



How to Replace Old Style Control Manifold with New Style Manifold on AS-Series Pumps

This guide provides step-by-step instructions on replacing an old-style (revision E or earlier) control manifold (11805) with a new-style manifold (revision F).

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PARTS:

- [Control Manifold Assembly 11805](#) (1)
- [Control Manifold Upgrade Kit 14768](#) (1)

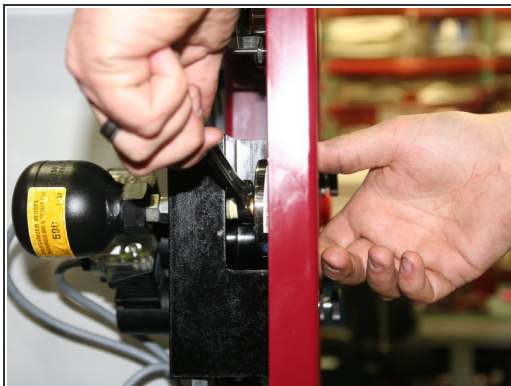
Step 1 — How to Replace Old Style Control Manifold with New Style Manifold on AS-Series Pumps



- Turn power OFF to AccuStream pump and at main breaker supplying pump.

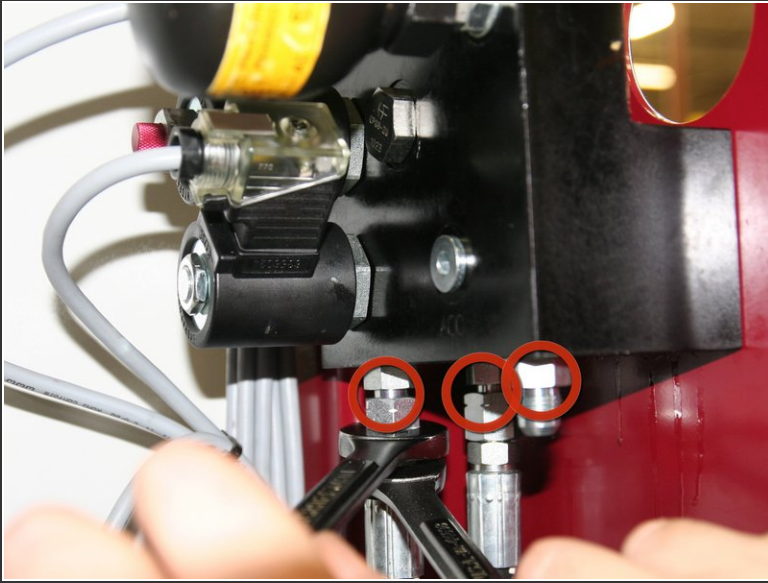
⚠ All lockout/tagout procedures must be followed. Failure to do so could result in serious injury or death.

Step 2



- Remove hydraulic pressure gauge.
- Remove control knobs from front of manifold.
- ① Label control knots "Cut" and "Pierce", respectively, to identify for re-installation.

Step 3



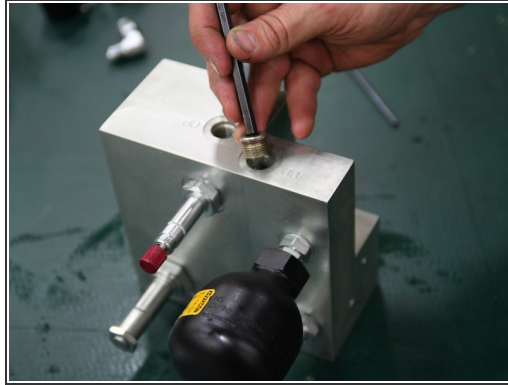
- Disconnect hoses and fittings from bottom of old control manifold.
- Remove DIN connectors from solenoids on back of old control manifold.
- ① Label DIN connectors "Cut" and "Pierce", respectively, for re-installation.

Step 4



- Remove both 24VDC coils from solenoids on back of old control manifold.

