

## GENUINE GRACO PARTS & ACCESSORIES Pneumatic Control Box Conversion Kit

For Conversion of 918205 Controls to 243559 In Unidrum Ram Packages

## **INFORMATION ENCLOSED**

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## WARNING

To reduce risk of serious injury: (1) Relieve fluid pressure in system before attempting any service. (2) Lower ramp plate completely before attempting to service pneumatic controls. If not lowered, ram plate will fall when pressure is vented from pneumatic controls.

## Installation Instructions

- 1. Before attempting to service pneumatic controls, ensure that ram plate is completely lowered.
- 2. Relieve fluid pressure in system.
- 3. Shut off main air supply and vent air in system using valves at base of ram tubes.
- 4. Open control box and remove push button switch DV5.
- 5. Use ¼" straight connector (551122) to connect ends of line 1.
- 6. Drill out hole in front panel to 7/8".
- Mount selector switch assembly (551594, 551659, 551663) in enlarged hole and connect line 18 to port 4.
- 8. Cut line 21 (out of DV7) and install 5/32" tee fitting (113278).
- 9. Connect 5/32" tee to port 3 of selector w/ approximately 8" of 5/32" tubing.
- 10. Remove ¼"NPT x ¼"tube tee from inlet of R3.
- 11. Remove short section of 1/4" tubing and connect main air supply line 1 to 1/4" tee.
- 12. Replace fitting removed from R3 with ¼"tube x ¼"NPT elbow (C19391).
- Remove approximately ½" section of ½" tubing between "Ram Up" regulator and "Ram Air Up" bulkhead fitting in bottom center of the control box.
- Insert ½" tube tee (513226) and ½" to ¼" tubing adapter (114156), (It may be necessary to loosen the bulkhead fitting).
- Connect ½" to ¼" reducer to new inlet elbow of R3 with approximately 6" of ¼" tubing.
- Remove similar section of tubing from ½" tubing section between "Ram Down" regulator and "Ram Air Down" bulkhead fitting in top of control box.
- 17. Insert ½" tube tee (513226) and ½" to ¼" tubing adapter (114156).
- 18. Remove "Vent Closed" line 22 from bulkhead fitting in top of panel.
- 19. Connect check valve (115828) to line 22 such that flow into line 22 is blocked and out of line 22 is allowed.

- 20. Connect check valve to supplied ¼" tube tee (C20344) with approximately 4" of ¼" tubing.
- 21. Connect one of two remaining connections on tee to "Vent Closed" bulkhead fitting with approximately 6" of 1/4" tubing.
- 22. Connect last tee connection to  $\frac{1}{2}$ " to  $\frac{1}{4}$ " reducer installed in step #17.
- 23. Completely remove line 3 from "Vent Open" bulkhead fitting in top of panel and top of SV4 (leave ¼" to 5/32" adapter in place).
- 24. Drill .166" diameter hole in bottom of control box approximately 3.50" from front and 3.50" from right side of box.



- 25. Remove one end of ¼" tubing from loop on supplied timer assembly (115826).
- 26. Attach blue air valve portion of timer assembly to control panel using 8-32 x 1¼" SHCS so that ¼" tube loop is toward back of box and flow control knob points toward top of box.
- 27. Route loose end of  $\frac{1}{4}$ " tube loop as necessary and reattach to timer assembly.
- Connect output of timer assembly (port #2 on blue valve) to "Vent Open" bulkhead fitting in top of control box with approximately 3' of 5/32" tubing.
- 29. Connect output of SV4 to inlet of timer assembly (tee connector on flow control).
- 30. Test function of control box. *Note: Loose or leaking connections in the timer assembly circuit may cause the plate vents to not open.*