

67327 LOW LEVEL CUTOFF For 10" and 12" Air Motors



**READ THIS MANUAL CAREFULLY BEFORE INSTALLING,
OPERATING OR SERVICING THIS EQUIPMENT.**

It is the responsibility of the employer to place this information in the hands of the operator. Keep for future reference.

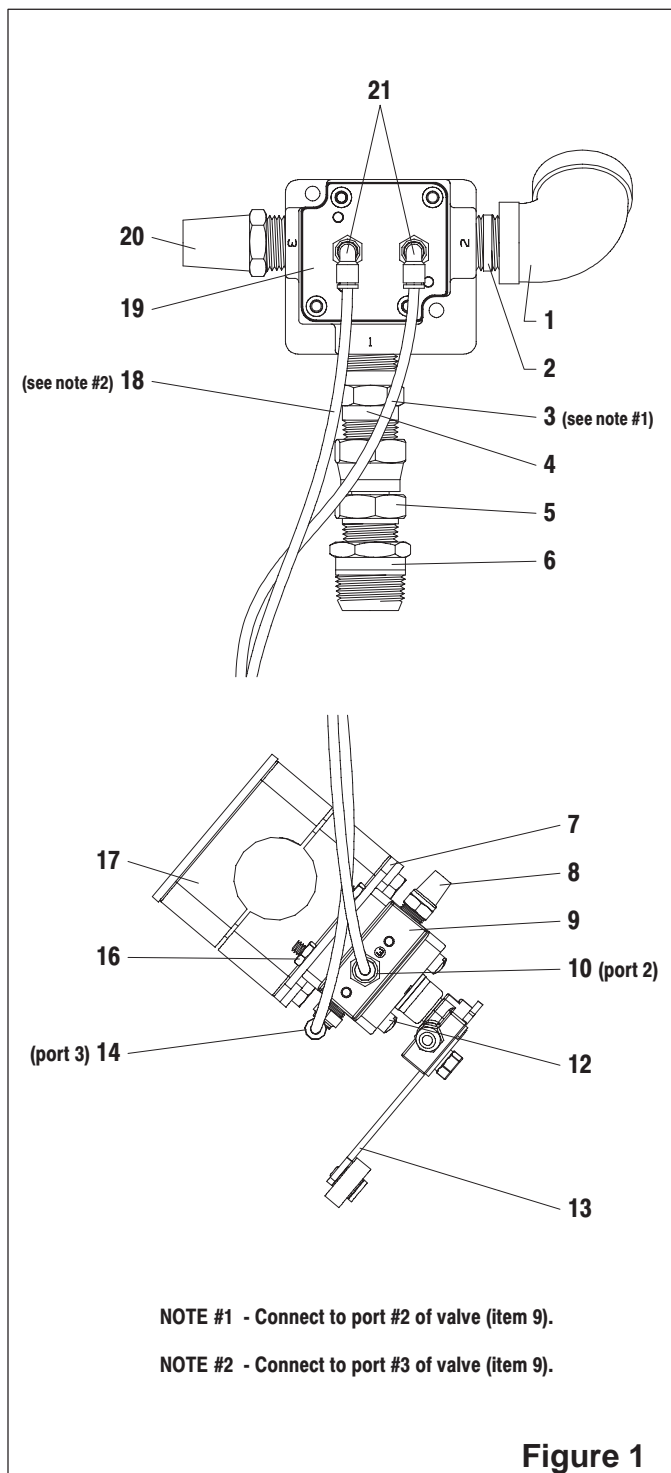


Figure 1

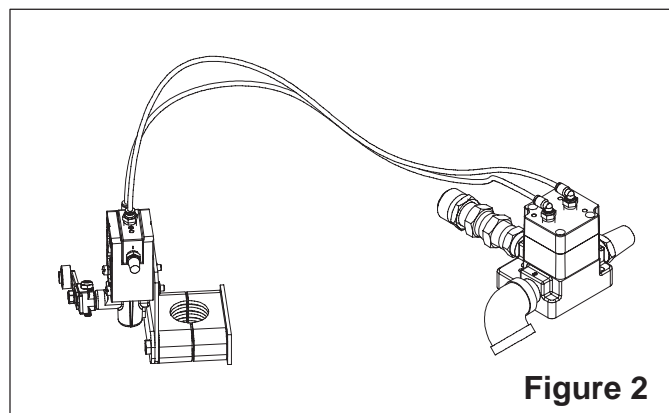


Figure 2

PARTS LIST

Item	Description (size in inches)	Qty	Part No.
1	90° Reducing Elbow (3/4 N.P.T. x 1/2 N.P.T.)	(1)	Y129-3-C
2	Nipple (1/2 - 14 N.P.T. x 1-1/8")	(1)	Y27-4-C
3	Tubing (5/32" o.d. x 31" long)	(1)	94981-XXX
4	Adapter (1/2 - 14 N.P.T.F x 1.810")	(1)	96248
5	Swivel Union (1/2 N.P.T.F. male x 1/2 N.P.S.M. female)	(1)	75366
6	Reducing Bushing (3/4 N.P.T. male x 1/2 N.P.T. female)	(1)	Y45-9-C
7	Mounting Plate	(1)	96124
8	Exhaust Muffler (1/8 - 27 N.P.T.)	(1)	20312-1
9	3-Way Limit Valve	(1)	402-A
10	Connector (1/8 - 27 N.P.T. x 5/32" o.d. tube)	(1)	59474-4
12	Machine Screw (#10 - 24 x 1-3/4")	(2)	Y19-115-C
13	Roller Lever Assembly	(1)	450
14	Elbow (1/8 - 27 N.P.T. x 5/32" o.d. tube)	(1)	59756-4
16	Nut (#10 - 24)	(2)	Y22-10-C
17	Clamp Assembly	(1)	96125
18	Tubing (5/32" o.d. x 31" long)	(1)	94981-XXX
19	"H" Series 3-Way Valve	(1)	H254PS
20	Exhaust Muffler (1/2 - 14 N.P.T.)	(1)	20312-4
21	Elbow (1/8 - 27 N.P.T. x 5/32" o.d. tube)	(2)	59756-4

3 Bulk tubing (5/32" o.d. x 100' long).

INSTALLATION

1. Install a pump shut-off valve upstream from the Filter-Regulator-Lubricator.
2. Remove fittings from the Lubricator outlet.
3. Using (6) reducing bushing, connect port #1 of (19) 3-way valve to 651729 Filter-Regulator-Lubricator and tighten.
4. Using (1) 90° reducing elbow, connect port #2 of (19) 3-way valve to 622651-1-F hose and connect opposite end of hose to inlet port #1 of the air motor valve.