Step 5



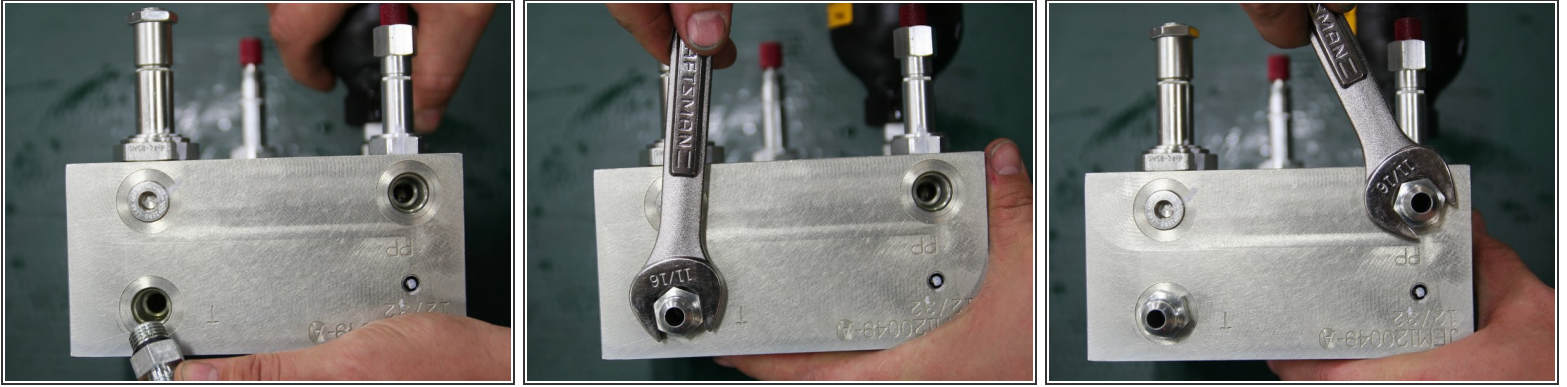
- Remove old control manifold from pump frame.
- Install plug (6MBP) into port stamped BD on top of new manifold.

Step 6



- Install 90° fitting (6MJ-6MB90) into port stamped CP on top of new manifold.
- ⓘ Be sure to have fitting facing towards pressure gauge port as shown in picture.

Step 7



- Install straight fittings (removed from old manifold) into ports, labeled T and PP, on bottom of new manifold.
- Install large 24VDC coil (removed from old manifold) onto large solenoid stem of control manifold.

Step 8



- Install new manifold onto pump frame.
 - ⓘ Use medium strength thread lock on fasteners.

Step 9



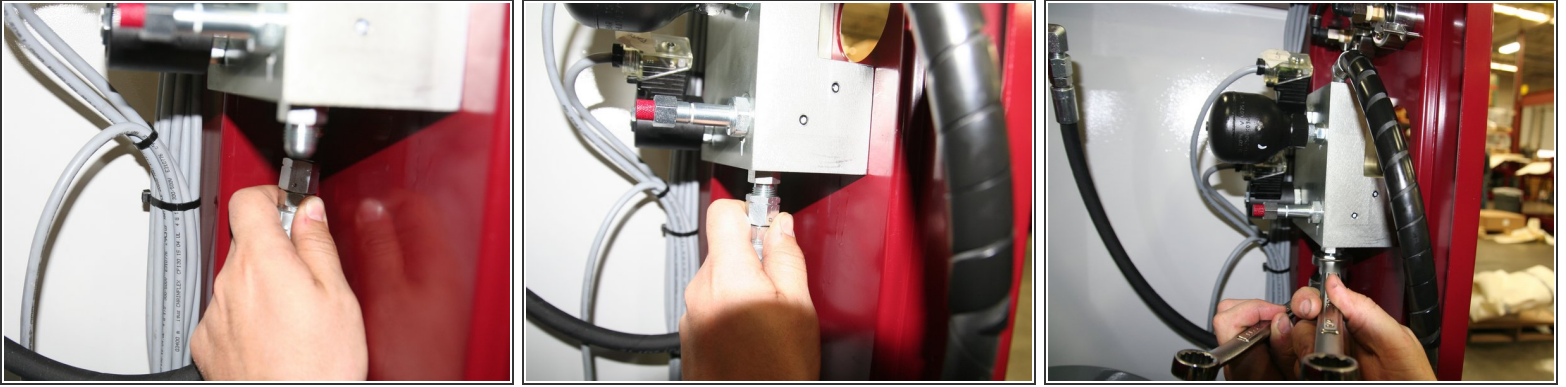
- Install large 24VDC coil (removed from old manifold) onto large solenoid stem of control manifold.
- Install small 24VDC Coil (12586) onto small solenoid stem above large stem and beside bullet accumulator.
- ❗ Solenoid directly below oil accumulator (black bulb) is not used in this application.

