

## Air Controls

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334201B  
EN

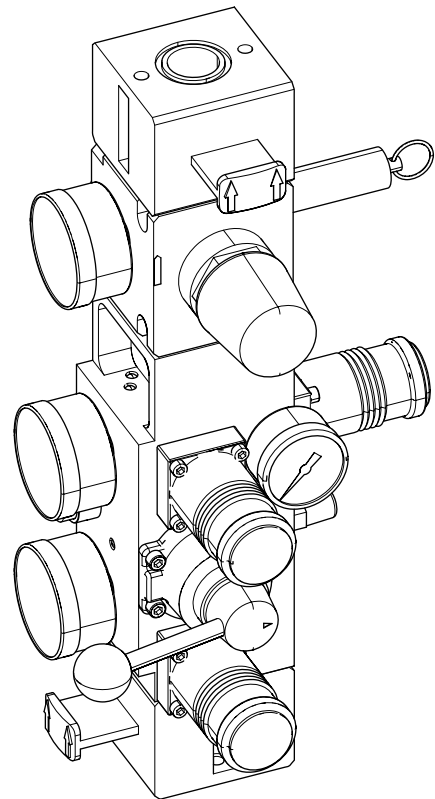
Integrated Air Controls for Therm-O-Flow® 20 and 200 Systems. For professional use only.



### Important Safety Instructions

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

See page 2 for model information and maximum working pressure.



ti25387a

## Models

Kit No.	Description	Maximum Regulated Working Pressure	Air Inlet Size
24W870	Integrated Air Controls for TOF20 and TOF200	125 psi (0.8 MPa, 8.6 bar)	3/4 npt (f)

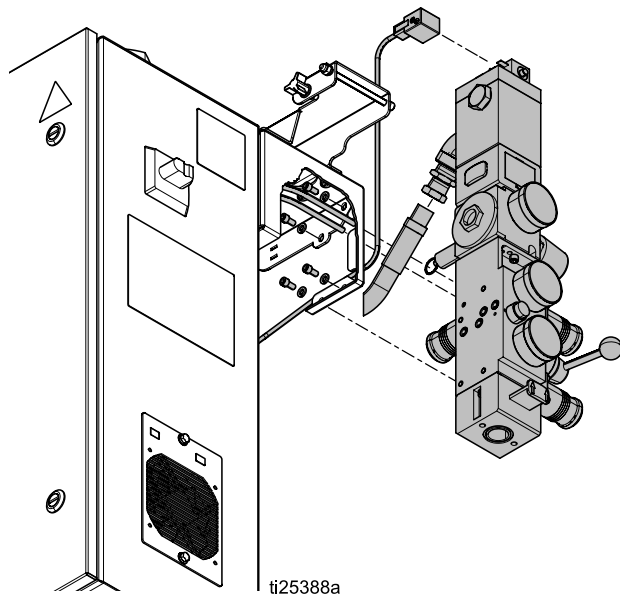
## Related Manuals

Manual	Description
334129	Therm-O-Flow 200, Instructions-Parts
334130	Therm-O-Flow 20, Instructions-Parts

# Repair

## Remove

1. Relieve pressure. See system manual for instructions.
2. Disconnect all hoses and tubing from air control.
3. Remove 4 screws and washers.



## Replace Director Valve

1. Relieve pressure. See system manual for instructions.
2. Remove screws (5a) and take off director valve.

3. Remove spring (5c), valve plate (5d), and o-ring (5b).

### Note

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 (5g) and four valve seats (5e) with o-rings (5f).
5. Insert new valve seats (5e) with o-rings (5f) and new pin (5g).
6. Insert new director valve plate (5d, see Note above) spring (5c), and o-ring (5b).
7. Attach new director valve with screws (5a). Tighten screws until snug.

