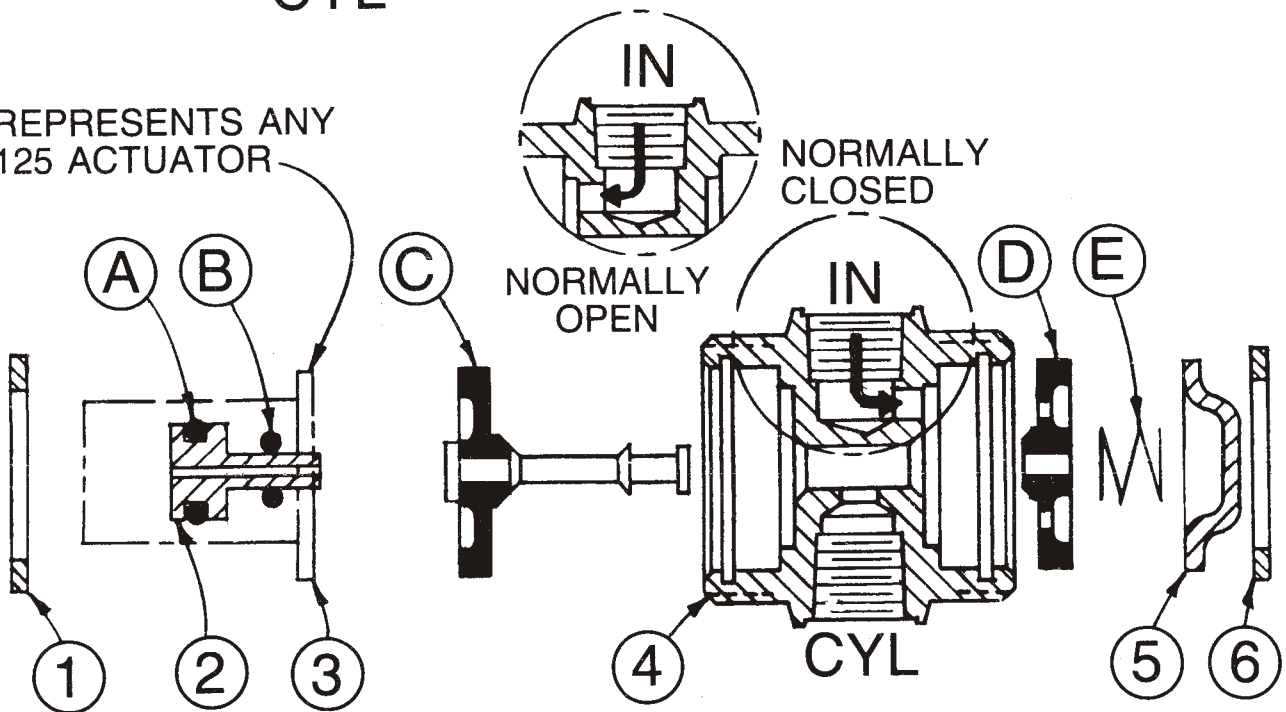


**SEALS REPAIR KIT**  
**SRK125A**  
*Humphrey* PRODUCTS  
 KILGORE AT SPRINKLE ROAD  
 KALAMAZOO, MICHIGAN 49003

REPAIRS SEALS ON ANY:  
 125A Series  
 125B Series  
 125HO Series

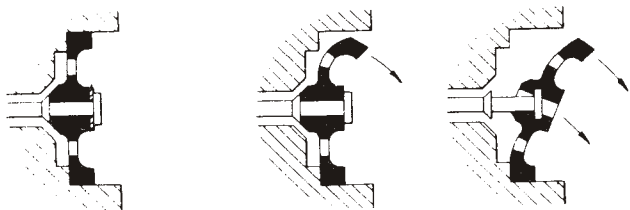
141-1

REPRESENTS ANY  
125 ACTUATOR



**DISASSEMBLY PROCEDURE**

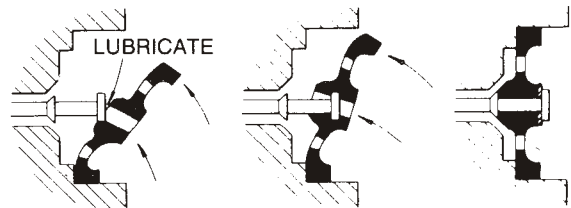
1. Remove Retaining Ring **6**, End Cap **5** and Spring **E**.
2. Remove Diaphragm **D** as SHOWN.
3. Remove Retaining Ring **1**, Actuator **3**.



4. Remove Piston **2** from Actuator **3** (On 125A Normally Open Only).
5. Remove "O" Rings **A & B** from Piston **2** and Actuator **3** (On 125A Normally Open Only).
6. Remove Main Stem and Diaphragm Assembly **C** NOTING relationship to "IN" port to assure correct reassembly.

**REASSEMBLY PROCEDURE**

1. Insert New Main Stem and Diaphragm Assembly **C** into Valve Body **4** in correct relationship to "IN" port.
2. Assemble New Diaphragm **D** to main stem as SHOWN.



3. Add New Spring **E**, End Cap **5** and Retaining Ring **6**.
4. Add New "O" Rings **A & B** to Piston **2** and Actuator **3** (125A Normally Open Valve Only).
5. Lubricate and Assemble Piston **2** to Actuator **3** (125A Normally Open Valve Only). Use CARE when sliding piston over threads.
6. Assemble Actuator **3** to Valve Body **4** with Retaining Ring **1**.

**NOTE:** "O" Rings A & B are used on 125A Normally Open Valve with Booster ONLY. Short Spring E is used in 125A Normally Closed Only.