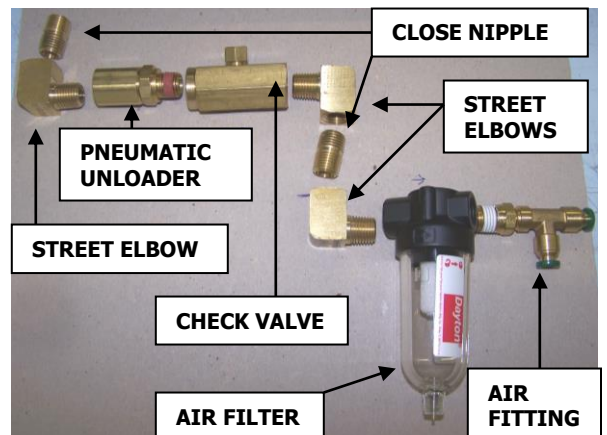
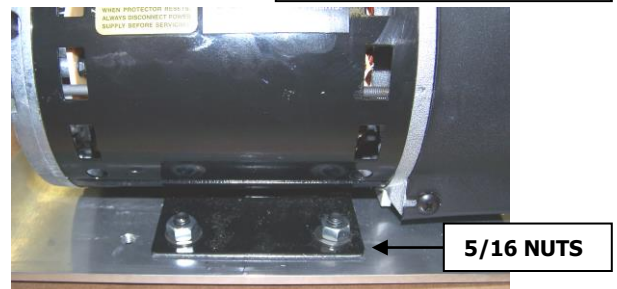
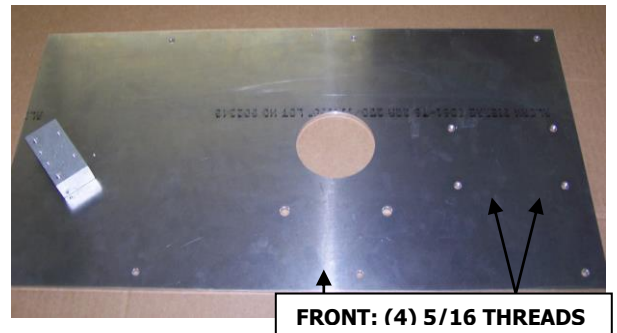
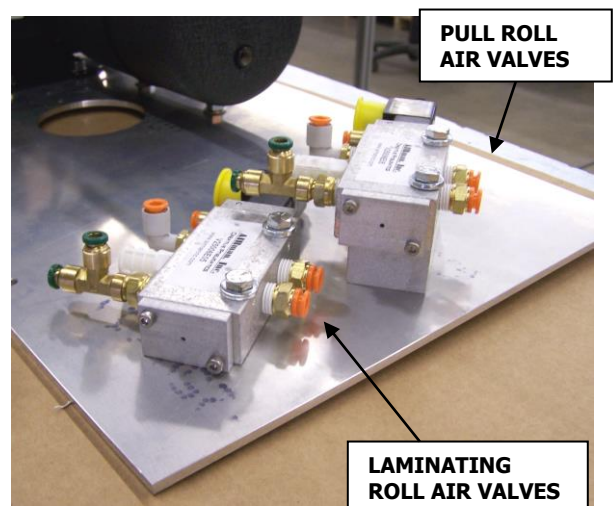
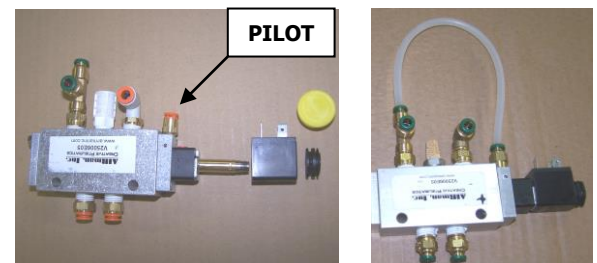
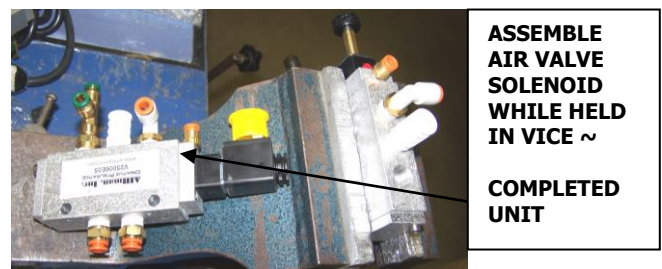
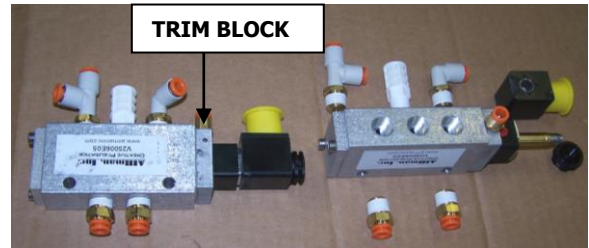


