Aire Form

Model

AF1

OWNER'S MANUAL

CISSELL MANUFACTURING COMPANY
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THIS MANUAL MUST BE GIVEN TO THE EQUIPMENT OWNER.

MAN60 4/95 Part No. D0101

WARRANTY

The Cissell Manufacturing Company (Cissell) warrants all new equipment (and the original parts thereof) to be free from defects in material or workmanship for a period of one (1) year from the date of sale thereof to an original purchaser for use, except as hereinafter provided. With respect to non-durable parts normally requiring replacement in less than one (1) year due to normal wear and tear, including, but not limited to, cloth goods, valve discs, hoses, and iron cords, and with respect to all new repair or replacement parts for Cissell equipment for which the one (1) year warranty period has expired, or for all new repair or replacement parts for equipment other than Cissell equipment, the warranty period is limited to ninety (90) days from date of sale. The warranty period on each new replacement part furnished by Cissell in fulfillment of the warranty on new equipment or parts shall be for the unexpired portion of the original warranty period on the part replaced.

With respect to electric motors, coin meters and other accessories furnished with the new equipment, but not manufactured by Cissell, the warranty is limited to that provided by the respective manufacturer.

Cissell's total liability arising out of the manufacture and sale of new equipment and parts, whether under the warranty or caused by Cissell's negligence or otherwise, shall be limited to Cissell repairing or replacing, at its option, any defective equipment or part returned f.o.b. Cissell's factory, transportation prepaid, within the applicable warranty period and found by Cissell to have been defective, and in no event shall Cissell be liable for damages of any kind, whether for any injury to persons or property or for any special or consequential damages. The liability of Cissell does not include furnishing (or paying for) any labor such as that required to service, remove or install; to diagnose troubles; to adjust, remove or replace defective equipment or a part; nor does it include any responsibility for transportation expense which is involved therein.

The warranty of Cissell is contingent upon installation and use of its equipment under normal operating conditions. The warranty is void on equipment or parts; that have been subjected to misuse, accident, or negligent damage; operated under loads, pressures, speeds, electrical connections, plumbing, or conditions other than those specified by Cissell; operated or repaired with other than genuine Cissell replacement parts; damaged by fire, flood, vandalism, or such other causes beyond the control of Cissell; altered or repaired in any way that effects the reliability or detracts from its performance, or; which have had the identification plate, or serial number, altered, defaced, or removed.

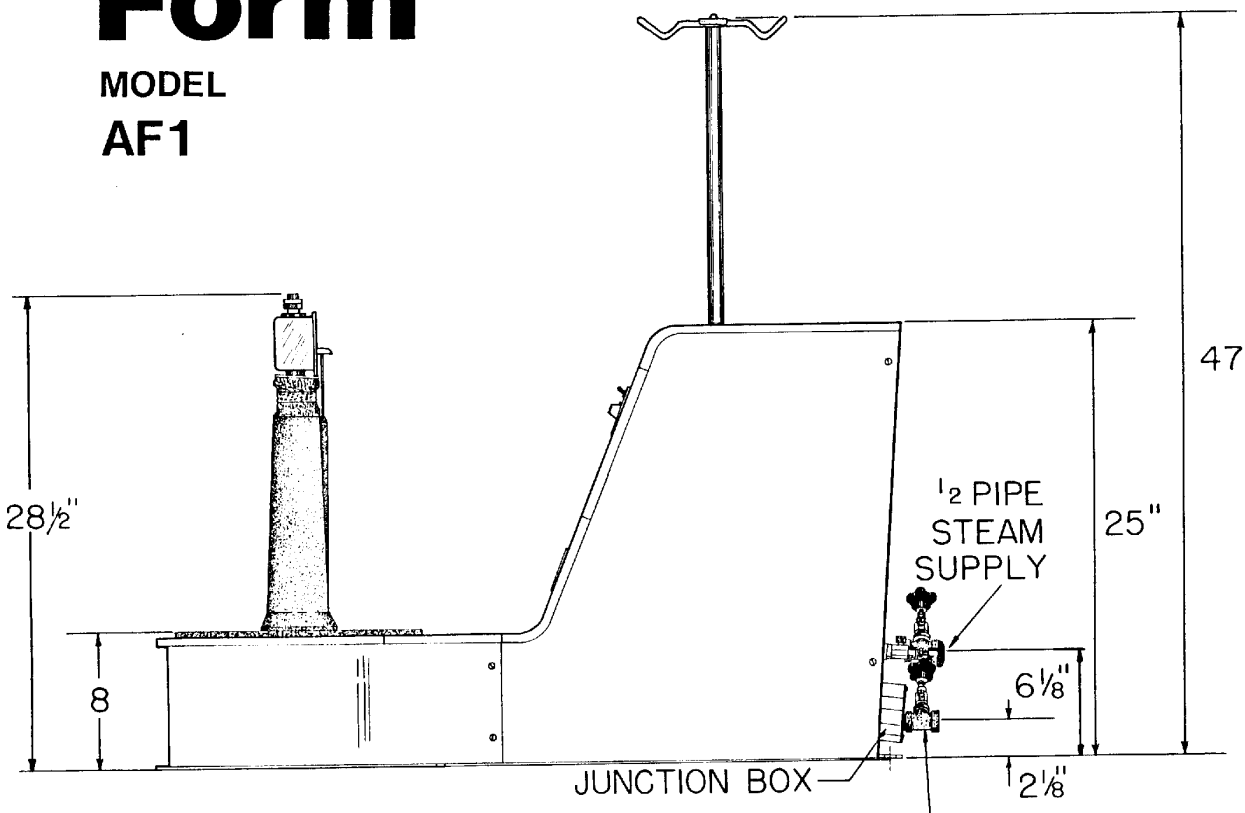
No defective equipment or part may be returned to Cissell for repair or replacement without prior written authorization from Cissell. Charges for unauthorized repairs will not be accepted or paid by Cissell.

CISSELL MAKES NO OTHER EXPRESS OR IMPLIED WARRANTY, STATUTORY OR OTHERWISE, CONCERNING THE EQUIPMENT OR PARTS INCLUDING, WITHOUT LIMITATION, A WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE, OR A WARRANTY OF MERCHANTABILITY. THE WARRANTIES GIVEN ABOVE ARE EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED. CISSELL NEITHER ASSUMES, NOR AUTHORIZES ANY PERSON TO ASSUME FOR IT, ANY OTHER WARRANTY OR LIABILITY IN CONNECTION WITH THE MANUFACTURE, USE OR SALE OF ITS EQUIPMENT OR PARTS.

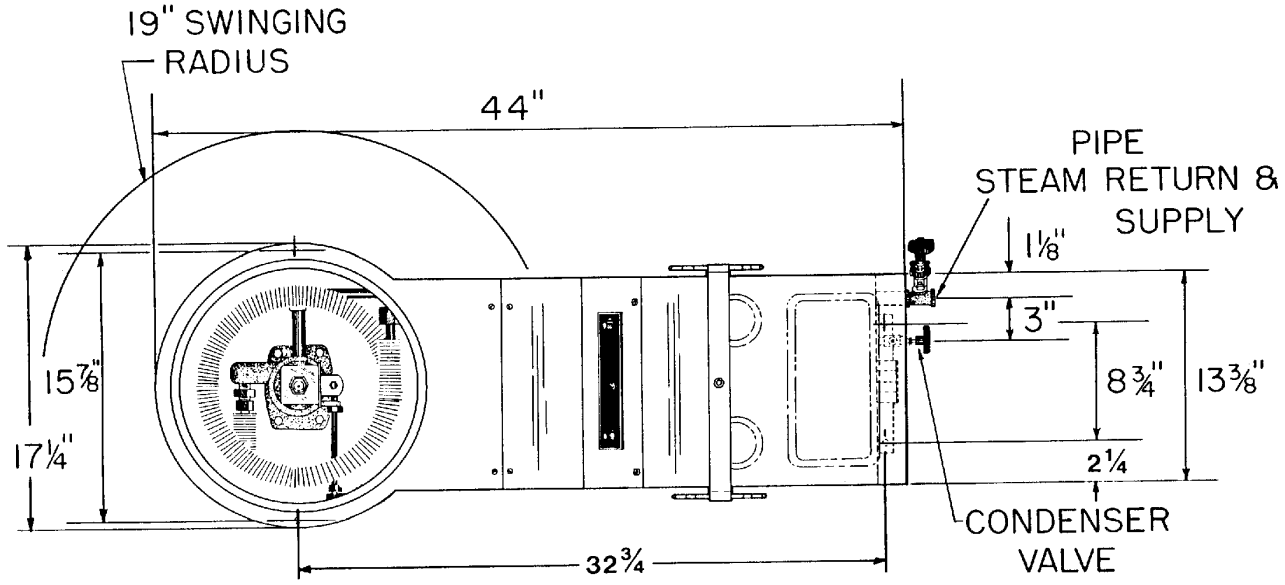
For warranty service, contact the Distributor from whom the Cissell equipment or part was purchased. If the Distributor cannot be reached, contact Cissell.

Aire Form

MODEL
AF1



SIDE VIEW



TOP VIEW

INSTALLATION

Refer to illustration sheet

(1) UNCRATE MACHINE. Check the nameplate voltage and current, making sure it is the same as the supply voltage and current.

(2) SET MACHINE IN POSITION.

(3) REMOVE THE REVOLVING FORM by holding the turning knob and the opposite weight "bucket" and lifting approximately 22".

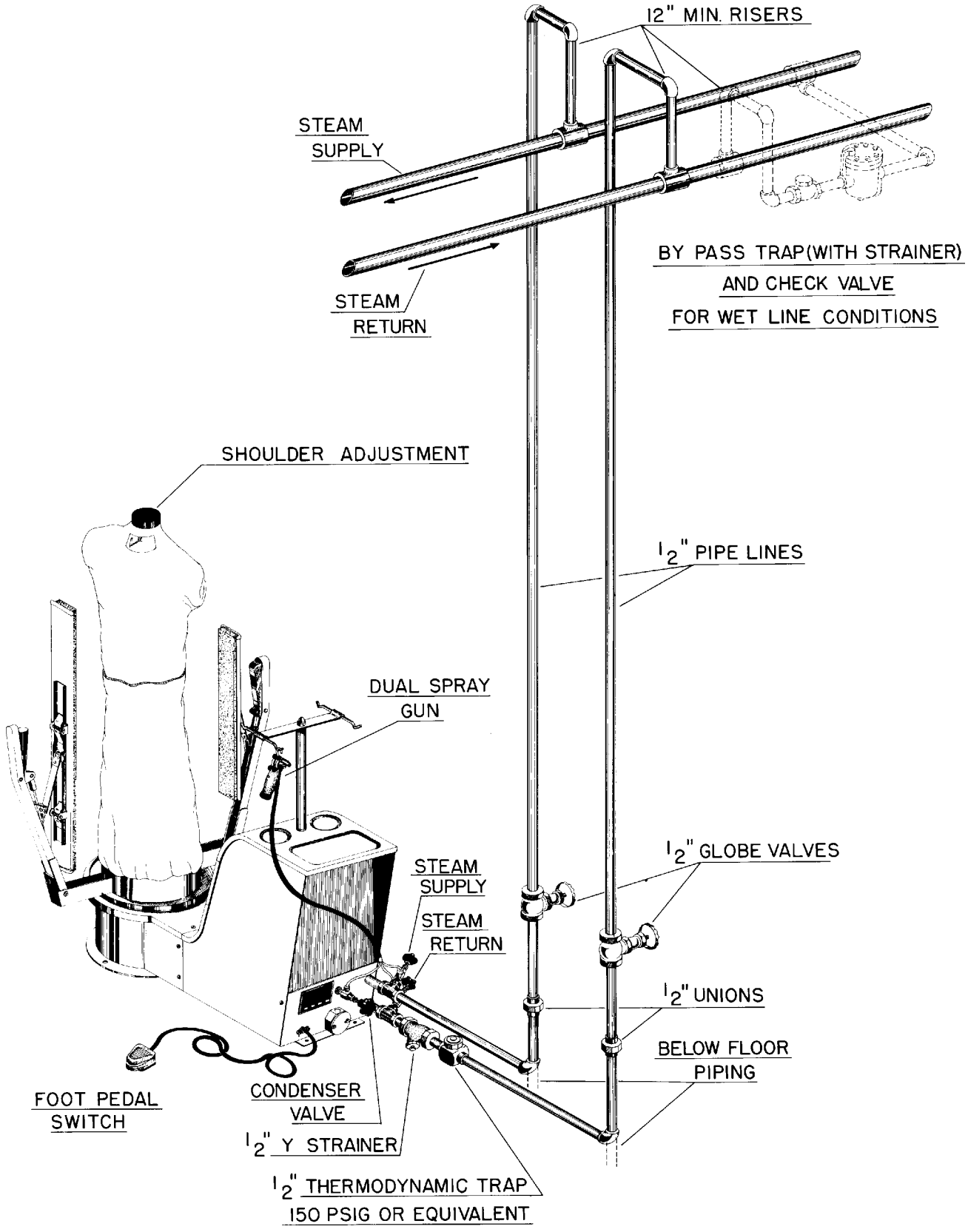
(4) CONNECT STEAM SUPPLY LINE as shown on next page.

