

BETTIS

SERVICE INSTRUCTIONS

DISASSEMBLY & REASSEMBLY

FOR MODELS

ST30X-SR AND ST40X-SR

SERIES SPRING RETURN

HYDRAULIC ACTUATORS

PART NUMBER: 113077

REVISION: "A"

DATE: May, 1994

1.0 **INTRODUCTION**

- 1.1 This service procedure is offered as a guide to enable general maintenance to be performed on Bettis ST30X-SR and ST40X-SR Spring Return Hydraulic series actuators. When the model number has a "-S" as a suffix then the actuator is special and may have some differences that are not included in this procedure.
- 1.2 **SAFETY STATEMENT:** Products supplied by Bettis, in its "as shipped" condition, are intrinsically safe if the instructions contained within this Service Instruction are strictly adhered to and executed by a well trained, equipped, prepared and competent technician.

WARNING: For the protection of personnel working on Bettis actuators, this procedure should be reviewed and implemented for safe disassembly and reassembly. Close attention should be noted to the **WARNINGS, CAUTIONS and NOTES** contained in this procedure.

1.3 **DEFINITIONS:**

WARNING: If not observed, user incurs a high risk of severe damage to actuator and/or fatal injury to personnel.

CAUTION: If not observed, user may incur damage to actuator and/or injury to personnel.

NOTE: Advisory and information comments provided to assist maintenance personnel to carry out maintenance procedures.

1.4 **BASIC SERVICE INFORMATION:** Complete actuator refurbishment requires the actuator be dismantled from the valve or device it is operating.

1.5 The maximum recommended service interval for this actuator series is five years. Storage time is counted as part of the service interval.

1.6 This procedure is applicable with the understanding that all electrical power and hydraulic pressure has been removed from the actuator. Also, it is understood that the actuator has been removed from the valve as well as all piping and accessories that are mounted on the actuator have been removed.

2.0 **SUPPORT ITEMS AND TOOLS**

2.1 Support Items - Service/Seal Kit, commercial leak testing solution, and non-hardening thread sealant.

2.2 Tools - All tools are American Standard inch. Two each medium screwdrivers, small standard screwdriver with corners rounded, putty knife, rubber or leather mallet and torque wrench (up to 5,000 in. lbs.). For recommended tool list refer to Chart No. 2 on page 11.

3.0 **REFERENCE BETTIS MATERIALS**

3.1 Assembly Drawing 107954 for ST30X-SR(CW) fail clockwise actuators.

3.2 Assembly Drawing 109019 for ST30X-SR(CCW) fail counter clockwise actuators.

3.3 Assembly Drawing 107957 for ST40X-SR(CW) fail clockwise actuators.

3.4 Assembly Drawing XXXXXX* for ST40X-SR(CCW) fail counter clockwise actuators.

* Part number not assigned at release date of this procedure.

4.0 GENERAL DETAILS

- 4.1 This procedure should only be implemented by a technically competent technician who should take care to observe good workmanship practices.
- 4.2 Numbers in parentheses, () indicate the bubble number (reference number) used on the Bettis Assembly Drawing and Actuator Parts Lists.
- 4.3 This procedure is written using the stop screw side of the housing (1-10) as a reference and this side will be considered the front of the actuator. The housing cover (1-20) will be the top of the actuator.
- 4.4 To help at re-assembly mark or tag all mating surfaces.
- 4.5 When removing seals from seal grooves, use a small screwdriver with sharp corners rounded off or a commercial seal removing tool.
- 4.6 Use a non-hardening thread sealant on all pipe threads.

CAUTION: Apply the thread sealant per the manufacture's instructions.

- 4.7 Disassembly of actuator should be done in a clean area on a work bench.
- 4.8 Some components of this actuator are very heavy and will require a means of assistance. For actuator approximate weight refer to Chart No. 1 on page 10.
- 4.9 LUBRICATION REQUIREMENTS - HOUSING AND SPRING CARTRIDGE: Lubricants, other than those listed in steps 4.9.1 and 4.9.2, should not be used without prior written approval of Bettis Product Engineering.
 - 4.9.1 Standard and high temperature service (-20°F to +350°F) use Bettis ESL-5, Kronaplate 100 lubricant. ESL-5 is contained in the Bettis Service/Seal Kit.
 - 4.9.2 Low temperature service (-50°F to +150°F) use Kronaplate 50 lubricant. This lubricant is not contained in the Low Temperature Service/Seal Kit.
- 4.10 FLUID REQUIREMENTS: For use in the hydraulic power cylinder (2-10). The following listed fluids are recommended fluids only and does not limit the use of other hydraulic fluids compatible with supplied seals and coatings.
 - 4.10.1 Standard and high temperature service (35°F to +350°F) use Dexron II Automatic Transmission Fluid.
 - 4.10.2 Low temperature service (-65°F to +180°F) use Exxon Unavis J13 Hydraulic Fluid.