HD 60 INDUSTRIAL SERIES COMPRESSOR PAN ASSEMBLY

- 1) ASSEMBLE THE HD 60 AIR COMPRESSOR, AIR TANK, FITTINGS AND TUBINGS ON THE MOUNTING PLATE BEFORE SECURING IT TO THE CHASSIS.
- 2) PLACE THE ENLARGED AIR COMPRESSOR MOUNTING PLATE (H380 211.4A) **LOFT 2** ON A WORKTABLE ORIENTED AS IT WOULD FIT IN THE HD 60 LAMINATOR FROM THE FRONT. THE (4) 5/16 TAPPED OPENINGS FOR AIR COMPRESSOR ARE TO THE RIGHT.
- 3) SECURE THE AIR SOLENOID MOUNTING BLOCK (H380 217.4) **AS13** ONTO THE LEFT SIDE OF THE AIR COMPRESSOR MOUNTING PLATE, LARGER THREADS OUTWARD. USE (2) 10-32 X $\frac{3}{4}$ BSHH THROUGH MOUNTING PLATE UNDERSIDE INTO AIR SOLENOID MOUNTING BLOCK.
- 4) SECURE AN AIR COMPRESSOR (PRA003) **AS13** TO AIR COMPRESSOR MOUNTING PLATE THROUGH (4) 5/16 TAPPED HOLES. THE MOTOR FACES THE REAR OF THE HD60 AND THE FITTINGS FACE THE FRONT. SECURE AIR COMPRESSOR USING 5/16-18 X $\frac{3}{4}$ BSHH THROUGH THE MOUNTING PLATE AND COMPRESSOR SLOTS, SLIDE INWARD. ADD A 5/16 FLAT WASHER ON EACH THREAD AND TIGHTEN WITH (4) 5/16 HEX NUTS.
- 5) ALL FITTING PARTS FOR THE FOLLOWING ASSEMBLY ARE LOCATED IN **AS19**. THE FITTINGS THAT DO NOT HAVE SEALER COVERING THREADS, BRUSH ON PIPE THREAD SEALER WITH TEFLON. THREAD A 112B-4-4 CLOSE NIPPLE (PRA034) INTO THE AIR COMPRESSOR. THREAD A 2202PA-4-4 STREET ELBOW (PRA028) INTO THE CLOSE NIPPLE WITH THE OPEN ELBOW THREADS FACING INWARD. THREAD A PNEUMATIC UNLOADER (PRA004) ONTO THE STREET ELBOW THREADS. THREAD THE CHECK VALVE (PRA005) ONTO THE PNEUMATIC UNLOADER THREADS, WITH THE AIR

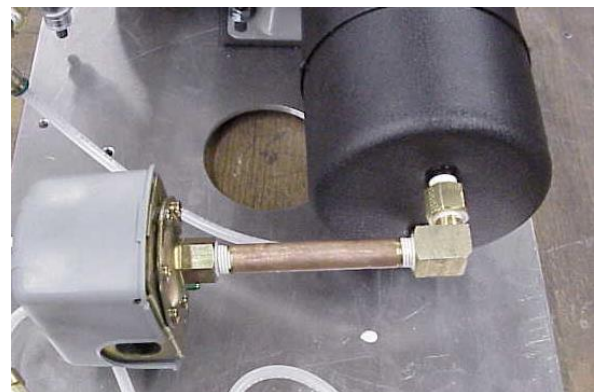
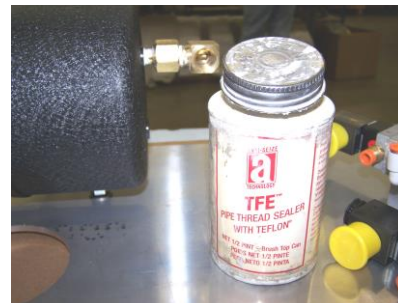
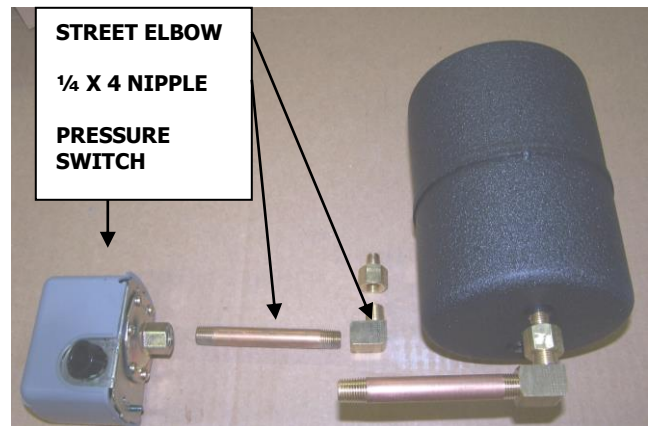
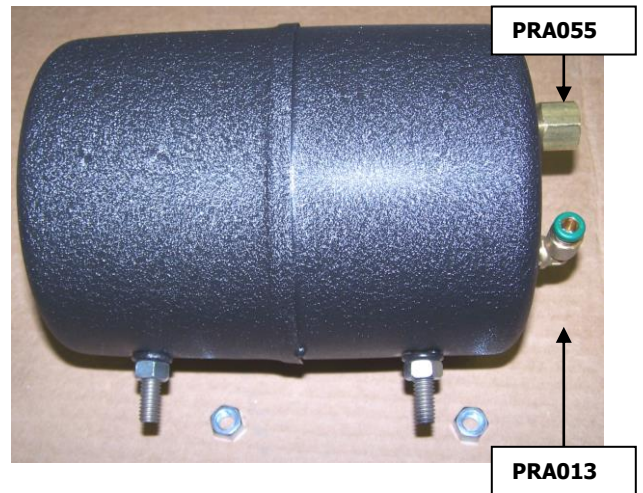