(5) CONNECT RETURN LINE as shown on next page.

NOTE: Before final return line connection is made, open the steam supply valve and blow all foreign matter out of the steam lines and chamber. Failure to do so will cause trap to leak.

(6) MAKE ELECTRICAL CONNECTIONS in 3" junction box on rear of the machine, according to applicable electric codes. Connections should include a fused disconnect switch or circuit breaker with "slo-blow" characteristics and be capable of carrying 15 amps 115 volts or 8 amps 230 volts.

(7) TURN ON ELECTRICAL POWER AND TEST THE MACHINE.
Replace the revolving assembly, remove the plastic protective bag, and open the return and steam lines.


12" MIN. RISERS
STEAM SUPPLY
STEAM RETURN
BY PASS TRAP(WITH STRAINER) AND CHECK VALVE FOR WET LINE CONDITIONS
SHOULDER ADJUSTMENT
1/2" PIPE LINES
DUAL SPRAY GUN
1/2" GLOBE VALVES
STEAM SUPPLY
STEAM RETURN
1/2" UNIONS
BELOW FLOOR PIPING
FOOT PEDAL SWITCH
CONDENSER VALVE
1/2" Y STRAINER
1/2" THERMODYNAMIC TRAP 150 PSIG OR EQUIVALENT

AIRE FORM OPERATING INSTRUCTIONS

On the front panel of unit, set timers for required cycle. (Preferred is 5 seconds steam; 10 seconds air).

NOTE: A toggle switch on the control panel may be set to give steam followed by air (AUTO). Set timers switches as described above. Or you may give air only (ON). Most fabrics will finish better with the Auto cycle.

Where possible, perform all touch-up of sleeves, collars, trim, etc., prior to finishing on the Aire Form. In this way, differences in sheen will be eliminated from the garment.

OPERATION INSTRUCTIONS FOR "AIRE" FORM FINISHER

(Machine can be operated from either side)

1. Place overbag on the form.

2. Position garment on form and adjust shoulders. A knob on top of the form is used to adjust the form shoulder width. Turn knob clockwise to increase shoulder width.

3. Step on foot switch to activate the automatic cycle.

4. Remove garment from form.

GENERAL SUGGESTIONS:

To finish coats and other open front garments, use front paddle clamp to hold front of garment in place. Use the hand vent clamps to hold rear vent or pleat.

When additional moisture is needed for hard set wrinkles, use the water spray gun, spraying into the steam from a distance of approximately 15". Rotate the garment to the spray gun, using the turning knob on the revolving assembly.

Keep the nylon bag clean and in good repair. A vacuum cleanable air filter is provided to help keep the bag clean. Vacuum clean the filter weekly. Remove nylon bag (see detailed instructions) and wet clean as required. Repair holes or worn spots. To obtain proper characteristics of cloth porosity, bag size, and control strings, use only genuine Cissell replacement bags.

NET OVERBAG FOR CISSELL STEAM-AIR FINISHER

This overbag is for use ONLY when finishing sweaters or other soft garments that do not require bag contact for proper finishing.

DO NOT use overbag with hard fabrics or heavy garments. Hard set wrinkles will not be removed when using the overbag.

The Cissell overbag holds the form to a narrow size, thereby spreading steam and gentle diffused air throughout the garment to eliminate distortion.

THE NET OVERBAG IS EASY TO USE

1. Place the net bag over the form so that it fully covers the standard nylon bag.

2. Place the garment on the form and operate the machine per standard instructions, using “large size” setting for faster drying.

In general, garments including bonded knits and wool dresses can be finished without the overbag.

When ordering additional net overbags, specify F816.

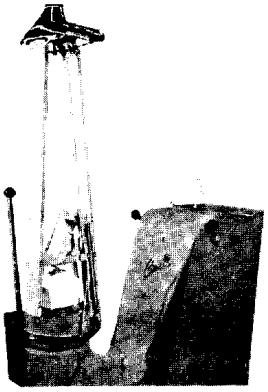
TO REMOVE BAG

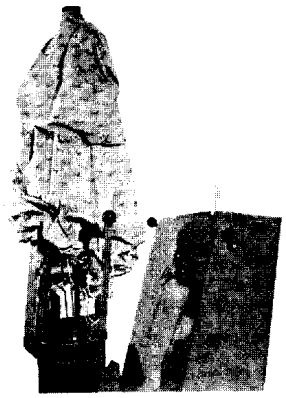
(1) Remove yellow weights, 1 each side.

(2) Raise the lower control ring (inside bag).

(3) Open zipper and untie bottom string.

(4) Lift bag off over revolving assembly shoulder form.





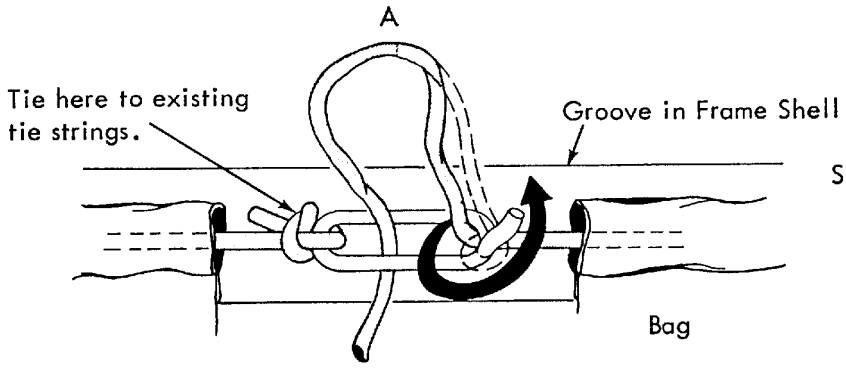
TO REPLACE BAG

(4) Replace yellow weights, one each side, on end of control strings.

(3) Lower the control ring inside bag.

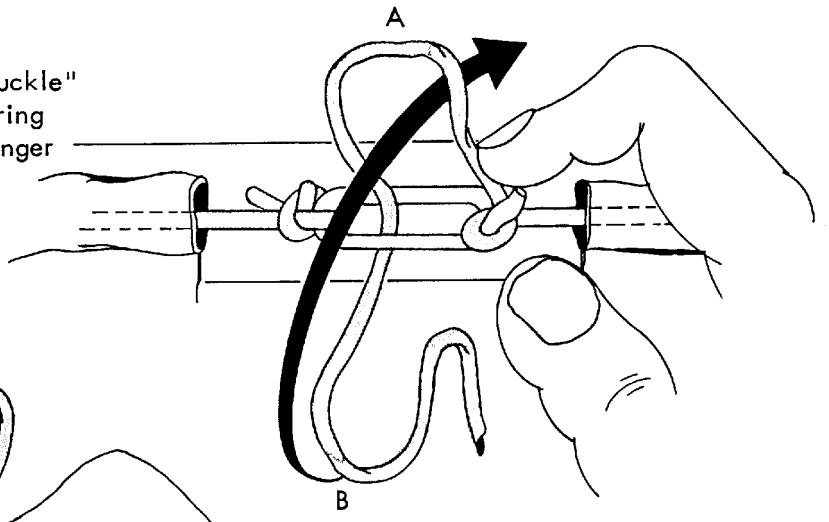
(2) Tie bottom string in groove and close zipper. Refer to instructions on next page for proper knot when tying string. Straighten bag until control strings are at the sides.

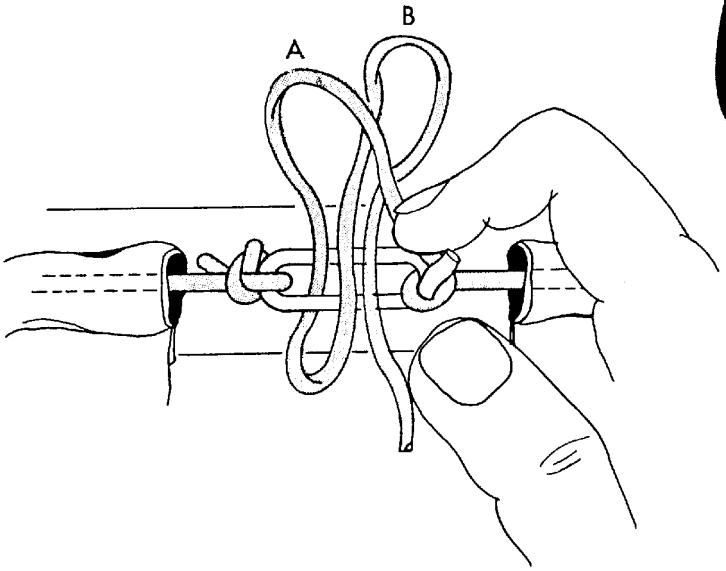
(1) Place bag over revolving assembly shoulder form, with front of bag toward front of form.



STEP 1 Work tie string into the groove, loop through the "buckle" as shown and pull string tight into groove.

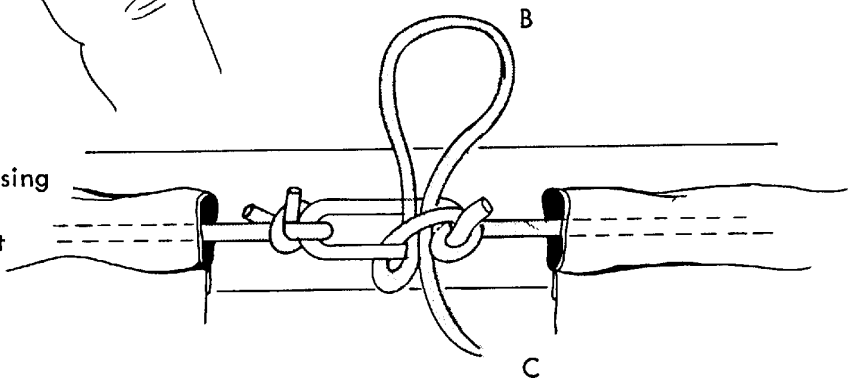
STEP 2 Loop tie string around "buckle" horn and grip horn and string between thumb and forefinger as shown above. This will prevent slipping and steady the buckle for the next operation.





STEP 3 Loop additional tie string B through existing loop A, still holding the buckle.

STEP 4 Pull on loop B and tighten the knot on the buckle. Using look B and string C tie an overhand knot to keep knot from slipping.



CISSELL FORM FINISHER

INSTRUCTIONS FOR ADJUSTING HEIGHT OR REVOLVING FORM

Should the revolving form "drag" on the Form Finisher base rather than turn freely, the form must be raised.

Conversely, if the revolving form rides too high above the Form Finisher base, permitting steam to escape from the space between the form and base, the form must be lowered.

WHEN AN ADJUSTMENT MUST BE MADE, REMOVE REVOLVING FORM BY SIMPLY LIFTING IT SRAIGHT UP OFF THE FORM FINISHER BASE

PROBLEM: Revolving Form "drags" on base of Form Finisher

TO CORRECT: Loosen F-286 Bearing Lock Nut. Turn F-287 Bearing Adjustment Screw COUNTER-CLOCKWISE.

