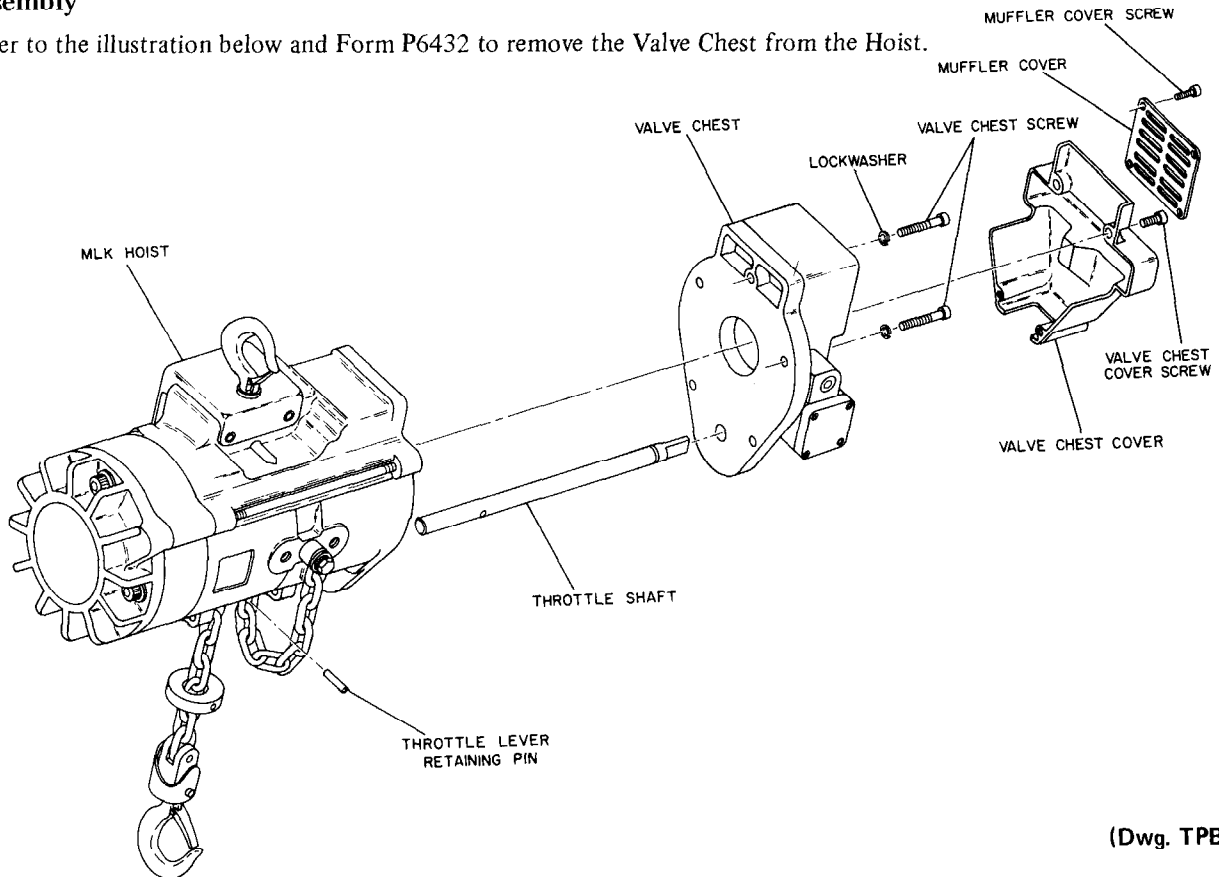


MLK-CONVPTL545 CONVERSION KIT INSTALLATION INSTRUCTIONS
for
CONVERTING MODELS ML25K, ML50K AND ML100K AIR CHAIN HOISTS
TO THE NEW STYLE VALVE CHEST

WARNING:
DISCONNECT THE AIR SUPPLY HOSE BEFORE CONVERTING
THIS HOIST TO THE NEW STYLE VALVE CHEST.

Disassembly

Refer to the illustration below and Form P6432 to remove the Valve Chest from the Hoist.



(Dwg. TPB697)

1. Remove the Muffler Cover Screws and the Valve Chest Cover Screws. **Note:** If the Hoist has pendent control, remove the Pendent Hose Bundle from the Valve Chest.
2. Remove the Valve Chest Screws and Lock Washers.
3. Lift off the Valve Chest from the Hoist.
4. Using a pin punch and hammer, drive out the Throttle Lever Retaining Pin from the Throttle Shaft.
5. Grasp the square end of the Throttle Shaft and withdraw the Shaft from the Hoist.

For a complete listing of repair parts refer to the Operator and Maintenance Manual, Form P6554.

Refer All Communications to the Nearest
Ingersoll-Rand Office or Distributor.