- VALVE NUT DOWNWARD AND AIR FLOW ARROW INWARD. THREAD A STREET ELBOW INTO THE AIR VALVE WITH THE OPEN ELBOW FACING DOWNWARD. ADD ANOTHER CLOSE NIPPLE AND ANOTHER STREET ELBOW, WITH ELBOW THREADS FACING INWARD. THREAD AN AIR FILTER (PRA101) ONTO STREET ELBOW ****ORIENTED WITH AIR FLOW ARROW FACING INWARD**. THREAD A 171PL-4-4 AIR FITTING (PRA053) INTO THE AIR FILTER WITH MIDDLE CONNECTION FACING THE FRONT.**
- 6) **ASSEMBLE (2) AUTO-SOLENOID AIR VALVE, AIR-MAN KITS (PRV001) **AS13**. PARTS FOR THIS ASSEMBLY ARE INCLUDED IN KIT. TRIM BLOCK FOR PILOT FITTING IF NECESSARY. ONE AT A TIME, SECURE THE SOLENOID AIR VALVES IN A VICE. THREAD THE TEE AIR FITTING INTO THE END #5 AIR VALVES. FINGER THREAD AN EXHAUST MUFFLER FROM THE SOLENOID AIR VALVE KIT INTO THE #1 AIR VALVE. THREAD A FITTING ELBOW INTO THE #3 AIR VALVE. SECURE THE SMALLER THREADED PILOT AIR FITTING INTO THE PLUG END OF THE AIR VALVE. **DO NOT OVER TIGHTEN PILOT**. TURN SOLENOID AIR VALVE IN VICE AND **FROM THE OTHER SIDE**, SECURE (2) AIR FITTINGS IN THE KIT INTO #2 AND #4 ON THE AIR VALVE. REPEAT FOR SECOND VALVE.**
- 7) **REMOVE YELLOW CAP AND UNTHREAD THE BLOCK KEEPER. ORIENT PLUGS WITH MUFFLER AND FITTINGS, RETHREAD KEEPER AND REPLACE CAP.**
- 8) **CONNECT 10" OF NATURAL AIR TUBING 1/4" (PRA027) **AS19** BETWEEN #5 AIR FITTING AND AIR FITTING BY PLUG END ON EACH AUTO-SOLENOID AIR VALVE. ALWAYS USE PLASTIC TUBING CUTTER TO OBTAIN CLEAN, STRAIGHT CUT ENDS.**
- 9) **MOUNT ASSEMBLED PULL ROLL AUTO-SOLENOID AIR VALVE TO THE AIR SOLENOID MOUNTING BLOCK USING (2) 1/4-20 X 1 1/2 HEX HEAD BOLTS WITH A 1/4 X 5/8 X 1/8 FLAT WASHER ON EACH. MOUNT THE LAMINATING ROLL AUTO-**



SOLENOID AIR VALVE TO MOUNTING PLATE USING THE SAME HARDWARE AS THE PULL ROLL AUTO SOLINOID.

