

# SaniForce™ Air Controls 3A5800D

EN

***Integrated Air Controls for use with Sanitary Supply Systems.  
For professional use only.***

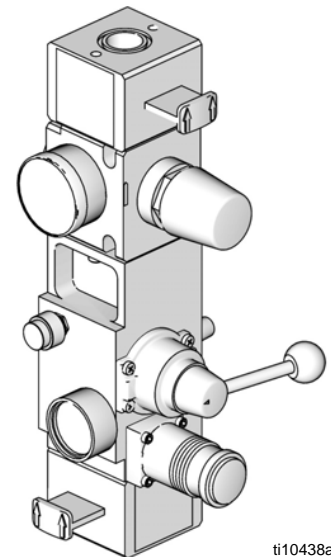


**Important Safety Instructions**

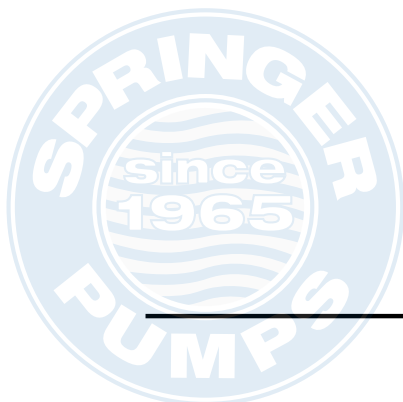
Read all warnings and instructions in this manual.  
Save these instructions.

See page 2 for Model information.

Integrated Air Controls



ti10438a



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# Models

## Air Controls

Model No.	Description	Maximum Regulated Working Pressure psi (MPa, bar)	Air Inlet Size
<b>25M879</b>	Air Controls for SPU 5 gal (20 l) and SDU 55 gal (208 l) Sanitary Supply Systems, Carbon Steel Frame, Static Seal	100 (0.7, 7)	3/4 npt(f)
<b>25E030</b>	Air Controls for SDU 55 gal (208 l) Sanitary Supply Systems, Stainless Steel Frame, Static Seal	100 (0.7, 7)	3/4 npt(f)
<b>25E650</b>	Air Controls for SDU 55 gal (208 l) Sanitary Supply Systems, Stainless Steel Frame, Inflatable Seal	100 (0.7, 7)	3/4 npt(f)
<b>25E651</b>	Air Controls for SDU 55 gal (208 l) Sanitary Supply Systems, Carbon Steel Frame, Inflatable Seal	100 (0.7, 7)	3/4 npt(f)



3A5800D

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# Integrated Air Controls

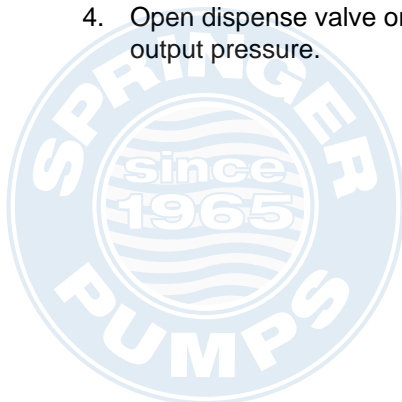


Follow the Pressure Relief Procedure whenever you see this symbol.

<b>! WARNING</b>				
<p><b>PRESSURIZED FLUID HAZARD</b></p> <p>This equipment stays pressurized until pressure is relieved manually. To help prevent serious injury from moving parts, or from pressurized fluid, such as splashing in the eyes or on skin, follow the Pressure Relief Procedure when you stop pumping and before you clean, check, or service the equipment.</p> <p><b>PERSONAL PROTECTIVE EQUIPMENT</b></p> <p>Wear appropriate protective equipment when in the work area to help prevent serious injury, including eye injury or hearing loss.</p>				

## Pressure Relief Procedure

1. Close the air motor slider valve (BH) and the main air slider valve (BA).  
**NOTE:** Both are relieving air valves.
2. Set the ram director valve (BD) to DOWN. The ram will slowly drop.
3. Jog the ram director valve (BD) up and down to bleed air from ram cylinder.
4. Open dispense valve or trigger gun to relieve pump output pressure.