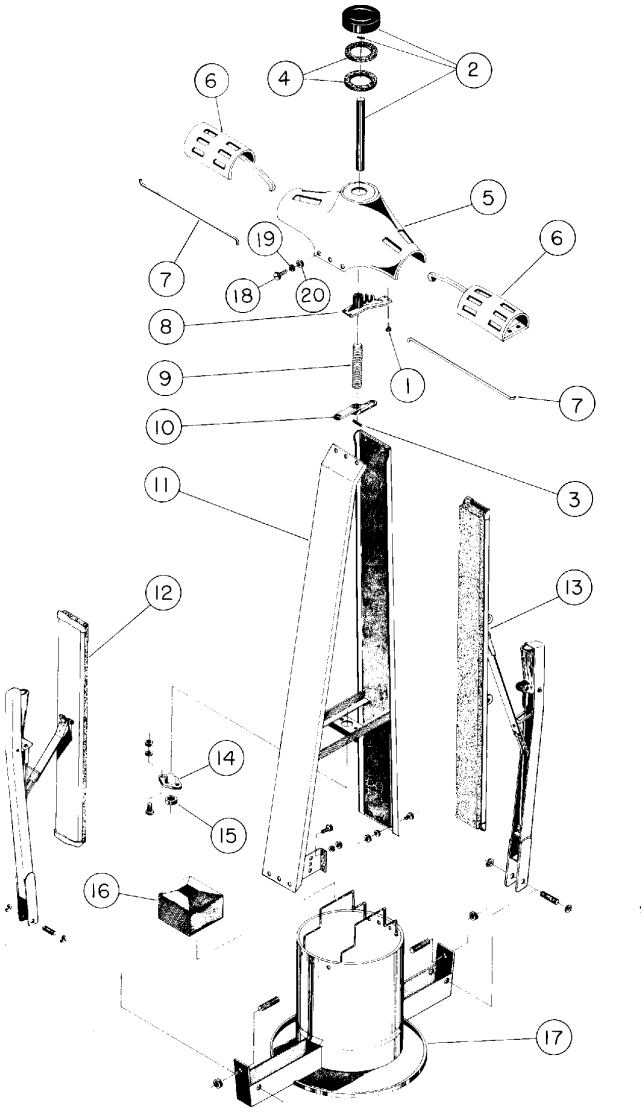
CHECK ADJUSTMENT: Replace revolving form on Form Finisher base. Rotate form. If perfectly adjusted, form will rotate freely and snugly on felt seal around top of base. If form is still too low...or too high...repeat adjustment until it is correct.

PROBLEM: Revolving Form rides too high above Form Finisher base.

TO CORRECT: Loosen F-286 Bearing Lock Nut. Turn F-287 Bearing Adjustment Screw CLOCKWISE.

CHECK ADJUSTMENT: Replace revolving form on Form Finisher base. Rotate form. If perfectly adjusted, form will rotate freely and snugly on felt seal around top of base. If form is still too high...or too low...repeat adjustment until it is correct.

F517 - Adjustable Shoulder Assembly
Consists of 1-10, 18, 19, 20.



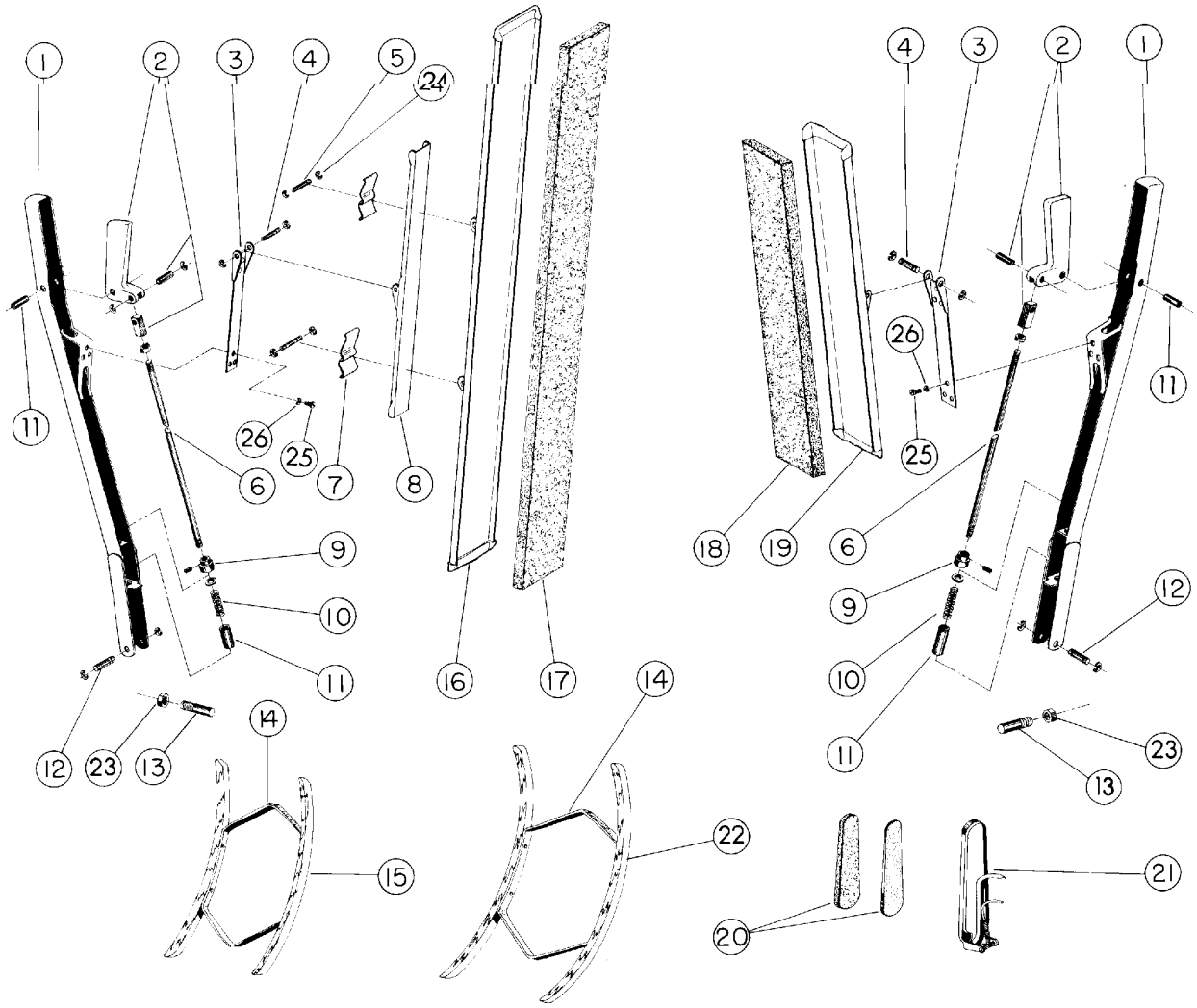
AIR FORM REVOLVING FORM

AF115 - Revolving Form w/Front & Rear Clamps
AF181 - Revolving Form w/o Clamps

Ref. No.	Part No.	Description
1	TU3478	#8 x 1/2" Screw
2	F381	Shoulder Adjustment Rod, Knob, & Pin
3	F49	Shoulder Lever Pin
4	F192	Insulating Gskt. (2 required)
5	F492	Neck Form w/4 Bolts, Nuts & Washers
6	F493	Shoulder Extension
7	F336	Shoulder Connecting Link
8	F494	Bearing Plate w/Scrs.
9	F197	Shldr. Tension Sprg.
10	F317	Shoulder Lever
11	AF113	Frame Assm. w/Hdwe.
12	AF121WH	*Rear Paddle Clmp. Asm.
13	AF176WH	*Front Paddle Clmp. Asm.
14	F1060	Bearing Assy.
16	AF207	Collar
17	AF153	Form Assembly
18	TU3477	#10 - 24 x 1/2 Screw
19	FB187	#10 Lockwasher (pkg. 6)
20	FB185	#10 Nut (pkg. 6)
	AF114	Replacement Bag (not shown)

*See Separate Page for Exploded View

Painted parts furnished in white unless otherwise specified



FRONT PADDLE CLAMP ASSEMBLY - AF176
REAR PADDLE CLAMP ASSEMBLY - AF121

Ref. No.	Part No.	Description	Ref. No.	Part No.	Description
1	FG135	Handle Weldment	13	FG277	Stud
2	AF157	Trigger Release w/Rodhinge, Pin, "E" Rings	14	F63	Springs w/Hardware (Set of 2)
			15	F11	No. 11 Sleevers (Set of 2)
3	F218	Clamp Leaf Spring w/Hardware	16	F432	Front Paddle Channel
4	F267	Pivot Pin w/"E" Rings	17	F433	Sponge for Front Paddle
5	F240	Clamp Slide Supp. Pin	18	AF165	Sponge for Rear Paddle
6	FG443	Clamp Latch Rod	19	AF168	Rear Paddle Channel
	FG450	Latch Pin	20	F904	Sponge Pad (Set 6/F842)
7	F243	Slide Spring Clip	21	F842	Vent Clamp
8	F237	Clamp Slide	22	F24	No. 24 Sleevers
9	F215	Set Collar	23	TU4787	Hex Nut
10	F197	Spring	24	F888	"E" Rings
11	F949	Pin	25	F901	#10-24 x 3/8 Screw
12	FG288	Pin	26	FB187	#10 Lockwasher
	F489	"E" Rings			

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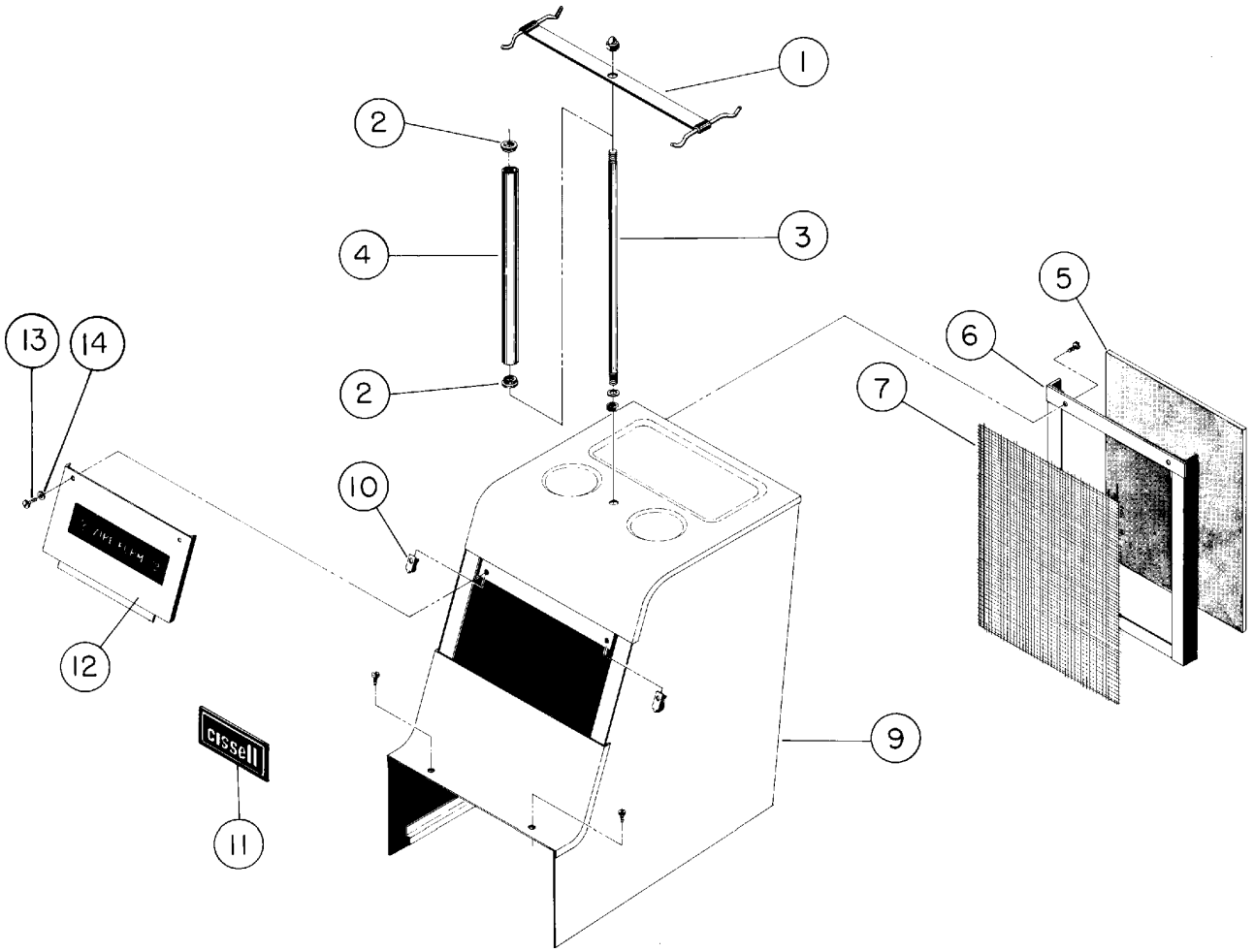

