



ASSEMBLY INSTRUCTIONS:

1. Apply Braycote 803 grease to the 180-55K seat plug thread and place in body.
2. Using the 18R2-2 stem, screw the seat plug clockwise to seated position.
3. Place 18R2-6 seal washer on top valve body sealing surface.
4. Place the 18R2-14 thrust washer into groove of 18R2-3A bonnet.
5. Screw 18R2-3A bonnet assembly over valve body clockwise to seated position.
6. Torque 18R2-3A bonnet to 190 Ft/lbs.
7. Install 180-5 handle, 306-11 spring, and 306-17 nut.

NOTE: The bonnet assembly is pre-lubed with Bracote 803. If additional lubrication is required use Braycote 803. Halocarbon is not an acceptable lubricant for the Rod T-Seal.

Made in the U.S.A