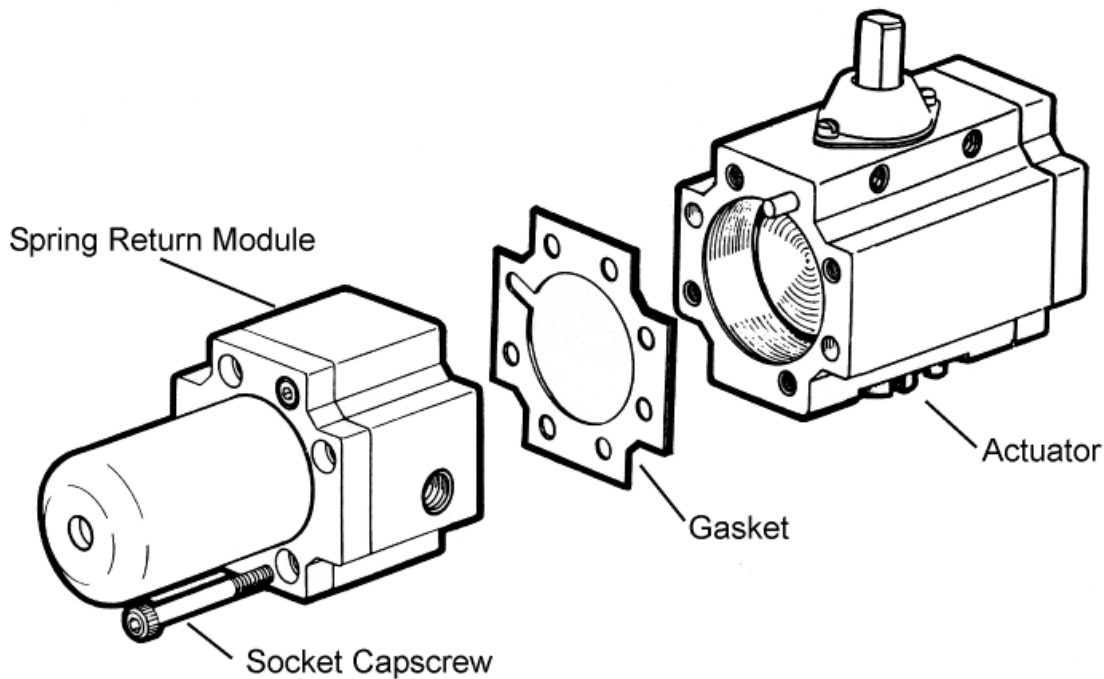




Installation Instructions for Gemini Spring Return Module SMB412 and SMA422

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The following procedure applies to the conversion of a double-acting actuator Gemini B412D to a spring-return B412SR using the SMB412 Spring Module and the conversion of a double-acting A422D, or A422DA to an A422SR or A422SRA spring-return using the SMA422 Spring Module:

1. Remove the right hand end cap (the end cap with air connection ports). If the gasket adheres to the actuator body, it need not be

disturbed; if it adheres to the end cap, carefully remove it so as to avoid damage and replace it on the actuator body with the notch at the 10 o'clock position as shown in the above sketch.

2. After removing the rubber band (if present) from the assembly screws, place the spring module in position so that the air inlet is on the opposite side from the actuator nameplate. The stamped 'SR' identification on the far side

of the spring module should be on the same side as the actuator nameplate.

3. Secure the spring module with the four long socket capscrews. These screws must be tightened securely to prevent gasket leakage.

The unit is now ready for service once the air connection is made.