AIRE FORM JACKET

Ref. No.	Part No.	Description
1	AF120	Gun Support Bracket
2	AF117	Locating Plug
3	PU47	Shaft
4	AF152	Tube Cover
5	AF102	Removable Air Filter
6	AF104	Frame Weldment
7	AF103	Filter Screen
9	AF144	Jacket Weldment
10	FG344	Speed Nut
11	TU8013	Cissell Nameplate
12	AF161	Control Panel Assembly (See Separate Page)
13	FG343	Screw w/Wear Washer
14	FG345	Retaining Washer

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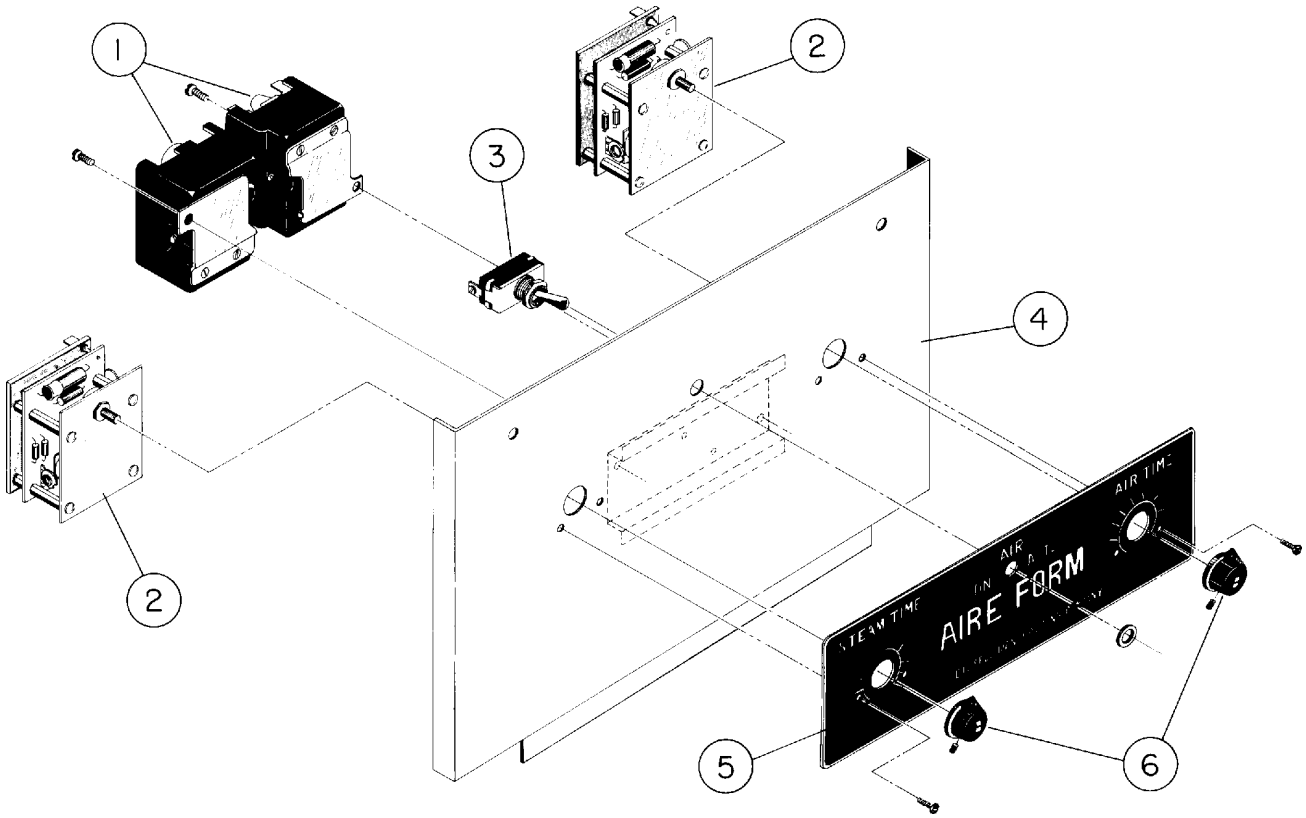
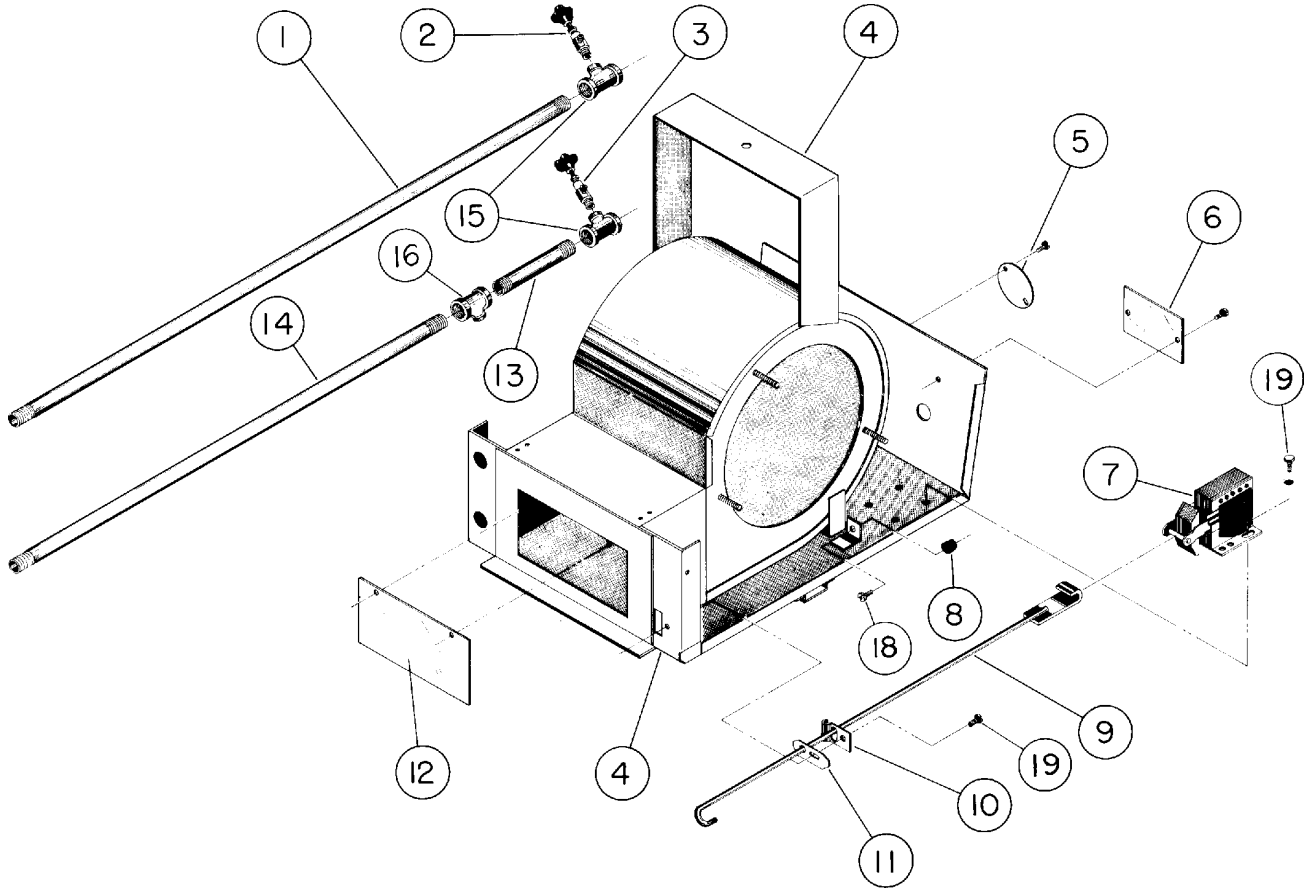


CONTROL PANEL - AF161

Ref. No.	Part No.	Description
1	FG235	Relay - 115V/50-60 Hz.
	FG234	Relay - 230V/50-60 Hz.
2	FG453	Timer - 115-230V
3	AF185	Toggle Switch
4	AF162	Panel
5	AF100	Nameplate
6	PT118	Timer Knob
7	C196	Set Screw
8	LB291	#6-32 x 3/8 Rd. Hd. Screw
	AF203	Wiring Harness (not shown)
	AF216	Resistor, 200VL w/Piggy Back End & Black Insulation
	AF217	Resistor, 500VL w/Piggy Back End & Black Insulation



AIR FORM REAR BASE

Ref. No.	Part No.	Description	Ref. No.	Part No.	Description
1	FG274	1/2” Pipe 30” Long	10	F520	Seal Spring
2	SGV13	Supply Valve	11	F519	Nylon Seal
3	SGV40	Return Valve	12	AF128	Damper
4	AF124	Rear Base Weldment	13	OP296	1/2” Pipe 5” Long
5	SB170	Junction Box Cover	14	FG273	1/2” Pipe 28 - 1/2” Long
6	PIU94	Nameplate	15	OP306	Tee - 1/2” x 1/2” x 3/8”
7	F739	Solenoid - 115V	16	FG143	Tee - 1/2” x 1/2” x 1/4”
	F738	Solenoid - 230V	17	M155	Strain Relief
8	TU3549	Rubber Bumper	18	RC385	Round Head Screw
9	FG175	Rod Extension	19	M263	Sheet Metal Screw

