

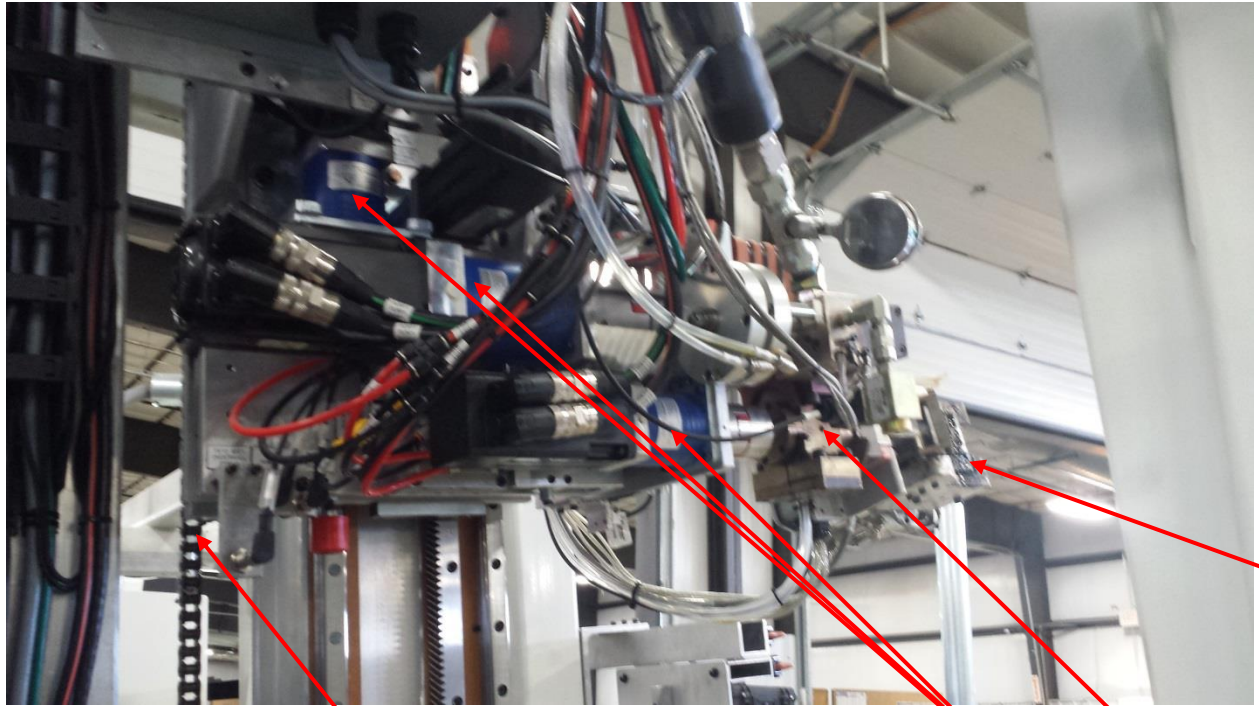
# 7500 TWO HEADED SEALER

## MAINTENANCE INSTRUCTIONS

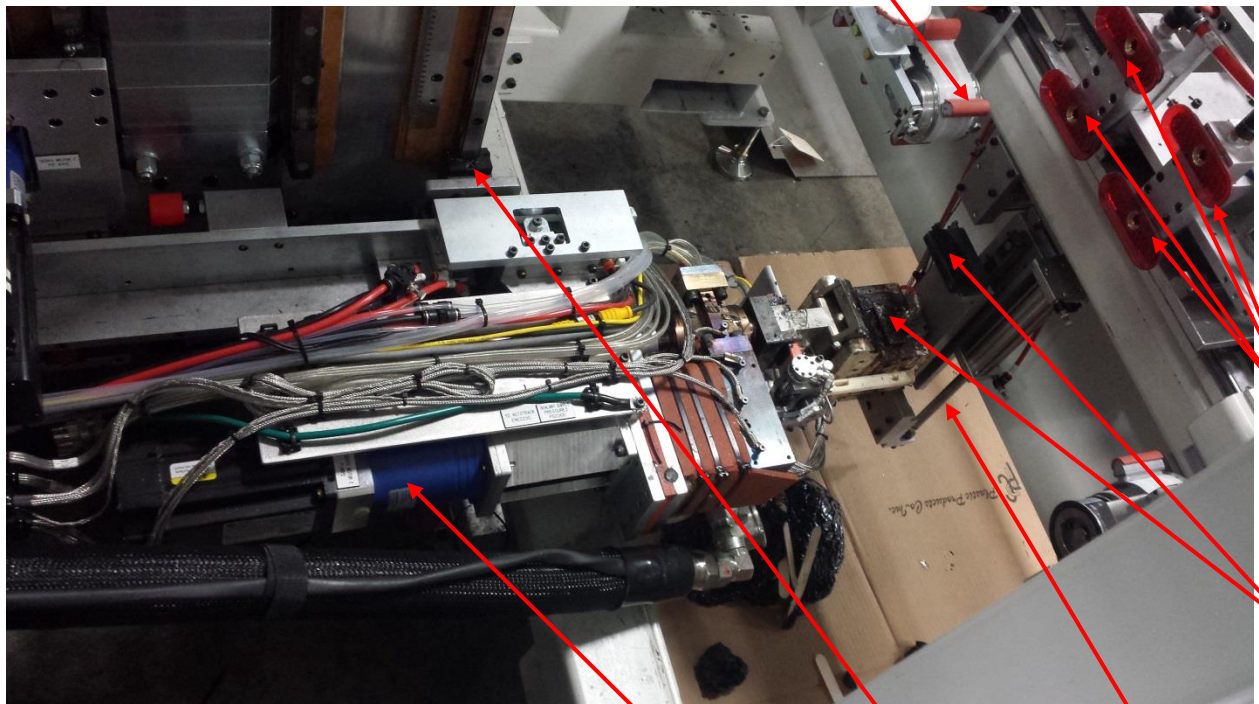
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Upper head



