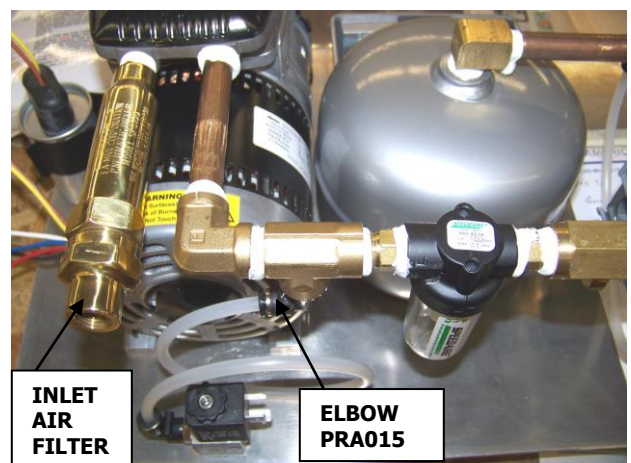
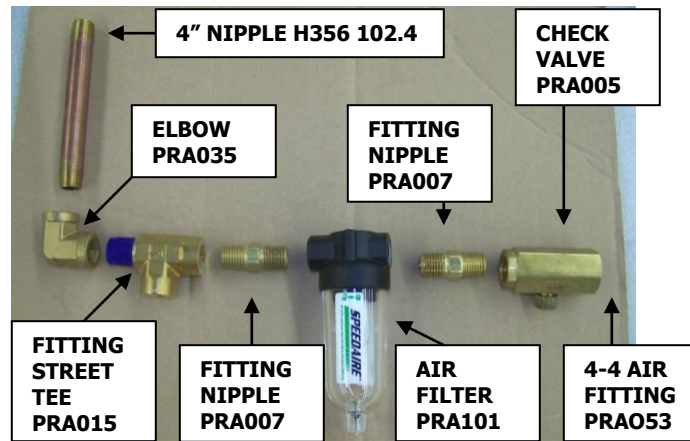
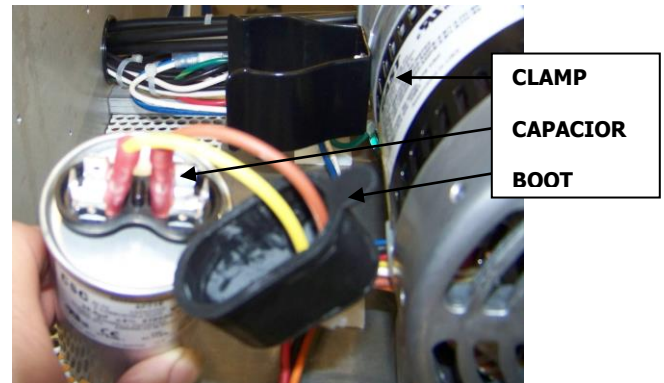
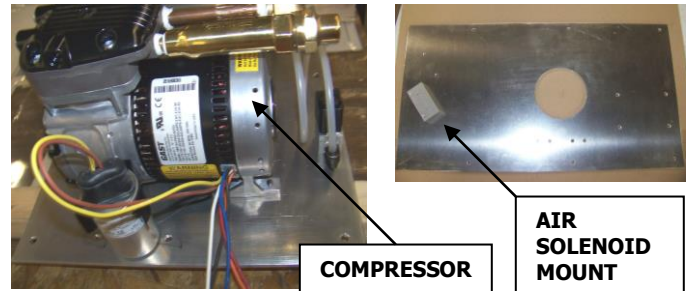
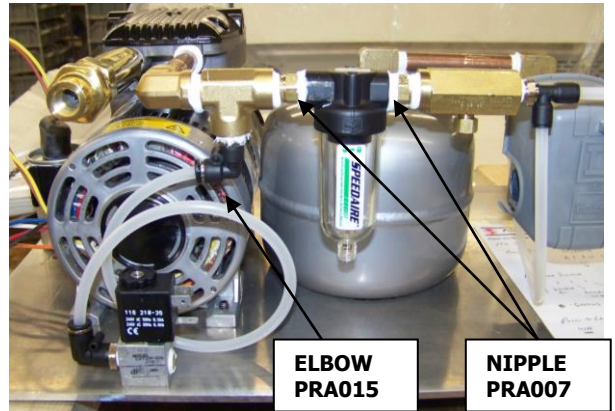