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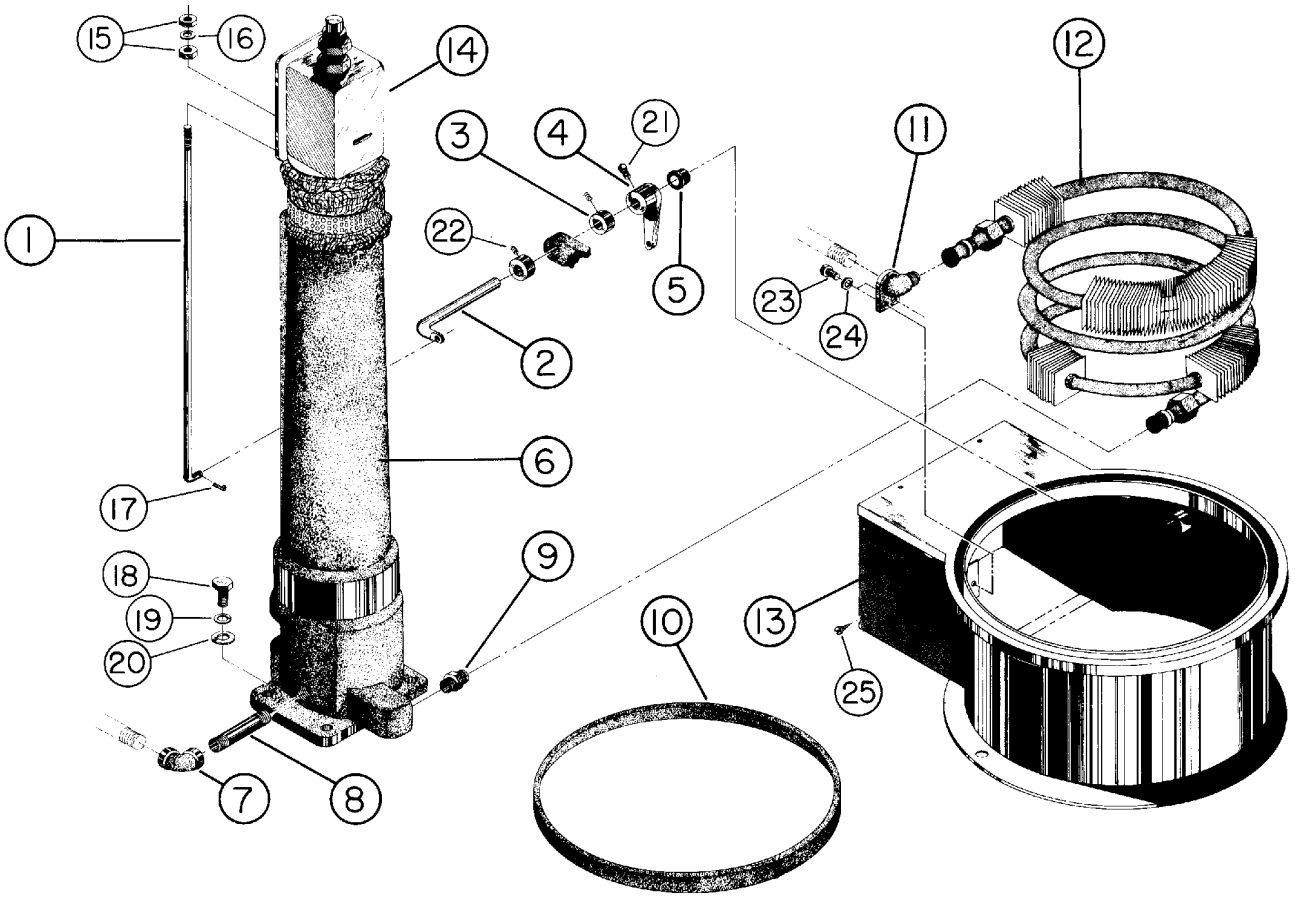
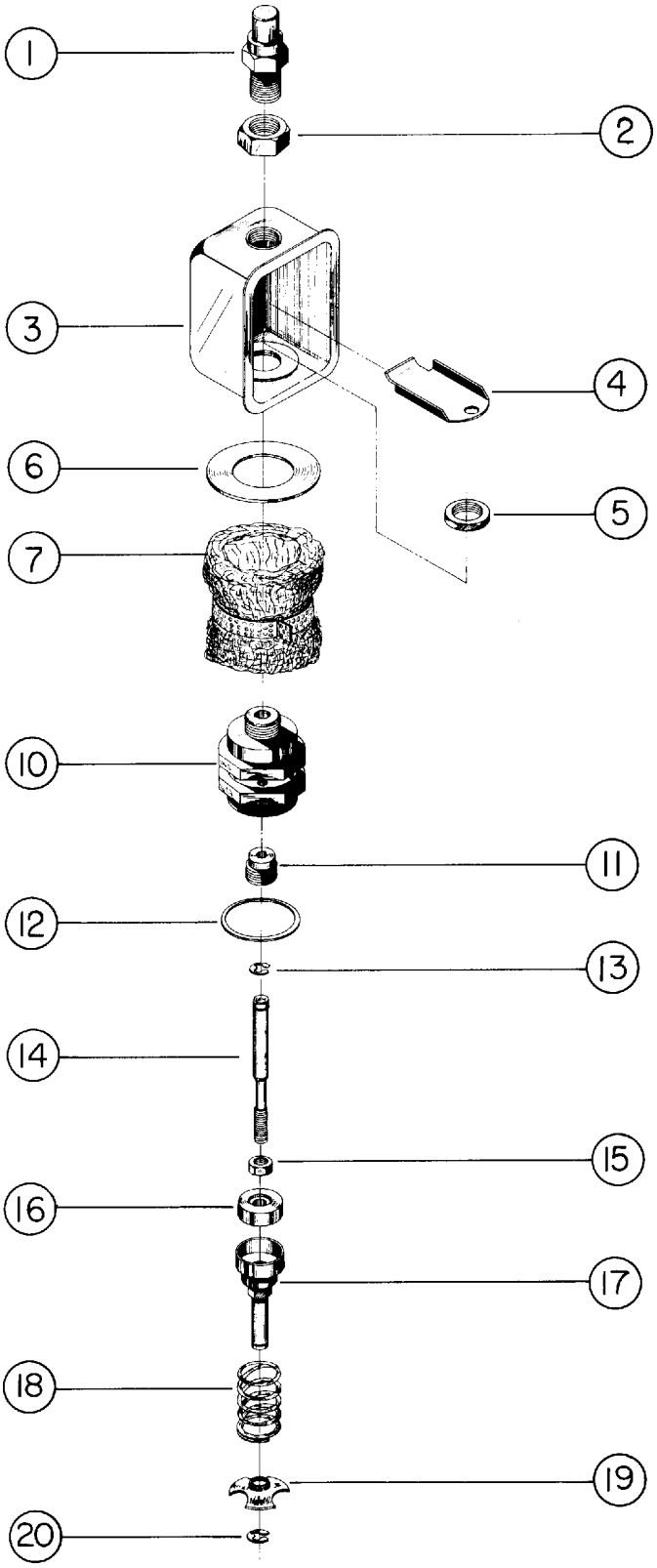
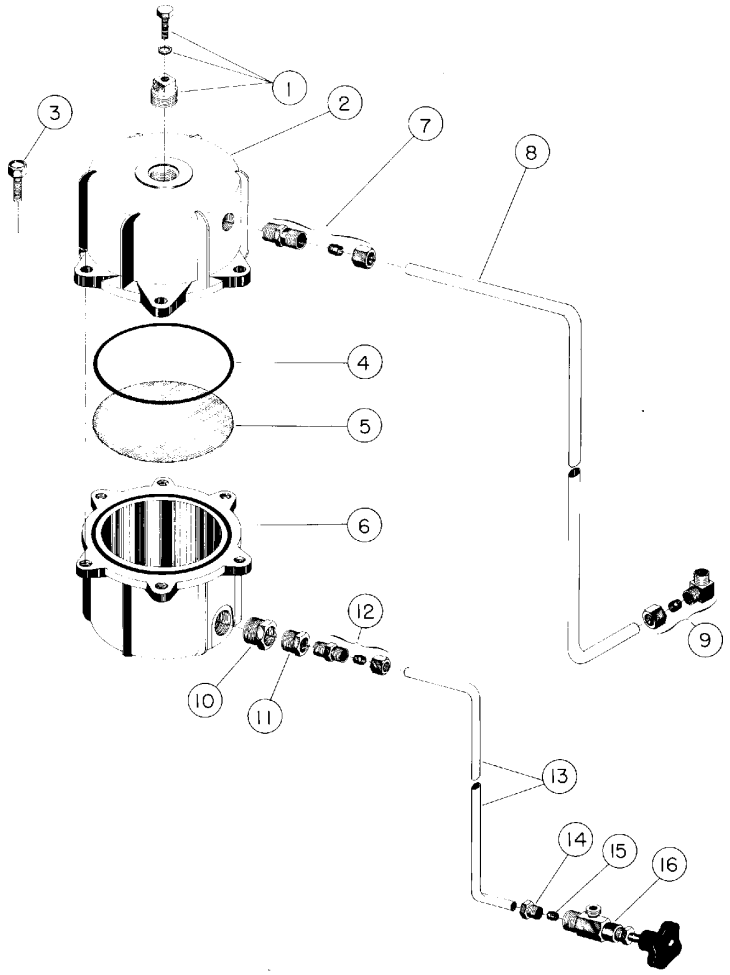


Ref. No.	Part No.	Description
1	F149	Steam Valve Pull Rod
2	FG320	Extension Bar
3	F215	Set Collar, 2 req'd
4	FG275	Steam Valve Lever Ass'y
5	TU49	Delrin Bearing (Pkg. 2)
6	F539	Stm. Chamber
7	TU4593	1/2" x 90º Pipe Elbow
8	LB20	1/2" Pipe Nipple 3" Long
9	FG319	Stm. Coil Adapter
10	F357	Felt Air Seal
11	FG321	Steam Manifold
12	FG322	Steam Coil
13	FG323	Shallow Base Welded Ass'y

Ref. No.	Part No.	Description
14	------	See Separate Parts Sheet
15	F122	1/4" - 28 Brass Nut
16	RC349	1/4" Lockwasher
17	V02	1/16" x 1/2" Cotter Pin
18	IB139	3/8" x 1-1/4" Hex. Hd. Scw.
19	VSB134	3/8" Split Lockwasher
20	IB140	3/8" Flat Washer
21	F819	5/16" - 18-5/8" Sq. Hd. Set Scw.
22	P126	1/4" - 20 x 1/4" Set Scw.
23	TU3210	5/16" - 18 x 5/8" Hex. Scw.
24	TU2814	5/16" Split Lockwasher
25	TU2793	#8 x 5/8" S.M.S.



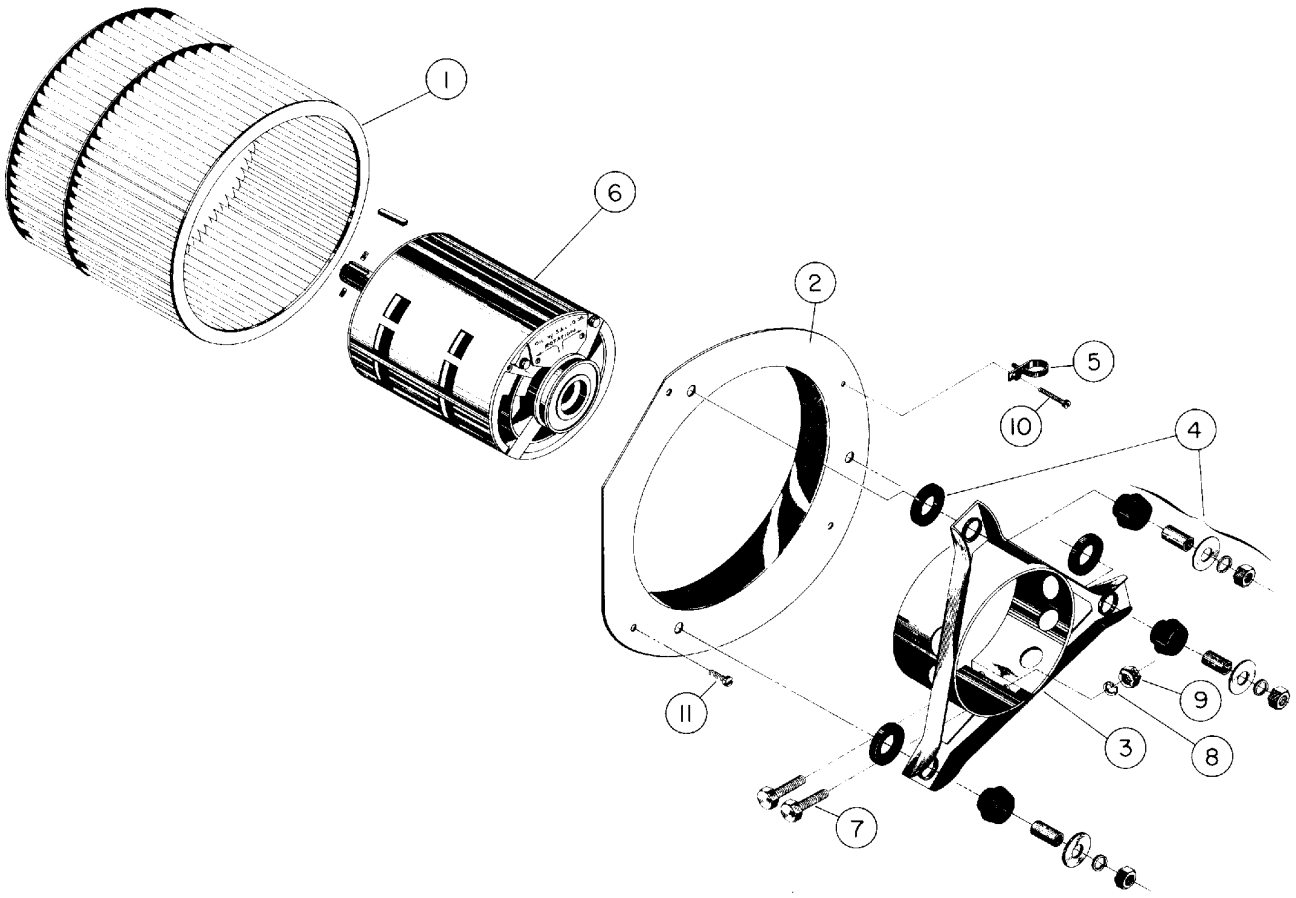
Ref. No.	Part No.	Description
1	F287	Bearing Adjustment Scr.
2	F286	Bearing Locknut
3	F285	Bearing Support Box
4	FV101	Valve Lever
5	OP547	Locknut
6	FV106	Collar Retainer
7	F18	Steam Spreader
	FV110	Valve Ass'y CONSISTS OF REF. NO. 10-20
10	FV100	Valve Body
11*	V36	Valve Seat
12*	P103	Gasket
13	F359	"E" Ring
14*	FV103	Valve Stem
15*	V15	Small Locknut
16*	V16	Teflon Disc
17	FV104	Valve Disc Holder
18*	V330	30 Lb. Spring
19	FV105	Spring Retainer
20*	F358	"E" Ring
	*K451	Repair Kit for FV110 Valve