Lower head



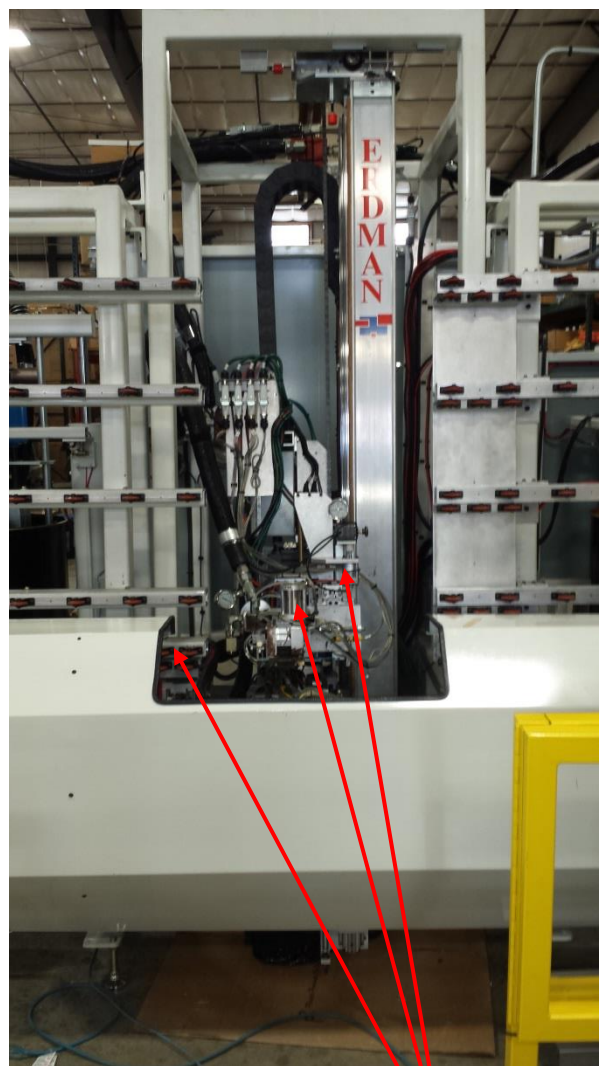


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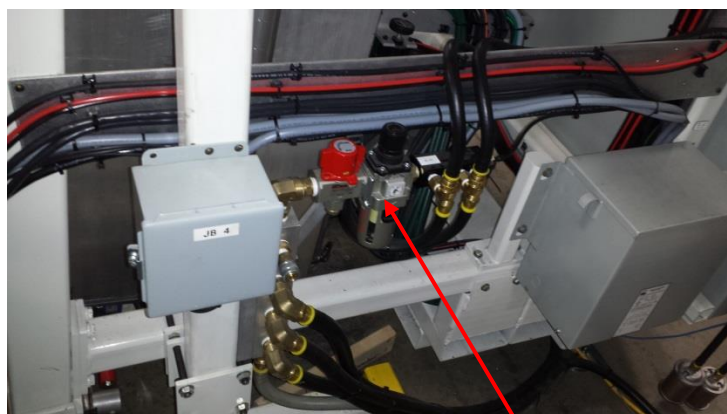
12

6

3



7



11



## 1. Precision Gear Box

- a. Location: Gantry drive, applicator head drive, pump drive (2), applicator head rotate (2), applicator head raise/lower, suction cup shuttle travel, infeed conveyor drive, out feed conveyor drive
- b. Lubricated for their service life by the manufacturer with a mineral oil-based lithium soap
- c. Inspect for leakage and damage



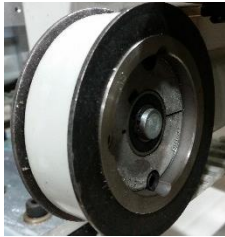
## 2. Roller Chain

- a. Location: Center counterweight
- b. Inspection: Check for dust build up. Check for tension, wear, abrasions. Replace per manufacturer's instructions and recommendations
- c. Type: Crown 363115-001 Chain Lube
- d. Frequency: Inspect and lubricate once per month



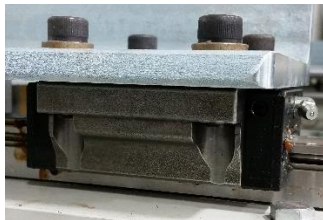
### 3. Transfer Roller

- a. Location: Vertical bed surface
- b. Inspect and replace as needed



### 4. Bearing

- a. Location: Transfer belt pulleys, infeed and out feed conveyor.
- b. Sealed and lubricated from the factory
- c. Inspect and replace as needed



### 5. THK bearings

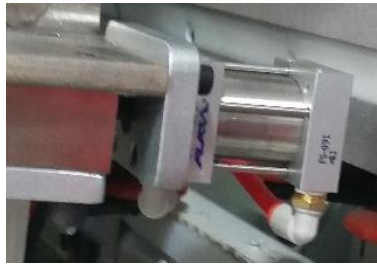
- a. Location: Gantry travel, head travel (2), floating head setup (2), roller bed shift, vacuum shuttle travel, vacuum shuttle shift
- b. Pay special attention to Blocks and Rails

- c. Wipe any contaminants such as dust or silicone from rail surfaces daily at minimum, between shifts is preferred
- d. Type: NLGI 2 EP Lithium
- e. Frequency: Grease every 20,000 units



6. Spare nozzle heater box

- a. Location: Front center
- b. Clean interior as needed



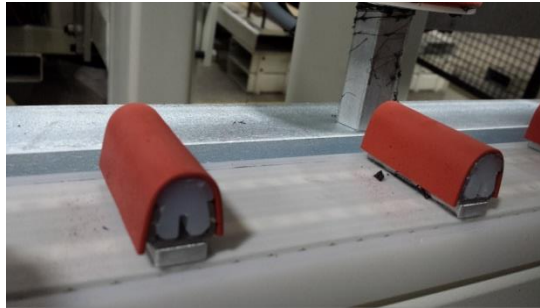
7. Air cylinder

- a. Location: Head shift, floating head setup, suction cup shuttle, applicator head, product stop
- b. Wipe any contaminants such as dust or silicone from rod surface



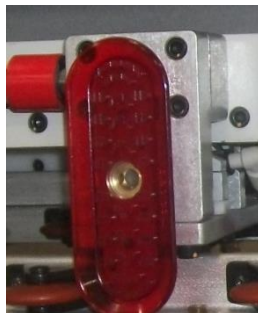
#### 8. Dodge bearings

- a. Location: Gantry
- b. Type: NLGI 2 EP Lithium
- c. Frequency: Grease every 219,000 units



#### 9. Conveyor Belt

- a. Location: Front shuttle
- b. Clean with lukewarm water. A mild soap may be used, dry with a soft cloth.
- c. Check for dust, silicone build up. Check for tension, wear, abrasions. Replace flight covers as needed



#### 10. Suction cups

- a. Location: Front shuttle/stop
- b. Clean with lukewarm water. A mild soap may be used, dry with a soft cloth.
- c. Replace if damaged



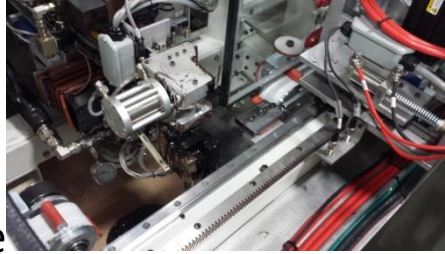
#### 11. Pneumatic regulator

- a. Location: Back
- b. Check the amount of water in the collector
- c. Empty as needed



#### 12. Vacuum pump

- a. Location: Front In-feed
- b. Check filter for clogging
- c. Clean and replace as needed



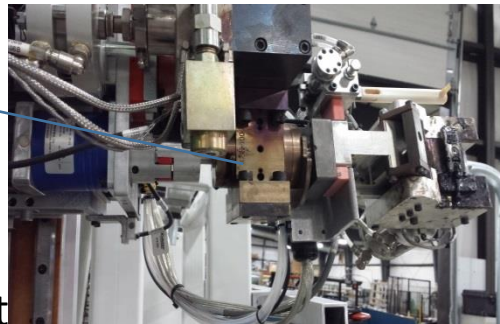
### 13. Corner wiper and nozzle

- a. Location: Front center of machine.



- b. While hot use tongue depressor to wipe excess sealant off nozzle and corner wiper. Be careful to not get burned. The nozzle and wiper will be hot.
- c. Should be done as need and or once per shift.