## Disassembly

<b>! WARNING</b>				
<p><b>PRESSURIZED FLUID HAZARD</b></p> <p>This equipment stays pressurized until pressure is relieved manually. To help prevent serious injury from moving parts, or from pressurized fluid, such as splashing in the eyes or on skin, follow the Pressure Relief Procedure when you stop pumping and before you clean, check, or service the equipment.</p>				

1. Perform the pressure relief procedure.
2. Disconnect all hoses and tubing from existing air control.
3. Remove four screws and washers from the mounting bracket and remove the integrated air controls.

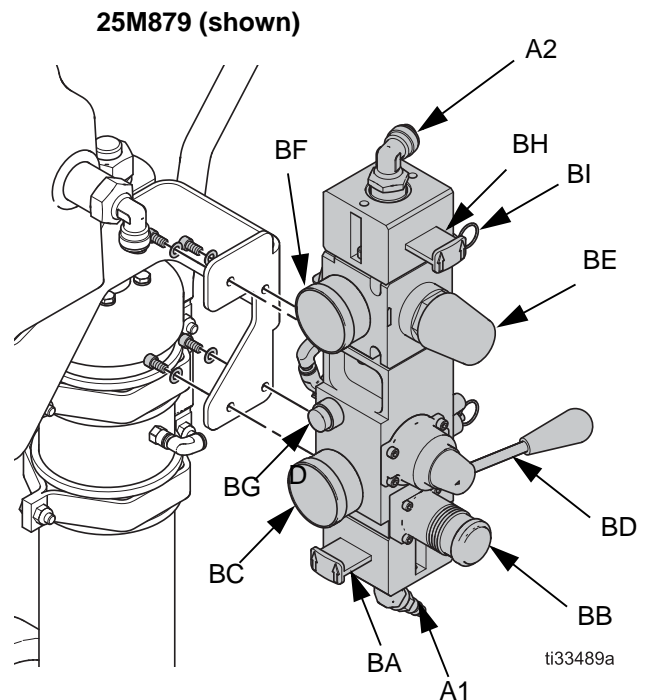


FIG. 1

The integrated air control includes:

- **Source air supply (A1):** facility air supply to power SPU.
- **Air motor drive air (A2):** air supply to drive pump air motor.
- **Main air slider valve (BA):** turns air on and off to the system. When closed, the valve relieves pressure downstream.
- **Ram air regulator (BB):** controls ram up and down pressure and blowoff pressure.
- **Ram air pressure gauge (BC):** displays the air pressure used to raise and lower the ram.
- **Ram director valve (BD):** controls ram direction.
- **Air motor regulator (BE):** controls air pressure to motor.
- **Air motor pressure gauge (BF):** displays the air pressure used to drive the air motor.
- **Blowoff button (BG):** turns air on and off to push the platen out of an empty pail.
- **Air motor slider valve (BH):** turns air on and off to the air motor. When closed, the valve relieves air trapped between it and the air motor. Push the valve in to shutoff.
- **Air motor safety relief valve (BI):** prevents over-pressurization of air motor air supply.

## Replace Director Valve

Numbers in parentheses refer to FIG. 2.

1. Disassemble the air control. See **Disassembly**, page 4.
  2. Remove screws (4a) and take off director valve.
  3. Remove spring (4c), valve plate (4d), and o-ring (4b).
- Note the orientation of the director valve plate when you remove it. The opening should be on the opposite side (left) of the lever.
4. Remove and discard pin (4g) and four valve seats (4e) with o-rings (4f).
  5. Insert new valve seats (4e) with o-rings (4f) and new pin.
  6. Insert new director valve plate (4d, see Note above) spring (4c), and o-ring (4b).

7. Attach new director valve with screws (4a). Tighten screws until snug.

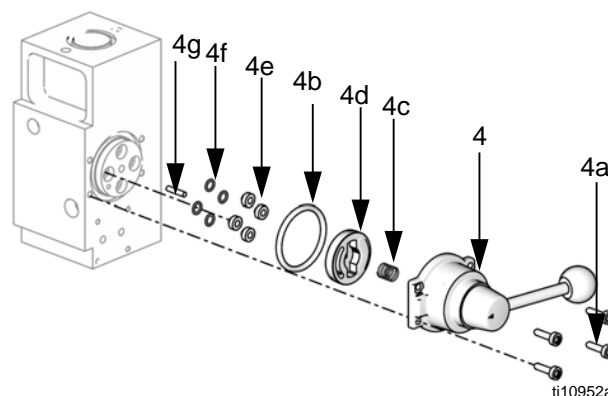


FIG. 2

## Replace Air Motor Regulator

Numbers in parentheses refer to **Parts**, page 7.