HD 38/60 INDUSTRIAL SERIES COMPRESSOR MOUNTING PLATE 2016

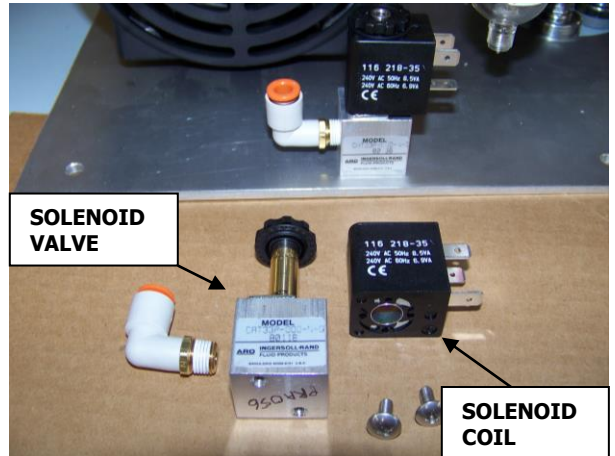
- 1) ASSEMBLE HD 38/60 "GAST" AIR COMPRESSOR (PRA003) **AS18**, AIR TANK, FITTINGS AND TUBINGS ON MOUNTING PLATE BEFORE SECURING TO CHASSIS.
- 2) SET AIR COMPRESSOR MOUNTING PLATE (H380 211.4A) **AS15** ON TABLE. COMPRESSOR WIRES FACE OUTWARD. SECURE CAPACITOR CLAMP OUTWARD. CRIMP A FIF ONTO YELLOW AND BROWN WIRES. TERMINATE ON INNER CAPICITOR POSTS, SLIDE ON BOOT.
- 3) SECURE THE AIR SOLENOID MOUNTING BLOCK (H380 217.4) **RACK 6** ONTO THE SIDE OF THE AIR COMPRESSOR MOUNTING PLATE, LARGER THREADS OUTWARD. USE (2) 10-32 X $\frac{3}{4}$ BSHS THROUGH MOUNTING PLATE UNDERSIDE INTO AIR SOLENOID MOUNTING BLOCK.
- 4) SECURE THE GAST AIR COMPRESSOR TO AIR COMPRESSOR MOUNTING PLATE THROUGH (4) 5/16 TAPPED HOLES. THE FITTINGS FACE THE HD *REAR* AND MOTOR WIRES FACE THE *OUTWARD*. SECURE AIR COMPRESSOR USING 5/16-18 X $\frac{3}{4}$ BSHS THROUGH THE MOUNTING PLATE UNDERSIDE AND COMPRESSOR SLOTS, SLIDE *INWARD*. ADD A 5/16 FLAT WASHER ON EACH THREAD AND TIGHTEN WITH (4) 5/16 HEX NUTS.
- 5) USE FITTINGS FROM **RACK 6**. IF FITTINGS DO NOT HAVE PIPE SEALANT COVERING THREADS, ADD TEFLON PIPE THREAD SEALER *CLOCKWISE*. REMOVE PLASTIC PLUGS FROM COMPRESSOR AND DISCARD. ON LEFT, THREAD AN INLET AIR FILTER (PRA234). ON RIGHT THREAD A 4" FITTING NIPPLE (H356 102.4) INTO THE AIR COMPRESSOR. THREAD A 100B-4-4 ELBOW (PRA035) INTO THE FITTING NIPPLE, ENDING WITH THE UNUSED ELBOW THREADS FACING INWARD. ON THE MIDDLE FEMALE THREADS OF A $\frac{1}{4}$ " NPT $\frac{3}{4}$ " FITTING-STREET TEE (PRA015) SECURE A 269P 04X04 FITTING ELBOW (PRA009)



