

# Pneumatic Tips & Tricks

- **Minimize Leaks (better yet, remove them completely) by careful use of teflon tape and careful assembly of tubing and fittings. Teflon tape should start two threads back and wrap in the direction of the threads.**
- **With no movement taking place the compressor should charge the tanks and then shut off. It should not restart until a valve and cylinder is operated.**
- **Use the Compressor Vibration Isolators. The Compressor is a reciprocating device and will cause sympathetic vibrations throughout your assembly unless they are used.**
- **When ordering custom cylinders, use extreme care on the form, both on the address and models ordered. Check the required stroke and resulting dimensions**
- **Because of the amperage rating, the Pressure Switch must be used as an input to the controller. It cannot handle the current flow (amperage) of the compressor.**
- **The Regulators have different maximum pressure ranges. The higher pressure one (Norgren) should be first with the lower (Monnier) unit used after that if needed. Check the specs.**
- **Make sure you have adequate pilot pressure (30 psi) for the *internally piloted* valves. Check the specs. Remember double-pilot valves are bi-stable, single-pilot valves are not.**
- **When using the double solenoid valve, energize only coil one at time to avoid signal races.**
- **Fittings are not required in the exhaust ports of valves unless the circuit design requires them. Thread fittings carefully and cut the tubing square.**
- **Always stay clear of cylinders in motion. Until compressed air is being metered (restricted), flow controls do little to control speed. On first pressurization the air may not yet be compressed.**
- **You can get specific component info as well as links to the component manufacturer's web sites at [www.PneumaticsFIRST.org](http://www.PneumaticsFIRST.org)**
- **For more help on circuitry, you are welcome to contact [JohnGroot@aol.com](mailto:JohnGroot@aol.com) or [FHeimall@KnottsCo.com](mailto:FHeimall@KnottsCo.com).**
- **For help on specific kit components, please contact the appropriate manufacturer.**