LUBE  
POINT



### 14. Sealer head main shaft

- a. Location: Front center (upper & lower)

Lube with 2000 deg. Anti-seize (McMaster Carr part # 1367K51 or equivalent) weekly.

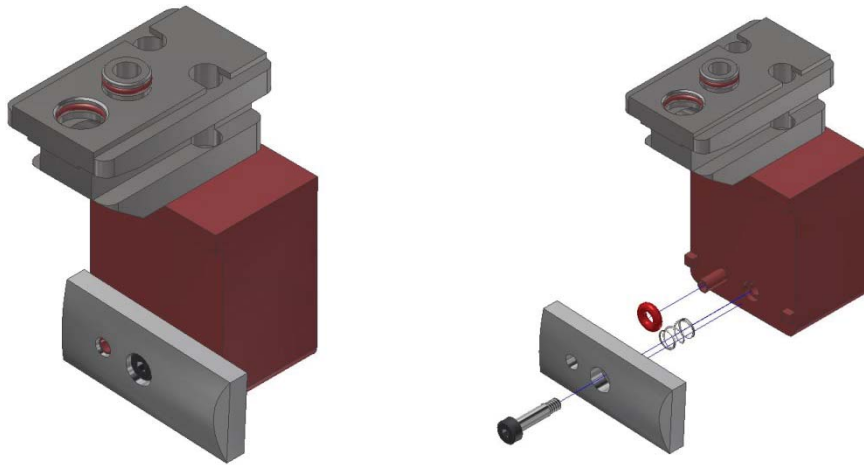


15. Upper and lower depth probe change out.



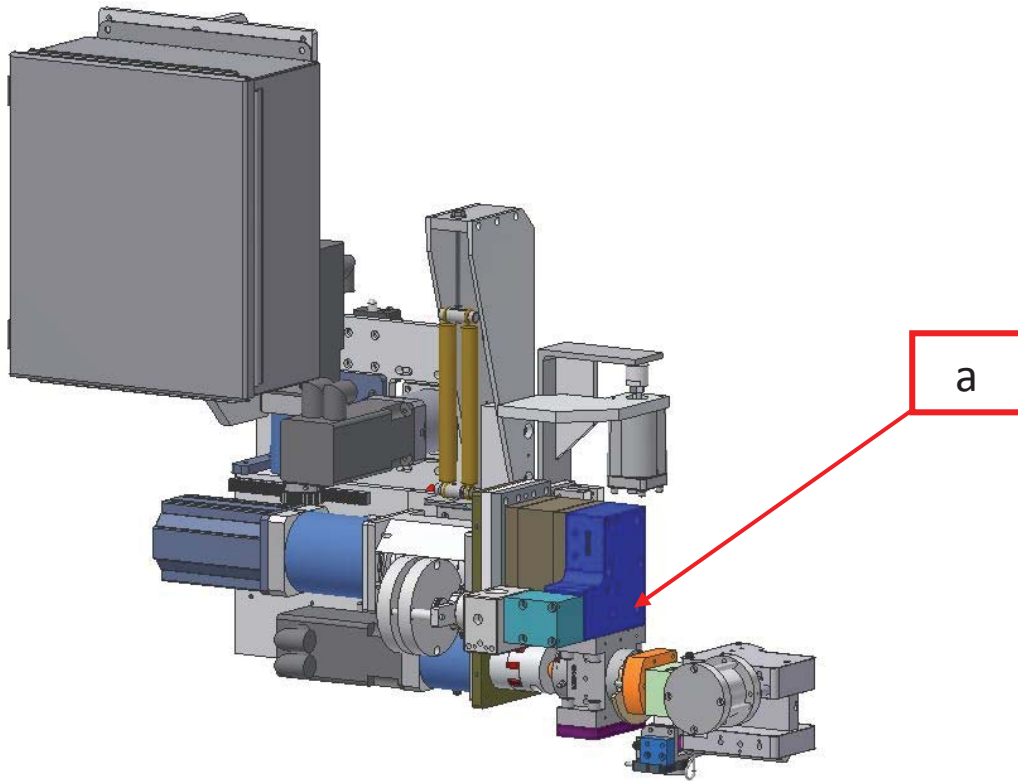
- a. Place machine into purge mode.
- b. Once in purge mode. Open the safety gate.
- c. Locate the desired probe to be changed out (upper or lower head)
- d. Remove the hitch pin clip.
- e. Lift depth probe off of dowel pins.
- f. Replace with new depth probe. (Be sure that new probe is located properly and seated in correct position over the dowel pins)
- g. Replace hitch pin clip.
- h. After exiting machine and closing safety gate. Take machine out of purge mode.
- i. Recalibrate machine for any variance in the new depth probe compare to the old.