1. Disassemble the air control. See **Disassembly**, page 4.
2. Disconnect air motor hosing and fittings.
3. Remove two screws (9a) and take off the shutoff valve (3) at top of module. If your supply system has an air solenoid, it can remain attached to the shutoff valve.
4. Remove two screws (9b) and take off the air motor regulator (6).
5. Attach new regulator to manifold. Orient so the gauge lines up with the gauge on the ram air regulator and the direction of flow arrow points up. Tighten screws until snug. Recommend using thread locker Loctite 220 or equivalent.
6. Reattach shutoff valve (3) at top of regulator. Make sure that o-ring (5) is in place on valve (3).

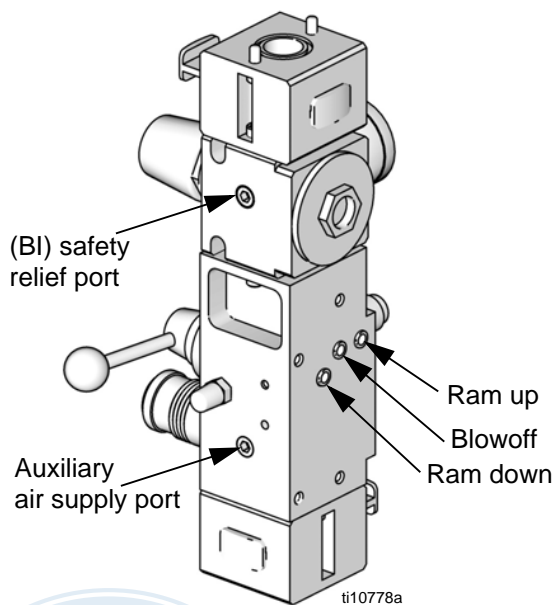
## Replace Ram Air Regulator

Numbers in parentheses refer to **Parts**, page 7.

1. Disassemble the air control. See **Disassembly**, page 4.
2. Remove four screws (7a) and take off the ram air regulator (7).
3. Replace o-rings (7b) on back side of regulator.
4. Attach new air regulator to manifold. Use index pin for correct orientation. Tighten screws until snug.

## Reassembly

1. Using four screws and washers, attach the integrated air controls to the mounting bracket. See FIG. 1.
2. Attach the ram up, ram down, and blowoff air lines as shown in Figure FIG. 3.