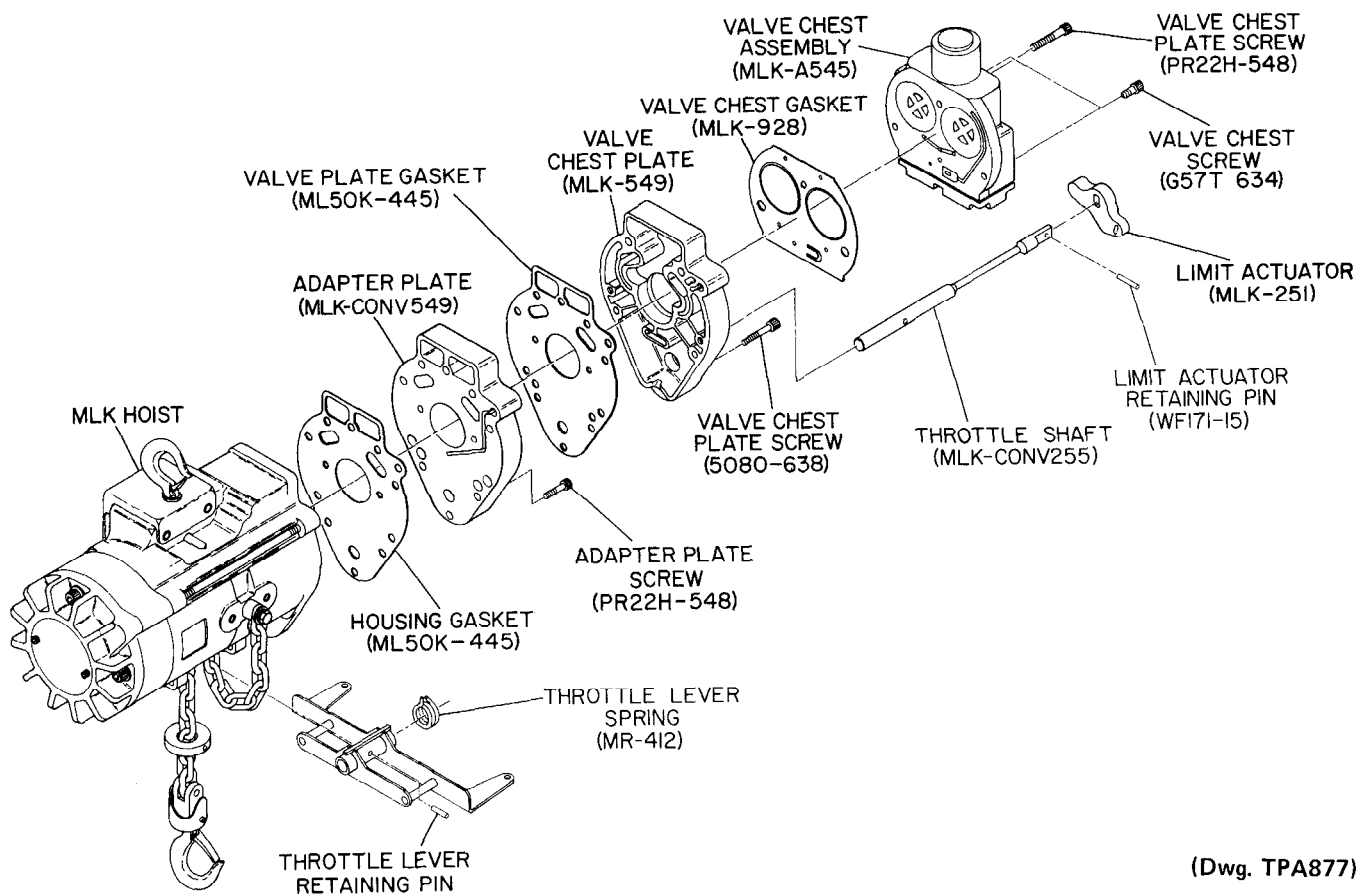
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AIR HOISTS & WINCHES

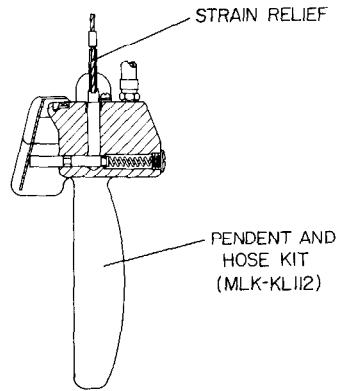
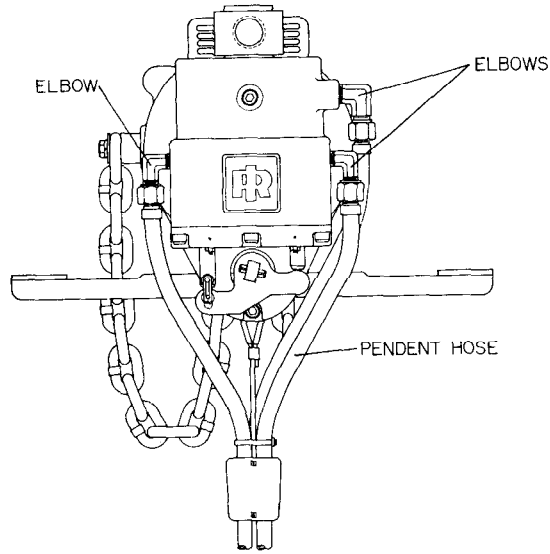
Assembly

Refer to the illustration below to install the **MLK-CONVPTL545 Conversion Kit**.