5.0 GENERAL DISASSEMBLY

WARNING: Ensure that all operating pressure is removed from the hydraulic cylinder.

- 5.1 Mark or tag stop screw (1-60) left and right. Measure the exposed length of right and left stop screws (1-60) and record each before loosening for removal.
- 5.2 To ensure correct re-assembly; that is, with pneumatic cylinder on same end of housing as was, mark or tag right or left and mark mating surfaces.
- 5.3 Record the locations of the pressure ports in the cylinder assembly (2-10) mounting flange.
- 5.4 Remove snubber valves (1-190) from the housing cover (1-20) and the housing (1-10).

6.0 SPRING CARTRIDGE REMOVAL

WARNING: Under no circumstances should the spring cartridge be cut open as the spring is pre-loaded with the end caps and cylinder welded around the loaded spring.

CAUTION: Due to the weight and size of the spring cartridge, support equipment will be required when removing the spring cartridge from the actuator housing.

- 6.1 When the spring cartridge is installed on the actuator the spring is under compression.

CAUTION: Do not remove the spring cartridge until the actuator has the stop screw "pre-load" removed.

- 6.2 Remove spring cartridge stop screw "pre-load" as follows: Using a suitable hydraulic power source apply pressure to the pressure inlet port located in outer end of cylinder (2-10).
 - 6.3 Refer to assembly drawing page 2 of 2 Detail "A". Locate stop screw (1-60) that is on the opposite side of housing (1-10) from spring cartridge (4-10). Loosen jam nut (1-120) and remove stop screw (1-60).
 - 6.4 Remove hydraulic pressure from pressure inlet port of cylinder assembly (2-10).
 - 6.5 Locate stop screw (1-60) that is on the opposite side of housing (1-10) from the stop screw removed in step 6.3. Loosen jam nut (1-120) and remove stop screw (1-60).
 - 6.6 Remove socket screw (4-60), lockwasher (4-50) and nut retainer (4-40) from the end of spring cartridge (4-10).
 - 6.7 Loosen the two large hex nuts on the outboard end of the spring cartridge (4-10). Unscrew the tie bars until the spring cartridge is free from housing (1-10). Flats are provided on the outboard end of the tie bars for wrench placement. Care should be taken so that the tie bars are not pulled back into the spring cartridge. Place the spring cartridge to one side.
- NOTE:** To keep from inadvertently pulling the tie bars back into the spring cartridge use 7/8 inch 9 UNC hex nuts and screw them on to the spring cartridge tie bars.
- 6.8 Unscrew and remove push rod (4-20) from yoke pin nut (1-30).

7.0 HYDRAULIC POWER CYLINDER ASSEMBLY REMOVAL

- 7.1 Using a 1/2 inch square drive extension through the outer end of cylinder assembly (2-10), unscrew the piston rod (2-80) from the yoke pin nut (1-30).
- 7.2 Use suitable lifting equipment to support the cylinder assembly (2).
- 7.3 Around the large flange of the cylinder assembly (2-10) are eight in number socket cap screws (2-110) and (2-120). To identify four in number socket cap screws (2-120), use the top of the cylinder flange as a starting point, go clockwise around the cylinder flange to one o'clock, four o'clock, seven o'clock and ten o'clock these screws will be item (2-120). Remove the four in number socket cap screws (2-120).
- 7.4 As the socket cap screws (2-120) are removed, the cylinder assembly can be removed from the cylinder adapter (2-130). Remove the cylinder assembly to a clean area for disassembly. See section 7.0 for hydraulic cylinder assembly dismantling procedure.

