

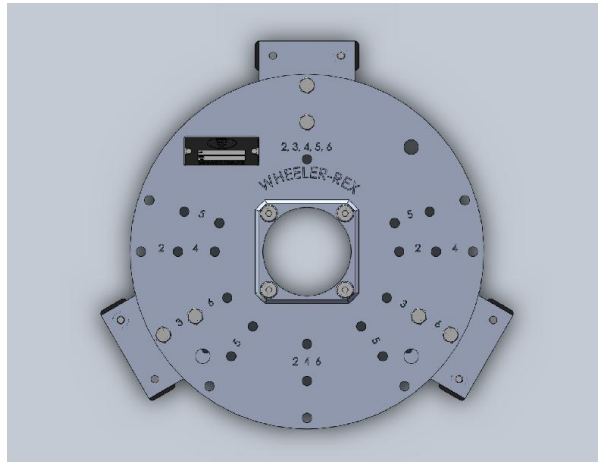
# Rising Stem Instructions

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## 13968 Rising Stem Torque Adapter



## 13970 Rising Stem Hand Wheel Adapter



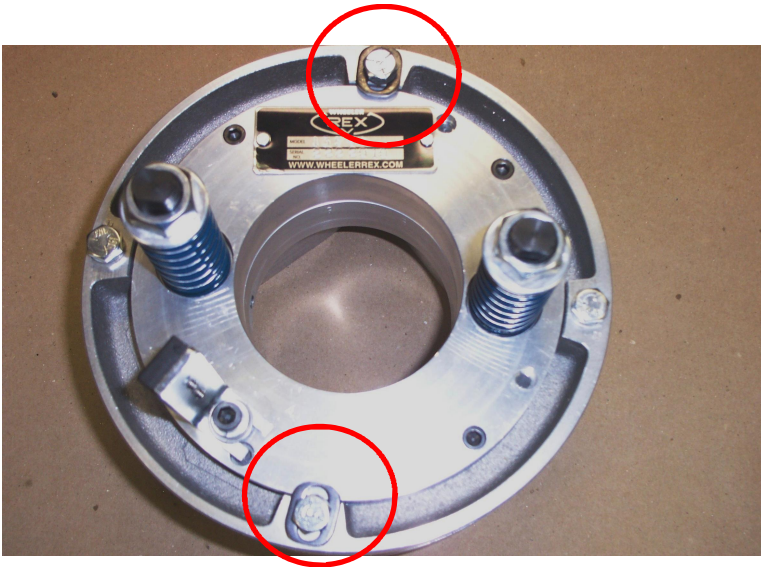
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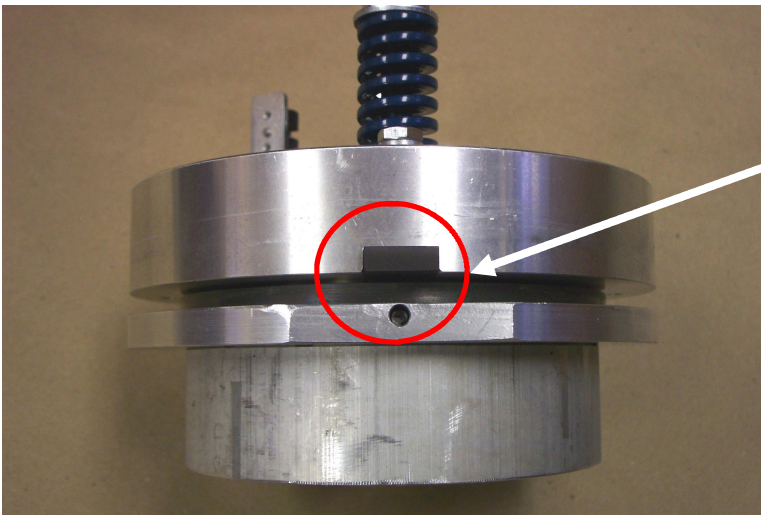
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# 13968 Rising Stem Torque Adapter

