



D55 Repair Kit Instructions For G2 Internal



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Components from the top going clockwise: nozzle base, nozzle, easy arc adjust cap, arc adjust, retainer, shaft cap, hub and o-ring, locknut, washer and (riser) o-ring.

Removing the G2 internal assembly from the rotor body. Using the snap ring tool in the cap snap ring access hole pull the internal up and hold in place by hand.



Using the snap ring tool again, hook the window in the snap ring and pull it up and out of the body groove. This may need to be done again in the other snap ring window to free the snap ring from the body groove. The internal is now free to be removed from the body.



Hold the internal down by the cap and remove the 2 screws on top with a Philips head screw driver. Slowly let the cap up and the spring to relax to remove the parts.



Using a small and large screw driver and needle nose pliers, remove the arc adjust, nozzle, shaft cap and retainer and the hub.

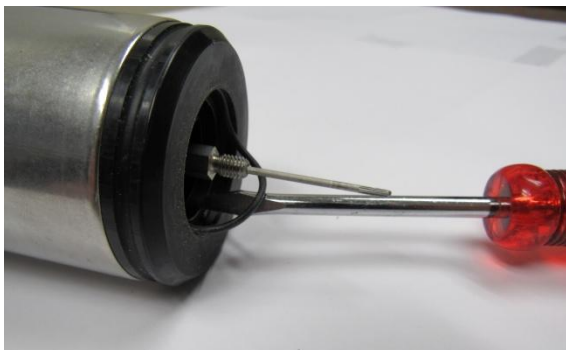
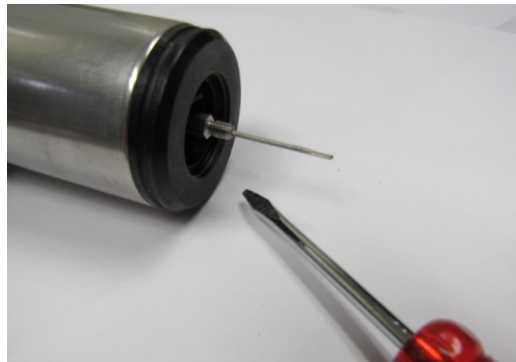




Old parts removed.



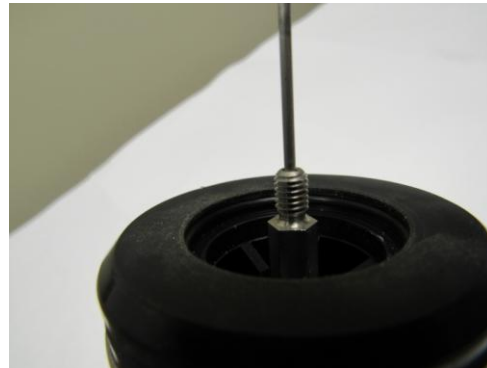
Using needle nose pliers or a socket wrench remove the locknut while holding the nozzle base from turning. Remove the nozzle base and steel washer. Remove the o-ring from the side groove in the riser using a small flat head screw driver.



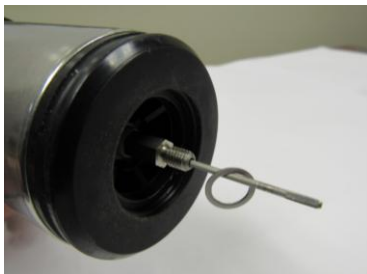
Old parts removed.



Now install the repair kit starting with the new o-ring for the side groove in the riser.



Add the new steel washer, nozzle base and lock nut. Do not reuse the old lock nut. The new lock nut has a machined lip on the bottom of it.



The new lock nut is on the right side in both photos having a machined lip on the bottom side.



Old Nut
(Top Side) New Nut
(Top Side)



Old nut New Nut
(Machined Side)

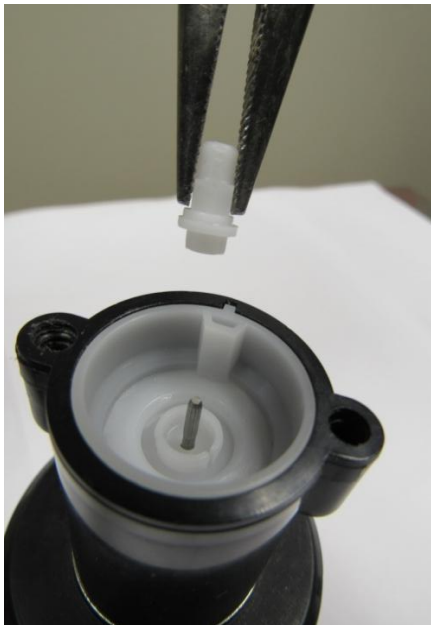
Install the lock nut with the bottom side down on the threads as shown. Hand tighten for a snug fit.



Push on the new hub with o-ring flush with the top of the nozzle base fitting into a notch.



Install the shaft cap onto the metal shaft pushing it down until it hits bottom.



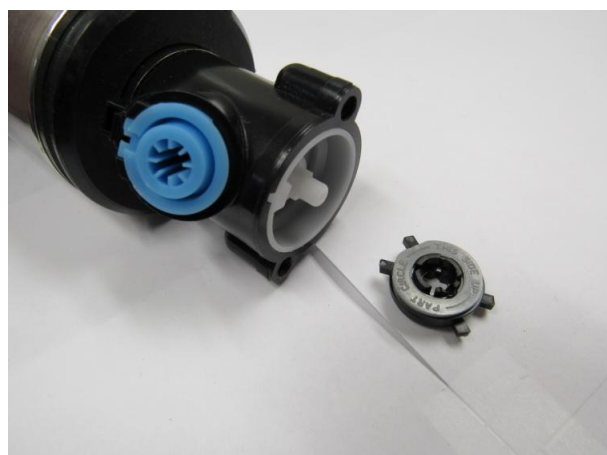
Install the retainer over the shaft cap and push it down until it snaps in place.



Install the nozzle by pushing it in until it hits bottom.



Install the arc adjust snapping it in. Grey side for part circle and black side for full circle.



Remove and replace the arc adjust cap.



Place the snap ring under the cap lip on the cap bottom side for internal installation back into the body.



Install the rest of the components as they were removed. Hold the cap and spring down as the 2 screws are installed.



Place the internal into the body and press down. Use snap ring tool through 2 slots on top of cap to push snap ring down and into body groove to lock in. Pull up internal to see that it is locked in place.



Open top cap and adjust the arc adjust as needed.



(Note: Components shown in this document could be of a different material or color compared to components in hand. The assembly concepts are the same.)

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