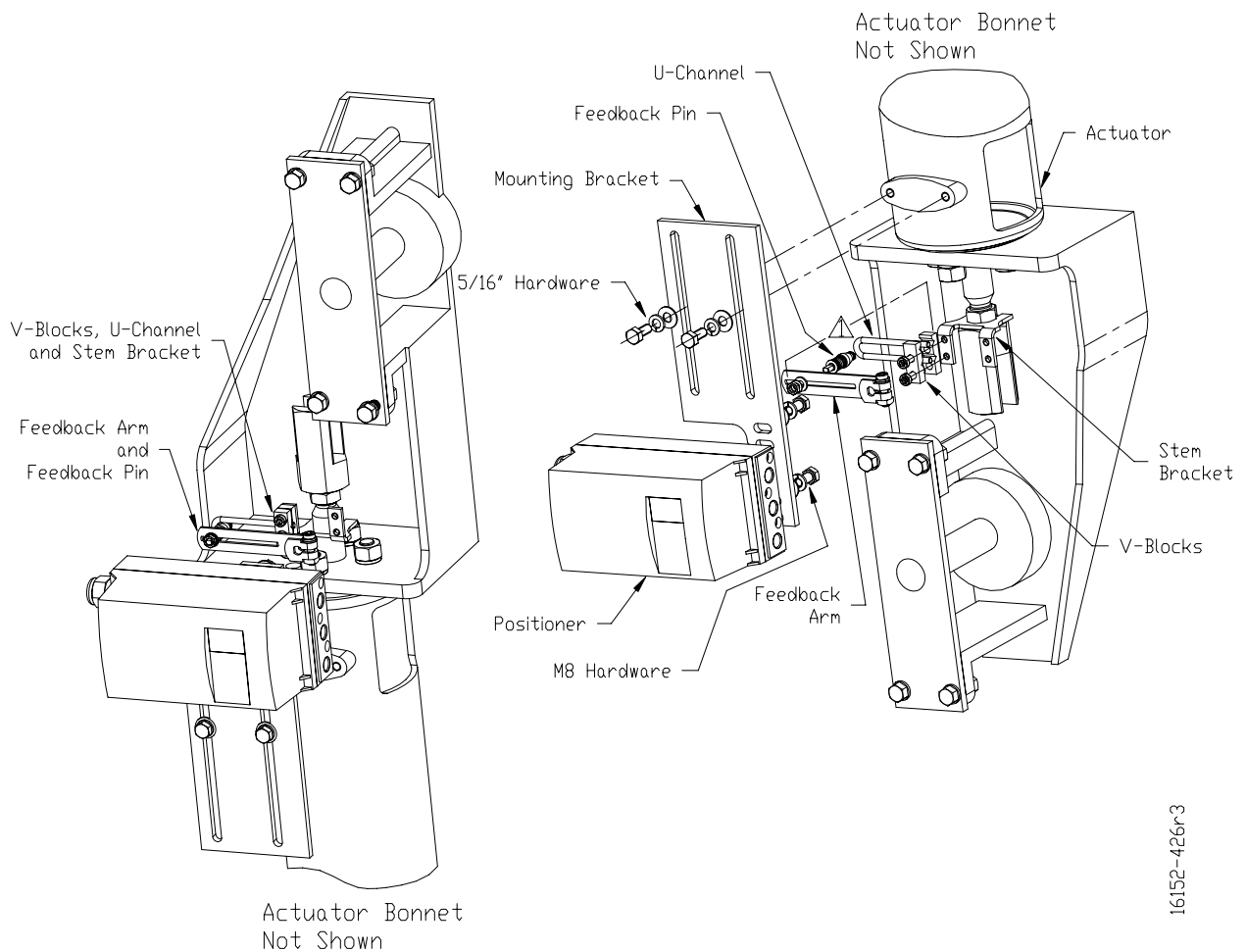


Kit PN TGX:16152-426

15900-676
Rev 2
February 2006

SIPART PS2 MOUNTING BRACKET FOR FISHER 656 SIZE 60 ACTUATOR

This Instruction provides installation procedures to mount a Siemens SIPART PS2 to the above Fisher actuator and to install the mechanical feedback linkage. Typical installations are shown in the illustration below. Installed views are shown on page 3.



Actuator Orientation is Bonnet Down

Actuator Orientation is Bonnet Up

Drawing Note:

1. These feedback linkage parts are not included in kit TGX:16152-426. Order Siemens Kit PN 6DR4004-8VL.

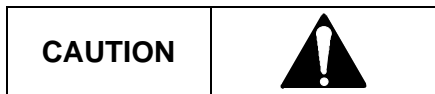
TGX:16152-426 KIT PARTS

Item	Description	Quantity
1	Mounting Plate	1
2	Stem Bracket	1
3	5/16-18 x 0.75" Hex Hd Screw	2
4	5/16" Medium Split Lockwasher	4
5	5/16" Flat Washer	4
6	M8 x16 Hex Hd Screw, DIN 933-A2	2

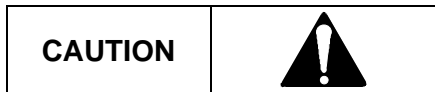
INSTALLATION

Refer to the following procedure and to the positioner and actuator installation instructions while performing the installation. The current revision of the positioner instruction is available at the Siemens Internet site. See Contact Information later in this Instruction for the URL.

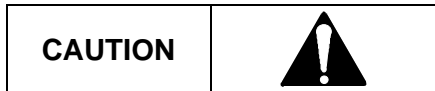
Before beginning the installation, note the following cautions.



Do not apply supply pressure to the actuator or the valve positioner during the installation process. Applying supply pressure before the equipment is properly mounted could cause unexpected movement that could lead to personal injury or equipment damage.