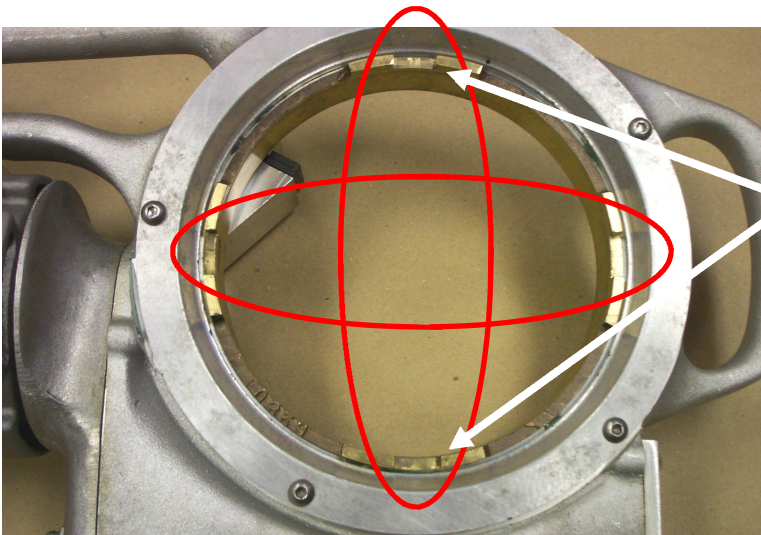


**13968 Rising Stem Torque Adapter**  
Note the position of the “Finger Lock” Washers”



**Drive Tabs**

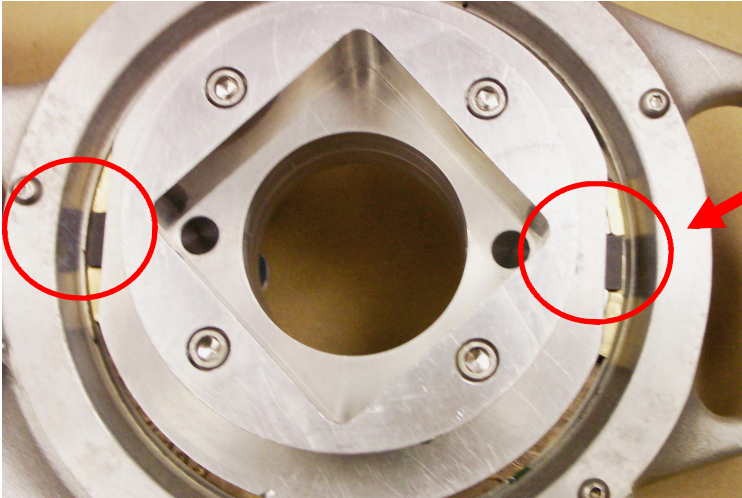
There are two (2) drive tabs on the unit.



**2 Sets of Slots**

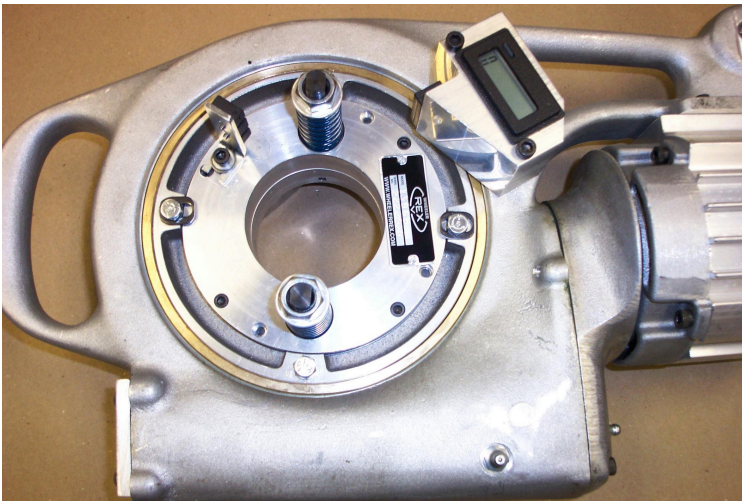
This is the bottom view of the 68115 Power Drive. There are two (2) sets of slots located on the bottom drive gear.

## 13968 Rising Stem Torque Adapter continued . . .

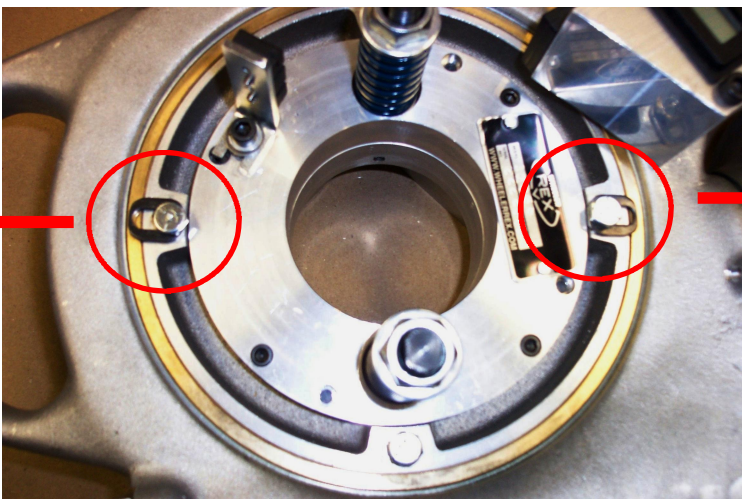


**Tabs in Slot**

With the power drive & torque adapter upside down, place the torque Adapter inside of the power drive. Drive tabs should be properly placed in the drive gear slots of the 68115 power drive.



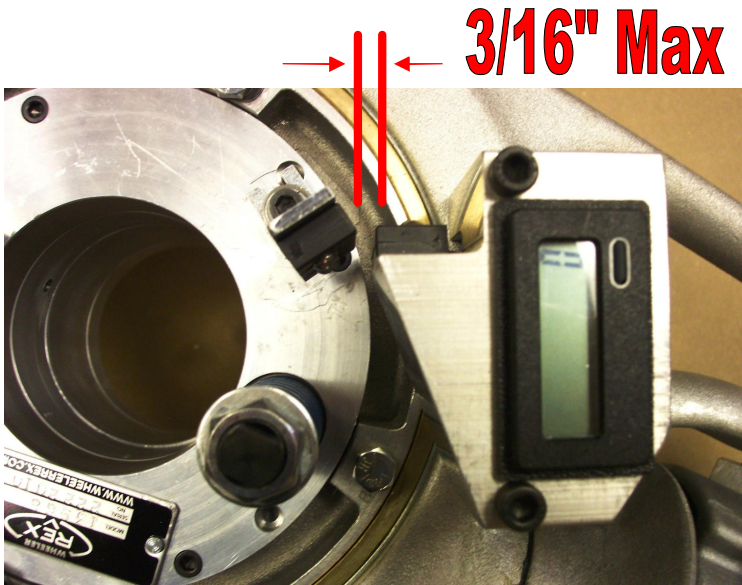
Flip the power drive over with the torque adapter inside of the drive gear.



