

RAP R82: Service and Adjustment Procedure
Dashpot
09/06/11

Shafer Dashpot

Service and Adjustment

The purpose of this procedure is to guide and verify the disassembly, repair and assembly of a Shafer Dashpot.

This procedure is to be used in conjunction with the following drawings

Shafer Dashpot Assembly	58630

Preparation

WARNING: Before beginning work on a Shafer Actuator Valve Operating System or any actuator using pressurized gas:



1. Turn power oil off.
2. Bleed down the power storage tank if applicable.
3. Move control handles back and forth to relieve pressure from poppet block.
4. Turn pilot gas off (if applicable).

REMOVAL AND DISASSEMBLY

1. Shut off the return line valve.
2. Remove tubing from the shuttle valve on top of Dashpot.
3. Remove the four mounting bolts from the left side of the Dashpot and remove the Dashpot, also remove the two o-rings that are between the Dashpot and the Poppet Block. (See Figure 1).

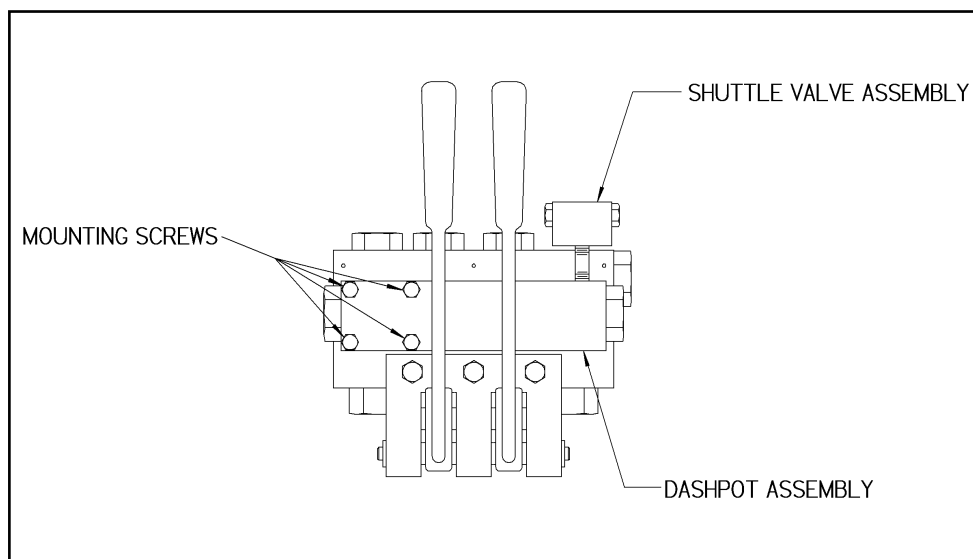


Figure 1: View of Poppet Block with Dashpot

4. Place the Dashpot (item 1) in a vice.
5. Remove end caps (items 4 & 5) and o-rings (items 9 & 12), see Figure 2.
6. With a blunt object push piston stem (item 3) and piston (item 2) out of the Dashpot.
7. Remove wear rings (item 8), o-ring (item 6) and back-up ring (item 7) from the piston.
8. Remove o-ring (item 10) and back-up ring (item 11) from the piston stem.

