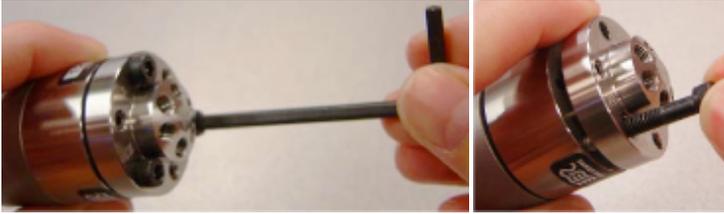


How to use a RheBuild kit for a 3 point adjust front loading valve (model 7125 used)



1. Remove the stator screws.



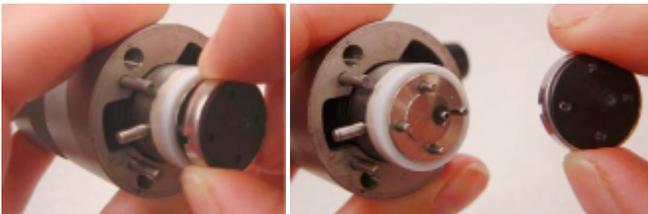
2. Remove the stator and stator face assembly (SFA).



3. Pull off the stator ring.



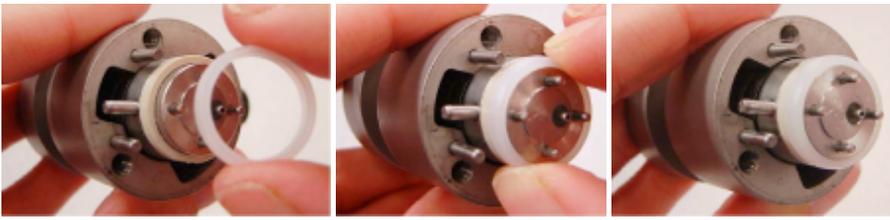
4. Remove the rotor seal.



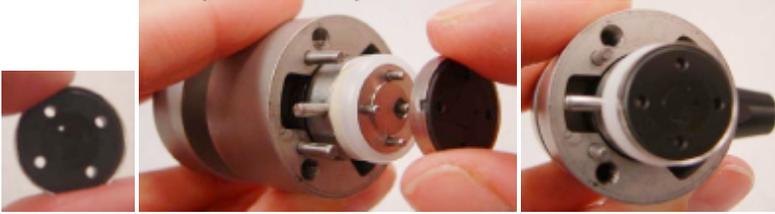
5. Remove the isolation seal. (This part is not included in all RheBuild kits. This part may not require replacement.)



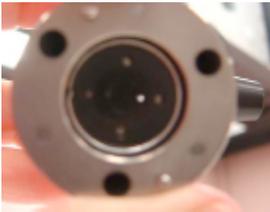
6. Put in the new isolation seal. The open side faces the bearing ring. (toward the handle end)



7. Put the new rotor seal on the shaft with the grooves facing toward you, so you can see them. The notch in the ring should line up with the rotor pin.



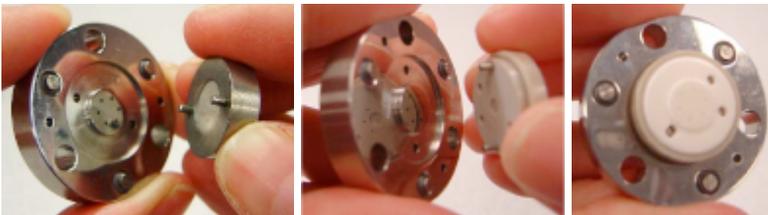
(There is another way to check that the rotor seal is in the correct position. You should be able to see through the hole in the rotor seal all the way up the needle tube in the handle if you look at a light.)



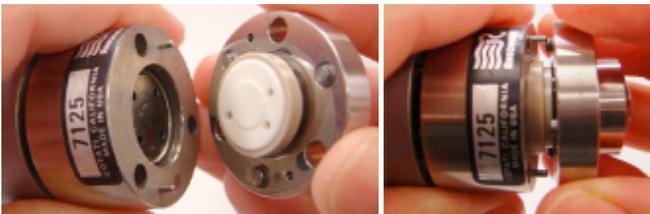
8. Replace the stator ring. The stop pins fit in holes in the ring. (Make sure that the rotor pin is between the stop pins!)



9. Remove the stator face assembly from the stator and replace with the new one. (For SFAs with 2 pins, it can be put in either way. For SFAs with three pins it can only be inserted in the correct direction.)



10. Replace the stator so that the holes line up with the pins on the stator ring.



11. Replace the stator screws and tighten to 1/2 turn past finger tight. (Check that the set screws are all touching the stator ring.)



Reattach the valve to your system. Test the valve to see if it holds pressure. If the valve leaks you will need to tighten the valve. First loosen the set screws the same amount for each one.



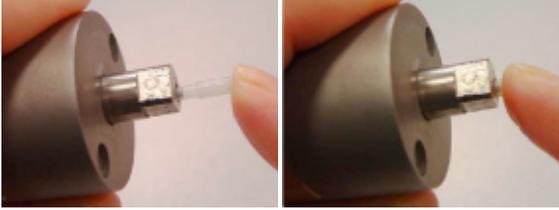
12. Tighten each stator screw a little at a time (1/8 turn or less, working your way around the valve) until the leaking stops. Double check that the gap between the stator and stator ring is the same all the way around. Retighten the set screws so that they touch the stator ring.



13. Remove the needle guide in the handle. (Use pliers if necessary.) You can do this with the handle removed if you prefer. (To remove the handle, loosen the 2 set screws.



14. Push in the new needle guide until it stops.



(You may need to reform the needle seal in the rotor seal. To do this, push against the needle guide with the eraser end of a pencil. Test the fit by loading a sample. If fluid comes out the needle guide while you are filling the loop reform the seal again.)



15. Replace the handle, if removed, by tightening the 2 set screws against the flat portions of the shaft.



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[Watch video.](#)

(*Note: If the video appears in strange colors, make sure you are running at least version 10 of the Windows Media Player*)