

1. **Release Date:** 02/15/2017
2. **Service Letter No.:** SL25 66-12105
3. **Reason for Change:** Specific work instructions for easier installation of 66-12106 Sleeve to 66-12105 Trunnion.
4. **Part/Assembly No.:** 66-12020, 66-12105, 66-12106
5. **Float Model Affected:** 6650
6. **Disposition of Product in Field:** N/A
7. **Approval:** All information provided is in accordance with approved data.
8. **Corrective Action:** As required
9. **Time Required:** 15 minutes + time for temperature stasis
10. **Payments:** None

To install 66-12106 Sleeve to 66-12105 Trunnion:

1. Clean trunnion pins of debris and contaminants.
2. Apply EZ Turn Lubricant to all contact faces of trunnion pins.
3. Place 66-12105 Trunnion(s) in a freezer or other freezing environment of 0°-30°F, approximately. (This is to shrink the aluminum slightly and ease installation.)
4. Assure cleanliness of 66-12106 Sleeve(s).
5. With the trunnion(s) cooled (approximately 3-6 hours, min.), heat sleeve(s) to approximately 350° - 425°F in a capable oven. (Kitchen, commercial or toaster oven will suffice.) This will take 30 – 60 minutes. (This is to expand the stainless slightly and ease installation.)

WARNING

Use proper mitts or other protection when handling heated metal parts, or injury may occur.

Caution

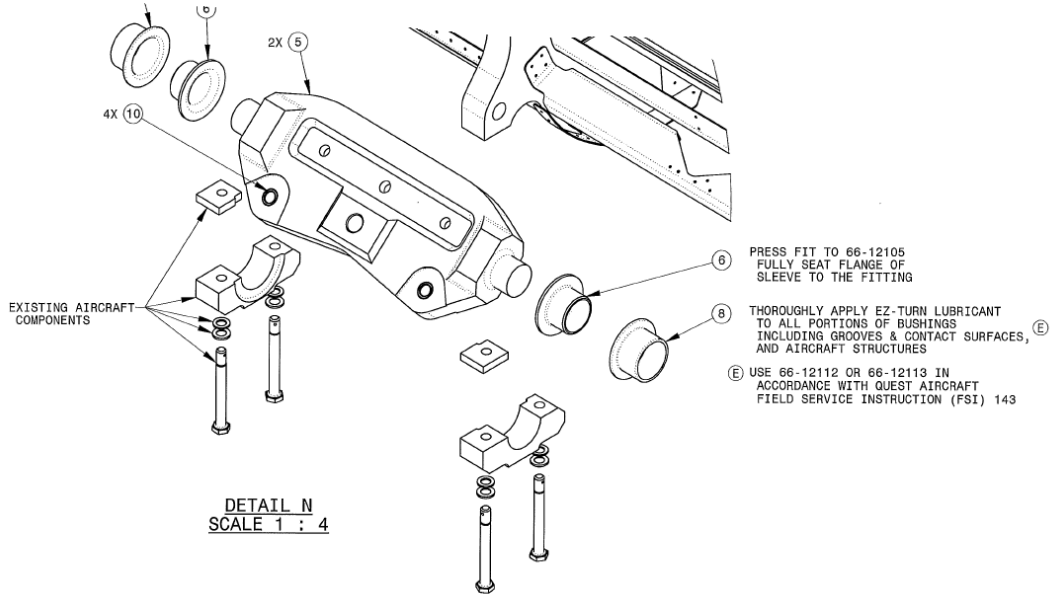
Work quickly, one heated sleeve at a time, leaving any other sleeves in the oven to keep the temperature hot while the workpiece is being installed. If the workpiece cools too much, then the pressing will become more difficult, requiring an arbor press or possibly destructive removal.

6. Stand trunnion on end, on wood over a solid floor or solid surface. Work quickly to avoid cooling of the sleeve, align the sleeve over the trunnion pin and press the sleeve fully, the hat section seating against the aluminum shoulder of the trunnion. A sand mallet or rubber mallet may be used if needed to assure full seating.

WARNING

Do not use a steel or brass (or any other metal) mallet to seat the sleeves, or damage may occur.

7. Repeat for all other sleeves as necessary.



Note: Item 5 is 66-12105, Trunnion; Item 6 is 66-12106 Sleeve.

REVISION RECORD

Rev	Date	Summary of Change	Authorized by
I/R	02/15/2017	Initial Release	LM
A	03/17/2020	Added revision record	LM

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