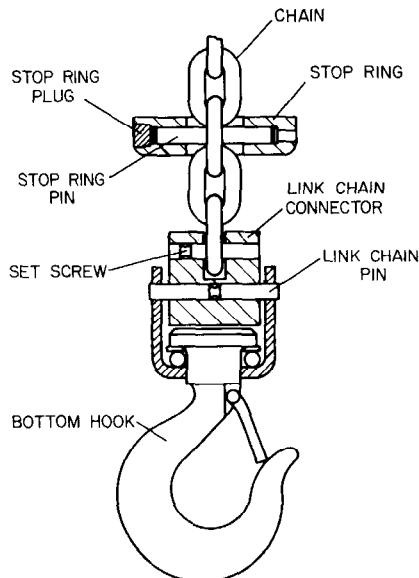
1. Position the Housing Gasket (ML50K-445) onto the motor end of the Hoist.
2. Install the Adapter Plate (MLK-CONV549) aligning the holes in the Adapter Plate with the holes in the Gasket and motor end of the Hoist.
3. Using the four Adapter Plate Screws (PR22H-548), secure the Adapter Plate to the motor end of the Hoist.
4. Place the second Housing Gasket (ML50K-445) onto the Adapter Plate and install the Valve Chest Plate (MLK-549) with the Valve Chest Plate Screws (5080-638).
5. Stand the Hoist upright on the brake end. Place the Valve Chest Gasket (MLK-928) on the Valve Chest Plate, making certain that the small flapper is properly positioned in the recess between the two parts. **Caution: If the Valve Chest Gasket is flipped over, the flapper will not be in the recess between the two ports, and the brake will not release.**
6. Center the two round rubber discs in corresponding recesses in the Valve Chest Plate.
7. Place the assembled Valve Chest (MLK-A545) on the Valve Chest Gasket and install the Valve Chest Screws (518-104 and G57T-634).
8. Place the Throttle Shaft Spring (MR-412) over one hub of the Throttle Lever so that the bent leg of the Spring is toward the inside of the Throttle Lever.
9. Hold the Throttle Lever in the housing recess beneath the Chain Wheel so that the Throttle Shaft Spring is toward the valve chest end of the Hoist and the legs of the Spring engage a rib on the bottom of the Chain Guide. Place a Throttle Lever Thrust Washer at each end of the throttle lever bore, and insert the Throttle Shaft (MLK-CONV255), round end first, through the Valve Chest Plate, Adapter Plate, Housing and Throttle Lever. Install the Throttle Lever Retaining Pin (WF171-5).

10. Place the Limit Actuator (MLK-251) on the square end of the Throttle Shaft, and install the Limit Actuator Retaining Pin (WF171-15).
11. Connect the three Pendent Hoses at the Elbows (see illustration below.) Install the Strain Relief.



(Dwg. TPA876)

Refer to the illustration below to remove the Bottom Hook from the ML25K and ML50K, 1/4 ton and 1/2 ton Hoist respectively.



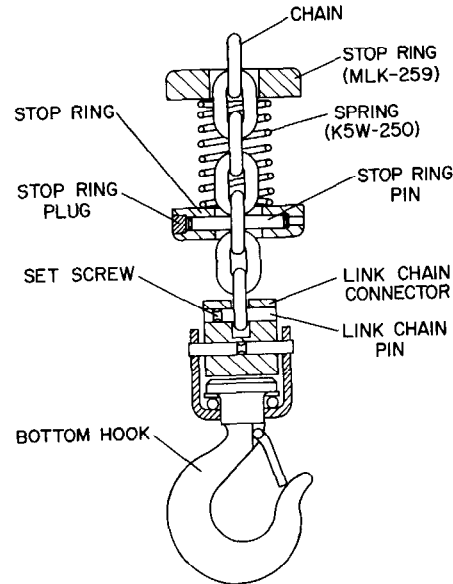
(Dwg. TPD715)

Disassembly

1. Remove the Set Screw and Link Chain Pin from the Link Chain Connector.
2. Remove the Bottom Hook from the Chain.
3. Remove the Stop Ring Plug and Stop Ring Pin from the Stop Ring.
4. Remove the Stop Ring from the Chain.

Assembly

Refer to the illustration below to install the Bottom Hook for the ML25K and ML50K, 1/4 ton and 1/2 ton Hoist respectively.



(Dwg. TPD716)

1. Slide the upper Stop Ring (MLK-259) beveled end first, over the Chain followed by the Spring (K5W-250).
2. Install the lower Stop Ring, beveled end trailing over the Chain.
3. Insert the Link Chain Pin through one end of the Stop Ring, Chain and into the other end of the Stop Ring. Retain the Pin with the Stop Ring Plug.
4. Install the Link Chain Connector onto the last chain link and insert the Link Chain Pin through the Connector, Chain and into the other end of the Connector until the Pin is flush on both ends of the Connector.
5. Retain the Link Chain Pin with the Set Screw.
6. Connect the air supply and operate the Hoist to see if it is functioning properly. See operating practices in Form P6554.