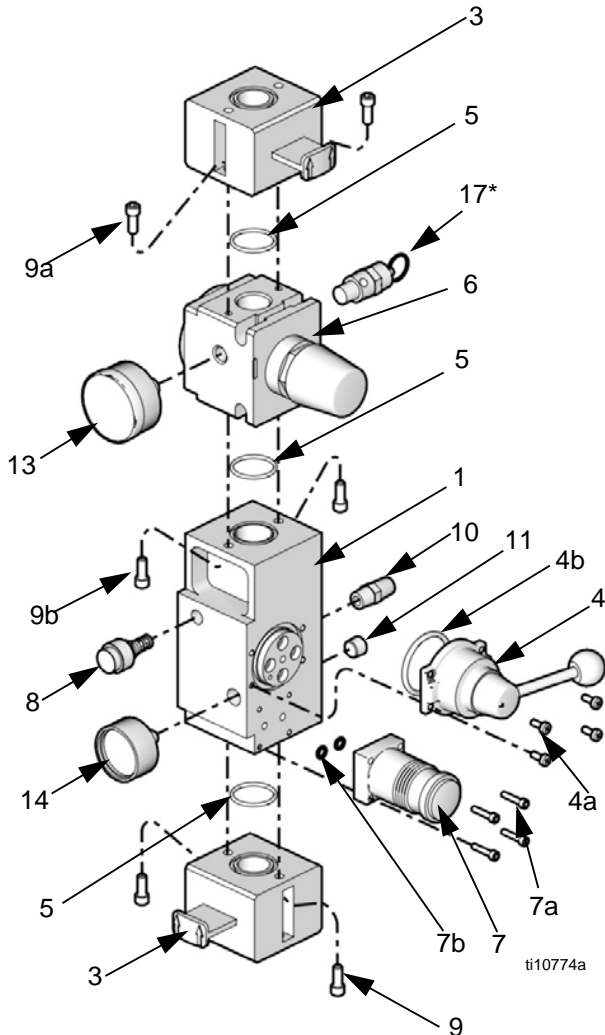


**FIG. 3**

3. Attach all other hoses and replace shrouds.
4. If replacing entire control assembly, install the safety relief valve (BI) from previous control assembly.

# Parts

## Integrated Air Controls



\* Ref 17 must be ordered separately, based on working pressure for installed pump, or re-used from existing control (if it is being replaced).

## Models 25M879, 25E030, 25E650, 25E651

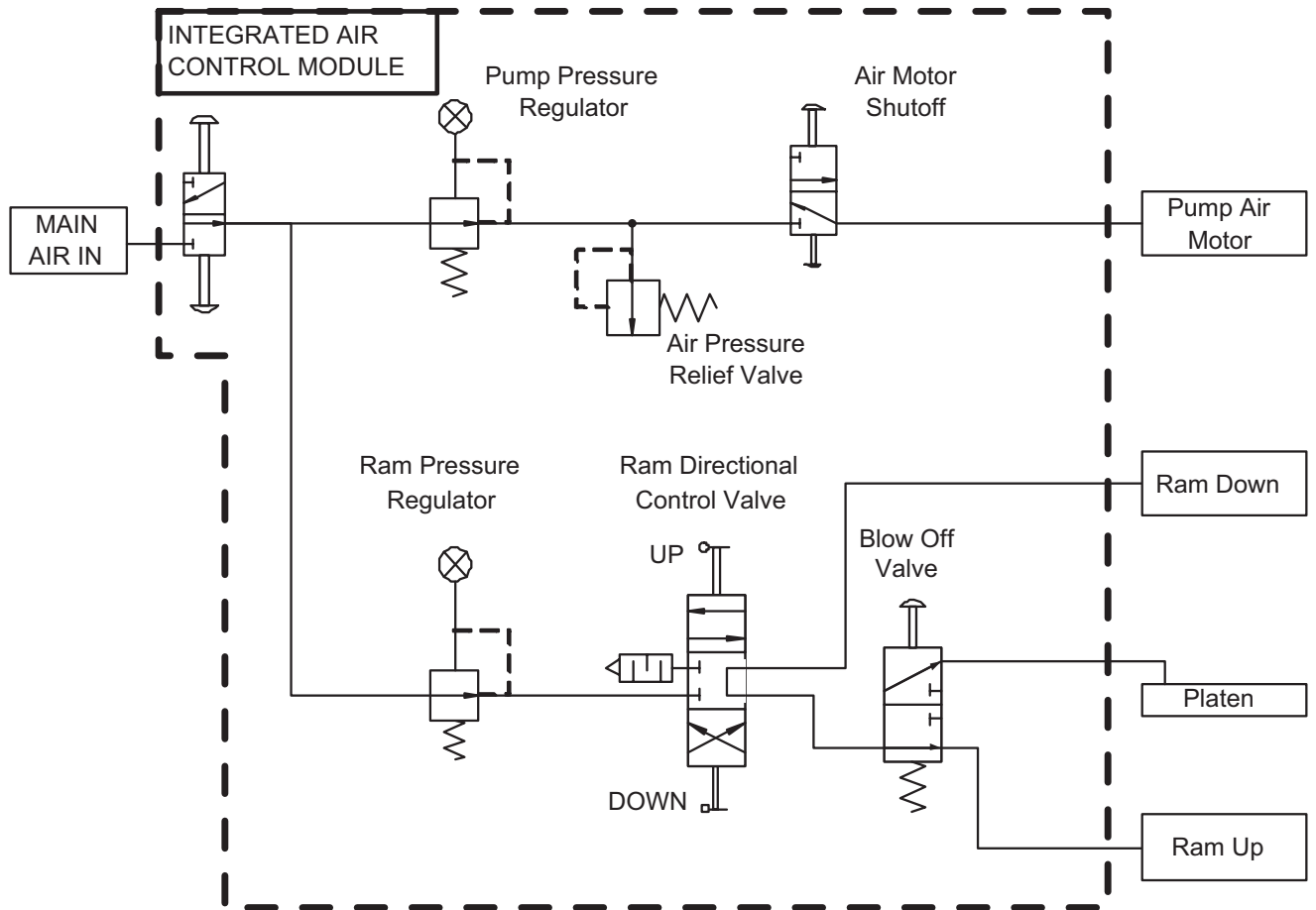
Ref.	Part	Description	Qty
1	---	MANIFOLD	1
3†	16Y167	VALVE, shutoff, modular, 3/4 npt	2
4		VALVE, director (includes 4a and 4b, plus all parts shown in FIG. 2)	1
	121107	models 25M879, 25E030	
	16Y157	models 25E650, 25E651	
4a	---	SCREW	4
4b	---	O-RING	1
5†	121110	O-RING, buna	3
6	255651	REGULATOR, air motor (includes regulator, o-ring, and screws)	1
7		REGULATOR, ram (includes 7a and 7b)	1
	121106	models 25M879, 25E651	
	17W740	models 25E030, 25E650	
7a	---	SCREWS	4
7b	---	O-RING	2
8	121109	VALVE, blowoff (includes valve and push button)	1
9†	121112	SCREW, cap, socket head 1/4-20 x 5/8	6
10	517449	MUFFLER	1
11	100721	PLUG, pipe, auxiliary air supply	1
13	C36260	GAUGE, air pressure, 0-160 psi (0-1.1 MPa, 0-11 bar)	1
14		GAUGE, air pressure,	1
	C36260	0-160 psi, models 25M879, 25E651	
	17W903	0-60 psi, models 25E030, 25E650	
15	113318	FITTING, elbow, plug-in (not shown, 25M879 only)	2
16†	15V954	LABEL, valve, shutoff, air control (not shown)	1
▲			
17*		VALVE, Air motor safety relief	1
	120306	85 psi	
	103347	100 psi	
	114003	130 psi	