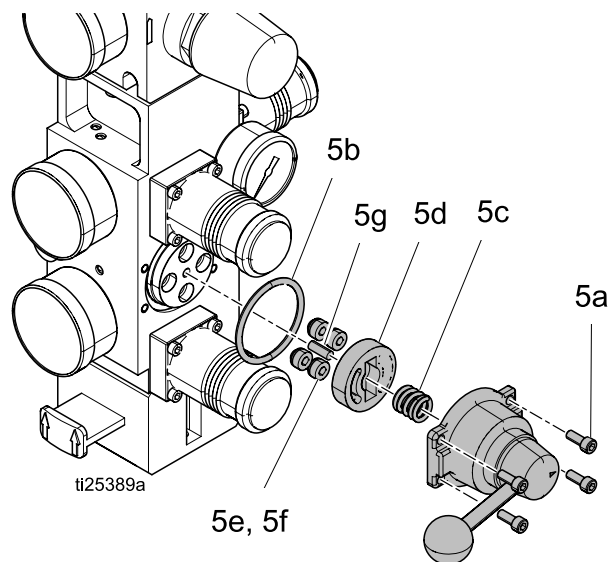


Figure 1

## Replace Air Motor Regulator

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

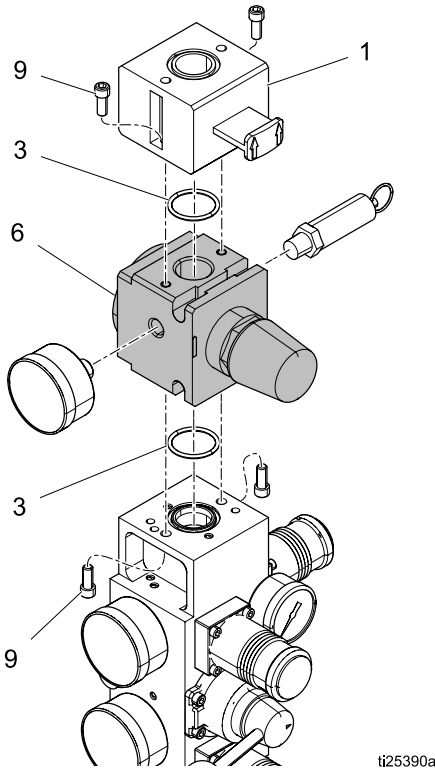


Figure 2

## Replace Air Regulators

Identify which knob regulator (8) needs to be replaced.

- Ram Down Air Regulator (CB)
- Ram Up Air Regulator (CD)
- Blowoff Air Regulator (CJ)

1. Relieve pressure. See system manual for instructions.
2. Remove four screws (8a) and take off the air regulator (8).
3. Replace o-rings (8b) on back side of regulator.
4. Attach new air regulator to manifold. Use index pin for correct orientation. Tighten screws until snug.

