



## Product Repair Guide

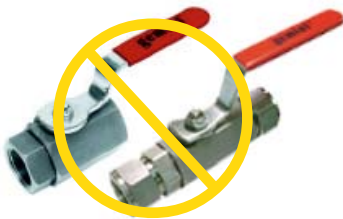
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### 76 Series Valves - Single Piece Body



The Gemini Series 76, one piece body design, is not regarded as a maintainable product by Gemini Valve. Series 76 valves which have become worn out are ordinarily replaced. Additionally, the use of a special tool is necessary in dismantling and reassembling the valve. This tool is not available from Gemini Valve. Note that the price of a seat and seal kit may approach 60% of the cost of a new valve and does not include labor and any safety related issues should the valve be incorrectly repaired.

### 86 / 96 and 82 Series Valves - Two Piece Body



The Gemini Series 86 / 96 and 82 valves are of a two piece body design, which permits disassembly without any special tools. Although still promoted as maintenance free, replacement of the seats and stem seal may enable the valve to be returned to service. For stainless steel valves problems associated with 'galling' of the mating parts could result in body seal leakage and subsequent safety issues. Note the price of a seat and seal kit may approach 60% of the cost of a new valve and does not include labor and any safety related issues should the valve be incorrectly repaired.

### 89 Series Valves - Three Piece Body & 98 Series Valves - Wafer Style



Gemini Series 89 Three Piece & 98 Series Wafer Style valves, can be readily removed from service for inspection or repair. Repairs may be made on site and the repaired valve quickly returned to service, or a spare center section may be substituted to minimize down-time.



### 309 Series Valves - Two Piece Body



Gemini Series 309 Series Diverter valves cannot be repaired and once worn beyond service life must be replaced.

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## 400 & A500 Series Pneumatic Actuators

Gemini 400 & A500 Series Pneumatic Actuators are designed to be maintenance free and normally are replaced vs. repaired.



**A512D / A522D**



**B411D / B412D / A421D / A422D**

**Double-Acting Models:** For double-acting models, rebuilding of the actuator by our *Factory Authorized Service Center* may enable the actuator to be returned to service depending on the duty cycle the actuator has seen. The cost to rebuild the actuator is generally 50% of the cost of a new actuator. For details on this service please contact us. Additionally, for those customer desiring to replace O-rings, gasket(s) and lubricant, we offer O-ring kits which contain these genuine factory components.



**A512SR / A522SR**



**B412SR / A422SR**

**Spring-Return Models:** For the A500 Series spring-return models, rebuilding of the actuator by our *Factory Authorized Service Center* may enable the actuator to be returned to service depending on the duty cycle the actuator has seen. The cost to rebuild the actuator is generally 50% of the cost of a new actuator. For details on this service please contact us. O-rings kits are not available for the A500 Series. The 400 Series are not recommended to be rebuilt and should be replaced when they have seen their useful life.

## 600 & 92 Series Electric Actuators



No cost effective options are available to repair / rebuild electric actuators and once worn out should be replaced.

## LS-1 Limit Switch & 4GP & 3GP Pilot Valves



No cost effective options are available to repair / rebuild limit switches. 4GP & 3GP pilot valves where the operating coil has become damaged or worn out can be easily replaced. No other components are recommended or available for replacement.