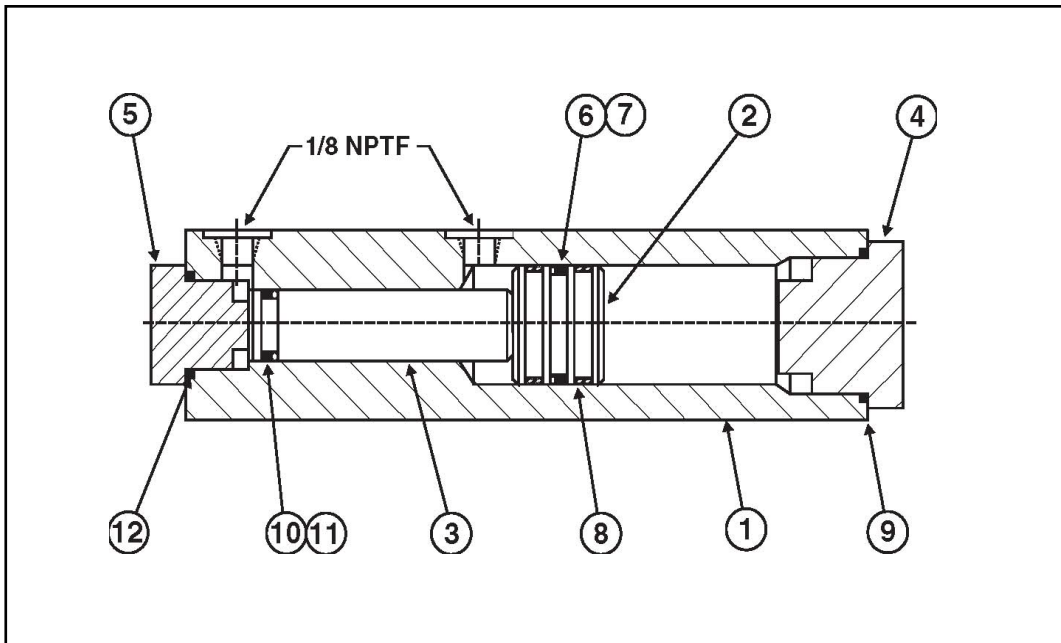


Figure 2: Cut-Away View of Dashpot

CLEAN AND INSPECT

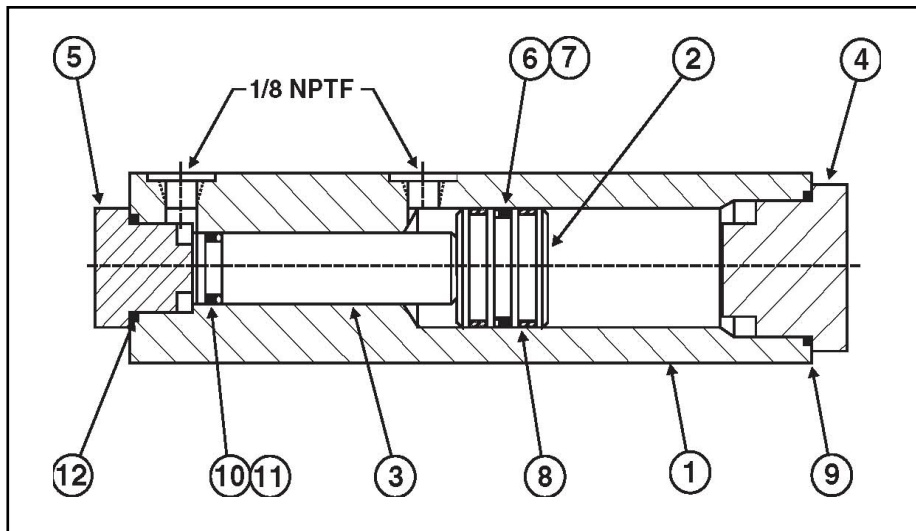
1. Remove all o-rings and wear bands.
2. Thoroughly clean and inspect all components.

ASSEMBLY AND TEST

1. Using o-ring grease install o-ring (item 10) and backup ring (item 11) on piston stem (item 3).
2. Grease piston stem and insert into Dashpot body (item 1) as seen in Figure 2.
3. Using o-ring grease install o-ring (item 6) and back-up ring (item 7) on piston (item 2).
4. Install wear rings (item 8) on piston (item 2).

5. Grease piston and insert into Dashpot body (item 1) as seen in Figure 2.
6. Using o-ring grease install o-rings (items 9 & 12) on end caps (items 4 & 5).
7. Install end caps (items 4 & 5) on Dashpot (item 1) and tighten.
8. Using o-ring grease install o-rings on the two 1/8" ports on the side of the Dashpot.
9. Install Dashpot using the four mounting bolts.
10. Reinstall the tubing to the shuttle valve.
11. Open the return line.
12. Turn pilot gas on (if applicable).
13. Open power oil valve.
14. Stroke the actuator to purge the Dashpot and look for leaks.

Dashpot Parts List



BILL OF MATERIAL			
ITEM	QUAN.	DESCRIPTION	DWG.
1	1	BODY 6061-T6 ALUM	
2	1	PISTON 6061-T6 ALUM	
3	1	PISTON STEM 6061-T6 ALUM	
4	1	END CAP	
5	1	END CAP	
6	1	O-RING PRP-568-121- 70 DURO	
7	1	BACK-UP RING #2103-121	TEFLON
8	2	PISTON WEAR RING GLASS FILLED	TEFLON
9	1	O-RING PRP-568-126	70 DURO
10	1	O-RING PRP-568-113	70 DURO
11	1	BACK-UP RING #2103-113	TEFLON
12	1	O-RING PRP-568-118	70 DURO

If any further information is required, please feel free to contact:

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Please visit our website for up to date product data. www.shafervalve.com

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