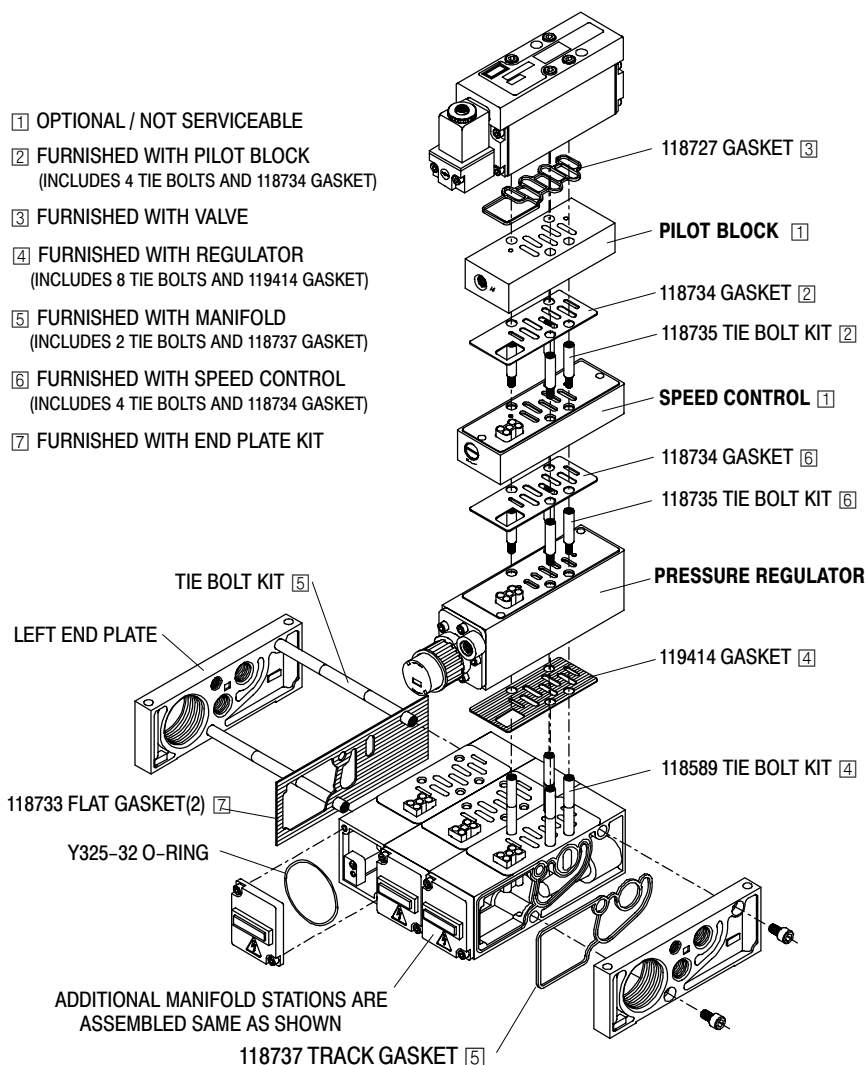


# INSTRUCTION SHEET

## GENESIS PLUG IN MANIFOLD ASSEMBLY INSTRUCTIONS

- ① OPTIONAL / NOT SERVICEABLE
- ② FURNISHED WITH PILOT BLOCK  
(INCLUDES 4 TIE BOLTS AND 118734 GASKET)
- ③ FURNISHED WITH VALVE
- ④ FURNISHED WITH REGULATOR  
(INCLUDES 8 TIE BOLTS AND 119414 GASKET)
- ⑤ FURNISHED WITH MANIFOLD  
(INCLUDES 2 TIE BOLTS AND 118737 GASKET)
- ⑥ FURNISHED WITH SPEED CONTROL  
(INCLUDES 4 TIE BOLTS AND 118734 GASKET)
- ⑦ FURNISHED WITH END PLATE KIT



A001

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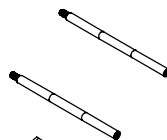


Part of worldwide Ingersoll-Rand

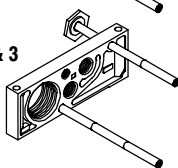
## INSTALLATION STEPS

1. Make two tie rods using all but two of the manifold tie bolts. The first tie bolt on each rod must be the long style.
2. Install tie rods in left end plate (the left end plate has a thru hole while the right end plate has a thru hole and a counter bore).
3. Install the lockwashers and nuts on the ends of the tie rods.
4. Install two black flat gaskets 118733 over the tie rods and slide them all the way to the left end plate. Line them up with the edges of the end plate.
5. Using the pipe plugs supplied with the manifolds, seal off the #2 and #4 ports that are not to be used. The ports are located on the rear and the bottom of the manifolds.
6. Install track gasket 118737 in the groove on the side of each manifold, it will be retained in place when properly installed.
7. Install all of the manifolds on the tie rods.
8. Attach the right side end plate, securing with two cap screws. Use a 5 mm hex wrench to hold the cap screws. Tighten the nuts evenly.
9. If no speed controls, regulators, or pilot blocks are used, skip to step 13.
10. For each regulator, screw 4 pairs of tie bolts into the manifolds and tighten snugly. Then install black flat gasket 119414 over the tie bolts and push it onto the manifold. Slide the regulator over the tie bolts and push it down to the gasket.
11. For each speed control, screw 4 single tie bolts into the manifold (or into the regulator tie bolts if used), and tighten snugly. Then install gray flat gasket 118734 over the tie bolts and push it down. Slide the speed control over the tie bolts and push it down to the gasket.
12. For each pilot block, screw 4 single tie bolts into the manifold (or into the regulator tie bolts or speed control tie bolts if used) and tighten snugly. Then install the gray flat gasket 118734 over the tie bolts and push it down. Slide the pilot block over the tie bolts and push it down to the gasket.
13. Install track gasket 118727 in the bottom of the valve. Place the valve over the manifold (or over the tie bolts if used) and push it down to engage the electrical pins. Tighten the 4 cap screws to 50 in-lbs.

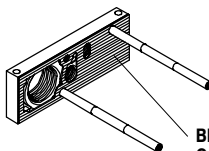
STEP 1



STEPS 2 & 3

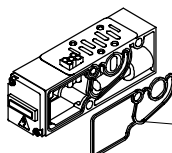


STEP 4



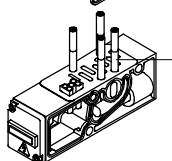
BLACK FLAT  
GASKET (2) 118733

STEP 6



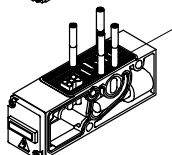
TRACK GASKET  
118737

STEP 10



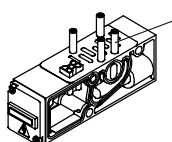
TIE BOLTS FOR  
REGULATOR

STEP 10



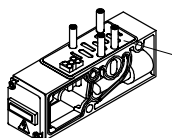
BLACK FLAT  
GASKET 119414

STEP 11



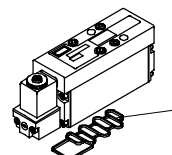
TIE BOLTS FOR  
SPEED CONTROL  
OR PILOT BLOCK

STEP 11



GRAY FLAT  
GASKET 118734

STEP 13



TRACK GASKET  
118727