CONDENSER PARTS

SGC9 - Condenser Only (Consists of Ref. Nos. 2, 3, 4, 5, 6)

Ref. No.	Part No.	Description
1	F578	Plug
2	SGC6	Upper Section
3	SG116	Taptite Bolts
4	SG77	“O” Ring
5	SG79	Strainer
6	SGC8	Lower Section
7	OP225	Straight Connector
8	FG340	Copper Tube - 24”
9	FG159	Elbow
10	OP305	Bushing 3/8 x 1/4
11	BR61	Bushing 1/4 x 1/8
12	SB88	Straight Connector
13	AF142	Tube - 16”
14	V63	Small Pack Nut
15	PU8	Bead
16	SGV12	Valve

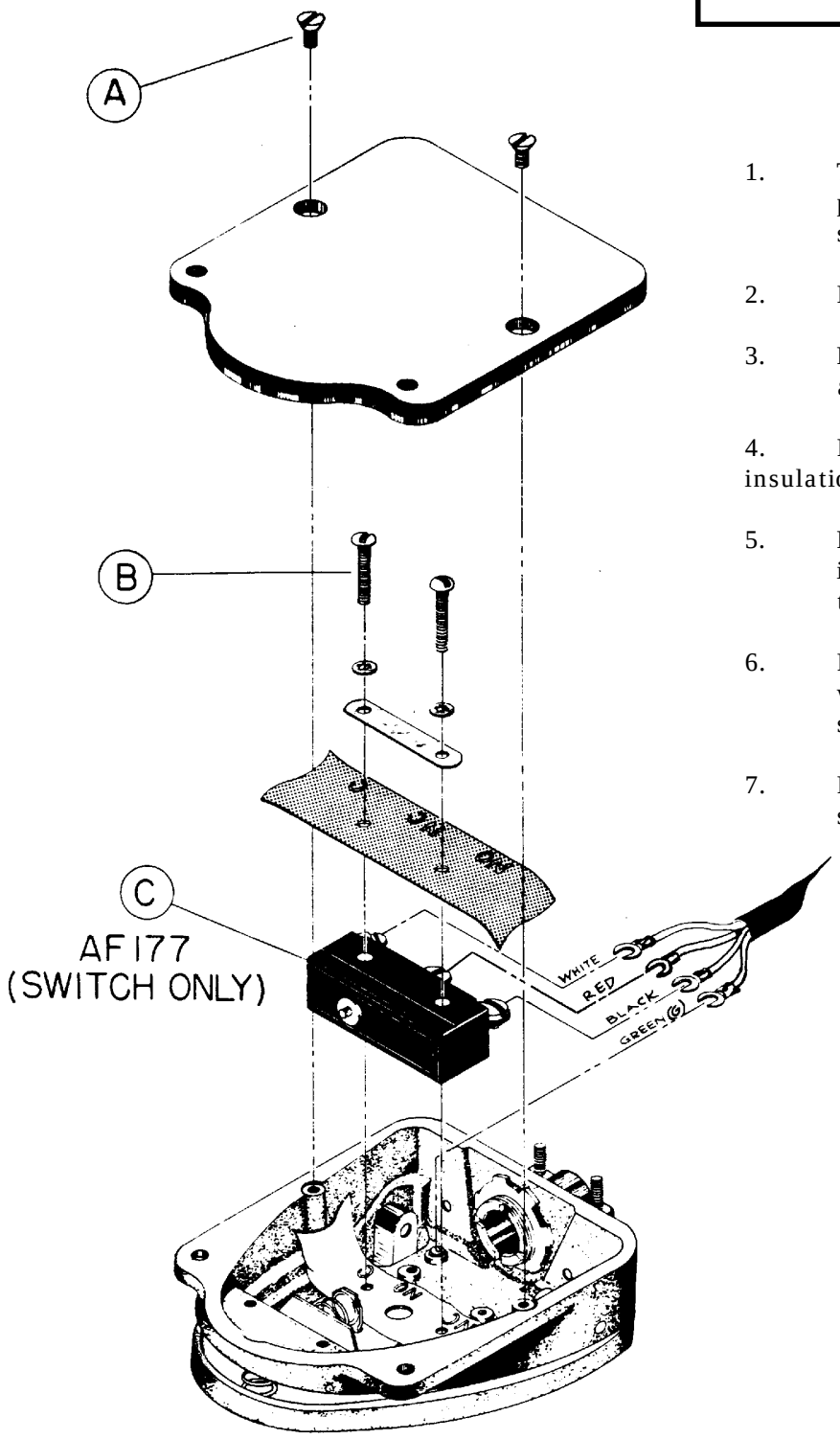


BLOWER & MOTOR MOUNT

Ref. No.	Part No.	Description
1	FG292	Blower Wheel
2	FG226	Inlet Cone
3	AF131	Motor Bracket w/Hardware (7, 8, 9)
4	AF130	Mounting Hardware (3 sets/pkg.)
5	FG148	Harness Clamp
6	MTR88	Motor - 110-120/220-240/50/60/1
7	FB124	Cap Screw
8	TU2814	Split Lockwasher
9	C249	Hex Nut
10	TU2793	Sheet Metal Screw
11	M263	Sheet Metal Screw

Consult factory for other voltages

FOOT PEDAL SWITCH ASSEMBLY - PT527



INSTALLATION INSTRUCTION FOR AF 177 SWITCH

1. Turn switch to upside down position and remove two (2) screws marked (A) as illustrated.

2. Lift off base plate pad.

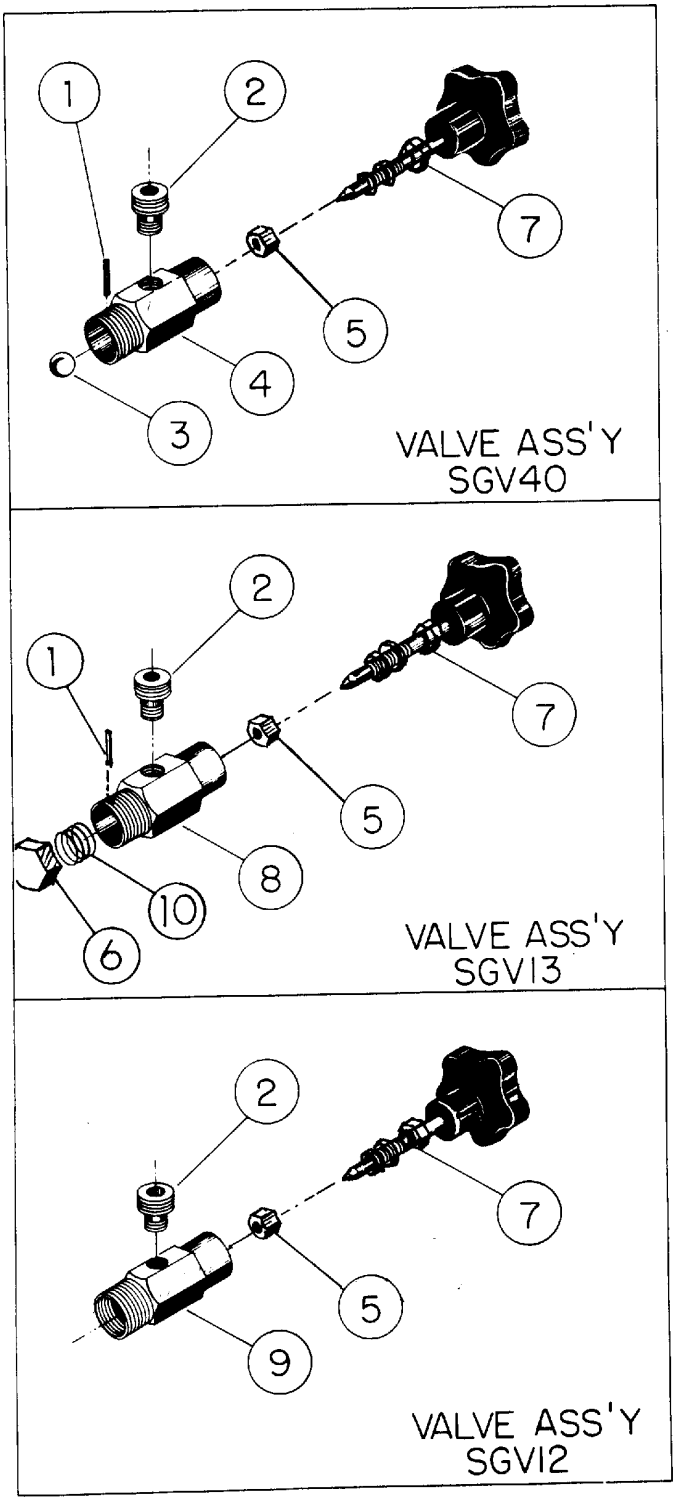
3. Remove two (2) screws marked (B) as shown.

4. Remove two (2) washers, plate, insulation and switch.

5. Remove wires from old switch and install wires on new switch and tighten securely.

6. Reinstall switch, insulation, plate, washers and screws and tighten securely.

7. Reinstall base-plate-pad and screws and tighten securely.

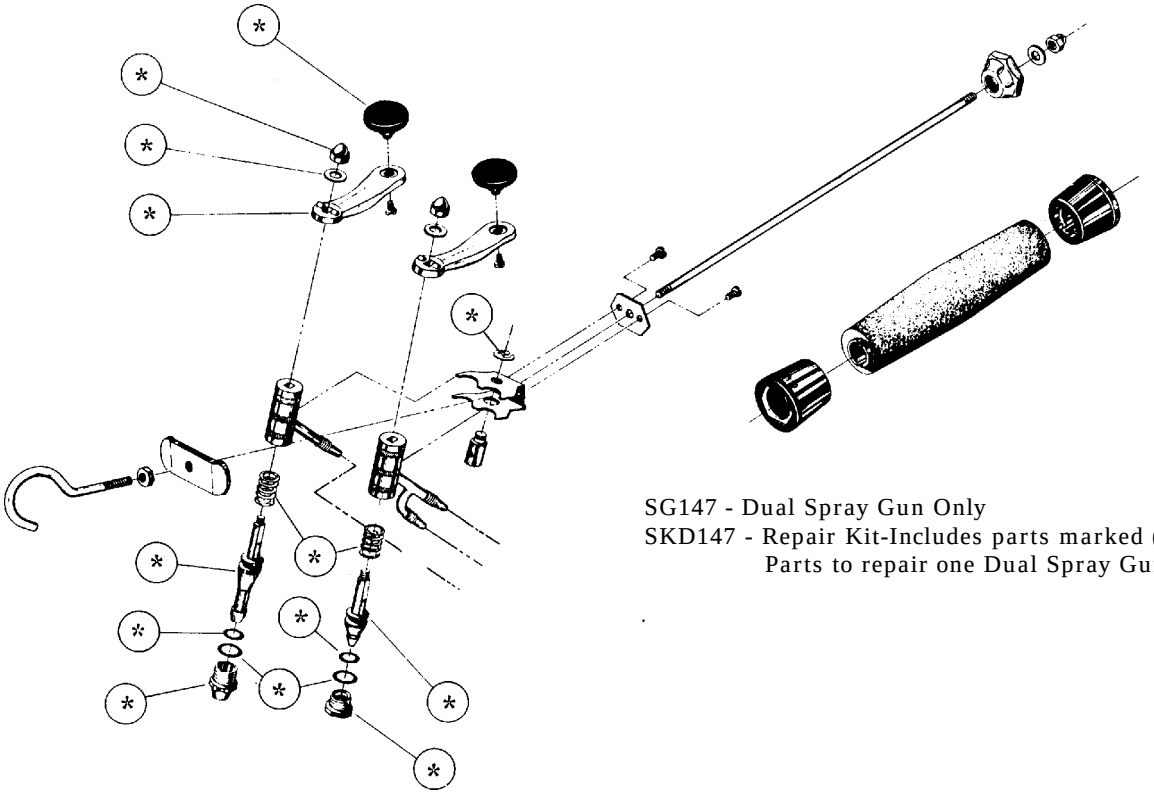


SPRAY GUN VALVE PARTS

Ref. No.	Part No.	Description
1	SGV38	Valve Pin
2	SGV41	Hose Adapter
3	SGV37	Teflon Ball
4	SGV56	Valve Body
5	V30	Small Pack Ring
6	SGV46	Piston
7	V73	Control Knob Asy.
8	SGV56	Valve Body
9	SGV57	Valve Body
10	SGV47	Valve Spring

