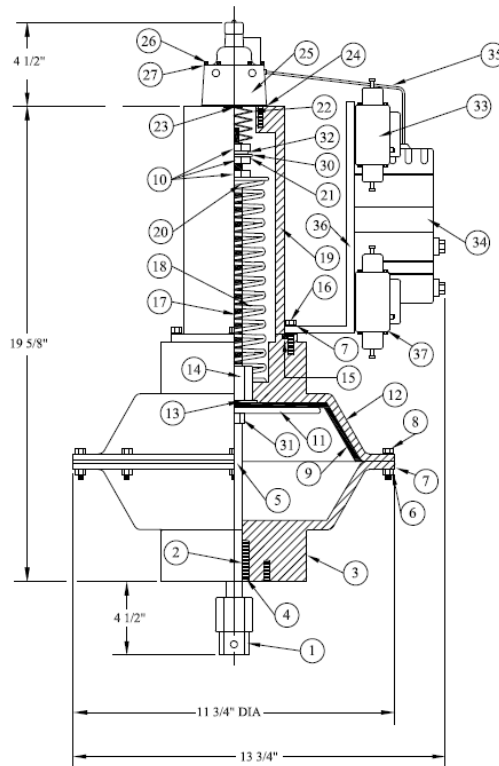


## INSTRUCTIONS FOR CONVERTING A DURASTROKE 1100 TO A DURASTROKE 1500 PNEUMATIC ACTUATOR

### Installation:

1. Observe all safety precautions – make the proper lock outs to ensure the safety of manpower and protection of equipment.
2. Remove the mounting plate containing two Fisher 67CFR Filter Regulator and Fisher 646 I/P transducer from the shipping box.
3. Remove two .375" x 1.5" long bolts from the spring housing (19) connection to upper housing (12) and attach plate via pre-drill holes using .375" x 2" long bolts supplied with the conversion kit.



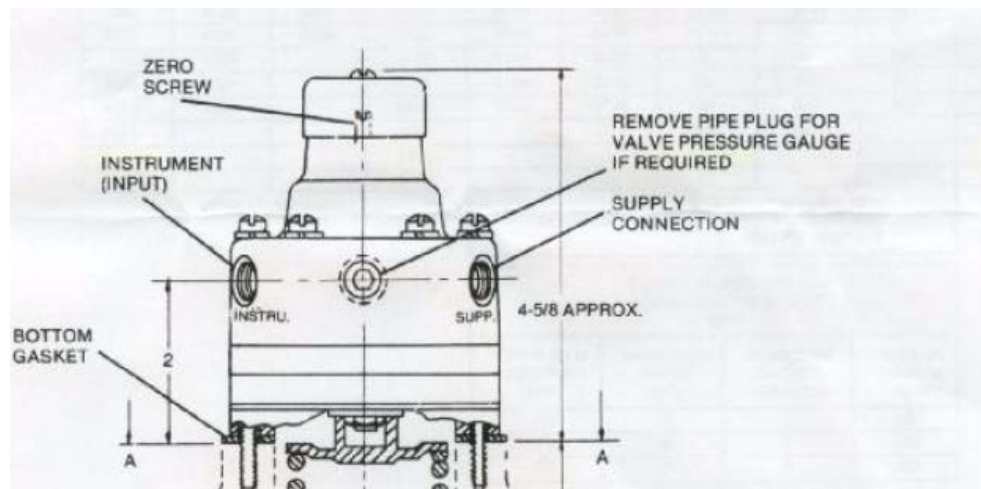
### Air Line Connections:

1. Blow out all piping before connections are made to prevent dirt, chips, etc from entering the positioned. Ensure all air entering the positioned and actuator is clean, dry and oil free. Failure to do so increases the possibility of operational problems and /or deviation from specified performance.
2. Refer to the attached schematic drawing for a Durastroke 1500 Pneumatic kit.
3. See the photo below for illustration of Durastroke 1500 Actuator

## Durastroke 1500 illustration



4. Connect the output port from 67CFR-237 to the "Supply" port on the positioner using the tubing and fittings provided in the conversion kit.
5. Connect the output port from Fisher 646 I/P to the "Instrument Air" port on the positioner using tubing and fittings provided in the conversion kit.
6. Connect Plant air to both Fisher Filter Regulators.
  - a. Hose and fittings for this connection are not supplied by Airtech Products.
7. Connect the 4-20 mA control signal into Fisher 646 I/P. Conduit adapters and other supplies for this connection are not included in the conversion kit.



**Note instrument air inlet port and supply air inlet port on above illustration.**