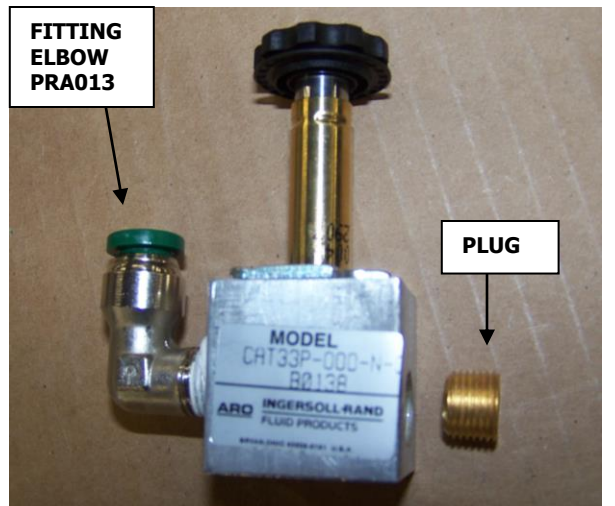
ENDING WITH THE AIR TUBING CONNECTION FACING LEFT. THREAD THE MALE END OF THE FITTING-STREET TEE INTO THE ELBOW ON THE COMPRESSOR, ENDING WITH THE MIDDLE FEMALE THREADS FACING DOWNWARD. BRUSH ON PIPE SEALER AND SECURE A NIPPLE (PRA007) ONTO THE FEMALE THREADS. ALIGN THE AIR FLOW ARROW INWARD/RIGHT ON AN AIR FILTER (PRA101) AND THREAD INTO THE NIPPLE. THREAD A SECOND FITTING NIPPLE (PRA007) INTO THE AIR FILTER. ALIGN THE AIR FLOW ARROW INWARD ON A CHECK VALVE (PRA005) AND THREAD THE CHECK VALVE ONTO THE FITTING NIPPLE, ENDING WITH THE AIR VALVE NUT DOWNWARD. THREAD A 171PL-4-4 AIR FITTING (PRA053) INTO THE CHECK VALVE, ENDING WITH THE MIDDLE AIR TUBING CONNECTION FACING THE DOWNWARD.



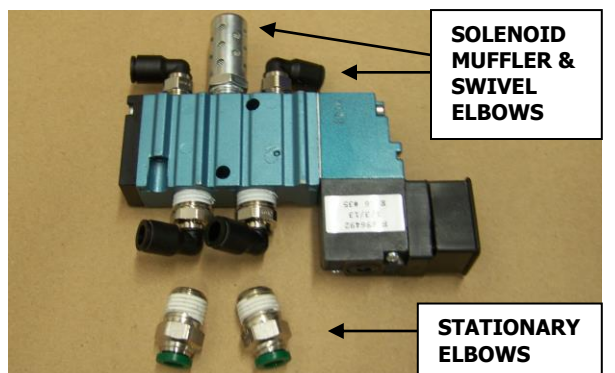
- 6) FROM **RACK 6** THE 1/8 SOLENOID VALVE (PRA056) HAS NUMBERS ENGRAVED ON *INWARD* SIDE. THREAD A 169PLN 4-2 FITTING ELBOW (PRA013) INTO #2 POSITION. ELBOW AIR FITTING FACES UPWARD. INSERT 1/4 PLUG (PRA014) INTO #1 THREADS, LOCATED OPPOSITE THE ELBOW. UNTHREAD NUT ON THE SOLENOID VALVE AND SLIDE SOLENOID COIL 240VAC (PRA057) ONTO SOLENOID VALVE SHAFT, WITH TERMINAL POSTS FACING OPPOSITE THE FITTING ELBOW. RETHREAD NUT, WITH NUT WASHER INWARD TO SECURE SOLENOID COIL TO SOLENOID VALVE.



- 7) SECURE SOLENOID VALVE TO THE COMPRESSOR MOUNTING PLATE FROM UNDERSIDE THROUGH COUNTERSUNK HOLES, WITH TERMINAL POSTS FACING INWARD. USE (2) 8-32 X 3/8 FH MS.

