STEM LENGTH ADJUSTMENT AND PROPORTIONAL BAND

PILOT CONTROLLERS

PRAP ADJUSTABLE PROPORTIONAL BANK TYPE

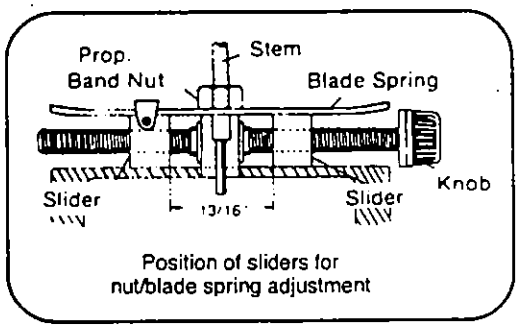
ADJUSTMENT PROCEDURE

Supply 20-22 psig operating pressure to the pilot controller. With output connection plugged, turn adjusting nut to compress adjusting spring to set upper diaphragm against its top limit stop. If possible remove fluid pressure from top of diaphragm, if not, compress spring sufficiently to overcome fluid pressure and move diaphragm to stop.

Adjust sliders 13/16" apart as shown in sketch below. Move proportional bank nut upward on adjust in pin thread sufficiently to keep nut from touching blade spring during stem length adjustment. Loosen adjusting pin set screw and turn adjusting pin either up or down until pilot air output is 21 psig. Then turn adjusting pin downward toward pilot body until pilot air output decreases from 21 to 0 psig. Lock set screw. Turn proportional bank nut down against blade spring until air output pressure increases from 0 to 3 psig. With pin in stem hole to keep stem from turning, loosen set screw and turn adjusting pin upward away from pilot body approximately 1-1/4 turns. Lock set screw.

When adjustments have been properly made, the proportional bands noted in table will be obtained when the sliders are set the approximate distances apart as shown.

Pilot Range	Contr. Press PSIG	Max. Prop. Band PSIG	Min. Prop. Band PSIG	Approx. Distance Between Sliders
50-800	50 800	17-20 25-28	4-6 6-8	1-1/32" - 2-3/4" 1-1/2" - 2-3/4"
5-70	5 70	3-5 4-6	.3-.5 .6-.9	1-3/32" - 2-3/4" 1-3/32" - 2-3/4"



Position of sliders for nut/blade spring adjustment