



#004-991 INSTALLATION INSTRUCTIONS

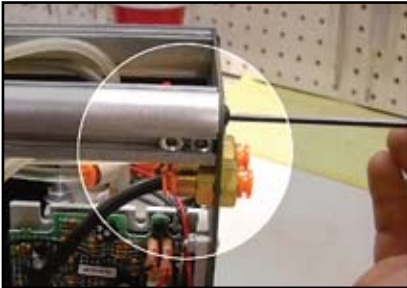
Air Solenoid Valve Kit

Installation of this kit assumes the user has a basic knowledge of mechanical practices. Tools required:

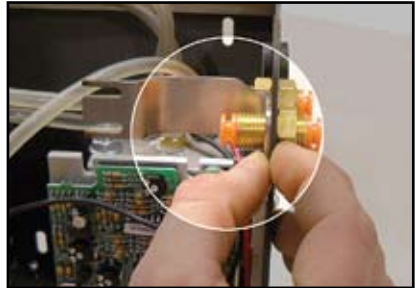
- 1/8" hex wrench (one of these came originally with your machine)
- Phillips head screw driver

When the package is opened you will see the following parts (see parts list on back side for illustrations):

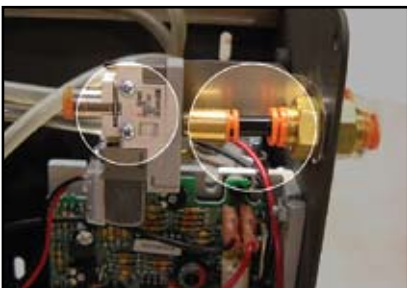
- Modified extruded top rail (044-246)
- Solenoid valve bracket (044-222)
- Solenoid output to regulator hose (044-137)
- Solenoid mounting screws with nuts (024-119 and 024-118)
- Pre-terminated solenoid valve assembly (assembled illustration)



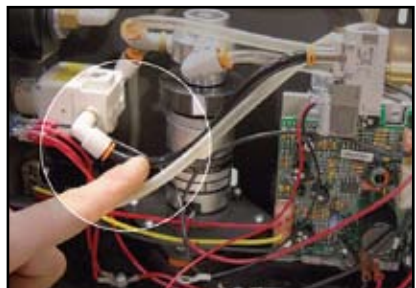
1. Remove the top and side panel closest to the air fittings in the rear of the machine. Remove the top extruded rail from machine. Save the 4 nuts used to hold the top and side covers.



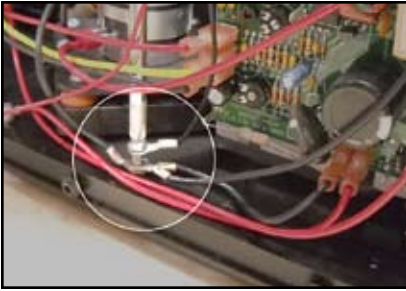
2. Remove the inside nut from the AIR INPUT fitting and slide the bracket over the fittings as shown. NOTE: The bend goes to the inside. Replace nut and secure.



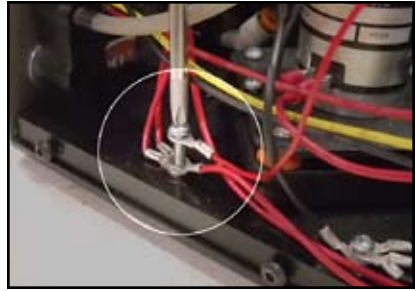
3. Install valve by connecting the short black hose to the AIR INLET port. Install screws, nuts to the inside of the bracket.



4. Connect longer black hose to the solenoid and the "SUP" side of the regulator. Press the fitting downward to take up any slack in the hose.



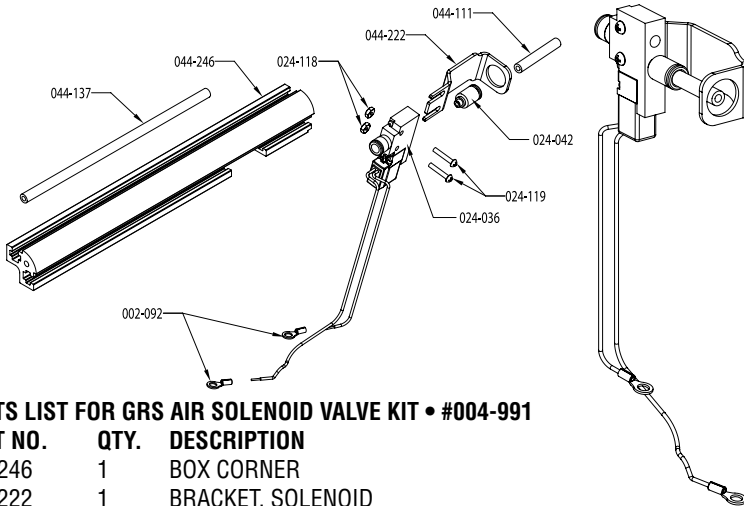
5. Connect the black solenoid wire to the black connection group.



6. Connect the red solenoid wire to the red connection group.



7. Note how the rail gap fits around the solenoid valve. Install the modified top rail (do not forget to put the 4 nuts in the rail). Before replacing the panels, check to make sure the valve works with air applied.



PARTS LIST FOR GRS AIR SOLENOID VALVE KIT • #004-991

PART NO.	QTY.	DESCRIPTION
044-246	1	BOX CORNER
044-222	1	BRACKET, SOLENOID
024-036	1	VALVE, 24VDC SOLENOID
024-042	1	FITTING, PTC 0.25" M#10-32
044-111	1	TUBING, PU BLK 0.250" O.D. 0.130" I.D.
024-119	2	RHMS, #4-40 X 0.63" Z/P
024-118	2	NUT, #4-40 HEX Z/P
044-137	1	AIR OUTPUT FROM "T" TO OUTPUT BULKHEAD FITTING
002-092	2	TERMINAL, 22-16 AWG #10 RING

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