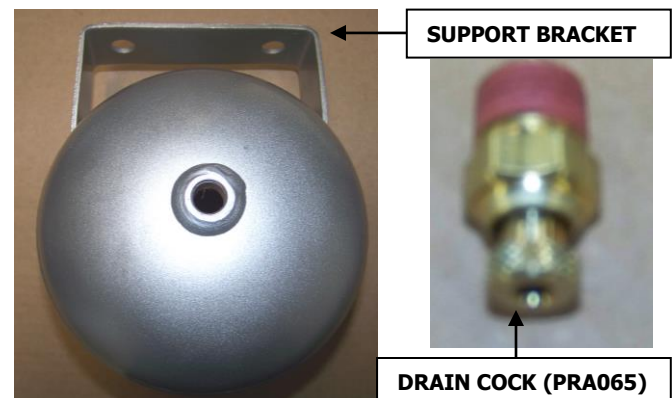
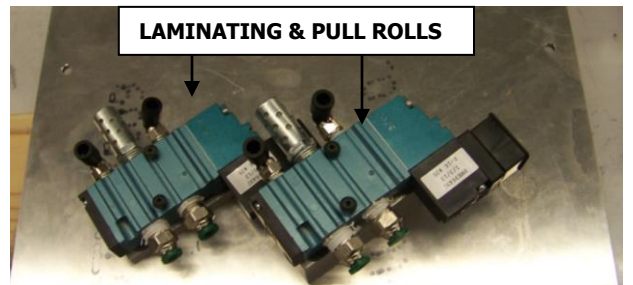
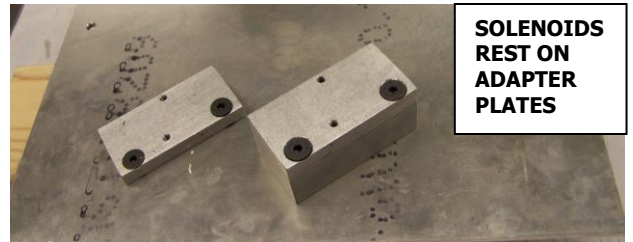
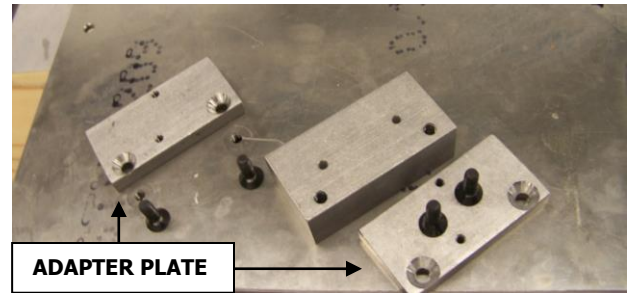


- 8) PREPARE (2) SOLENOID MAC VALVES (PRV003) 431A-BOA-DM-DJB1-1JM **RACK 6**. PARTS FOR THIS ASSEMBLY ARE INCLUDED IN KIT. DO NOT TRIM BLOCK AS NO PILOT FITTING IS NECESSARY. THE SOLENOID AIR VALVES SHOULD BE PROPERLY ASSEMBLED UPON ARRIVAL. IF NOT HOWEVER, THE CORRECT FITTINGS SHOULD BE: (2) SWIVEL ELBOW FITTINGS ON LOCATION #3 AND



#5 RIGHT AND LEFT OF THE MUFFLER WHICH IS LOCATED ON #1. LOCATION #2 AND #4 SHOULD HAVE STATIONARY MALE AIR FITTINGS (PRA017) **RACK 6**. IF SWIVEL FITTINGS ARE ON #2 AND #3, REMOVE AND REPLACE WITH MALE AIR FITTINGS. RETAIN SWIVEL FITTINGS.