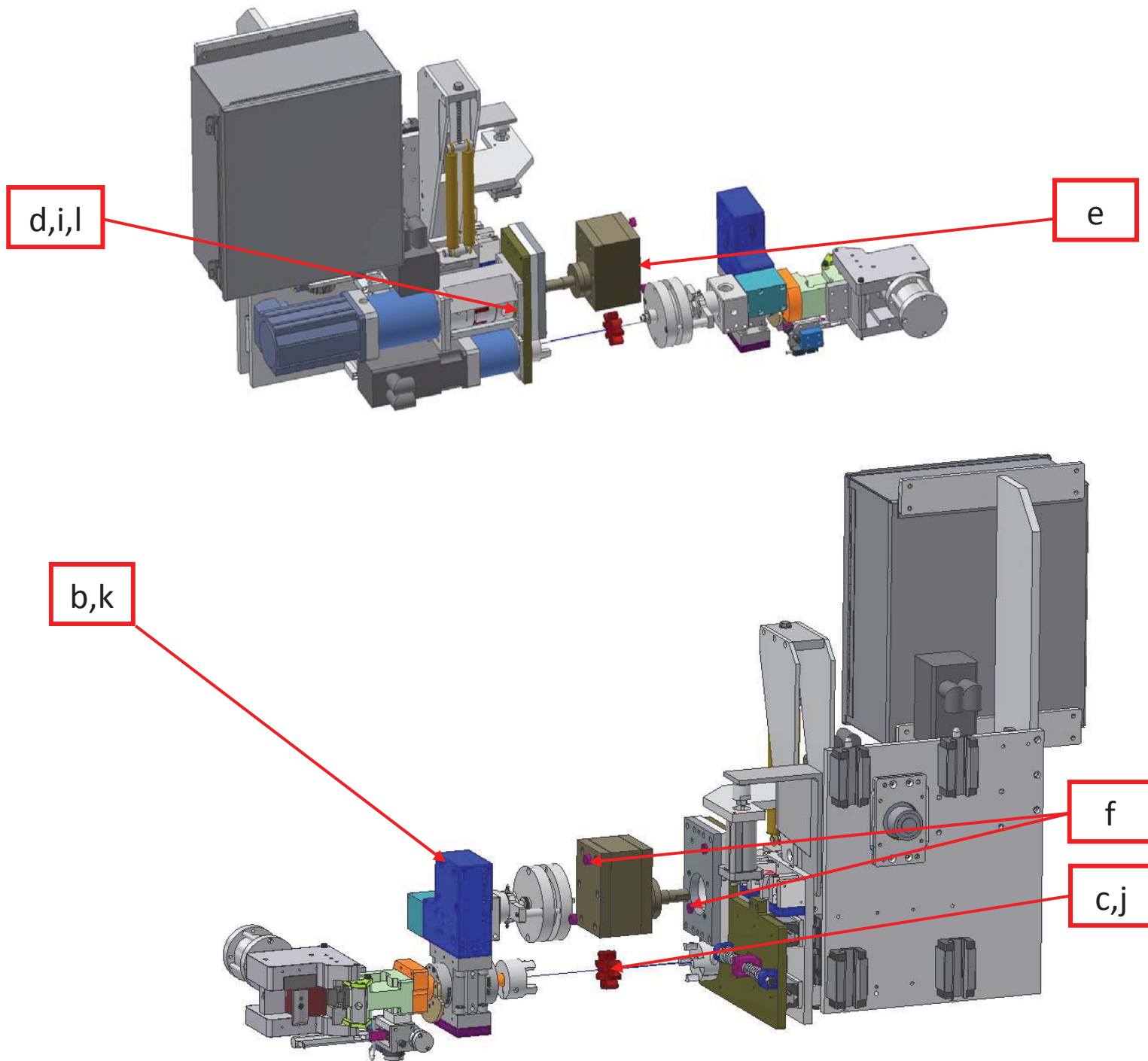
## 16. Nozzle pad change out



- a. With nozzle removed clean excess sealant from nozzle pad area.
- b. Remove shoulder bolt that retains the nozzle pad.
- c. Remove nozzle pad. (Be sure to retain the small spring behind the nozzle pad.)
- d. Remove and inspect nozzle pad O-ring.
- e. If O-ring appears to be ok reinstall or replace it.
- f. Place spring into spring pocket
- g. Install new nozzle pad.
- h. Reinstall and tighten shoulder bolt.
- i. Inspect all other O-rings before putting into service

## 17. Kawasaki change out

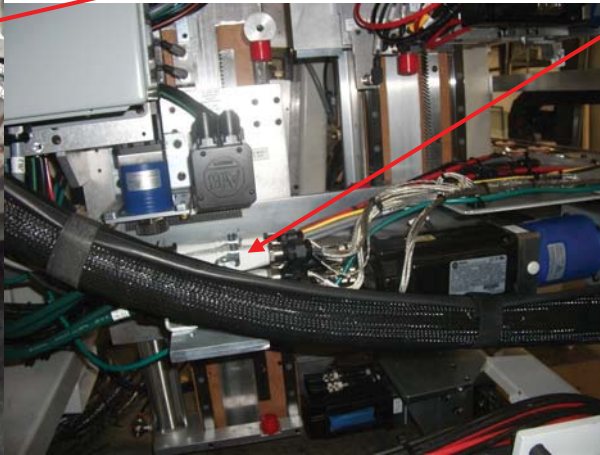




- a. With machine powered down and cool. Locate pump and pump adapter plate and remove insulation from pump.

- b. Support and remove bolts from pump adapter plate.
- c. Separate the lovejoy coupler and pull adapter plate out of the way.
- d. Loosen the lovejoy coupler on the pump shaft.
- e. Remove Kawasaki pump.
- f. Remove bushings from Kawasaki pump.
- g. Clean all surfaces that mate to the new Kawasaki pump. (Must be free of any and all debris).
- h. Insert bushings into the new pump.
- i. Reinsert pump shaft into lovejoy coupler (Do not tighten).
- j. Bring adapter plate into alignment with the Kawasaki as well as realign the lovejoy coupler that turns the head.
- k. Replace the bolts into the adapter plate.
- l. Tighten the lovejoy coupler onto the pump shaft.
- m. Reinstall insulation around the pump.

## 18. Heater and RTD change out.



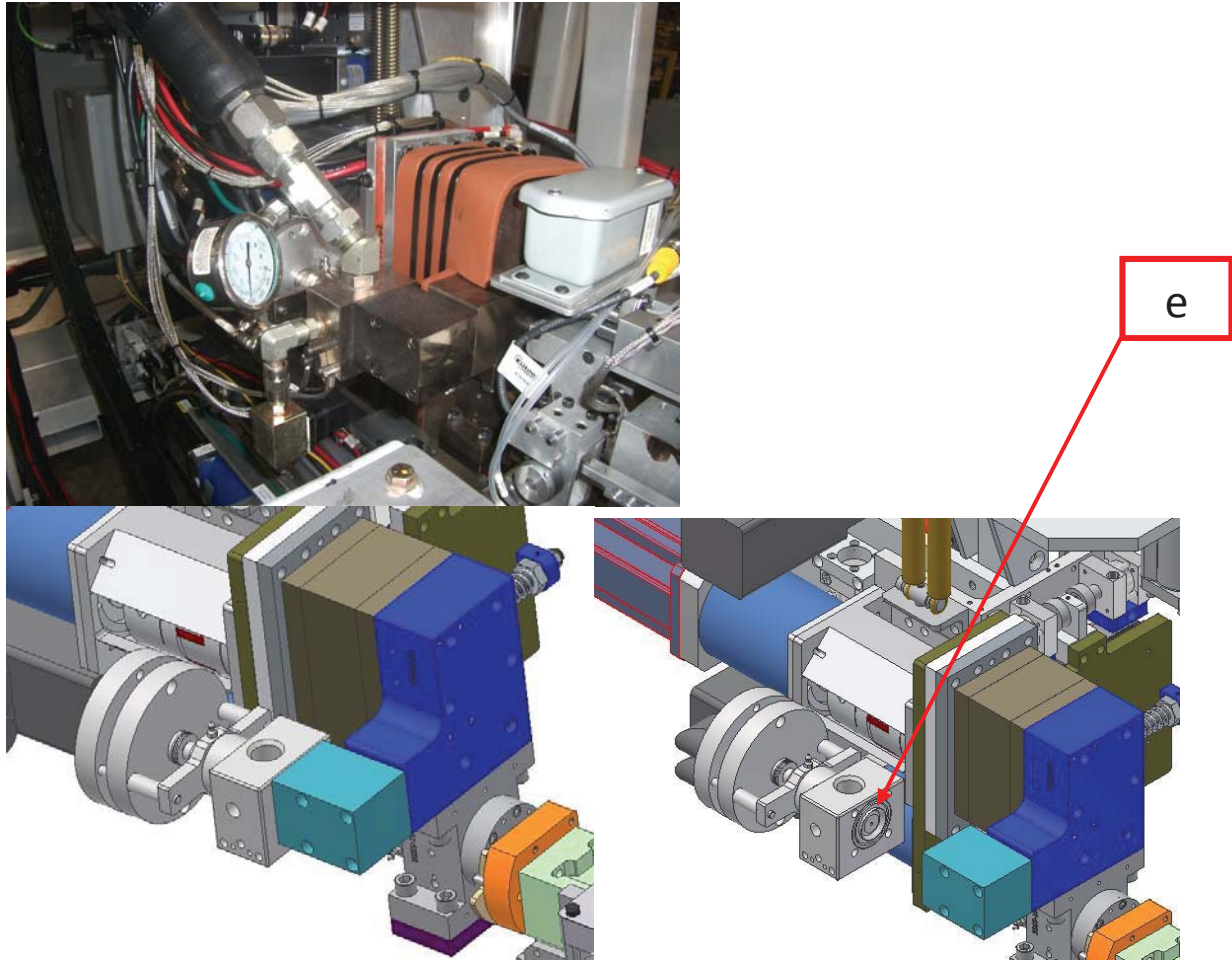
b

d

- a. With machine powered down. Determine which heater has failed by using an ohm meter to check resistance.(consult your wiring diagram for proper wattage and resistance)
- b. After locating faulty heater remove it by removing the retaining shoulder bolt.
- c. Gently pull the heater element out of the locating hole.
- d. Follow lead to plug.
- e. Unplug and disassemble the plug.