8.0 HYDRAULIC POWER CYLINDER ASSEMBLY DISASSEMBLY

- 8.1 Drain any residual hydraulic fluid from cylinder assembly (2-10) by opening the bleed valves (2-100) and then removing the cylinder drain pipe plugs (2-90). One is located on outboard end of cylinder and the other on the inboard end of cylinder.
- 8.2 Remove the four in number socket cap screws (2-110). Remove the cylinder inner end cap (2-20) from the cylinder assembly (2-10)
- 8.3 Carefully withdraw the piston rod (2-80) and piston (2-30) from the cylinder assembly (2-10)
- 8.4 NOTE: Keep the split rings in matched sets. Remove the split ring retainer (2-70) and the split rings (2-60) from the outboard side of the piston (2-30). Remove the piston (2-30) from the piston rod (2-80). Remove the inboard split ring retainer (2-70) and the split rings (2-60).
- 8.5 Remove the retaining ring (2-50) from the inner end cap (2-20).
- 8.6 Remove the piston rod bushing (2-40) from the inner end cap (2-20).

9.0 HOUSING GROUP DISASSEMBLY

- 9.1 Remove position indicator pin (1-170) from the position indicator drive assembly (1-230).
- 9.2 Unscrew and remove four in number hex cap screws* with gasket seals (3-100) from position indicator cover (1-210). *Item number for ST3 hex cap screw is (1-260) and for ST4 hex cap screws is (1-90).
- 9.3 Remove position indicator cover (1-210) from the housing cover (1-20).
- 9.4 NOTE: Mark and record the orientation of the position indicator drive (1-230) relative to the top of the yoke (1-160). On the yoke mark the hole location of the set screw (1-180). Unscrew and remove set screw (1-180) from position indicator drive (1-230).
- 9.5 Remove position indicator drive (1-230) from the top of the yoke (1-160).

- 9.6 Remove the housing cover hex cap screws (1-90) and gasket seals (3-100).
- 9.7 NOTE: The cover will have a very tight fit. It is not necessary to remove the cover pins (1-130). Remove the housing cover (1-20).
- 9.8 Remove the upper two yoke rollers (1-50) from the top of the yoke pin (1-40).
- 9.9 Remove yoke pin (1-40) from the yoke pin nut (1-30).
- 9.10 Remove yoke pin nut (1-30) from the yoke (1-160).
- 9.11 Remove lower two yoke rollers (1-50) from the housing (1-10).
- 9.12 Remove the yoke (1-160) by lifting it from the housing (1-10).
- 9.13 Remove the stop screws (1-60), jam nuts (1-120), thread seals (3-110) and countersunk washer (3-120). Be sure to mark or identify as left and right stop screws.
- 9.14 Remove the two socket cap screws (2-140) and remove the cylinder adapter (2-130) from the housing (1-10).
- 9.15 It is not necessary to remove the yoke bushings (1-200) from the housing (1-10) or the housing cover (1-20) unless these items are being replaced due damage or wear. It is not necessary to remove the pipe plugs (1-80) or (1-250), to service the actuator.

10.0 GENERAL RE-ASSEMBLY

CAUTION: Only new seals, that are still within the seals expectant shelf life, should be install back into actuator being refurbished.

- 10.1 Remove and discard all seals and gaskets.
- 10.2 All parts should be cleaned to remove all dirt and other foreign material prior to inspection.
- 10.3 All parts should be thoroughly inspected for excessive wear, stress cracking, galling and pitting. Attention should be directed to threads, sealing surfaces and areas that will be subjected to sliding or rotating motion. Sealing surfaces of the cylinder and piston rod must be free of deep scratches, pitting, corrosion and blistering or flaking coating.

CAUTION: Actuator parts that reflect any of the above listed characteristics must be replaced with new parts.

- 10.4 Before installation coat all moving parts with a complete film of lubricant. Coat all seals with a complete film of lubricant, before installing into seal grooves.

NOTE: The parts and seals used in the actuator housing assembly will be assembled using lubricant as identified in step 4.9. The parts and seals used in the cylinder assembly (2-10) will be assembled using the hydraulic fluid identified in step 4.10.

- 10.5 Prime and apply master gasket (510) to all surfaces as indicated on the assembly drawing, reference note number 5.