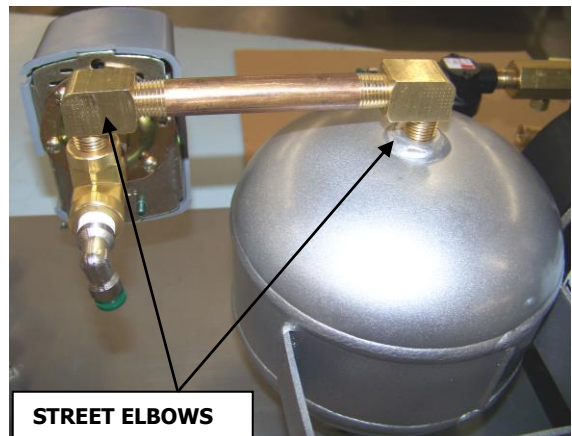
- 9) SECURE (2) ADAPTER PLATES (H380 218.4) **RACK 6** WITH THE COUNTERSINKS *UPWARD* TO THE SOLENOID MOUNTING BLOCK AND TO THE COMPRESSOR MOUNTING PLATE. USE 1/4-20 X 3/4 FHS.
- 10) PLACE ASSEMBLED SOLENOIDS ON ADAPTER PLATES WITH MUFFLERS INWARD. SECURE EACH SOLENOID TO ADAPTER WITH (2) 8-32 X 1 BHCS.
- 11) THE HIGHER PULL ROLL SOLENOID IS LOCATED IN FRONT ON THE ADAPTER SECURED TO THE MOUNTING BLOCK. THE LAMINATING ROLL SOLENOID IS IN THE REAR ON THE ADAPTER SECURED TO THE MOUNTING PLATE.
- 12) ALWAYS USE A PLASTIC TUBING CUTTER TO OBTAIN CLEAN, STRAIGHT CUT ENDS ON AIR TUBING. THE CLEAN, STRAIGHT CUTS HELP AVOID ANY AIR LEAKAGE.
- 13) THE BLACK AND NATURAL AIR TUBING CAN BE MEASURED AS YOU NEED IT, OR YOU CAN USE THE INCHES SUGGESTED IN THIS MANUAL.
- 14) CONNECT AND COIL 16" OF 1/4" NATURAL AIR TUBING (PRA027) **LOFT 2** BETWEEN THE LOWER FITTING ELBOW ON THE COMPRESSOR FITTING-STREET TEE AND THE SOLENOID VALVE ON THE COMPRESSOR MOUNTING PLATE. THE PLASTIC ELBOWS ROTATE TO ALIGN TUBING.
- 15) IN 2009 THE HD AIR TANK COMPLETE (PRA024A) **AS18** WAS INTRODUCED. BEFORE SECURING THE AIR TANK TO THE COMPRESSOR MOUNTING PLATE, THREAD A DRAIN COCK (PRA065) **RACK 6** INTO THE LOWER AIR TANK OPENING. THE DRAIN COCK ALIGNS ABOVE THE LARGE OPENING IN THE COMPRESSOR MOUNTING PLATE.



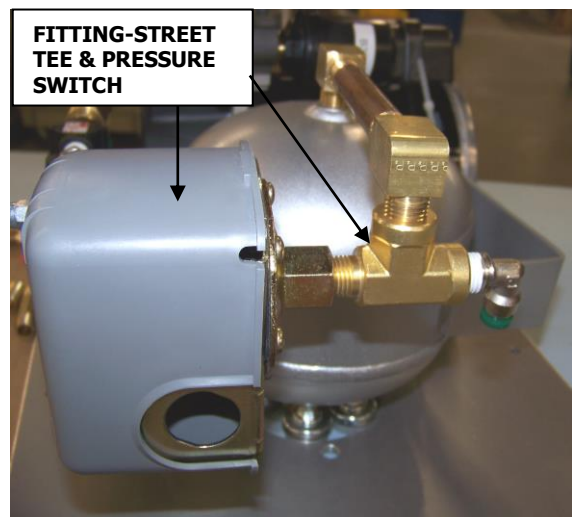
- 16) SECURE THE (2) AIR TANK MOUNTING BRACKETS (H380 212.4) **AS16** TO THE COMPRESSOR MOUNTING PLATE BY INSERTING (4) $\frac{1}{4}$ -20 X $\frac{3}{4}$ BSH THROUGH THE UNDERSIDE OF THE COMPRESSOR MOUNTING PLATE INTO THE THREADED AIR TANK MOUNTING BRACKETS, **EXCESS BRACKET INWARD**.
- 17) PLACE THE SUPPORT BRACKET THAT IS WELDED ONTO THE AIR TANK, **OVER** THE AIR TANK MOUNTING BRACKETS. INSERT (2) $\frac{1}{2}$ -13 X $1\frac{1}{4}$ BSH (H380 213.4) **AS11** THROUGH THE AIR TANK SUPPORT AND THE AIR TANK BRACKET CLEARANCE HOLES. SECURE THE INNER THREADS WITH (2) $\frac{1}{2}$ -13 HEX NUTS. THIS WILL BE A CLOSE FIT BY THE TANK.
- 18) ON THE UPPER AIR TANK OPENING, THREAD ON A 2202PA-4-4 STREET ELBOW (PRA028) **RACK 6** ENDING WITH THE FEMALE OPEN ELBOW THREADS FACING INWARD, TOWARD SOLINOIDS.
- 19) SECURE A $\frac{1}{4}$ X 4" AIR FITTING NIPPLE (H356 102.4) **RACK 6** ONTO THE STREET ELBOW.
- 20) ADD ANOTHER 2202PA-4-4 STREET ELBOW (PRA028) ONTO THE 4" AIR FITTING, ENDING WITH THE MALE THREADS FACING DOWNWARD.
- 21) THREAD A 269P 04X04 FITTING ELBOW (PRA009) **RACK 6** INTO THE FEMALE END OF A FITTING-STREET TEE (PRA015), ENDING WITH THE ELBOW AIR TUBING END FACING OPPOSITE CENTER THREAD.
- 22) THREAD MIDDLE FEMALE SECTION OF FITTING-STREET TEE INTO MALE STREET ELBOW FROM AIR TANK. END WITH FITTING ELBOW ON BRACKET SIDE.
- 23) ON THE MALE END OF THE FITTING-STREET TEE, THREAD THE PRESSURE SWITCH (PRS272) **LOFT 2**. WIRE THE PRESSURE SWITCH AT LATER TIME.
- 24) CONNECT A 5" SECTION OF AIR TUBING $\frac{1}{4}$ " NATURAL (PRA027) **LOFT 2** UPWARD BETWEEN THE LAMINATING ROLL AIR VALVE SOLENOID #5 AND A 164PL-4 FITTING TEE (PRA012) **RACK 6** MIDDLE.