DUAL SPRAY GUN & HOSE ASSEMBLY

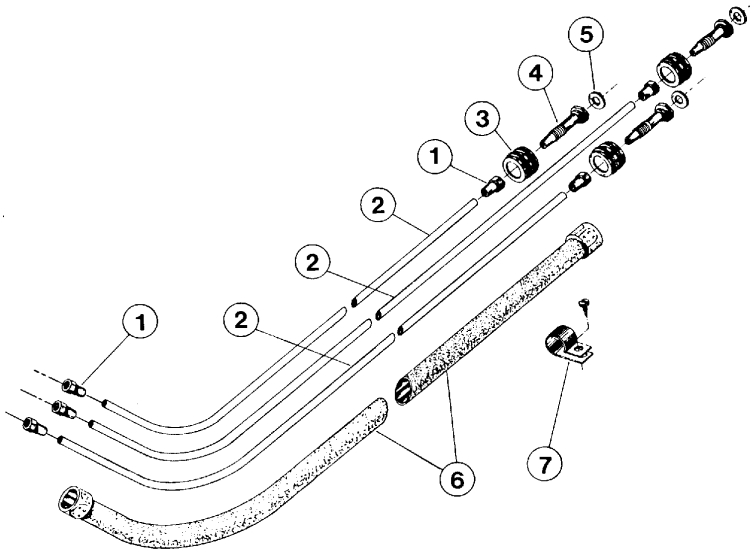
SG146 - Complete Gun & Hose Assembly



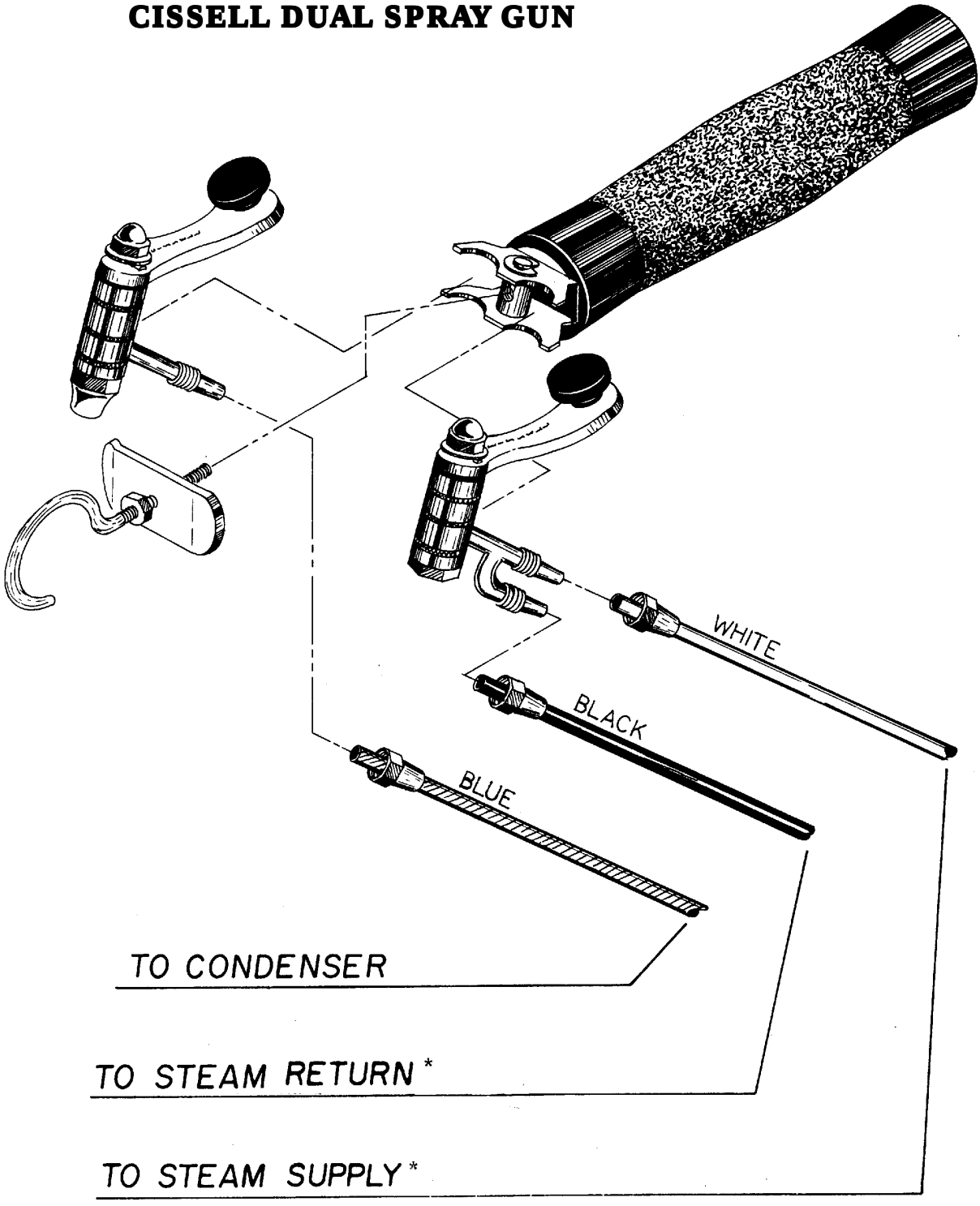
SG147 - Dual Spray Gun Only
SKD147 - Repair Kit-Includes parts marked (*).
Parts to repair one Dual Spray Gun.

SG148 - Hose Assembly Only

Ref. No.	Part No.	Description
1	SG122	Tube Adapter
2	SG136	Set of 3 Tubes (Black, White, & Blue)
	SG200	Blue Tube Only
	SG201	Black Tube Only
	SG202	White Tube Only
3	SG11	Tube Connection Nut
4	SG126	Tube Connector
5	SG25	Hose Gasket
6	SG137	Tube Cover Assembly
7	AF123	Hose Clamp (Not part of Assembly)



HOSE CONNECTIONS FOR CISSELL DUAL SPRAY GUN

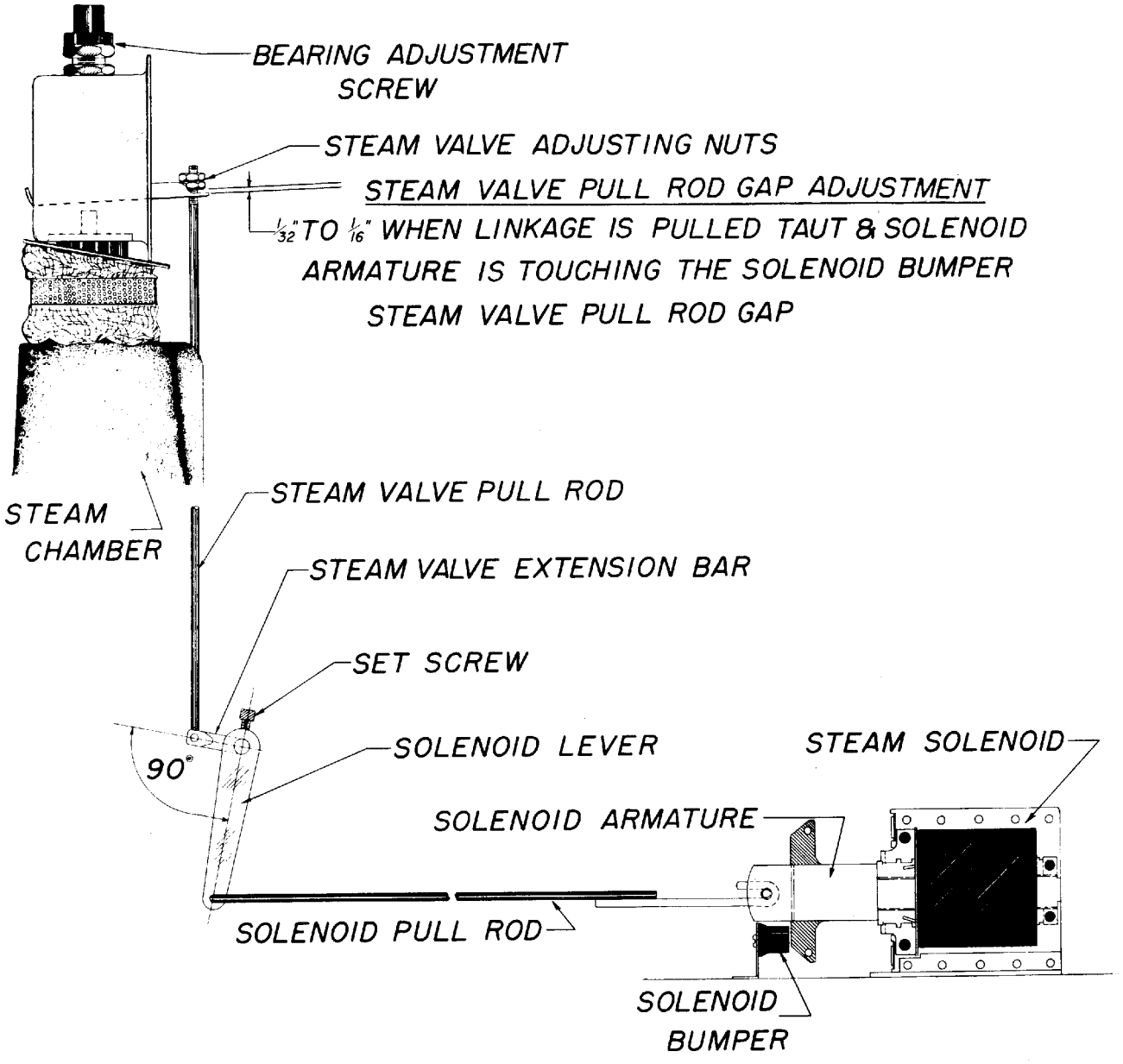


* NOTE: This connection works best in most installations. Should there be excessive condensate in the spray, reverse these two connections and use the configuration that has the best results.

TO ADJUST STEAM VALVE AND SOLENOID LINKAGE:

