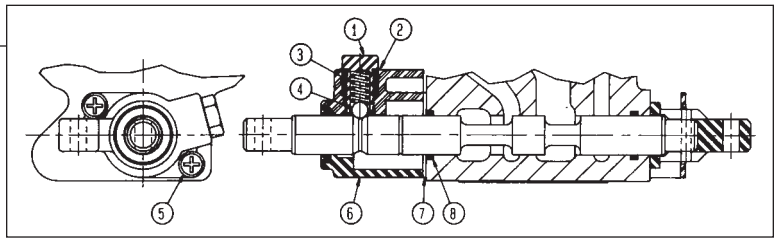
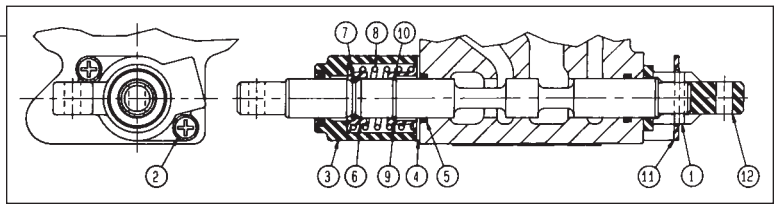
ACM-402 (S-SERIES)
AIR SHIFT INSTALLATION



DETENT REMOVAL

1. Remove Detent Cap, item #1; Lockwasher, item #2; Spring, item #3; and Ball, item #4.
2. Remove two Capscrews, item #5, and slide Detent End Cap, item #6, and Cover Plate, item #7 off the Spool.
3. Do not remove Quad Seal, item #8, from Valve Housing.
4. Clean mounting face of Valve Body and Spool to remove dirt, grease, and paint.
5. Continue with Air-Shift Installation Instructions.

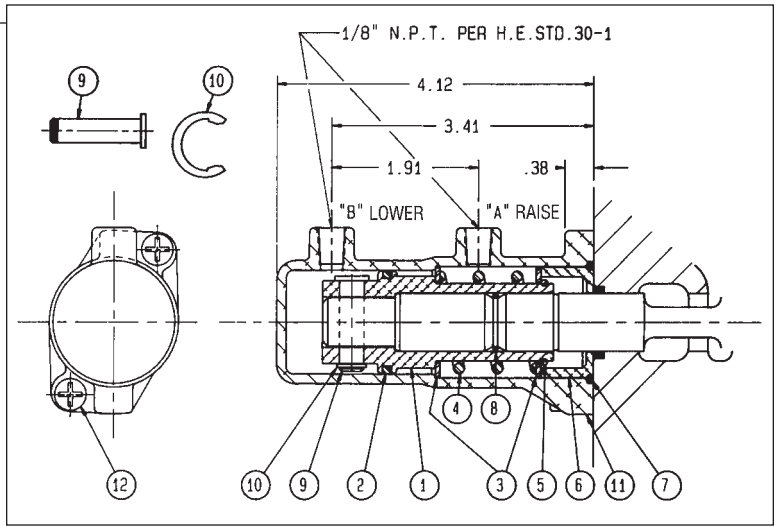


SPRING RETURN REMOVAL

1. Remove Spirol Pin, item #1, from Spool, End Cap, retain for re-use.
2. Remove two Capscrews, item #2, and slide Spring-Return End Cap, item #3, off the Spool and Spring Return assembly.
3. Remove Spool with Spring-Return assembly from Valve Body Cover Plate, item #4, and Quad Seal, item #5, will come off with Spool. Once Spool is removed from Valve Body, remove Cover Plate and Quad Seal from Spool. Retain Quad Seal for re-use.
4. Compress Spring by pushing against Spring Guide, item #6, to expose Retaining Ring, item #7. (This may require the use of an Arbor Press; force to compress Spring is 50-55 lbs.). Remove Retaining Ring.
5. Remove Spring, item #8; Spring Guide, item #9; and Retaining Ring, item #10.
6. Clean mounting face of Valve Body and Spool to remove dirt, grease, and paint.
7. Lightly oil Spool and slide into Valve Body.
8. Align hole in Spool with slotted hole in Spool End Cap, item #12, and install Spiral Pin, item #1. Spiral Pin should not interfere with Bracket, item #11, when Spool is operated.
9. Slide Quad Seal, item #5, over spool and locate in counterbore in valve body.
10. Continue with Air-Shift Installation Instructions.

ACM-402 INSTALLATION

ITEM	QTY	PART NUMBER	DESCRIPTION
1-5	**1**	**PS1-1400-AV**	**Piston Sub-Assembly**
1			Piston
2			Quad Seal Ring*
3			Spring Retainer
4			Spring
5			Wire Ring
6	1	PS1-1402-AV	Spring Retainer
7	1	PS1-1406-AV	“O” Ring
8	1	PS1-1403-AV	“O” Ring
9	1	PS1-1404-AV	Clevis Pin
10	1	PS1-1405-AV	Snap Ring
11	1	PS1-1407-AV	Pressure Cap



1. Place Spring Retainer, item #6, and “O”ring, item #7, over Spool, and locate against Valve Body.
2. Carefully locate “O”ring, item #8, into large detent groove of Spool. Apply light coating of grease to “O”ring.
3. While holding opposite end of Spool push on piston sub-assembly until piston hole lines up with spool hole. Slide in Clevis Pin, item #9, and attach Snap Ring, item #10.
4. Pressure Cap, item #11, should be positioned over this assembly and located against Valve Body. Attach with 2 Cap Screws, item #12. After Cap Screws are finger tight, move Spool (from other end) to ensure centering of the Air-Shift assembly. Tighten Cap Screws to 12 ft-lbs torque.
5. Cut Air Line to required length. Connect Air Supply to Control Valve and Control Valve to Shift Kit. Check operation of Spool.
   a. Minimum air pressure required: 80 psi.
   b. Air supplied to Port “A” shifts Spool to RAISE position.
   c. Air supplied to Port “B” shifts Spool to LOWER position.
   d. Air Dryer or Water Filter in the Air Supply recommended for proper cold weather operation.

Muncie® Power Products

Muncie Power Products, Inc. *Member of the Interpump Hydraulics Group*
General Offices and Distribution Center • P.O. Box 548 • Muncie, IN 47308-0548
(765) 284-7721 • *FAX* (765) 284-6991 • *E-mail* info@munciepower.com
Web site http://www.munciepower.com
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