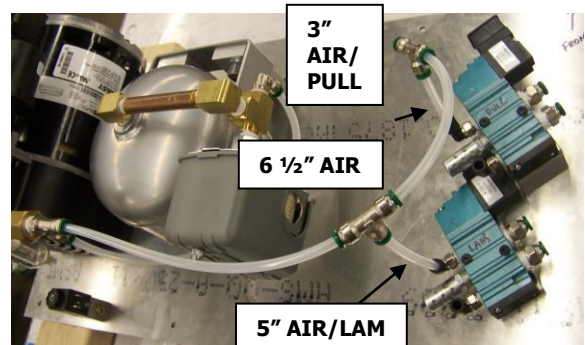
AIR TANK MOUNTING BRACKETS/ **EXCESS INWARD**



STREET ELBOWS



FITTING-STREET TEE & PRESSURE SWITCH



3" AIR/PULL

6 1/2" AIR

5" AIR/LAM

CONNECT A 3" SECTION OF 1/4" NATURAL AIR TUBING UPWARD BETWEEN THE PULL ROLL AIR VALVE SOLENOID #5 (ON MOUNTING BLOCK) AND FITTING TEE (PRA012) MIDDLE SECTION.

- 25) CONNECT BOTH OF THESE AIR FITTING TEES TOGETHER WITH A 6 1/2" SECTION OF 1/4" NATURAL AIR TUBING.

- 26) SOME PICTURES REFLECT AN EARLIER VERSION OF THE AIR COMPRESSOR. SOME FITTING END COLORS HAVE CHANGED. SOME BRASS FITTINGS HAVE BEEN REPLACED WITH PLASTIC FITTINGS. GENERAL ASSEMBLY OF THE AIR COMPRESSOR, TANK, TUBING, AND FITTING POSITIONS REMAIN THE SAME. SOLENOID NATURAL/BLACK POSITIONS HAVE REVERSED.

- 27) CONNECT A 10" SECTION OF 1/4 NATURAL AIR TUBING BETWEEN THE LAMINATING ROLL SOLENOID #5 (WITHOUT MOUNTING BLOCK) UPPER AIR FITTING TEE AND THE CHECK VALVE FITTING TEE.