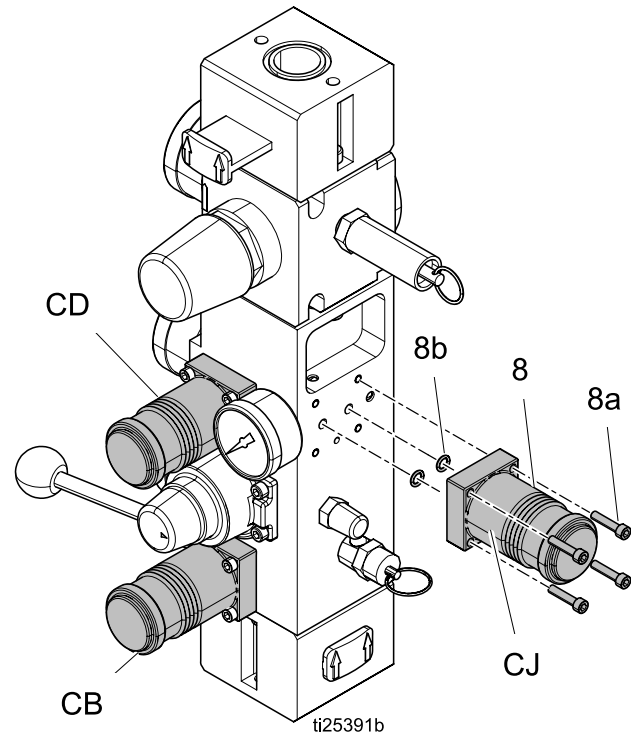
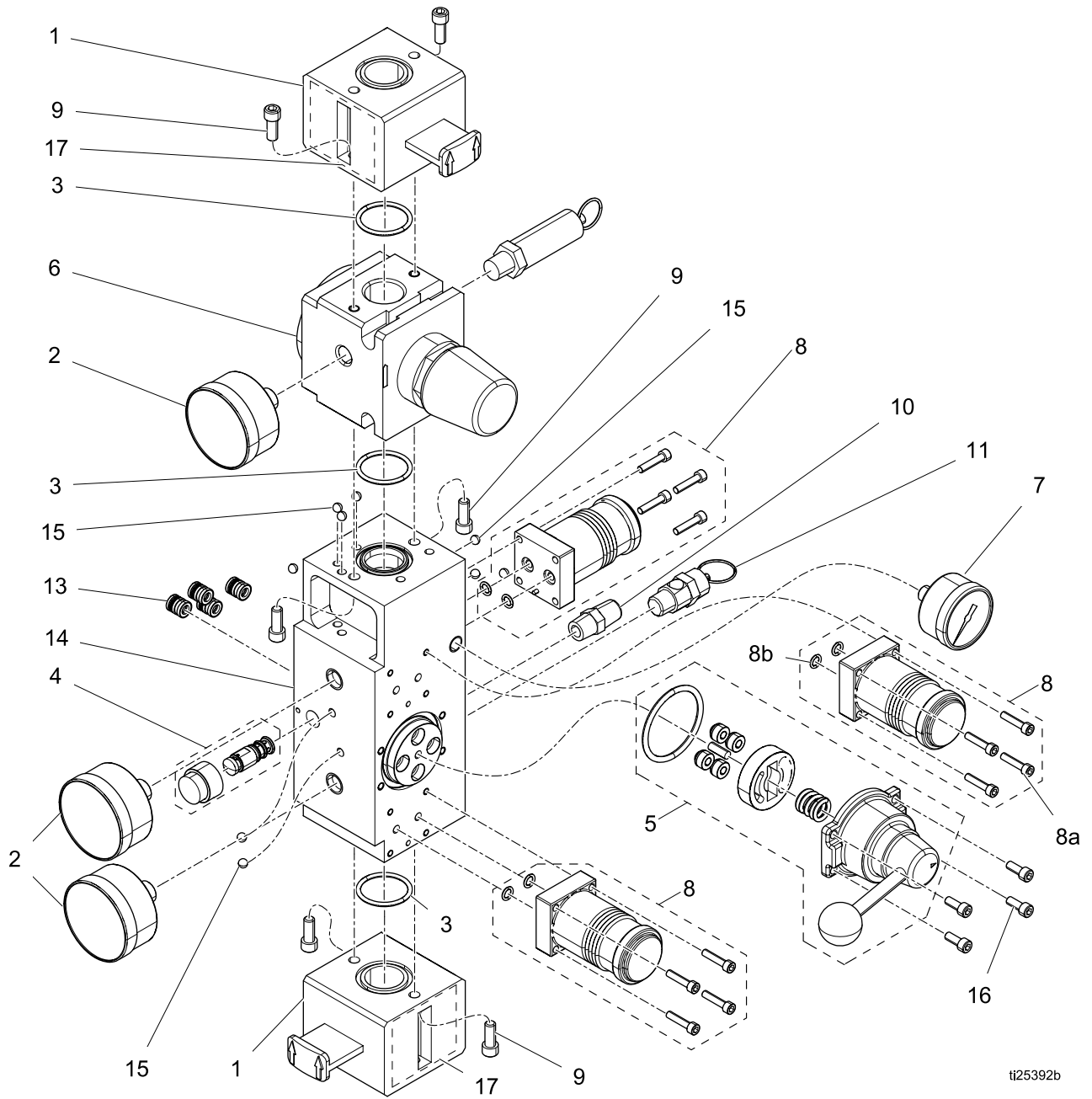


Figure 3

# Parts

## 24W870 Air Control



t125392b

*Graco Information*

Ref	Part	Description	Qty	Ref	Part	Description	Qty
1	- - -	VALVE, shutoff (includes o-rings and screws)	2	8a	- - -	SCREWS	4
2	101689	GAUGE, pressure, air; 0-200 psi (0-1.4 MPa, 0-14 bar)	3	8b	- - -	O-RING	2
3	121110	O-RING, buna	3	9	121112	SCREW, cap, socket hd	6
4	121109	VALVE, blow-off ( includes valve and push button)	1	10	517449	MUFFLER, 1/4 npt	1
5	- - -	VALVE, control	1	11	113498	VALVE, safety, 110 psi (0.8 MPa, 7.6 bar)	1
6	- - -	REGULATOR, modular	1	13	120602	FITTING, cartridge, 1/4	4
7	108190	GAUGE, pressure, air; 0-100 psi (0-700 kPa, 0-7 bar)	1	14	- - -	BLOCK, ram, control, 3 regulator	1
8	121106	REGULATOR, manifold (includes 8a and 8b)	3	15	- - -	BALL, sst, 7/32 dia	11
				16	120039	FASTENER, schcs, 10-32 x 1/2	4
				17▲	15V954	LABEL, valve, shutoff	1

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

## Graco Information

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

To place an order, contact your Graco Distributor or call to identify the nearest distributor.

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All written and visual data contained in this document reflects the latest product information available at the time of publication.

Graco reserves the right to make changes at any time without notice.

Original Instructions. This manual contains English. MM 334201

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