11.0 CENTER HOUSING GROUP RE-ASSEMBLY

- 11.1 If removed install pipe plugs (1-80) and (1-250).
- 11.2 Coat one of the yoke o-ring seal (3-50) with lubricant and install into the housing (1-10).
- 11.3 If the yoke bushings (1-200) was removed then install one in the housing yoke bore and one in the housing cover yoke bore.
- 11.4 Inside the housing (1-10) apply lubricant to the tracks and yoke bore and arrange the housing with the yoke bore nearest you.
- 11.5 Apply lubricant to the slots in the upper and lower arms of the yoke (1-160).
- 11.6 Apply lubricant to yoke (1-160) lower bearing surface and install into housing (1-10) as follows: Position the yoke arm to approximately 45° degree position in either direction and lower into the housing. NOTE: The hub with tapped holes faces up. Rotate the yoke back to approximately the mid-stroke (center) position.
- 11.7 Apply lubricant to all surfaces of all four yoke pin rollers (1-50). Place one yoke pin roller (1-50) in the track in the bottom of housing (1-10) and position it under the slot in the yoke arms. Place a second yoke pin roller (1-50) on top of the first yoke pin roller in the slot in the lower yoke arm and align the holes in the yoke pin rollers.
- 11.8 Coat the upper and lower surfaces of the yoke pin nut (1-30) with lubricant and insert into position between the yoke arms, parallel to the track in the housing. Align the yoke pin hole with the yoke pin rollers.
- 11.9 Lubricate yoke pin (1-40) and insert through the yoke pin nut (1-30) and the two yoke pin rollers (1-50).
- 11.10 Install the third yoke pin roller (1-50) over the yoke pin in the slot in the upper yoke arm and now install the fourth and last remaining yoke pin roller (1-50) on top of the yoke roller you just installed in the upper yoke arm slot. The top roller will remain partially above the yoke and will engage the cover track when cover is installed.
- 11.11 Lubricate the push rod (4-20) and slide into the opposite side of housing from the piston rod and screw into the yoke pin nut (1-30).

CAUTION: Do not tighten the piston rod or push rod (4-20) until the housing cover is installed later in the procedure.

- 11.12 Position the position indicator drive (1-230) onto the top of the yoke (1-160) with the slot positioned over the hole that was marked in step 9.4. Secure with the set screw (1-180).
- 11.13 Install the o-ring seal (3-150) over the position indicator drive shaft and down against the flat cover plate.
- 11.14 Prepare the mounting surfaces of the housing cover (1-20) and the housing (1-10) per master gasket instructions (reference note 5 on the assembly drawing).
- 11.15 Place the housing cover gasket (3-20) onto the master gasket prepared housing (1-10).

- 11.16 Install the remaining yoke o-ring seal (3-50) into cover (1-20).
- 11.17 Apply lubricant to the yoke bore and the track in the housing cover (1-20).
- 11.18 Apply lubricant to the upper bearing surface of the yoke (1-160).
- 11.19 Install the housing cover (1-20), being careful not to damage the gasket (3-20) or yoke o-ring (3-50).
- 11.20 Install eight in number cover screws (1-90) and seal gaskets (3-100). NOTE: Leave finger tight-do not tighten.
- 11.21 NOTE: Do this step only if you have pulled the cover pins (1-130) or if you are replacing the cover pins. Drive the four pins (1-130) through the cover (1-20) and into the housing (1-10) until the pin is flush with the cover. The pins are deeply grooved at one end, tapering to a smooth diameter at the other end. The pin should be installed smooth end first.
- 11.22 Tighten the cover screws (1-90).
- 11.23 Tighten push rod (4-20) securely with a strap wrench.
- 11.24 Place thread seals (3-110), countersunk washers (3-120) and jam nuts (1-120) on the stop screws (1-60). Install the stop screws into the housing, making sure the stop screws marked in step 9.13 are installed into the same stop screw holes as they were removed from.
- 11.25 Prepare the mounting surface of the position indicator cover (1-210) and the housing cover (1-20) per master gasket instructions (reference note 5 on assembly drawing).
- 11.26 Install the o-ring seal (3-140) into the bottom seal groove inside the position indicator cover (1-210).
- 11.27 Install the wiper ring (3-160) into the top groove inside the position indicator cover (1-210).
- 11.28 Install the o-ring seal (3-170) into the bottom seal groove on the bottom of the position indicator cover (1-210).
- 11.29 Install the position indicator cover (1-210), being careful not to damage the o-ring seals (3-140), (3-170) and wiper ring (3-160).
- 11.30 Install eight in number new gasket seals (3-100) on to hex cap screws*. *Item number for ST3 hex cap screw is (1-260) and Item number for ST4 hex cap screws is (1-90).
- 11.31 Install and tighten the position indicator cover hex screws*. *Item number for ST3 hex cap screw is (1-260) and item number for ST4 hex cap screws is (1-90).
- 11.32 Install the position indicator pointer (1-170) into the taped hole in the position indicator drive assembly (1-230).