Push the "Finger Lock Washers" out over the drive gear. This keeps the 13968 torque adapter attached to the 68115 power drive.

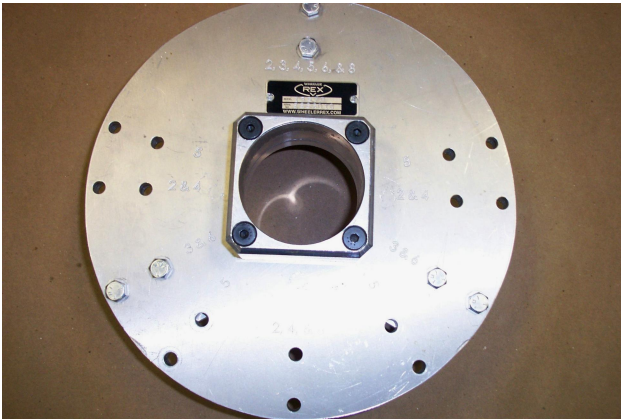
## 13968 Rising Stem Torque Adapter continued . . .

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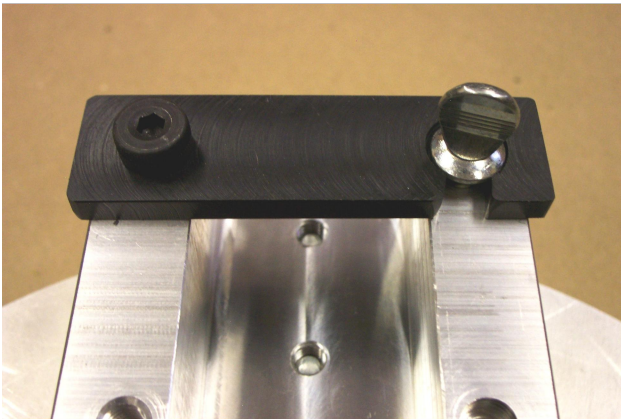


Check for proper clearance between the counter (located on the power drive) and the counter magnet (located on the torque adapter). There should be a maximum 3/16" gap between the counter and the magnet.

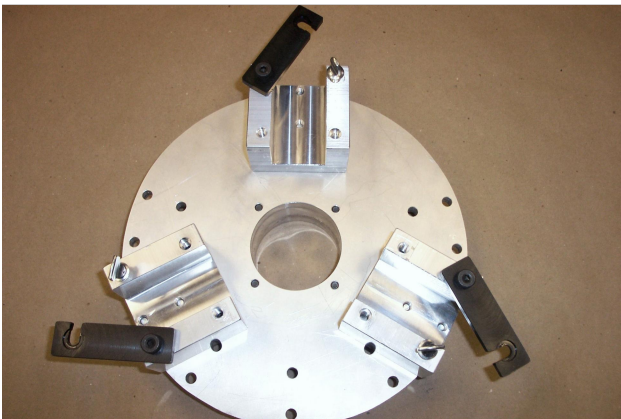
# 13970 Rising Stem Hand Wheel Adapter



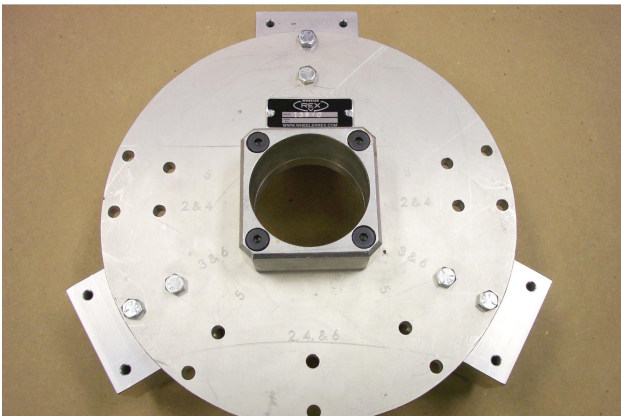
Adapter plate has many holes to fit different hand wheel spoke configuration.  
(See *Hand Wheel Configurations* page 7)



Swing clamp with thumb screw. Loosen thumb screw enough to allow swing clamp to move freely. When attached on hand wheel, make sure thumb screw is properly seated in the swing clamp groove.

