taken to maintain complete engagement of wrench pins in holes.
4. Remove Teflon shim and drive bearing.
5. Using  $\frac{9}{64}$ " (3.57 mm) allen wrench, remove socket head cap screw from trunnion.
6. Lift off washer and (4) locking dogs.
7. Lift out drive plate and additional Teflon shims.
8. Using  $\frac{9}{64}$ " (3.57 mm) allen wrench, remove (4) socket head screws.
9. Lift off trunnion bearing and remove trunnion.

### III. REASSEMBLY OF NEW TORK-LOK

1. Using  $\frac{3}{4}$ " (19.05 mm) socket, remove hex head screw from handle sub-assembly.
2. Lift off fiber washer, handle cover, handle assembly and stop plate.
3. Using  $\frac{5}{32}$ " (3.97 mm) allen wrench, remove (4) socket head cap screws and lift off trunnion retaining plate.
4. Remove ball trunnion, being careful not to lose (4) socket head cap screws remaining in adapter.
5. Install adapter onto old valve body and tighten down (4) socket head screws using  $\frac{5}{32}$ " (3.97 mm) allen wrench.
6. Install ball trunnion, aligning pilot on trunnion with hole in top of the ball.
7. Install trunnion retaining plate. Be careful to align spring tabs with cut-out in ball trunnion. If misaligned, tork feature will not work effectively.
8. Install (4) socket head cap screws and, using  $\frac{5}{32}$ " (3.97 mm) allen wrench, tighten down.
9. Install stop plate and position so that open and close position of the ball meets requirements.
10. Install handle assembly, handle cover, and fiber washer.
11. Using  $\frac{3}{4}$ " (19.05 mm) socket wrench, install and tighten down hex head cap screw. Check function and make sure stop limits of handle provide rotation desired on the ball. If not, disassemble following steps 1 and 2. Reposition stop plate as desired and reassemble following steps 9 through 11.



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