12.0 HYDRAULIC POWER CYLINDER ASSEMBLY RE-ASSEMBLY

NOTE: Where the procedure indicates to "coat or apply fluid", use hydraulic fluid for lubricating the part being installed.

- 12.1 Apply fluid to the o-ring seal (3-40) and install on the piston rod (2-80).

- 12.2 Install a set of matched split rings (2-60) into the inboard groove of the piston rod (2-80) and retain with retaining ring (2-70). Install the piston (2-30) onto the piston rod (2-80) and over the set of split rings. Install a set of split rings (2-60) into the outboard groove and retain with retaining ring (2-70).
- 12.3 Apply fluid and install two in number polypak seals (3-90), ensuring that they are both facing outward and are back to back. Install two in number back-up rings (3-200). Install two in number piston wear rings (3-80).
- 12.4 Apply fluid to the cylinder wall of cylinder assembly (2-10) and then carefully insert the piston assembly into the cylinder assembly.
- 12.5 Apply fluid and install two in number polypak seals (3-70). Install one, lip first, into the recess provided in the inner end cap (2-20). Install the second polypak, lip facing the rod bushing short side, into the rod bushing (2-40).
- 12.6 Apply fluid and install three in number o-ring seals (3-60), (3-180) and (3-190) to the inner end cap (2-20).
- 12.7 NOTE: Make sure that both polypaks (3-70) have their lips facing outward and are back to back. Install the rod bushing (2-40) into the inner end cap (2-20) and retain with the retaining ring (2-50).
- 12.8 Prepare the mounting surface of the cylinder assembly flange and both mounting surfaces of inner end cap (2-20) per master gasket instructions (reference note 5 on assembly drawing).
- 12.9 Install four in number stat-o-seals (3-210) on to four in number socket cap screws (2-110).
- 12.10 Carefully install the inner end cap (2-20) over the piston rod (2-80) and into the open end of cylinder assembly (2-10). Install four in number socket cap screws (2-110) and torque tighten to 240 ft lbs lubricated.
- 12.11 NOTE: Bettis does not require any special hydraulic fluid cleaning standard for this actuator. If required by customers facility, flush the hydraulic cylinder assembly to meet that facilities standard. Seal all openings after flushing.

13.0 HYDRAULIC POWER CYLINDER ASSEMBLY REPLACEMENT

- 13.1 Prepare both mounting surfaces of the cylinder adapter (2-130) and the cylinder adapter side of the housing (1-10) per master gasket instructions (reference note 5 on assembly drawing).
- 13.2 Install o-ring seal (3-10) into the housing side of cylinder adapter (2-130).
- 13.3 Install the cylinder adapter (2-130) on to the housing (1-10) and retain with two in number socket cap screws (2-140).
- 13.4 Apply loctite - 242 to external threads on the piston rod (2-80). NOTE: loctite cure time is ten to thirty minutes.
- 13.5 Install four in number stat-o-seals (3-210) on to four in number socket cap screws (2-120).
- 13.6 NOTE: Refer to step 5.3 for correct location for the cylinder assembly flange. Carefully install the piston rod (2-80) through the cylinder adapter (2-130) and bring the cylinder assembly (2-10), with the inner end cap (2-20), up to the cylinder adapter (2-130). Align the four in number cylinder assembly flange through holes with the tapped holes in the cylinder adapter (2-130). Retain the cylinder assembly (2-10) with four in number socket cap screws (2-120) equipped with the stat-o-seals (3-210) installed at step 13.5. Torque tighten to 150 ft-lbs lubricated.

- 13.7 Using a 1/2 inch square drive extension through the SAE port in the outer end of cylinder assembly (2-10), screw the piston rod (2-80) into the yoke pin nut (1-30) and torque tighten to 150 ft-lbs.

14.0 SPRING CARTRIDGE INSTALLATION

NOTE: Make sure that the stop screws (1-60) have not been screwed into the point that "pre-load" will be created on the spring cartridge (4-10).