Step 10



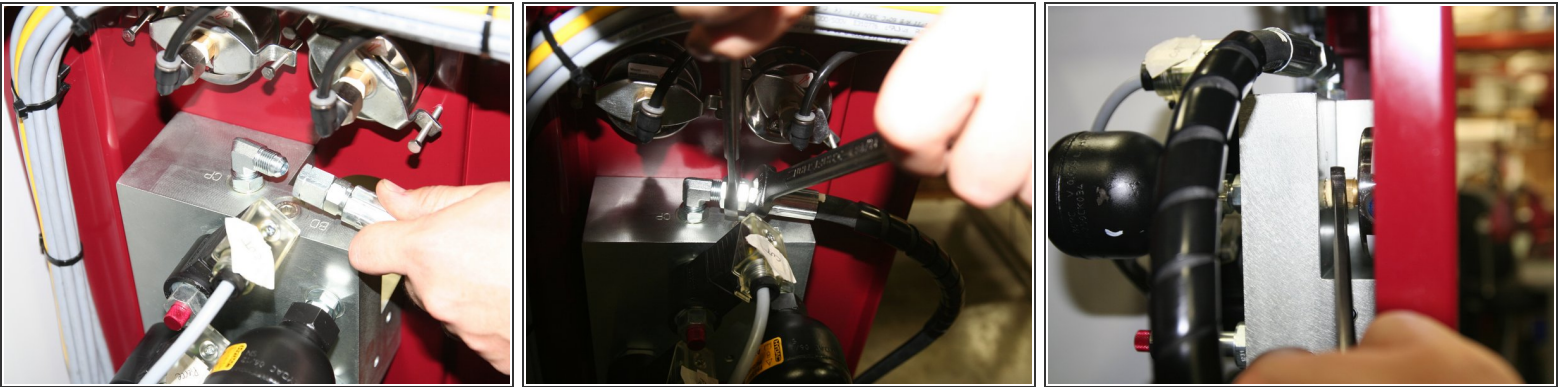
- Reinstall DIN connectors to respective coils as shown in pictures.
- Tighten DIN connectors to coils.

Step 11



- Connect short hydraulic line from "T" fitting near tank to port labeled T on bottom of new manifold.
- Connect hydraulic line from "T" fitting on hydraulic pump to port labeled PP on bottom of new manifold.

Step 12



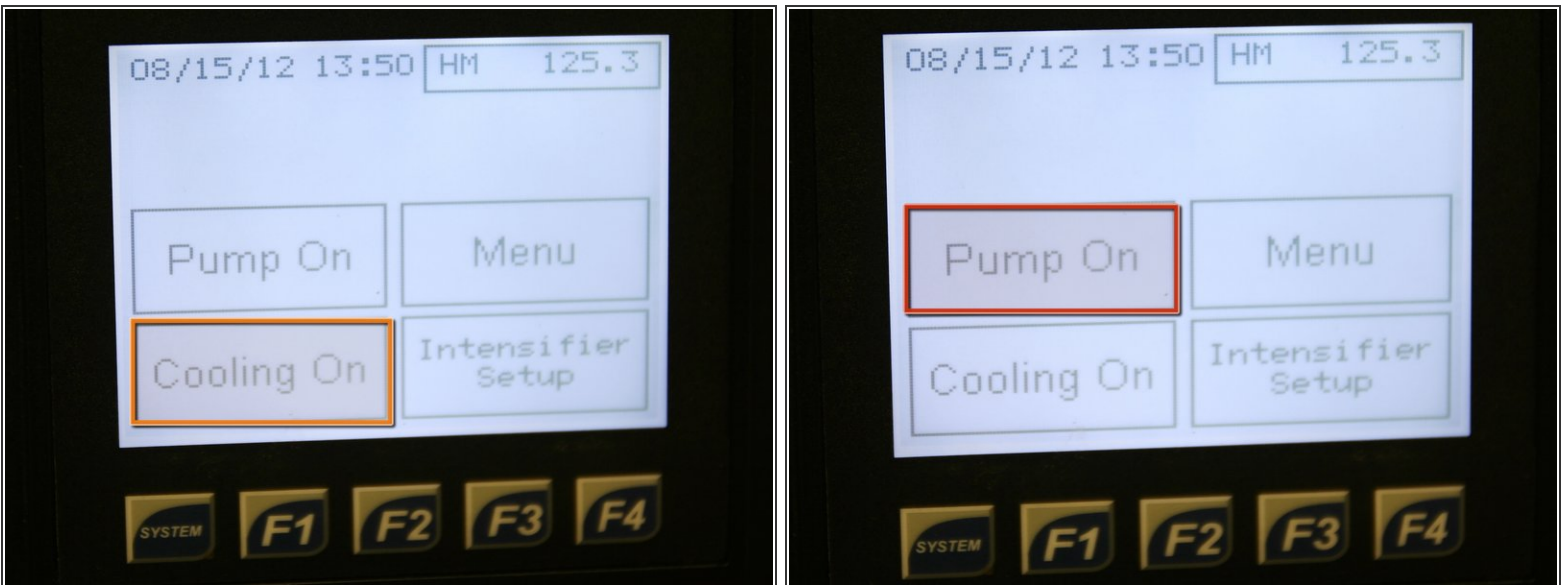
- Connect hydraulic line from compensator on pump to port labeled CP on top of new manifold.
- Install pressure gauge in new manifold.
- ① Use pipe tape and dope on gauge threads to prevent leaks.

Step 13



- Install control knobs "Cut" and "Pierce" into respective ports on front of manifold.

Step 14



- Turn pump on in cooling mode (Cooling On) to allow oil to cycle and re-fill hydraulic lines and manifold.
- Turn pump on in run mode (Pump On) and verify that "Cut" and "Pierce" control knobs function correctly.
- Pump is now ready to continue cutting process.