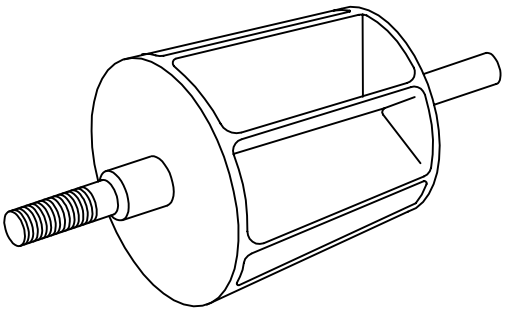
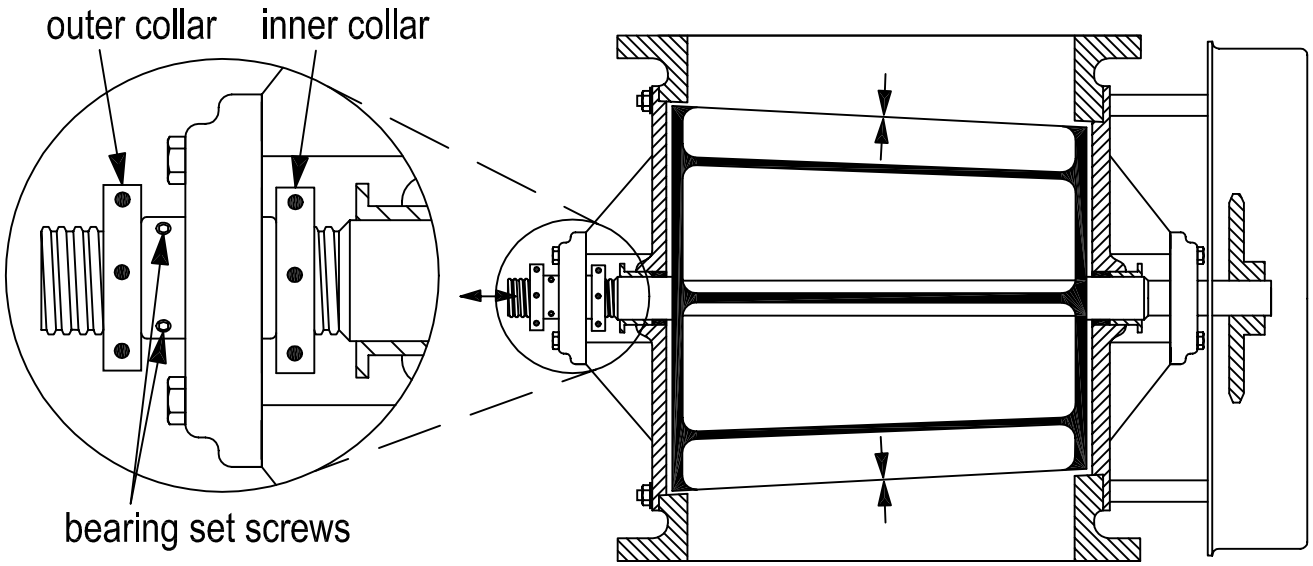
"SR" Tapered Rotor Clearance Adjustment





CAUTION: Always disconnect and lockout the drive before working on a rotary valve.

The preferred method of checking the rotor gap is with a flat feeler gauge. Insert the feeler gauge between the rotor tip and valve body. IF THE TOP OR BOTTOM FLANGE IS NOT ACCESSIBLE FOLLOW STEPS 1-7 FOR SETTING THE GAP "BLIND."

1) Loosen the two *bearing set screws* in the non-drive end bearing (failure to do so can crack the bearing housing).
2) Loosen the two locking collars on either side of the bearing.
3) Turn the inner collar *counterclockwise* to move the rotor into the bore and reduce the clearance.
4) Rotate the inner collar until resistance is felt - the rotor is now bottomed into the bore and the rotor clearance is zero.
   (*this assumes there is no material trapped behind the rear of the rotor*)
5) Turn the outer collar "*X*" turns (see table) *clockwise* until the desired rotor clearance is achieved.
   If a feeler gauge can be used, slide the gauge between the rotor tip and valve body to measure the gap.
6) Snug up the inner collar to the bearing. ***Do not over tighten - do not use pipe wrench.***
7) Tighten the *two bearing set screws* in the bearing. ****The two Bearing Set Screws hold shaft in place - DO NOT depend on the adjusting collar alone!***

	final gap required					
	0.003"	0.004"	0.005"	0.006"	0.007"	0.008"
Model	# of turns of outer collar					
SR15, SR20	0.60	0.80	1.00	1.20	1.40	1.60
SR25, SR30	0.53	0.70	0.88	1.05	1.23	1.40
SR35, SR40	0.47	0.63	0.78	0.94	1.09	1.25