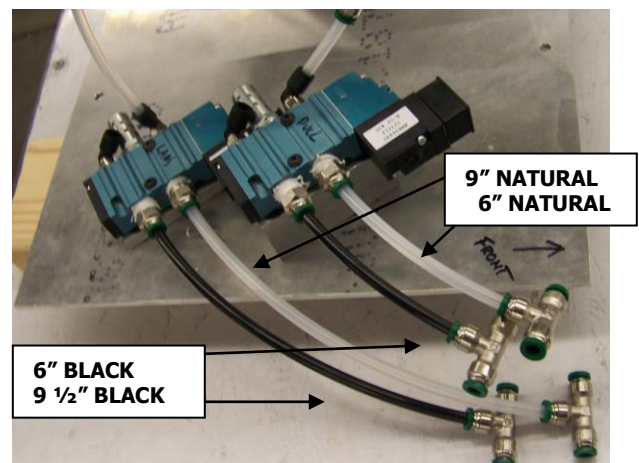
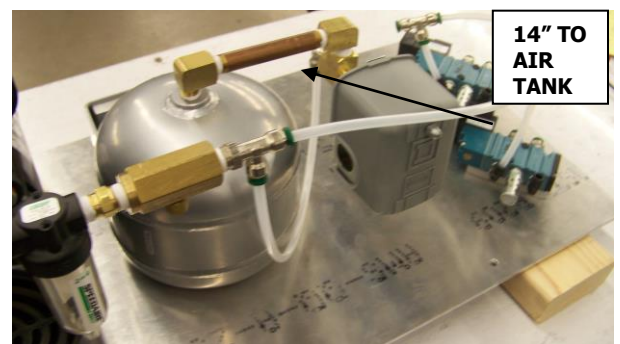
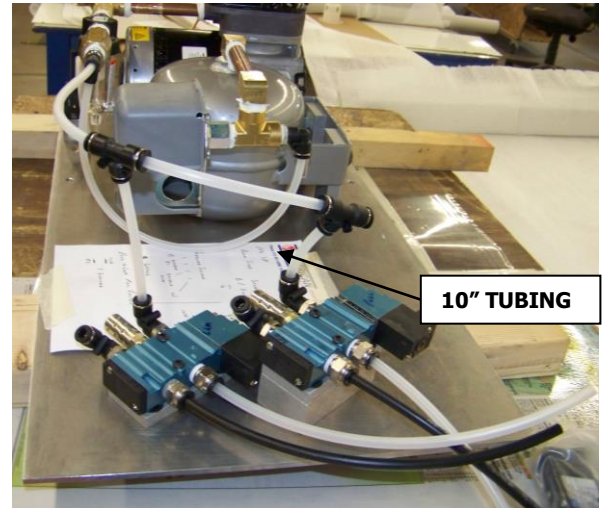
- 28) CONNECT A 14" SECTION OF 1/4 NATURAL AIR TUBING BETWEEN THE MIDDLE THREADS OF THE CHECK VALVE FITTING TEE AND THE FITTING ELBOW ON THE STREET FITTING TEE COMING FROM THE AIR TANK.

- 29) CONNECT 9 1/2" OF BLACK AIR TUBING (PRA026) **LOFT 2** TO THE #2 AIR FITTING ON THE LAMINATING ROLL SOLENOID, CONNECT 9 1/2" OF NATURAL AIR TUBING (PRA026) **LOFT 2** TO THE #4 AIR FITTING ON THE LAMINATING ROLL SOLINOID.

- 30) CONNECT 6" OF BLACK AIR TUBING TO THE #2 AIR FITTING ON THE PULL ROLL SOLINOID AND 6" OF NATURAL AIR TUBING TO THE #4 AIR FITTING ON THE PULL ROLL SOLINOID.

- 31) CONNECT THE MIDDLE SECTION OF (4) FITTING TEE (PRA012) **RACK 6** TO THE BLACK AND NATURAL OPEN ENDS OF THE AIR TUBINGS ON THE SOLINOID.

- 32) PREPARE THE COMPRESSOR WIRES. FOR A 230V MACHINE: CLOSE CAP THE ORANGE WIRE. COMBINE THE BLACK AND



RED WIRES AND CLOSE CAP THEM. THE BLUE AND WHITE WIRES ARE FOR THE "LINE IN." THE YELLOW AND BROWN WIRES GO TO THE CAPACITOR. USE SHRINK TUBING ON ORANGE, RED AND BLACK CAPPED WIRES. PRESS CLIP TO MOUNTING PLATE. PRESS CLIP CAPACITOR WIRES TO MOUNTING PLATE.