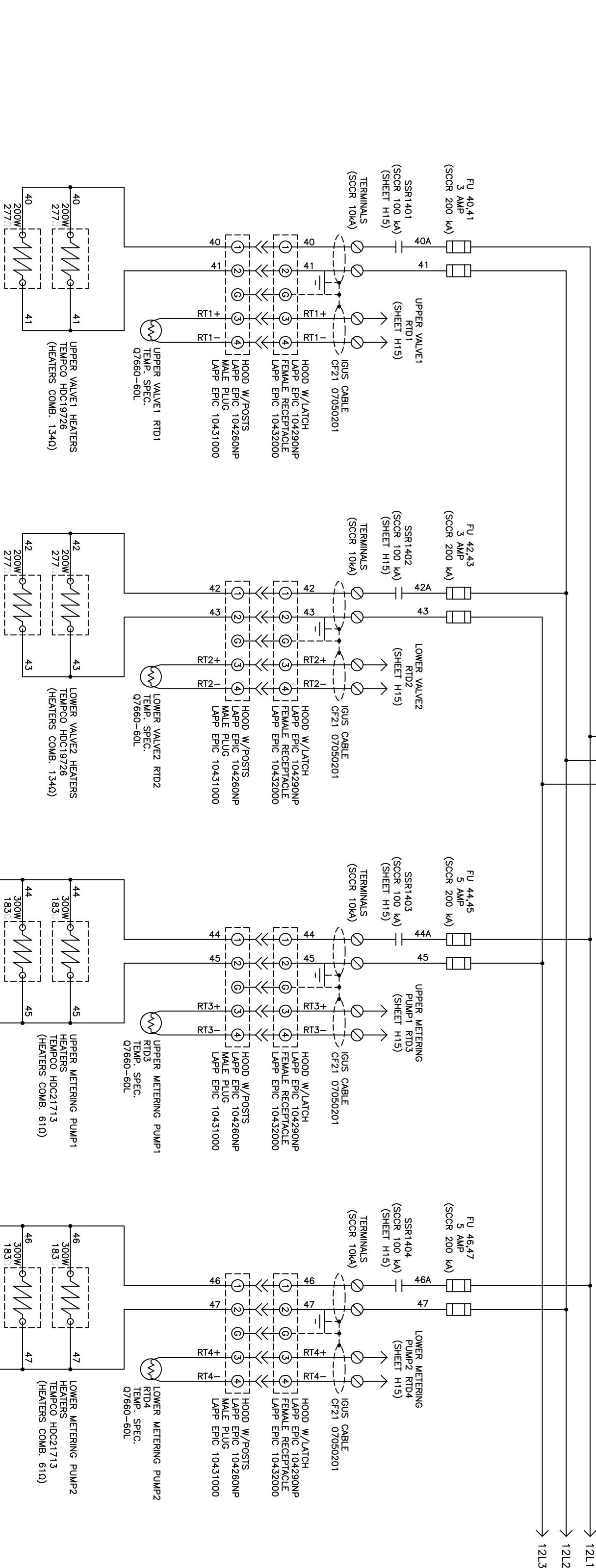
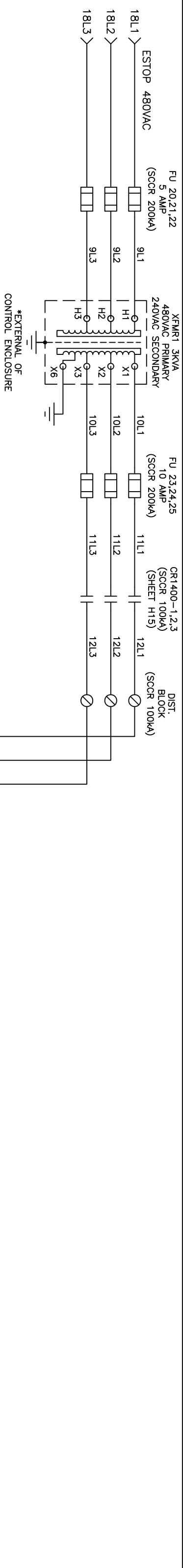
- f. Remove the faulty heater wires that are connected to the plug.
- g. Install new heater wires into plug and reassemble plug.
- h. Route the new heater lead in the same way the old heater lead was mounted.
- i. Use high temperature anti-seize (McMaster Carr part # 1367K51 or equivalent) on the heater probe.
- j. Place heater head into the locating hole.
- k. Reinstall the retaining shoulder bolt.

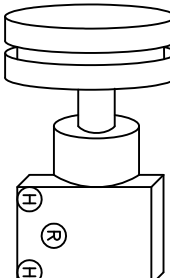
## 19. FMS valve replacement.



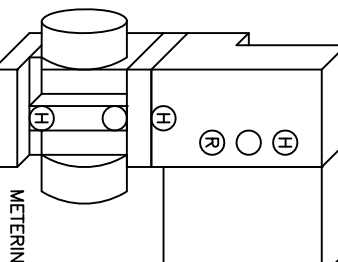
- a. With the machine cool and shut down locate the FMS valve that needs to be replaced.
- b. Remove the supply hose and pressure switch fittings and airlines.
- c. Remove heaters and RTD by removing the retaining shoulder bolts.
- d. Remove the 4 valve mounting bolts and remove valve. Take care to make sure the O-ring is removed as well.

- e. Unpack the new valve. Make sure that the Teflon O-ring is installed in new valve from manufacturer.
- f. Clean mating surfaces on the machine.
- g. Install new valve.
- h. Fill pressure switch fittings with Grease (Mobil 1 synthetic part# 121071)
- i. Use thread sealant (Loctite 565) on pressure switch fittings to install pressure switch.
- j. Reinstall the supply hose.
- k. Reinstall airlines.