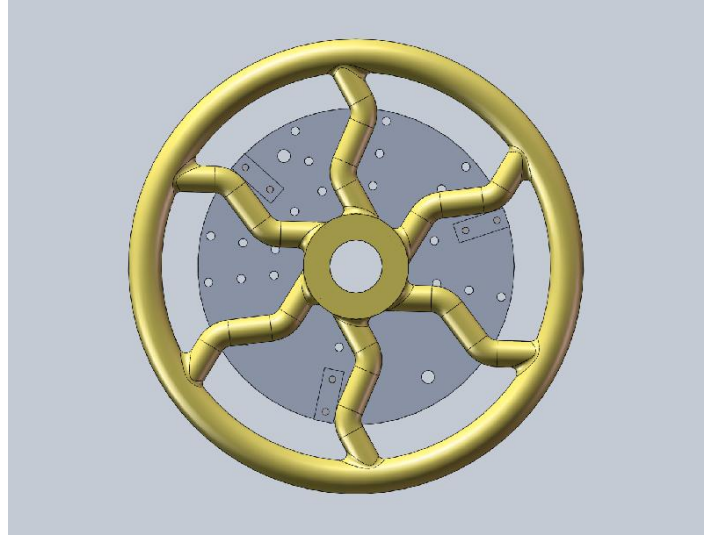
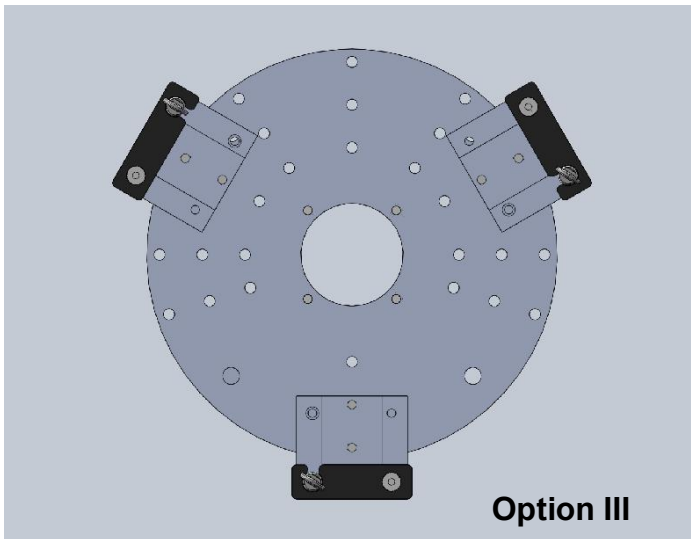
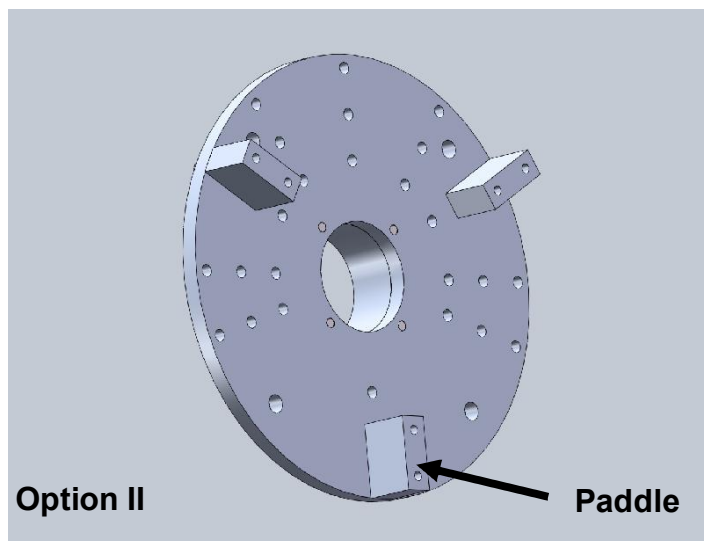
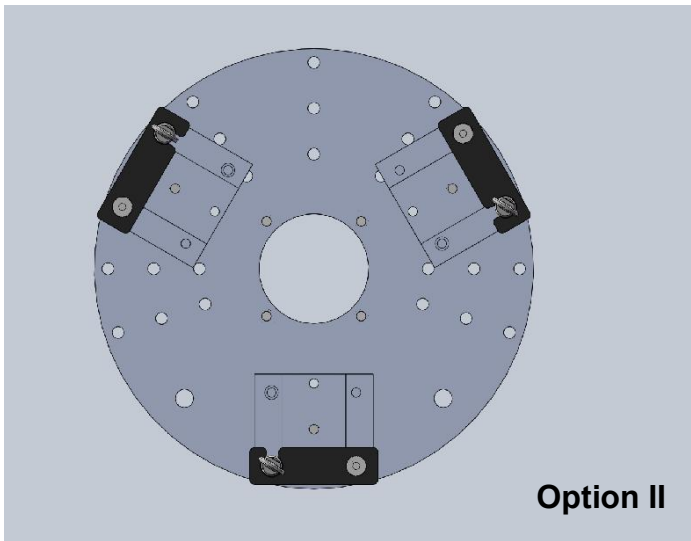
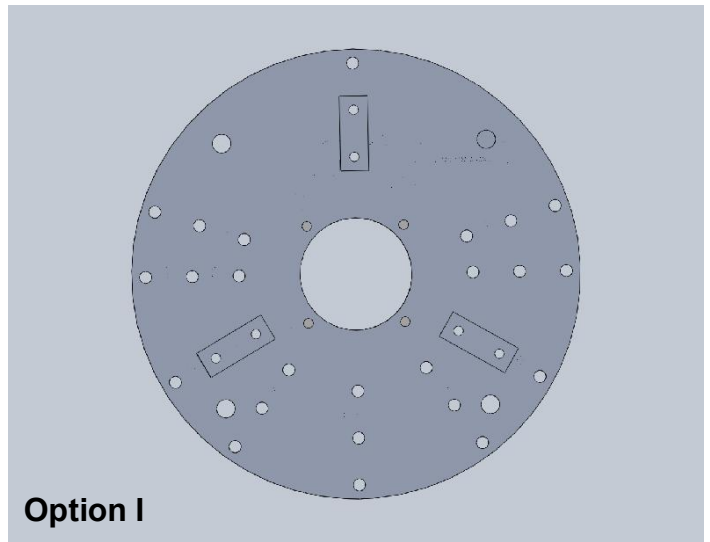
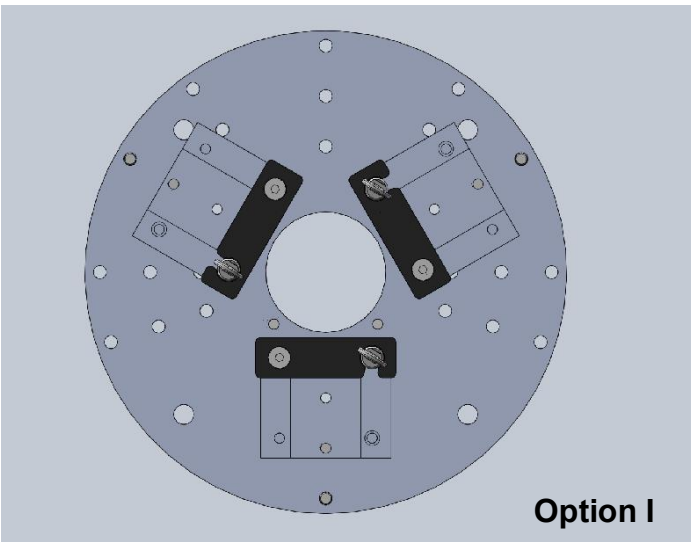