- 14.1 Prepare the mounting surface of the inboard end of spring cartridge (4-10) and spring cartridge side of the housing (1-10) per master gasket instructions (reference note 5 on assembly drawing).
- 14.2 Install the end cap o-ring seal (3-10) into the housing end of the spring cartridge (4-10).
- 14.3 Remove the tie bar nuts on outboard end of the spring cartridge (4-10) and install new thread seals (3-110) and countersunk washers (3-120).
- 14.4 Re-install the tie bar nuts onto the outboard end of the SR tie bars.
- 14.5 Remove the two nuts, installed in section 6, from the inboard end of the spring cartridge tie bars.
- 14.6 Install the SR cartridge (4-10) onto the push rod (4-20). Insert the tie bars into the tapped holes in the housing (1-10).

CAUTION: When installing the SR do not allow the spring cartridge tie bars to be pushed back into the cartridge.

- 14.7 NOTE: Flats are provided on the outboard end of the SR tie bars. These flats should be used to put a wrench on to tighten the tie bars. Screw the tie bars into the housing (1-10). Tighten the tie bars until the threads bottom out, then back the tie bars back out one half turn.

CAUTION: While the nuts are being tightened, do not allow the tie bars to turn.

- 14.8 Alternately tighten the tie bars nuts in 50 foot pounds increments until the spring cartridge is firmly against the housing (1-10) and then tighten to 65 ±7 foot pounds. NOTE: It is necessary that the flats on the hex nuts be aligned and parallel before going to the next step.
- 14.9 Install nut retainer (4-40), lockwasher (4-50), and socket cap screw (4-60).

15.0 RETURN TO SERVICE

- 15.1 Replace the software components of the snubber valves (1-190) and then install the snubbers in the housing cover port and the housing port.
- 15.2 Adjust both stop screws (1-60) back to settings recorded in section 5 under General Disassembly.
- 15.3 Tighten both stop nuts (1-120) securely, while holding stop screw (1-60).

- 15.4 After the actuator is installed on the valve all accessories should be hooked up and tested for proper operations and replaced, if found defective.

CHART NO. 1 - ACTUATOR WEIGHTS

ACTUATOR MODEL (1)	APPROXIMATE WEIGHT (POUNDS) (2)				
	SR1	SR2	SR3	SR4	SR5
ST302.5-SRX	521	415	311	318	322
ST303.0-SRX	528	422	318	325	329
ST303.5-SRX	537	431	327	334	338
ST304.0-SRX	548	442	338	345	N/A
ST403.0-SRX	N/A	593	487	384	395
ST403.5-SRX	594	603	497	394	405
ST404.0-SRX	605	614	508	405	416
ST405.0-SRX	647	656	550	447	N/A

- NOTES:**
- (1) Includes both fail clockwise (CW) and fail counterclockwise (CCW) actuator models.
 - (2) Weights listed for each actuator model are for bare actuators without accessories or valve mounting brackets.

CHART NO. 2 - RECOMMENDED TOOL STYLE & WRENCH SIZES

ITEM NO.	WRENCH SIZE	LOCATION	RECOMMENDED WRENCH STYLE
1-60	1/2"	Stop Screw	Open End or Adjustable
1-90	1/2"	T3 Cover Screws	Socket
1-90	9/16"	T4 Cover Screws	Socket
1-120	1-5/16"	Stop Screw Nut	Box End (1)
1-180	3/16"	Set Screws	Allen
1-190	7/8"	Snubber Valve	Deep Socket
2-80	1/2"	Piston Rod	Square drive extension
2-90	9/32"	Drain Plug	Open End or Adjustable
2-100	13/32"	Bleed Valve	Open End or Box
2-110	5/8"	Cylinder Screws	Allen
2-120	5/8"	End Cap Screws	Allen
2-140	3/4"	Cylinder Adapt. Screws	Allen
4-60	3/16"	SR Nut Retainer	Allen
None	1-5/16"	SR Tie Bar Nuts	Deep Socket

NOTES: (1) No alternate style recommended

ECN	DATE	REV	BY *	DATE
Released	May, 1994	A	COMPILED BC	02 May 94
			CHECKED BJ	02 May 94
			APPROVED RMM	02 May 94

* Signatures on Waller, Texas