VALVE



METERING PUMP

Ⓡ RTD TEMPERATURE SENSOR

Ⓜ HEATER

○ UNUSED HOLE

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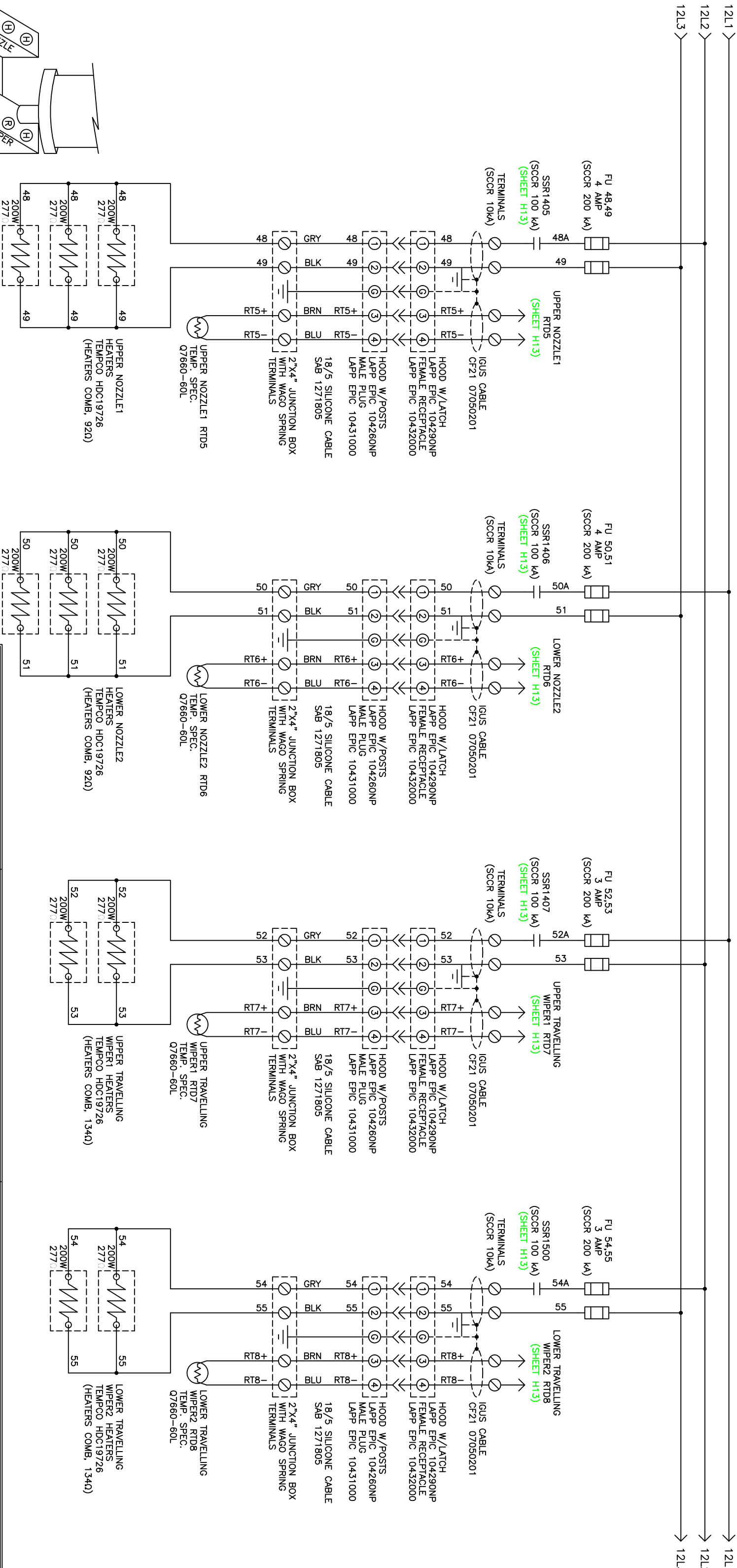
Description: IG GLAZER  
HEATER CONNECTIONS

Drawn By: JPP

Date: 3 / 2014

Dwg:131522 H5

Sheet 5 of 17



RTD TEMPERATURE SENSOR  
HEATER

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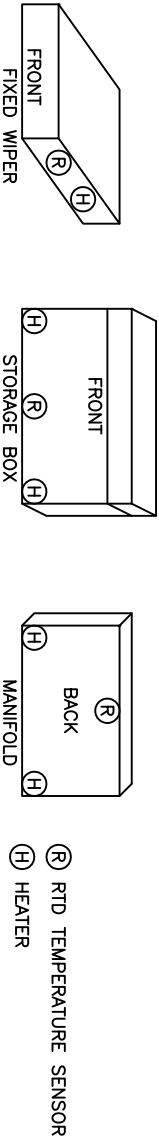
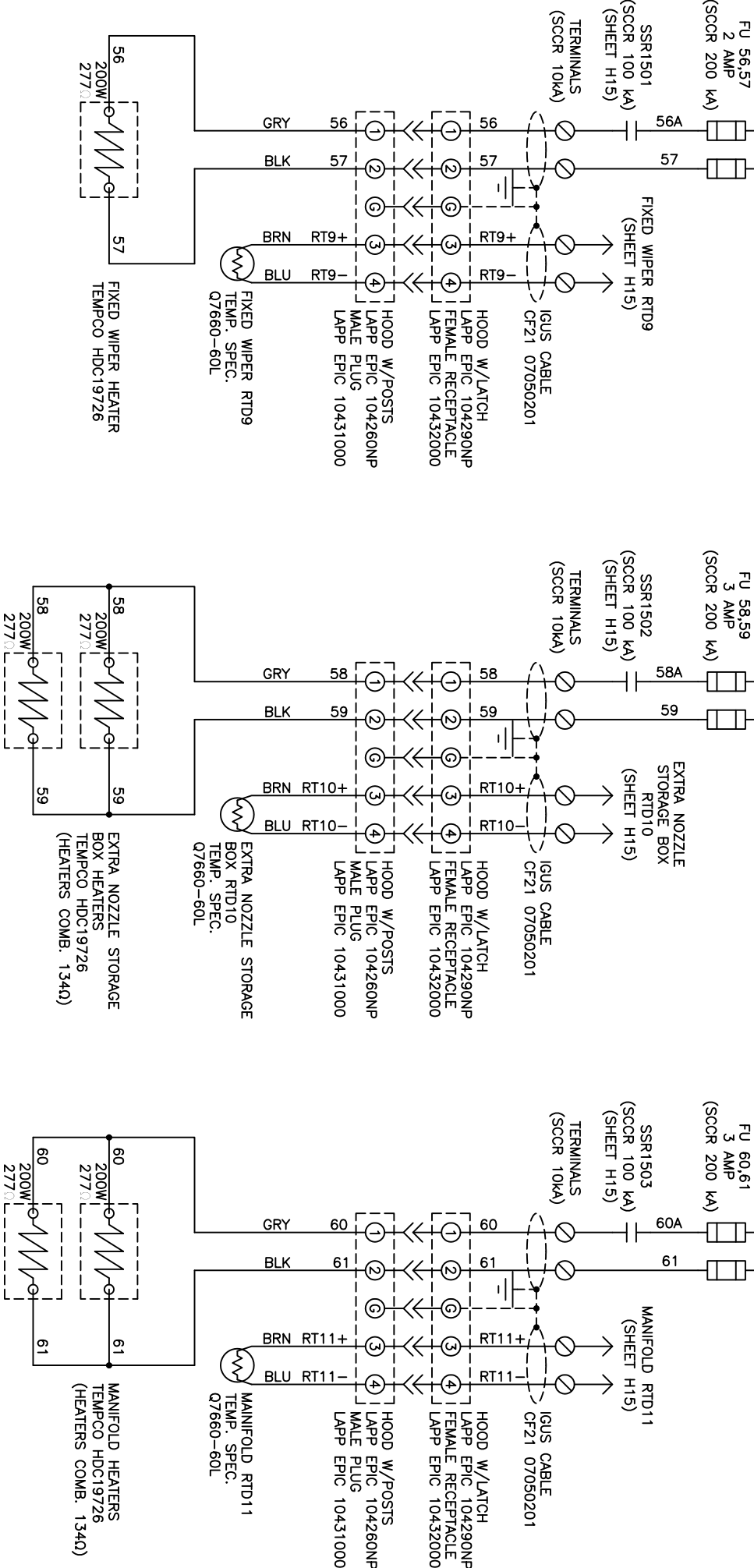
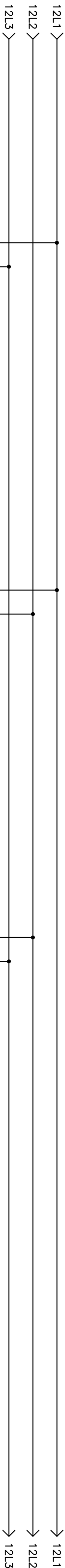
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Description: IG GLAZER  
HEATER CONNECTIONS