Bottom view with swing clamps open. Swing clamps can be installed to swing from each direction.



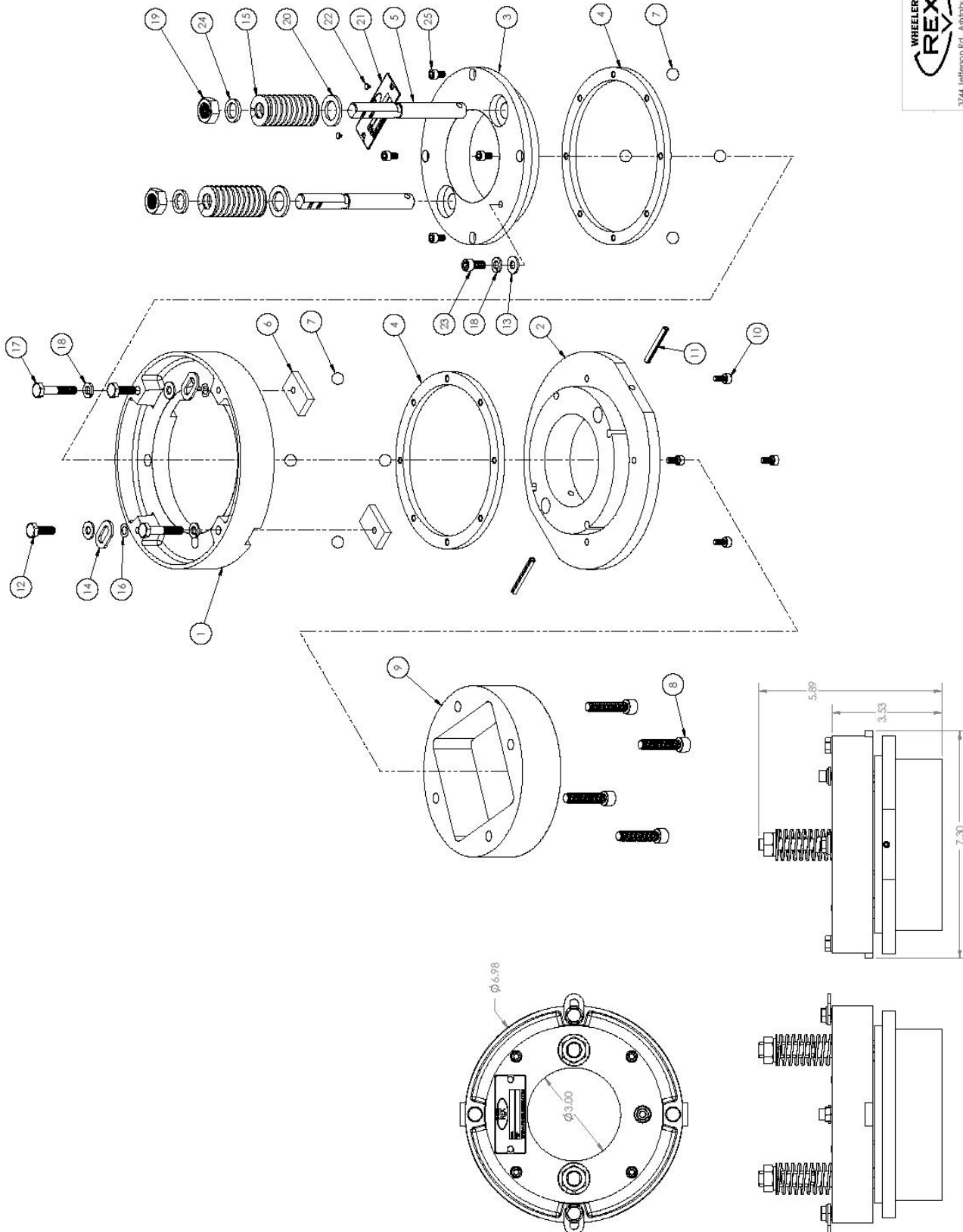
Brackets can be turned around to accommodate larger hand wheels.

