



DEL 3082-99-03 Assembly Instructions (PVG-32)

PLEASE READ INSTRUCTIONS BEFORE ATTEMPTING ASSEMBLY.  
 THIS AIR SHIFTER HAS BEEN ASSEMBLED AND PRE-LUBRICATED  
 FOR EASE OF FIELD INSTALLATION.  
 THE AIR SHIFTER DOES NOT HAVE TO BE DISASSEMBLED TO INSTALL.

1. Remove valve end cover and end plug - spool (18), as these items will not be used with the DEL shifter. Keep the four original screws (M6 x 15), or original seal and o-ring as these items will be used with the DEL shifter. Make sure that the valve spool and valve face are free of any foreign particle.
2. Fit the original seal and o-ring into the grooves of the end plate (13) as shown.
3. Apply a small bead of **removable threadlock** to the threads of the spool adaptor (12). Tighten the assembly into the end of spool **by hand** using a 1/4" hex hand wrench in rear fitting port at the end of piston (10).
4. Secure the assembly to the valve body using the four original screws (M6 x 15).
5. Install fittings and air lines and test for free movement and no air leaks.

FOR SHIFTER REMOVAL, FOLLOW ASSEMBLY PROCEDURE IN REVERSE ORDER.

TIGHTEN THE ASSEMBLY BY HAND USING  
 A 1/4" HEX WRENCH.  
 MAX TORQUE: 45-50 in-lbs  
 DO NOT USE AN AIR GUN.



SINCE 1945

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E-Z FIT AIR SHIFTER-3 POSITIONS,  
 ASSEMBLY INSTRUCTION  
 3082-99-03



UNITS: INCHES

SCALE: NTS

CHKD:

DRWN: 05. Feb 08/06

REVD: 05. Dec 29/06

SHEET SIZE: A

REV: A