DEL 3116-99-03 Assembly Instructions (PARKER-COMMERCIAL C101 AND EQUIVALENT).

PLEASE READ INSTRUCTIONS BEFORE ATTEMPTING ASSEMBLY.
REFER TO SHIFTER CUTAWAY DRAWING FOR ORIENTATION WHEN ASSEMBLING OR REMOVING THE SHIFTER.
THIS AIR SHIFTER HAS BEEN PRE-ASSEMBLED AND PRE-LUBRICATED FOR EASE OF FIELD INSTALLATION.

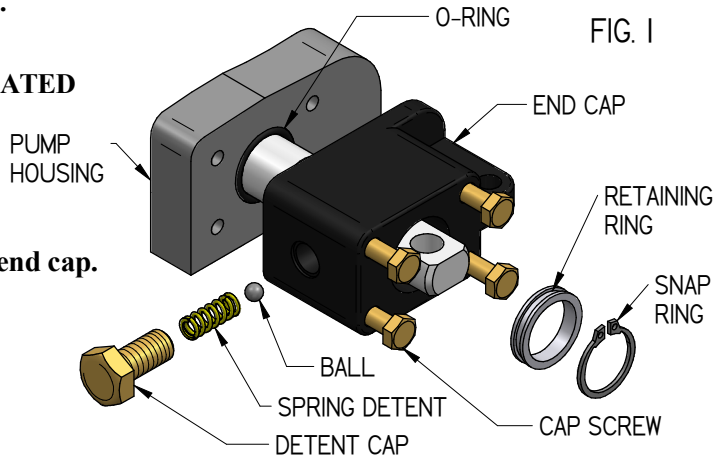

FIG. 1

A. Disassembly (follow Fig. 1)

1. **Using snap ring pliers, remove snap ring from valve spool.**
2. **Remove retaining ring from valve spool.**
3. **Place a piece of scotch tape over the snap ring groove to remove the end cap.**
4. **Remove detent cap, spring detent and ball from valve's end cap.**
5. **Remove the scotch tape.**
6. **Remove the four cap screws and slide end cap off spool.**
   Do not remove O-ring from pump housing.

B. Assembly

1. **Make sure that the valve spool and valve face are free of any foreign particle. Slide the O-Ring (2) and spacer (4) over the spool. (See Fig. 2). Slide O-Ring(1) over the spool, into the groove. Apply a coating of grease around the spool O-Ring area.**

2. **Slide piston assembly (3,6,9,10) over the spool (See Fig. 3). Align the piston and spool holes and insert the pin (7). Install the circip (13) in the pin groove.**

3. **Slide the cylinder (5) over the complete shift assembly, ensuring that the o-ring (2) is in place. Insert the four supplied 5/16-18x3.75" socket head screws (11) with lock washers (12) through cylinder mounting holes and progressively tighten to 15 ft.lbs/ 20 N.m.(See Fig. 4).**

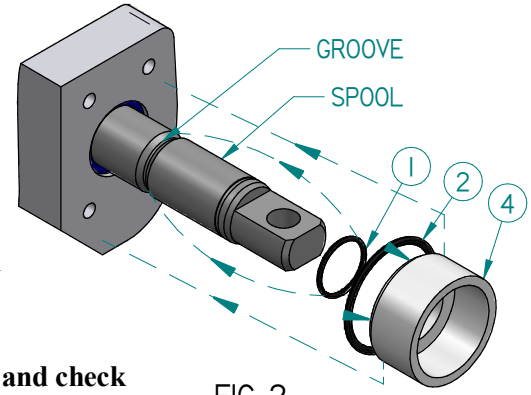

FIG. 2

4. **Install fittings and air lines. Apply air pressure (minimum 75 psi) to cylinder ports and check for air leaks. Make sure the shifter mechanism moves freely under the applied air pressure.**

FOR SHIFTER REMOVAL, FOLLOW ASSEMBLY PROCEDURE IN REVERSE ORDER.

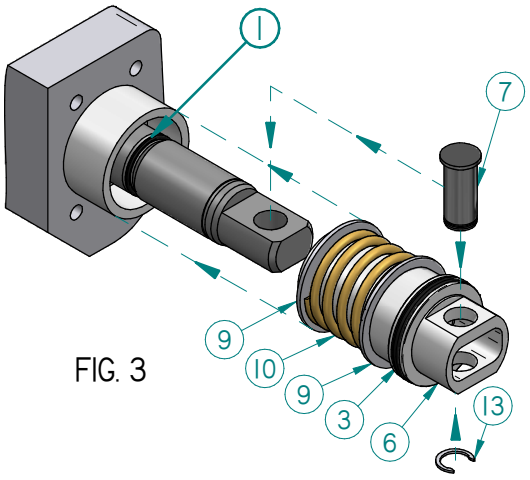

FIG. 3

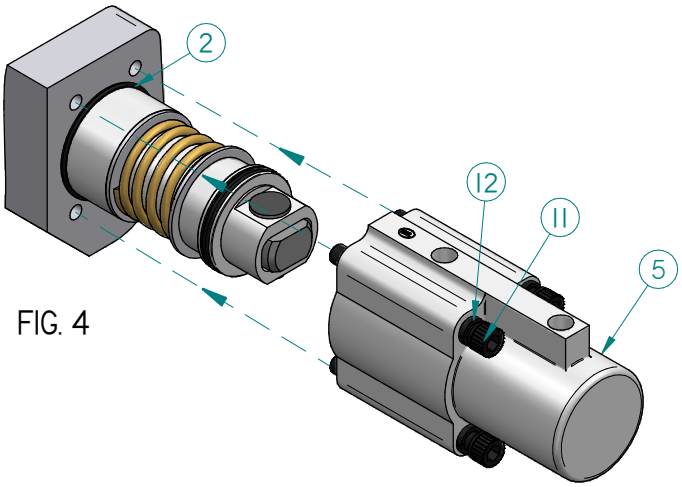
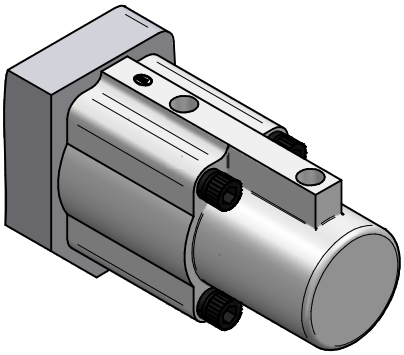
FIG. 4