# Hand Wheel Configurations



# 13968 Parts Diagram

  
 574 Jefferson Rd., Ashburn, OH 44005  
 (440) 285-1234  
 RISING STEM TORQUE ADAPTER  
 PART NO. 13968

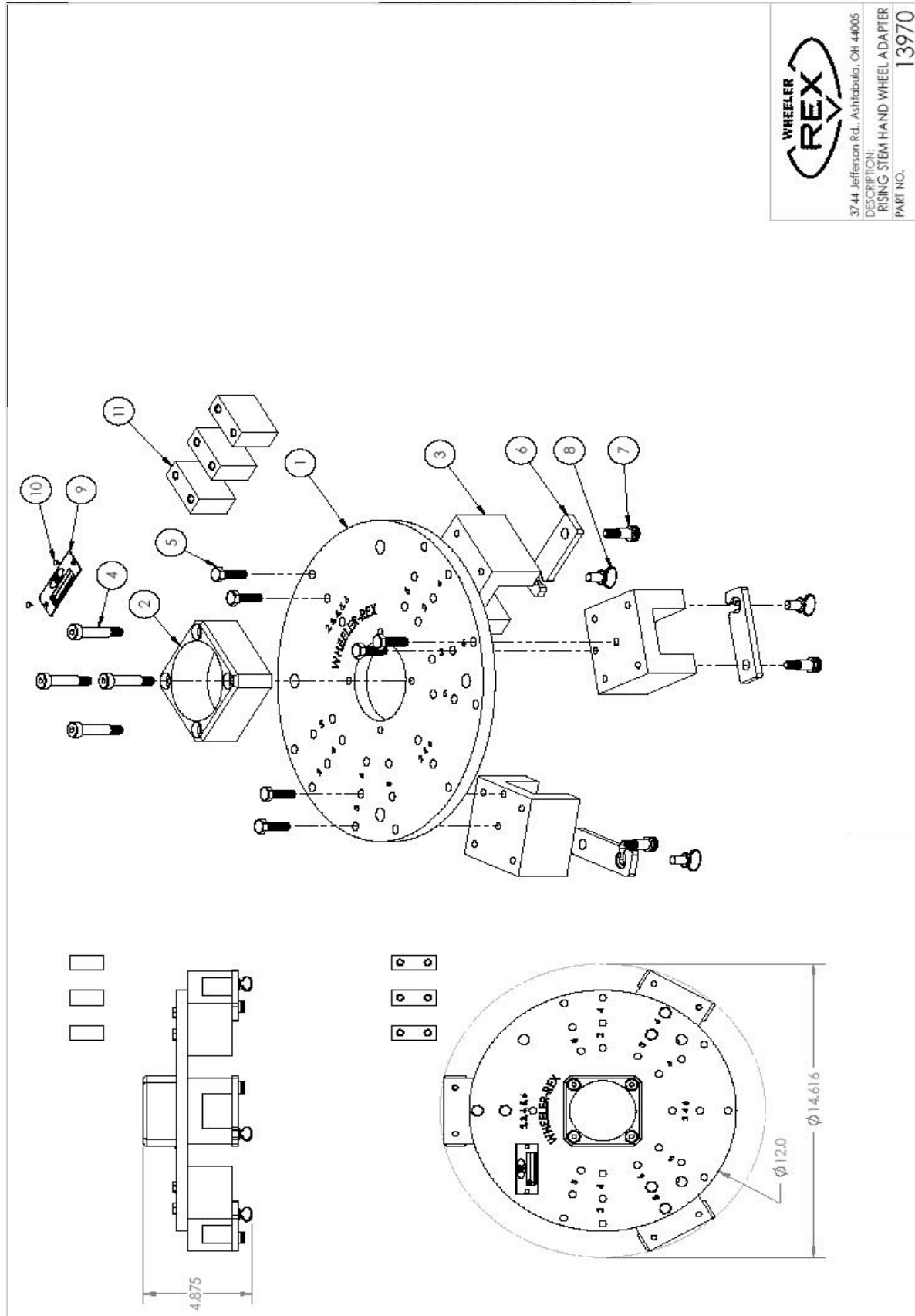




# 13968 Parts Diagram List

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	701250	CENTER RING	1
2	701249	LOWER RING	1
3	701251	UPPER RING	1
4	701248	WEAR RING	2
5	701252	CONTROL ROD	2
6	701253	DRIVE TAB	2
7	277105	CHROME BALL	8
8	275047	5/16-18 x 1 1/2" SHCS	4
9	701243	DIRVE ADAPTER, FEMALE	1
10	277121	#10-32 x 3/8 SHCS	4
11	275862	3/16" DIA x 1 1/2" ROLL PIN	2
12	560081	1/4-20 x 3/4" HHCS	2
13	10713	3/16" FLAT WASHER	3
14	11274	FINGER LOCK WASHER	2
15	277104	SPRING	2
16	5306	SPRING WASHER	2
17	276819	1/4-20 x 1 3/8" HHCS	2
18	275105	1/4" SPLIT LOCK WASHER	3
19	4117	1/2"-20 HEX JAM NUT	2
20	277103	SHIM WASHER	2
21	701159	SMALL NAME PLATE	1
22	276203	METAL TAK	2
23	277109	1/4-20 x 1/2" LONG SHCS	1
24	277122	SHIM WASHER	2
25	277106	#10-32 x 5/16" LONG SHCS	4

