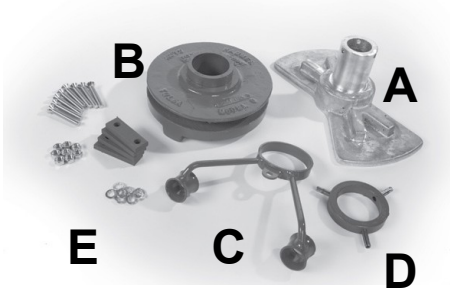


Installation Instructions

M Series *Hammer Blow Impact Actuator*

Chain Wheel

Model: Clamp-On



Procedure:

- 1) Upon opening carton, remove Set Collar, Chain Guide, and Hammer from Anvil.
- 2) Place Anvil in position on valve wheel with center of Anvil over valve stem. Mark outline of wheel on surface of Anvil.
- 3) Place clamps on marked surface of Anvil, centering the holes over outline of wheel. Mark and center-punch holes in clamps on the Anvil. Next, drill Anvil with clearance for bolts. Countersink top side of Anvil for flat head machine bolts.
- 4) Bolt Anvil to wheel being careful to center over valve stem.
- 5) Install Hammer (Chain Guide or Handwheel) and Set Collar. Drive the Set Collar Roll Pins into the matching holes on the Anvil. This assures unit integrity with both a pinning action and friction tightness.

Parts:

- A. Anvil
- B. Hammer (Chain wheel model shown)
- C. Chain Guide (Chain wheel model shown)
- D. Set Collar with Roll Pins
- E. Clamp Set

Caution:

Chain wheel **MUST** be installed properly for safe operation. Follow **ALL** Installation instructions carefully.

NEVER install an M-Series Impact Operation on **ANY** make, model or type of **GEAR OPERATED** valve.

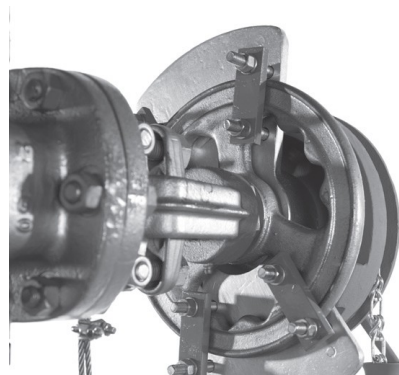
To eliminate any possibility of the valve handwheel retaining nut backing off the stem, **IT MUST HAVE A SET SCREW IN PLACE.**

EVERY Impact Operator must be scheduled for **REGULAR, PERIODIC inspection and maintenance.**

Roto Hammer **STRONGLY RECOMMENDS** that **EVERY** overhead Impact Operator be fitted with a **Roto Hammer Retaining Cable** (available from your local distributor or from Roto Hammer Industries).

Set screws and other threaded fasteners **MUST** be secure and tight.

Completed Assembly:



M Series back view



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