Do not exceed the maximum actuator and valve positioner air pressures stated in the manufacturer's literature. Exceeding these ratings could cause personal injury or equipment damage.



The actuator stem clamp must be loosened to install the kit. Always set valve and actuator stems to their relaxed positions before loosening the stem clamp to prevent possible injury to personnel or damage to equipment.

1. Determine the orientation of the *installed* actuator: bonnet up or bonnet down.

IMPORTANT

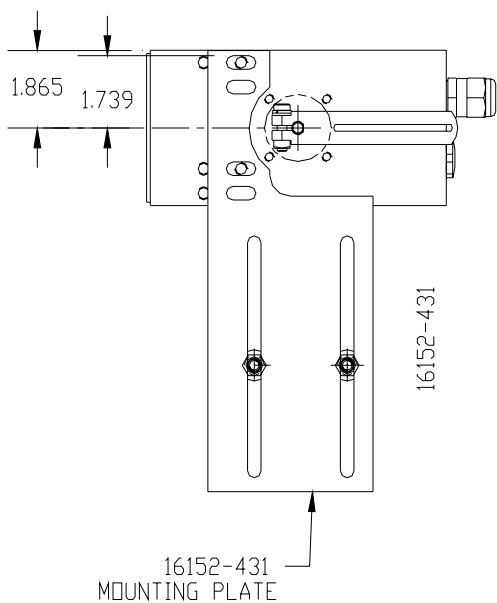
The installation of several kit components is dependent upon the orientation of the actuator: bonnet up or bonnet down. Pay particular attention to the orientation of the stem bracket and the attachment of the V-blocks and U-channel; see the two views on page 1.

2. From the 6DR4004-8VL kit, get two V-blocks, the U-channel, and two screws. Use the screws to fasten the V-blocks and U-channel to the stem bracket; see the two views on page 1. Later it may be necessary to slightly reposition the U-channel in the V-blocks to allow proper travel of the feedback pin.
3. Insert the stem bracket between the actuator shaft nut and coupling. Tighten the nut securely.
4. Fasten the mounting plate to the positioner.
 - 1) From the TGX:16152-426 kit, get the mounting plate, two M8 screws and two 5/16" lockwashers and flat washers.

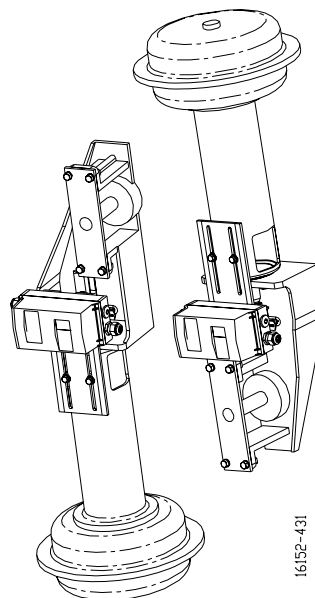
- 2) Orient the positioner and mounting bracket as they are to be installed on the actuator. Orientation depends upon actuator orientation: bonnet down or bonnet up.
- 3) Find the positioner mounting holes and the mounting bracket holes that center the positioner input shaft in the semicircular cutout in the mounting plate; see the view on page 3.
- 4) Secure the positioner to the mounting bracket with the hardware from step 1).
5. From the 6DR4004-8VL kit, get the feedback pin; a nut, lockwasher and flat washer; and the feedback arm. Fasten the feedback pin to the feedback arm using supplied hardware, if not already attached. The PS2 can function with a wide range of shaft rotations. For 60° rotation, for example, place the pin at a distance from the shaft equal to the stroke.
6. Fasten the feedback arm to the positioner input shaft.
7. From the TGX:16152-425 kit, get two 5/16" screws, lockwashers, and flat washers.
8. Read the "Important" note below and then fasten the mounting plate to the actuator, using the supplied 5/16" hardware, while engaging the feedback pin in the U-channel. Slide the mounting plate and PS2 positioner along the vertical mounting slots in the mounting plate until the feedback arm is perpendicular to the valve stem at the 50% stroke position; this alignment need not be exact. Tighten all hardware.

IMPORTANT

While fastening the mounting plate to the actuator, be sure the feedback pin is inserted into the U-channel. The spring in the feedback pin should be compressed approximately 3/16" to 1/4" (4.5mm to 6.5mm).



**Positioner Location on Mounting Plate,
Actuator Bonnet Down Shown**



Installed Views

9. Read the "Cautions" on page 2 and then apply the appropriate air pressures to fully stroke the valve. Inspect the positioner/actuator assembly to ensure that:
 - The feedback linkage does not prevent the valve from fully stroking.
 - The feedback pin moves freely within the U-channel for the entire valve stroke. Adjust the feedback pin and U-channel positions as necessary.
 - All linkage hardware is secure.
10. Once the feedback arm moves freely for the entire stroke, make necessary electrical and pneumatic connections and then proceed to the PS2 setup instruction found within the PS2 manual.

CONTACT INFORMATION

United States of America	Telephone	+1 800 569 2132, option 2 for Siemens and Moore brand instruments
	Fax	+1 215 646 3547
	E-mail	PITechSupp@sea.siemens.com
	Hours of Operation	8 a.m. to 4:45 p.m. eastern time Monday – Friday (except holidays)
	Public Internet Site	www.sea.siemens.com/ia/
	Repair Service	+1 215 646 7400 extension 3187

For contact information outside the U.S.A., visit the Siemens public Internet site (see the above table for the URL), locate "Customer Support Process Instrumentation," and click on the Contact Tech Support link to access the Global Support link.

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