Drawn By: JPP  
Dwg:131522 H6

Date: 3 / 2014  
Sheet 6 of 17

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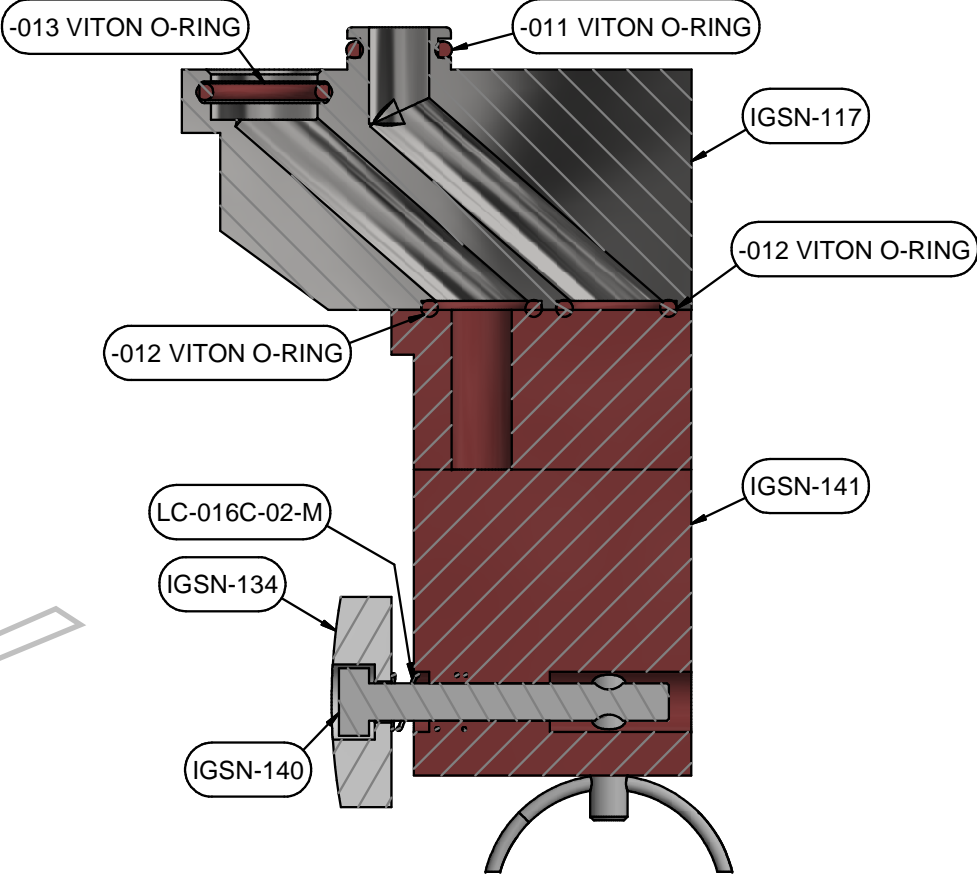
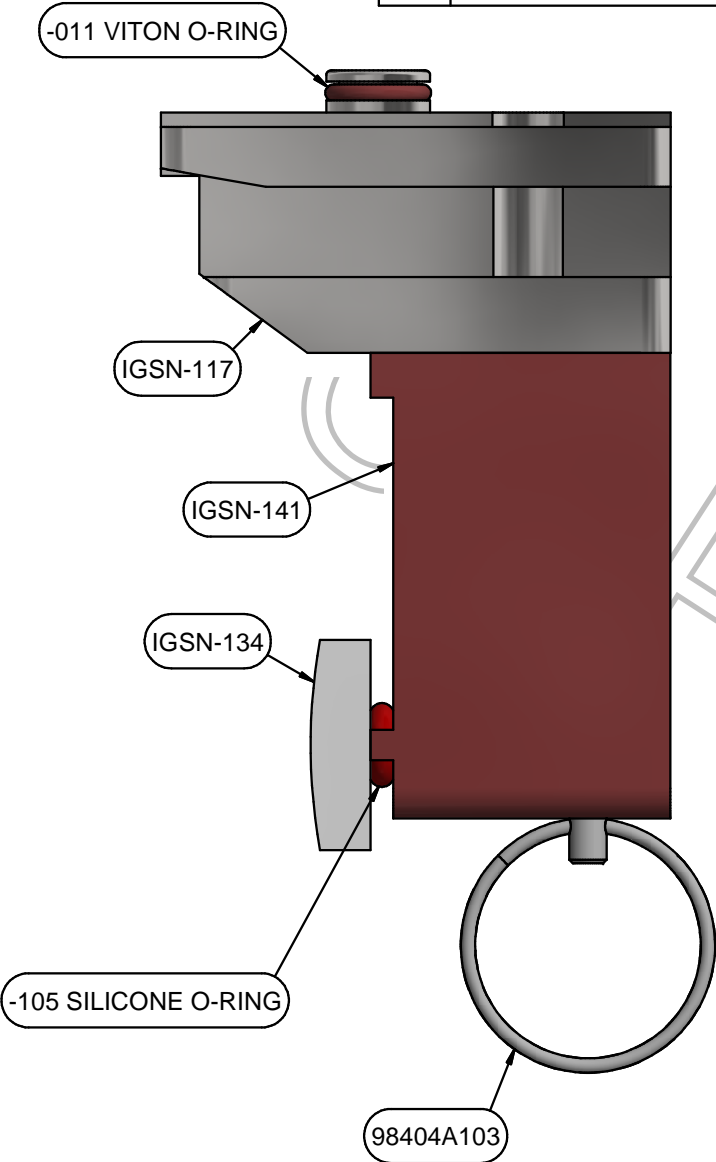
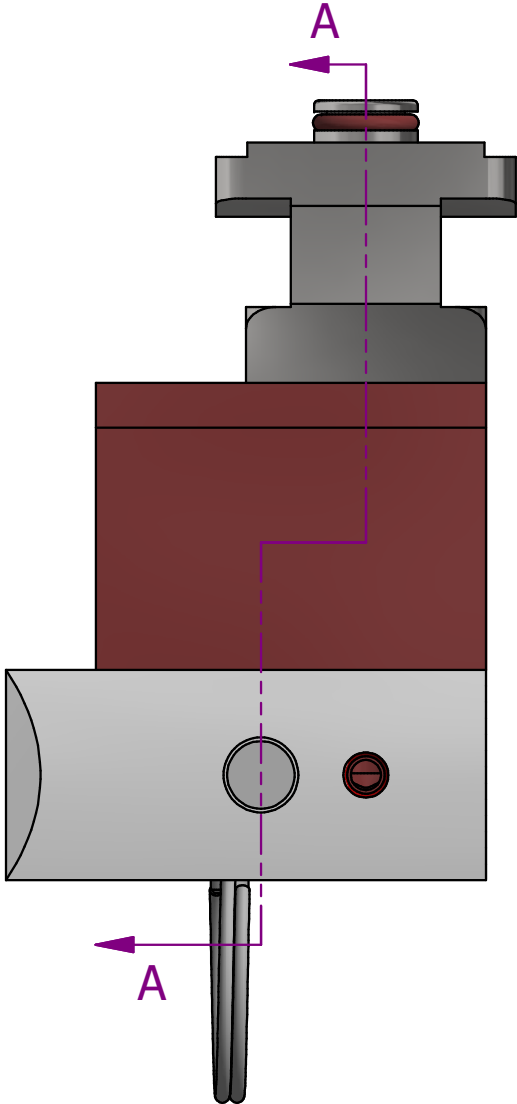