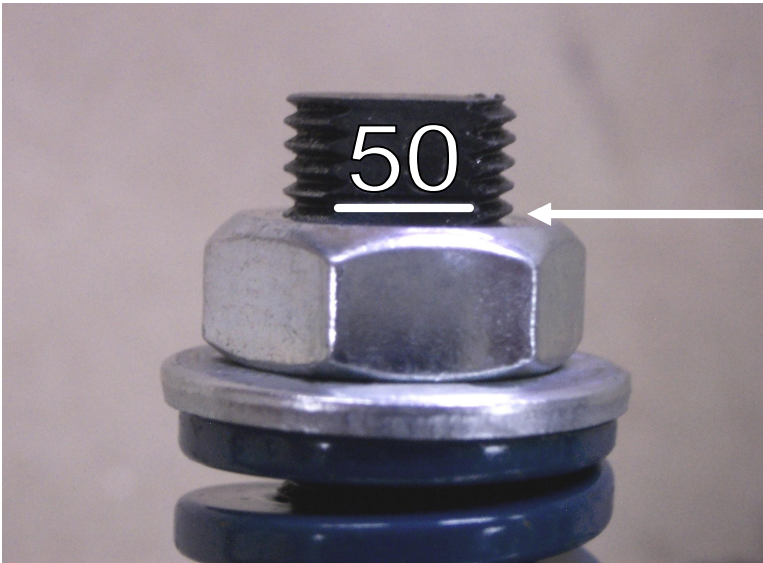
# 13970 Parts Diagram



# 13970 Parts Diagram List

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	701242	PLATE	1
2	701244	MALE DRIVE ADAPTER	1
3	701246	SPOKE DRIVER	3
4	277102	3/8 DIA x 1 1/4 LONG SHOULDER BOLT	4
5	1020	5/16-18 x 1" Hex Head Cap Screw	6
6	701247	SWING CLAMP	3
7	275952	Shoulder Screw 3/8 x 1/2" long	3
8	6511	THUMB SCREW	3
9	701159	SMALL NAME PLATE	1
10	276203	METAL TAK	2
11	701306	PADDLE	3

# Adjusting the Torque

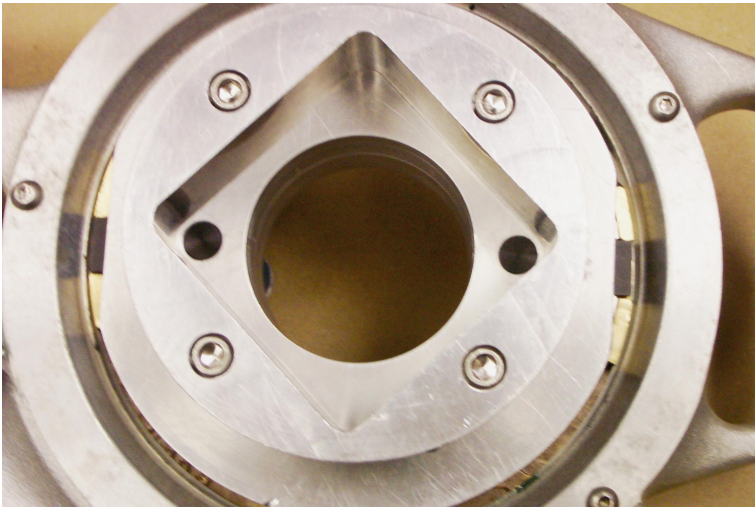


Each control rod has numbers stamped on both sides of it. The numbers are 50 ft/lb increments. The top of the nut should be level with the line scribed on the control rod.



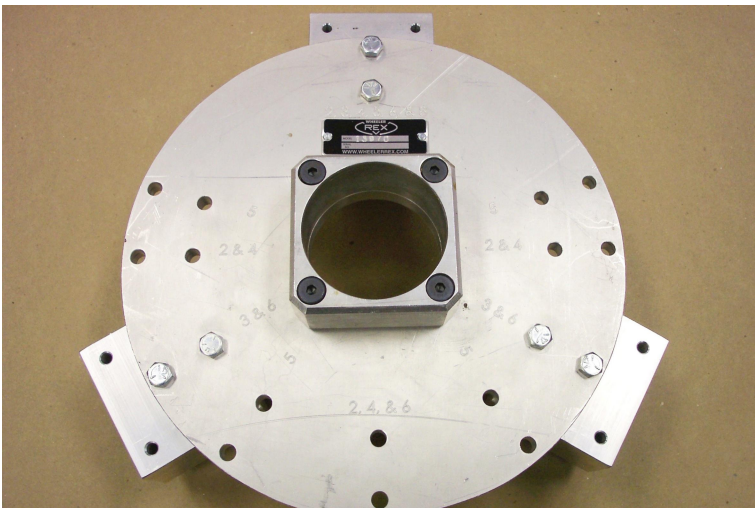
Back each adjusting nut off to start with minimal tension on each spring. Clutch will “pop” as the drive gear turns either direction. Make sure that the clutch has not been “popped” prior to increasing the torque. To increase the torque, simply turn the nut clockwise with a 3/4” box wrench. Adjust each nut equally. Slowly increase each nut until there is enough torque to turn the valve. You want to have just enough torque to drive the valve without having the clutch slip.

