

P/N 203985

4-Stack Air Manifold

Automated Equipment, LLC

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4-Stack Air Manifold P/N 203985 Replacement and Adjustment

Tools Required

- Small flat blade screw driver
- 9/32" wrench
- 5/32" allen wrench

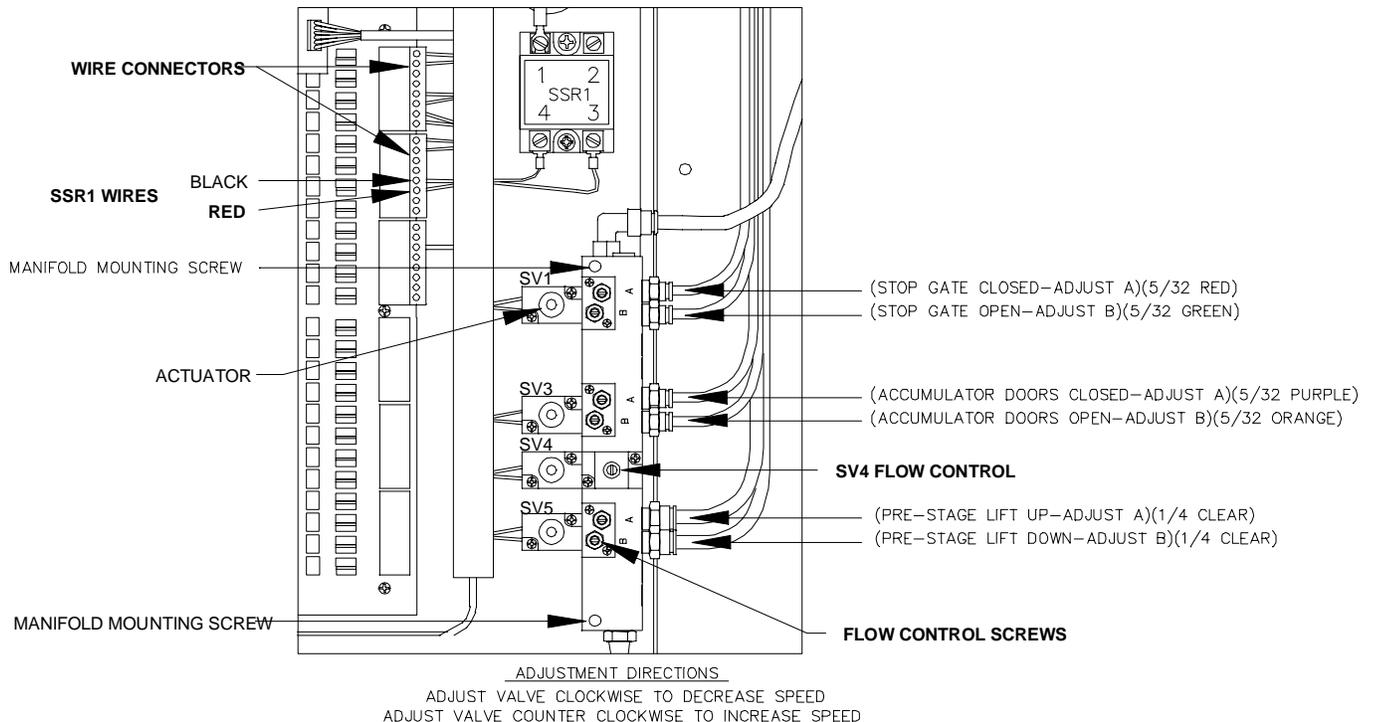
Procedure

Removal

1. Turn the power switch off.
2. Remove the airline from the dispenser.
3. Disconnect all airlines from the manifold.
 Push the hose into the fitting and push in on the flange at end of the fitting. While pushing in on the flange pull out on the hose.
4. Disconnect the solid state relay (SSR1) wires from the wire connector.
5. Unplug the two wire connectors from the controller board by pushing them to the right.
6. Remove the two screws securing the manifold to the chassis.

Installation

1. Mount the replacement manifold to the chassis with the two screws.
2. Connect the two wire connectors to the controller board.
3. Re-connect the solid state relay (SSR1) wires.
4. Connect the airlines to the manifold.
5. Connect the dispenser airline.
6. Check manifold speeds and make required adjustments. (page 2)
7. Check the dispenser for proper operation and put it back in service.



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Stop Gate cylinder speed adjustment

1. Turn the power switch off.
2. Connect the airline at the top of the dispenser. Verify the air pressure regulator is adjusted to 80psi.
3. Locate the solenoid valve SV1 on the manifold. When looking at the valve you will notice a small round “eye” in the end of the solenoid. This is the solenoid “actuator”.
4. Using a ball point pen press and hold SV1 actuator. The stop gate opens. When SV1 is released, the stop gate closes.
5. Monitor the speed of the stop gate. It should be 1 second opening and 1 second closing.
6. If the stop gate speed needs adjustment, loosen the lock nut on the flow control adjustment screw located to the right of SV1. The “A” screw controls the “closing” speed and the “B” screw controls the “opening” speed.
7. Adjust the flow control screw counter clockwise to increase the speed and -clockwise to decrease the speed.
8. When the speed is correct tighten the lock nut while holding the screw with a screwdriver.

Accumulator Door cylinder speed adjustment

1. Turn the power switch off.
2. Connect the airline at the top of the dispenser. Verify the air pressure regulator is adjusted to 80psi.
3. Locate the solenoid valve SV3 on the manifold. When looking at the valve you will notice a small round “eye” in the end of the solenoid. This is the solenoid “actuator”.
4. Using a ball point pen press and hold SV3 actuator. The accumulator doors open. When SV3 is released, the accumulator doors close.
5. Monitor the speed of the accumulator doors. It should be quick opening (about ½ second) and 1 second closing.
6. If the accumulator door speed needs adjustment, loosen the lock nut on the flow control adjustment screw located to the right of SV3. The “A” screw controls the “closing” speed and the “B” screw controls the “opening” speed.

Lift cylinder speed adjustment

1. Turn the power switch off.
2. Connect the airline at the top of the dispenser. Verify the air pressure regulator is adjusted to 80psi.
3. Locate the solenoid valves SV4 and SV5 on the manifold. When looking at the valve you will notice a small round “eye” in the end of the solenoid. This is the solenoid “actuator”.
4. From fully clockwise, adjust the SV4 flow control 3 full turns counter clockwise.
5. Using a ball point pen press and hold the SV4 actuator. The lift saddle will go up.
6. While holding the SV4 actuator, press and hold the SV5 actuator. The lift saddle will go down. Releasing SV5 only will cause the lift saddle to go back up.
7. Time the lift up and down speed. It should be two seconds in each direction.
8. If the lift speed needs adjustment, loosen the lock nut on the flow control adjustment screw to the right of SV5. The “A” screw controls the “up” speed and the “B” screw controls the “down” speed.
9. Adjust the flow control screw counter clockwise to increase the speed and clockwise to decrease the speed.
10. When the lift speed is correct tighten the lock nut while holding the screw with a screwdriver.