1. Set steam valve extension bar and solenoid lever at 90º as shown and tighten set screw.

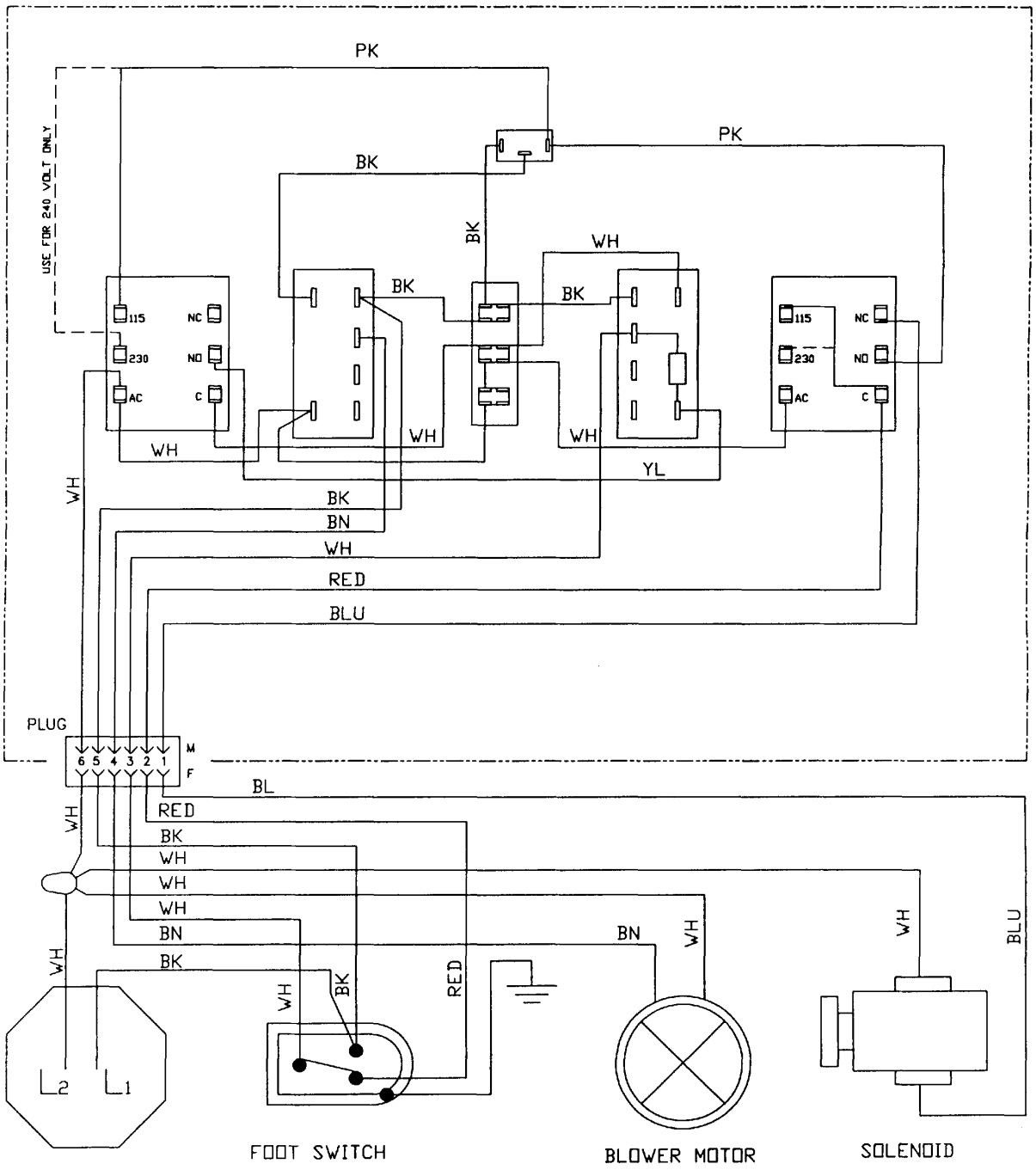
2. Adjust steam valve adjusting nuts until 1/32” to 1/16” gap is obtained as shown above and lock adjusting nuts tightly together.



Cissell
LOUISVILLE, KENTUCKY

WIRING DIAGRAM
AIRE FORM (MODEL AF-1)
120/240 VOLT, 50/60 HZ, 1 PH

FW148



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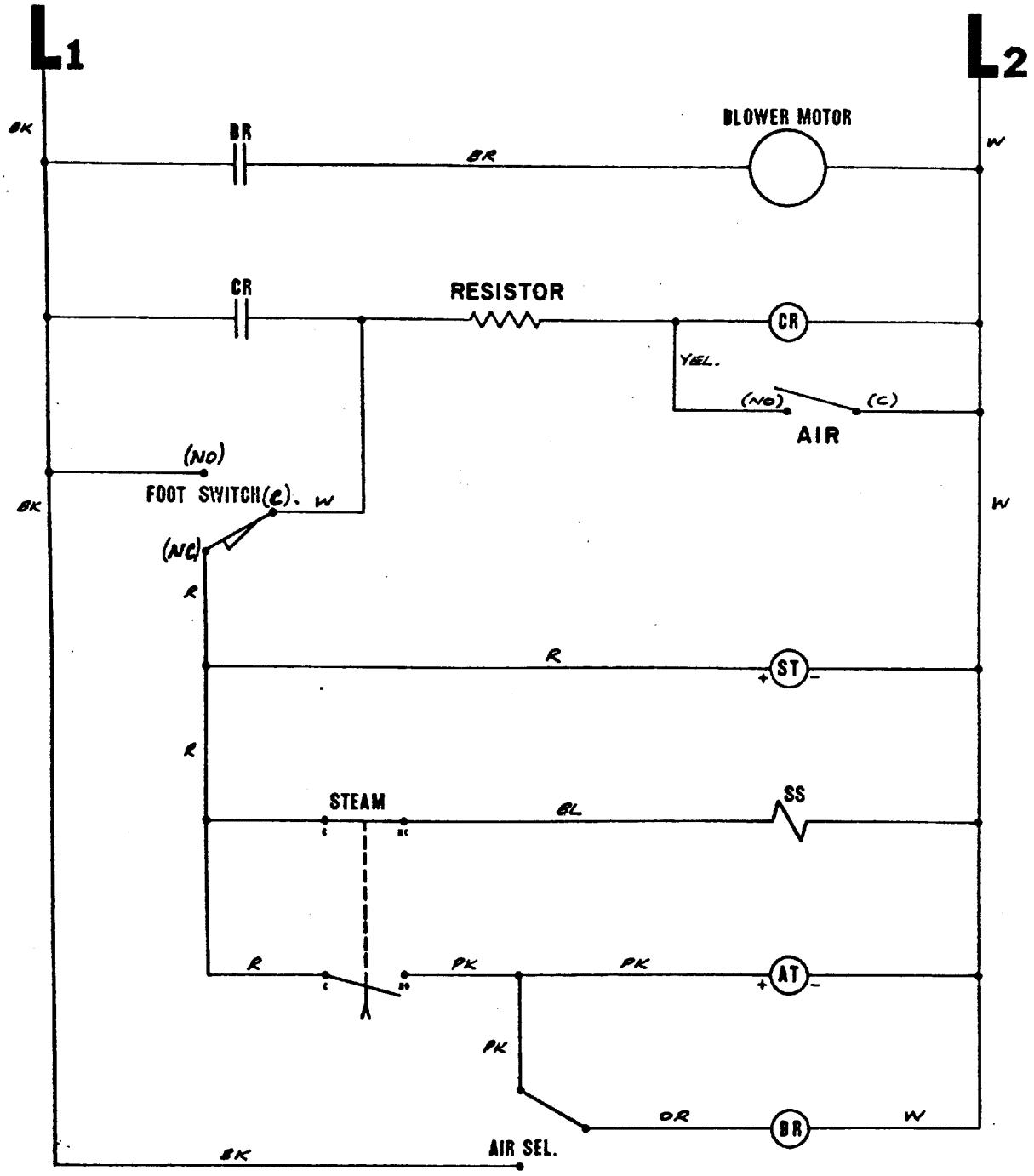
Cissell®

FW-143

AIRE FORM MODEL AF I

SCHEMATIC CONTROL DIAGRAM

I PHASE 50/60 CY. 240. OR LESS



	PROBLEM		CAUSE	REMEDY
(1)	No Steam	1A	Steam supply valve off.	Open valve in steam supply line.
		1B	Electric power “Off”	Inspect electric service for blown fuses & loose connections. Turn main disconnect “ON”.
(2)	Blower motor will start, steam won’t start	2A	Loose wires	Inspect and replace any loose wires.
		2B	Incorrect voltage of electrical parts	Inspect nameplate voltage and voltage on electrical parts, especially the solenoid. Replace switch if necessary.
		2C	Defective start switch	Check switch to see that it operates and will carry current. Replace switch if necessary.
		2D	Defective solenoid	Inspect solenoid. Replace if necessary.
		2E	Defective solenoid linkage	Check linkage between solenoid and steam valve for broken or loose parts. Repair or replace as required. (See adjustment instructions.)
(3)	Leaking steam valve	3A	Solenoid linkage adjusted incorrectly	Inspect linkage and adjust according to instructions. Tighten all lock nuts and set screws.
		3B	Loose valve seat	Inspect and tighten seat if required.
		3C	Worn valve	Inspect valve parts. Replace worn parts as required.
(4)	Wet steam	4A	Trap not operating	Check size and operation of trap. Repair or replace if required.
		4B	Trap installed incorrectly	Check to see that direction of flow in trap is correct and that trap is in or below machine return line.
		4C	Check valve installed wrong or sticking	Check to see that direction of flow is correct and valve not sticking.

	PROBLEM		CAUSE	REMEDY
(4)	Wet steam (Cont.)	4D	Strainer clogged	Inspect strainer and clean if necessary.
		4E	Return line turned off	Open valve in condensate return line.
		4F	Steam Cycle too long	Reduce amount of time set on steam timer.
		4G	Improperly installed steam lines	Check steam line installation to see that “risers” are installed, as shown on installation illustration.
		4H	Heavy condensate in supply line	Install a by-pass trap from supply header to by-pass condensate to return line.
		4I	Machine not individually trapped	Install a separate trap for each machine.
		4J	Back pressure in return line	Inspect all traps to see if one is stuck open, or improperly installed. Perform steps necessary to make return line drain by gravity to condensate return tank. See that return tank is adequately vented.
(5)	Water accumulates in base	5A	Steam too wet	See wet steam above.
		5B	Leak in finned tube or pipe fitting	Inspect machine and repair or replace any leaking parts.
		5C	Leaking steam valve	See leaking steam valve (3).
(6)	Excessive noise or vibration	6A	Foreign object in blower wheel	Inspect wheel and remove any foreign objects & lint.
		6B	Blower wheel out of balance	Inspect wheel for loose balance weights, out of round or damage, replace if necessary.
		6C	Motor bearings bad	Inspect motor to see if bearings are tight and motor free turning. Replace motor if necessary.
		6D	Motor mount bent	Inspect motor mount to see if machine has been dropped in transit, bending the mount, letting the blower wheel hit the housing. If so, inspect blower wheel for damage. Replace either or both if necessary.
		6E	Blower wheel loose on motor shaft	Check to see that wheel is mounted in center of housing, key is in keyway if used, and both set screws tight.
(7)	Blower motor won’t start, machine won’t steam	7A	No electrical power	Check electrical service and be sure main switch is “ON” all wires are tight and fuses are good.

	PROBLEM		CAUSE	REMEDY
(7)	Blower motor won't start, machine won't steam (Cont.)	7B	Incorrect supply voltage	Check power source. Voltage phase and frequency must be the same as specified on machine nameplate.
		7C	Air timer set at 0 time	Timer knob may slip on the shaft and leave the timer set at 0 time. Tighten knob set screw and set timer and knob to suit, approx. 20 seconds.
		7D	Defective blower relay	Check to see if the blower relay will operate. If not, replace relay.
		7E	Defective blower motor	Check motor to see if it will operate on normal nameplate electrical power. If not, replace the motor.
		7F	Loose wires	Check to see that all wires and connections are tight. If not, replace the wires and tighten connections.
(8)	Blower motor won't start, machine steams continuously after air switch is operated.	8	Defective start switch	Check switch to see that it operates and will carry current. Replace switch if necessary.
(9)	Blower motor will start, machine steams only while control knob is pushed	9A	Steam timer set at 0 time	Timer knob may slip on the shaft and leave the timer set at 0 time. Tighten knob set screw and set timer and knob to suit, approx. 8 seconds.
		9B	Defective steam timer	Check timer operation. See if timer switch operates properly. If not, replace timer.
		9C	Defective steam relay	Check to see if relay will operate on rated current and if contacts will carry current. If not, replace relay.

PROBLEM		CAUSE		REMEDY
(10)	Inadequate steam flow	10A	Steam valve linkage not properly adjusted	Adjust linkage according to adjustment instructions. Tighten all set screws and lock nuts.
		10B	Steam time set too short	Set steam timer for longer time. Tighten knob set screw if necessary.
(11)	Blower motor will start, steam starts but won't stop	11	Defective steam timer	Check timer operation. See if timer switch operates properly. If operation is not correct, replace the timer.
(12)	Blower Motor won't stop	12A	Defective Air timer	Check timer operation. See if timer switch operates properly. If operation is not correct, replace the timer.
		12B	Defective blower relay	Check to see if relay operates properly on rated current. If contacts are stuck or welded shut, or relay does not operate properly, replace it.

Aire Form AF1 Suggested Spare Parts

Part No.	Description
F218	Clamp Leaf Spring
F267	Pivot Pin w/"E" Rings
F63	Covered Spring Asm.
F11	Set No. 11 Sleevers
F433	Sponge for Front Paddle
AF165	Sponge for Rear Paddle
F904	Foam Rubber Pads, Vent Clamp
F357	Felt Air Seal
F287	Bearing Adjust Screw
F18	Steam Spreader Asm.
F739H	Solenoid
F738H	Solenoid
V30	Pack Ring
TU13224	RBM Relay, 115V
TU13225	RBM Relay, 230V
FG453	Timer
AF185	Toggle Switch
AF102	Air Filter
SKD147	Repair Kit for SG147 Gun
SG148	Teflon Hose Assy. for SG147
K451	Repair Kit for FV110 Valve