# Attaching Torque Adapter to Hand Wheel Adapter



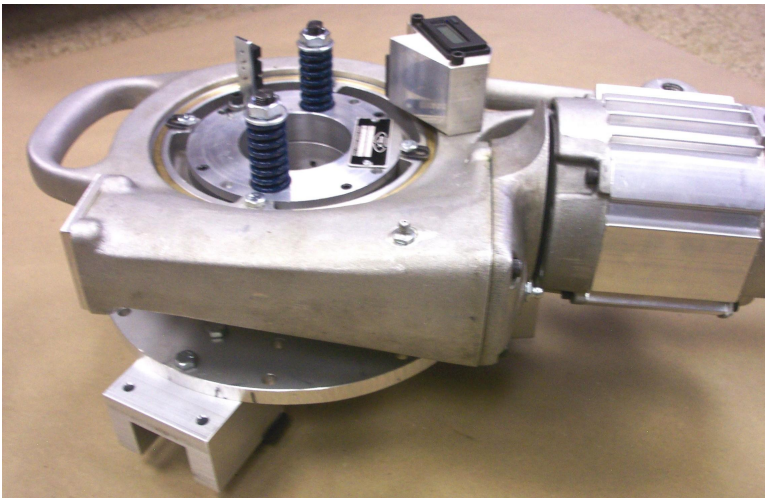
← Female

Female square drive, located on the torque adapter.



← Male

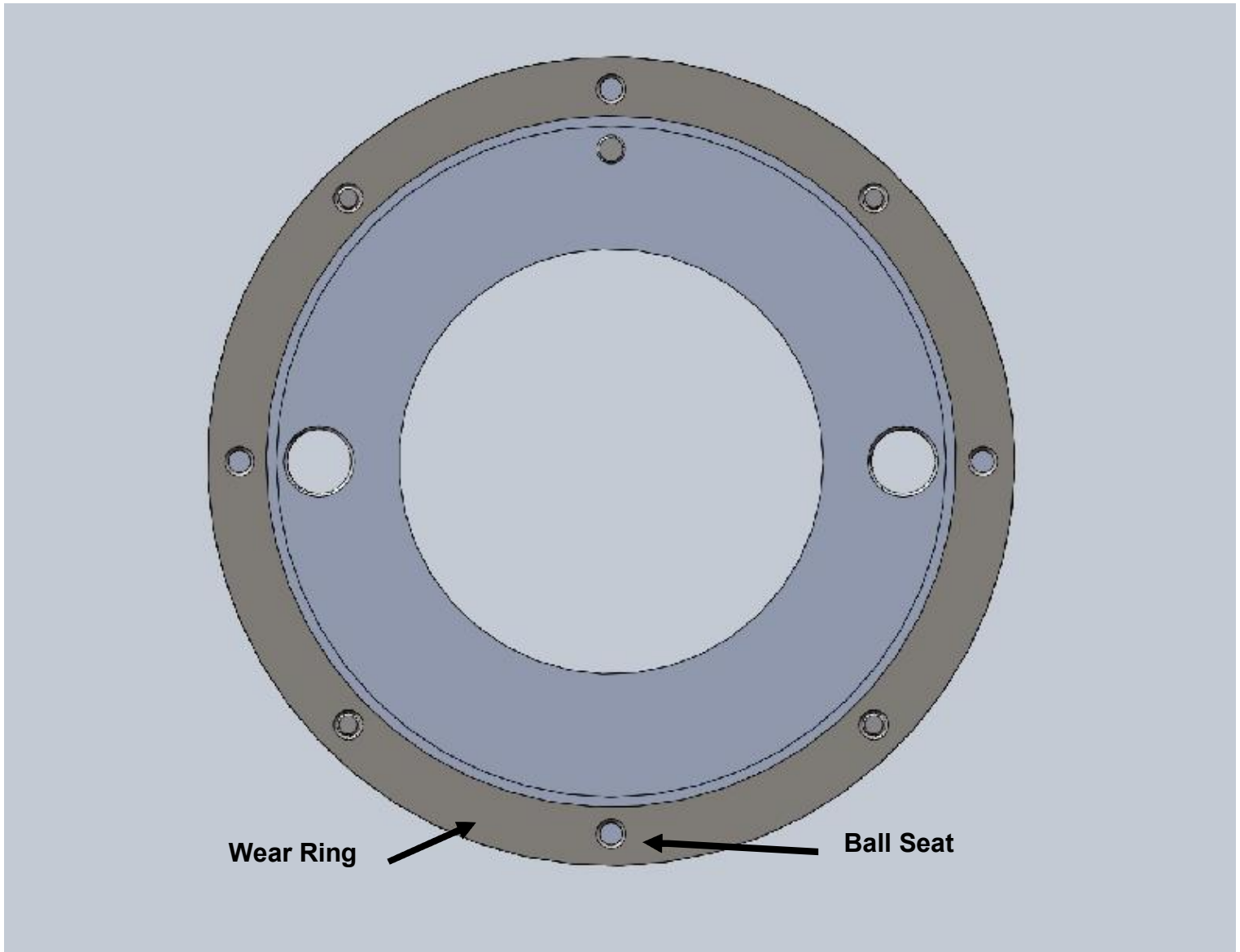
Male square drive, located on the hand wheel adapter.



Power drive with torque adapter placed on the hand wheel adapter.

# Wear Ring Instructions

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Wear rings are two (2) sided. Therefore, if one side becomes worn, it can be flipped over for extended tool life.

**Watch ball seats for wear. Normal ball seats are round. They will become oval with wear.**

With increased wear, the torque curve will also be less than what it is set for.

Example: Clutch is set at 50 ft/lb and only creates 40 ft/lbs before the clutch slips.