5. Using (17) clamp assembly, attach (9) 3-way limit valve to 94016 rod, as shown. NOTE: Align the valve arm with the center line of the post (see figure 3, "Top View").
6. Locate the (9) 3-way limit valve by raising the lift / ram 2 inches off the plate and set a clearance of 1/4 inch between the (13) roller lever assembly and 95173 cap and tighten the clamp.
7. Lower the lift / ram to actuate the (9) 3-way limit valve.
8. Test the setting by turning on the air supply to the assembly. The air motor should remain off.
9. CAUTION: When the lift / ram is raised and the (13) roller lever assembly disengages from the 95173 cap, the air motor will start.
10. To test the operation:
 - a. Set supply pressure to air motor @ 20 p.s.i. (1.4 bar) maximum.

b. Raise the lift / ram until the motor starts.

c. **DO NOT RUN THE PUMP DRY.**

11. Turn off the air supply to the air motor until you are ready for the pump to run.

OPERATION

1. Turn off the air supply to the pump.
2. Raise the lift / ram and place a drum of material into position.
3. Lower the lift / ram and, when ready, turn on the air supply to the pump.
4. As the material is consumed and the ram lowers, the (13) roller lever assembly will engage the 95173 cap, switching the (9) 3-way limit valve, removing the air signal from port #3 to port #2 and exhausting port #2 to atmosphere thru port #1.
5. When the pressure from port #2 exhausts, (19) 3-way valve shifts and removes the air supply to the pump, turning the pump off.
6. Before raising the lift / ram, turn off the air supply to the pump to prevent the pump from starting.
7. The location of the (9) 3-way limit valve will determine when the pump shuts off but **does not control the lift / ram**.
8. Caution should be used when lowering the lift / ram to prevent damage to the (9) 3-way limit valve.

TYPICAL INSTALLATION