- 10) **THREAD A 5/16-18 HEX NUT ONTO EACH OF THE MOUNTING STUDS ON THE AIR TANK COMPLETE (PRA024) AS19. THESE HEX NUTS ARE USED AS SPACERS. PLACE THE MOUNTING STUDS THROUGH THE AIR COMPRESSOR MOUNTING PLATE, WITH THE FITTING OPENINGS FACING AWAY FROM THE AIR COMPRESSOR. SECURE AIR TANK MOUNTING STUDS UNDER MOUNTING PLATE WITH A 5/16-18 HEX NUTS.**
- 11) **ON THE LOWER AIR TANK FITTING OPENING, THREAD A FITTING ELBOW 169PLNS 4-2 (PRA013) AS19 FACING INWARD. ON THE UPPER FITTING OPENING THREAD ON A PARKER AIR FITTING 1/8M TO 1/4F 222P-4-2 (PRA055) AS19. ON ANY THREADS THAT DO NOT ALREADY HAVE THREAD SEALANT, BRUSH PIPE THREAD SEALER WITH TEFLON ONTO THREADS.**
- 12) **THREAD A STREET ELBOW 2202PA-4-4 (PRA028) AS19 INTO THE PARKER UPPER AIR FITTING ON THE AIR TANK. ORIENT THE STREET ELBOW FACING THE REAR, ALONG WITH THE LOWER ELBOW.**
- 13) **THREAD AN AIR FITTING FOR HD 1/4" X 4" NIPPLE (H356 102.4) AS13 INTO THE STREET ELBOW.**
- 14) **ON THE OTHER END OF THE AIR FITTING NIPPLE THREAD ON THE PRESSURE SWITCH (PRS272) AS13. THE PRESSURE SWITCH WILL BE WIRED AT A LATER TIME.**
- 15) **CONNECT A 4" SECTION OF AIR TUBING 1/4" NATURAL UPWARD BETWEEN THE TEE FITTING LAMINATING ROLL AIR VALVE SOLENOID AND A FITTING TEE 164PL-4 (PRA012) AS19. CONNECT A 2" SECTION OF AIR TUBING 1/4" NATURAL UPWARD BETWEEN THE PULL ROLL AIR VALVE SOLENOID TEE (ON MOUNTING BLOCK) AND ANOTHER FITTING TEE.**



- 16) CONNECT BOTH OF THESE AIR FITTING TEES TOGETHER WITH A 4" SECTION OF 1/4 NEUTRAL AIR TUBING.

- 17) SOME PICTURES REFLECT AN EARLIER VERSION OF THE AIR COMPRESSOR AND SOME FITTING END COLORS HAVE CHANGED. BRASS FITTINGS HAVE BEEN REPLACED WITH PLASTIC FITTINGS IN SOME CASES. HOWEVER, THE GENERAL ASSEMBLY OF THE AIR COMPRESSOR, AIR TANK, AUTO SOLINIODS, AIR TUBING, ALONG WITH THE FITTING POSITIONS REMAIN THE SAME.

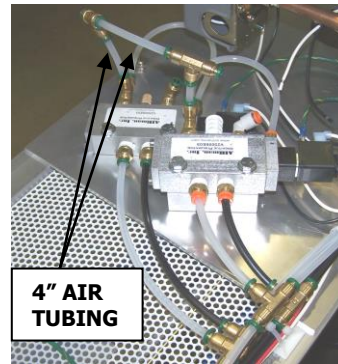
- 18) CONNECT A 10" SECTION OF 1/4 NATURAL AIR TUBING BETWEEN THE LAMINATING ROLL SOLENOID (WITHOUT MOUNTING BLOCK) AIR FITTING TEE AND THE AIR FILTER FITTING TEE.

- 19) CONNECT A 12" SECTION OF 1/4 NATURAL AIR TUBING BETWEEN THE MIDDLE THREADS OF THE AIR FILTER FITTING TEE AND THE AIR TANK LOWER FITTING ELBOW.

- 20) CONNECT 10" OF BLACK AIR TUBING TO THE #2 AIR FITTING ON THE LAMINATING ROLL AUTO-SOLENOID AND CONNECT 11" OF NATURAL AIR TUBING (PRA026) **AS17** TO THE #4 AIR FITTING ON THE LAMINATING ROLL AUTO-SOLINIODS.

- 21) CONNECT 4" OF BLACK AIR TUBING TO THE #2 AIR FITTING ON THE PULL ROLL AUTO-SOLINIOD AND CONNECT 5" OF NATURAL AIR TUBING TO THE #4 AIR FITTING ON THE PULL ROLL AUTO SOLINIOD.

- 22) CONNECT THE MIDDLE SECTION OF A FITTING TEE (PRA012) **AS19** TO EACH OF THE BLACK AND NATURAL OPEN ENDS OF THE AIR TUBINGS CONNECTED TO THE AUTO-SOLINIODS.



PLASTIC TUBING CUTTER