† Parts are available in kit 121108.

▲ Replacement warning labels, signs, tags, and cards are available at no cost.

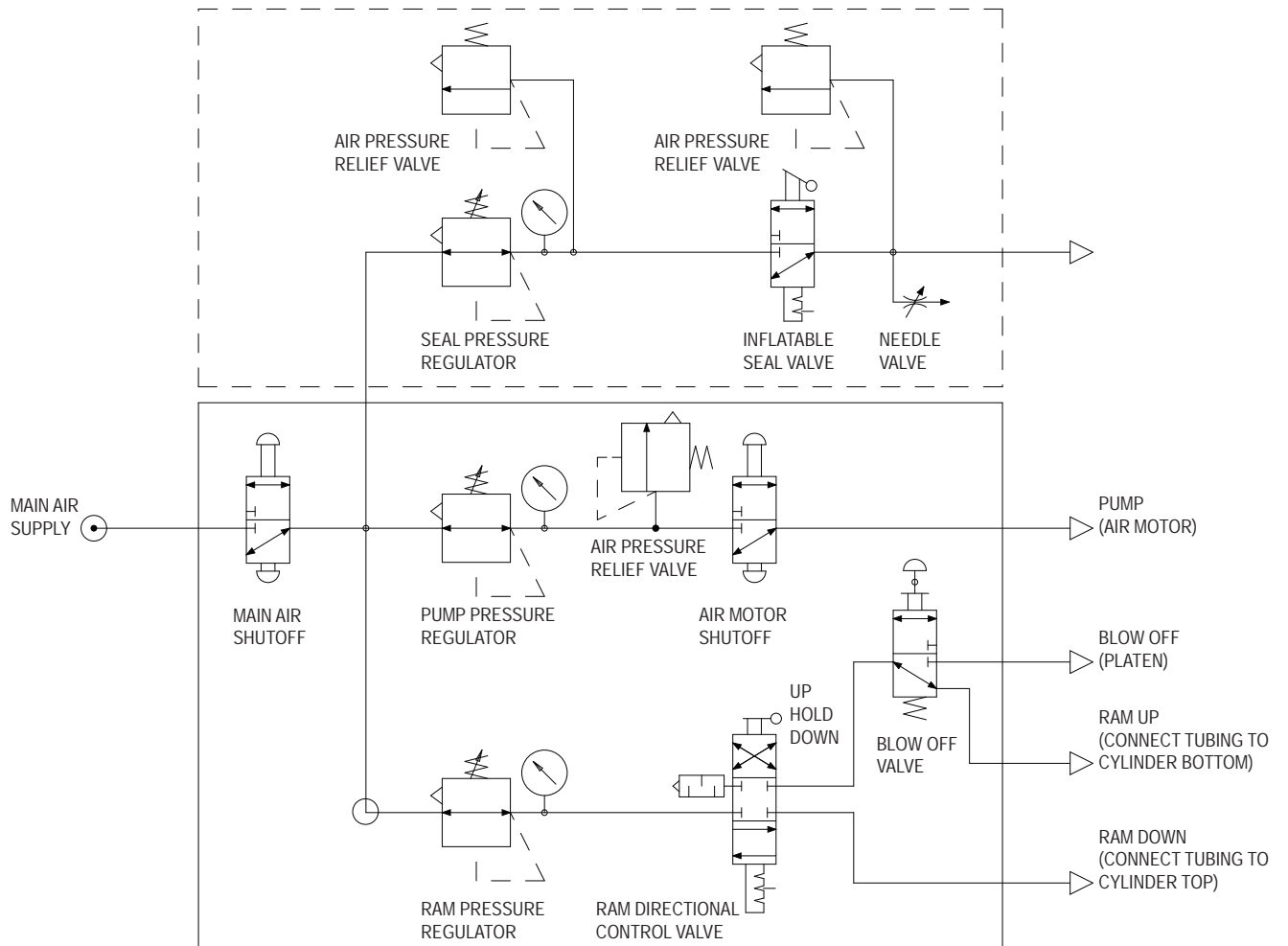
# Pneumatic Schematic

## Integrated Air Control Module 25M879, 25E030





# Integrated Air Control Module 25E650, 25E651



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# Graco Standard Warranty

Graco warrants all equipment referenced in this document which is manufactured by Graco and bearing its name to be free from defects in material and workmanship on the date of sale to the original purchaser for use. With the exception of any special, extended, or limited warranty published by Graco, Graco will, for a period of twelve months from the date of sale, repair or replace any part of the equipment determined by Graco to be defective. This warranty applies only when the equipment is installed, operated and maintained in accordance with Graco's written recommendations.

This warranty does not cover, and Graco shall not be liable for general wear and tear, or any malfunction, damage or wear caused by faulty installation, misapplication, abrasion, corrosion, inadequate or improper maintenance, negligence, accident, tampering, or substitution of non-Graco component parts. Nor shall Graco be liable for malfunction, damage or wear caused by the incompatibility of Graco equipment with structures, accessories, equipment or materials not supplied by Graco, or the improper design, manufacture, installation, operation or maintenance of structures, accessories, equipment or materials not supplied by Graco.

This warranty is conditioned upon the prepaid return of the equipment claimed to be defective to an authorized Graco distributor for verification of the claimed defect. If the claimed defect is verified, Graco will repair or replace free of charge any defective parts. The equipment will be returned to the original purchaser transportation prepaid. If inspection of the equipment does not disclose any defect in material or workmanship, repairs will be made at a reasonable charge, which charges may include the costs of parts, labor, and transportation.

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Graco's sole obligation and buyer's sole remedy for any breach of warranty shall be as set forth above. The buyer agrees that no other remedy (including, but not limited to, incidental or consequential damages for lost profits, lost sales, injury to person or property, or any other incidental or consequential loss) shall be available. Any action for breach of warranty must be brought within two (2) years of the date of sale.

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**TO PLACE AN ORDER**, contact your Graco distributor or call to identify the nearest distributor.

**Phone:** 612-623-6921 **or Toll Free:** 1-800-328-0211 **Fax:** 612-378-3505



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*For patent information, see [www.graco.com/patents](http://www.graco.com/patents).*

Original instructions. This manual contains English. MM 3A5800

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