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Description: IG GLAZER  
HEATER CONNECTIONS

Drawn By: JPP Dwg:131522 H7

Date: 3 / 2014 Sheet 7 of 17



PARTS LIST			
QTY	PART NUMBER	DESCRIPTION	VENDOR
1	IGSN-117	NOZZLE BODY ADAPTER - DUAL PORT	
1	IGSN-134	NOZZLE TIP INSERT , 7/32" GLASS SPACER (REGULAR WIDTH SHOE)	
1	IGSN-140	NOZZLE SHOE RETAINING PIN	
1	IGSN-141	NOZZLE TIP BASE, 7/32" GLASS SPACER	
1	LC-016C-02-M	LEE SPRING, .240 O.D., .016 WIRE DIA, .750 FREE LENGTH, ENDS ARE GROUND, MUSIC WIRE	LEE SPRING
1	-011 VITON O-RING	-011 VITON O-RING, 5/16" ID X 7/16" OD X 1/16" CS	LUTZ
2	-012 VITON O-RING	-012 VITON O-RING, 3/8" ID X 1/2" OD X 1/16" CS	LUTZ
1	-013 VITON O-RING	-013 VITON O-RING, 7/16" ID X 9/16" OD X 1/16" CS	LUTZ
1	-105 SILICONE O-RING	-105 SILICONE O-RING, 5/32" ID X 11/32" OD X 3/32" CS	LUTZ
1	98404A103	SS QUICK-RELEASE PIN, 5/32" DIA, 1" USEABLE LENGTH	MCMASTER CARR

REPLACES

**STANDARD PART**

STOCKING STATUS

MIN

MAX

**TOLERANCES:  
UNLESS OTHERWISE  
SPECIFIED**  
  
X = ± 0.1  
.XX = ± 0.02  
  
XXX = ± 0.005  
.XXXX = ± 0.0005  
  
ANGULAR ± 1°

REMOVE ALL BURRS & SHARP EDGES

SAND RADIUS ALL CORNERS (1/8"-1/4") UNLESS NOTED

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.

HOLES SPECIFIED MAX ∅ SHOULD BE TAPPED TO FULL DEPTH OF STANDARD TAP

**DO NOT SCALE THIS DRAWING**

DESIGNED BY: GWD  
DRAWN BY: GWD  
DRAWN DATE: 6/6/2016

**ERDMAN**  
Automation Corp.  
1603 So. 14th Street, Princeton, MN 55371

PART NAME: IG NOZZLE ASSEMBLY, 7/32" GLASS SPACER, SINGLE PUMP, QUICK RELEASE PIN, PLASTIC SHOE.

REV:

FINISH: AS SPECIFIED  
MATERIAL: AS SPECIFIED

**PART #:**  
**IGSN-A19**

FAB Qty: 1  
Erdman Job #: 150736

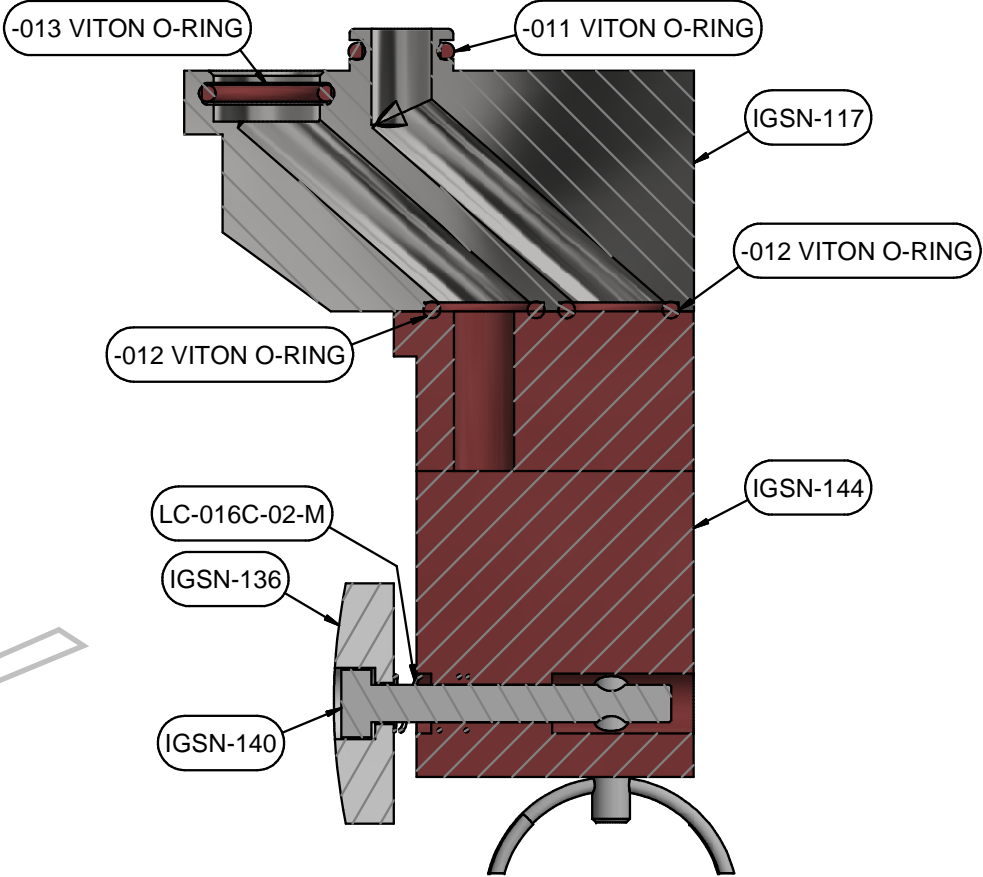
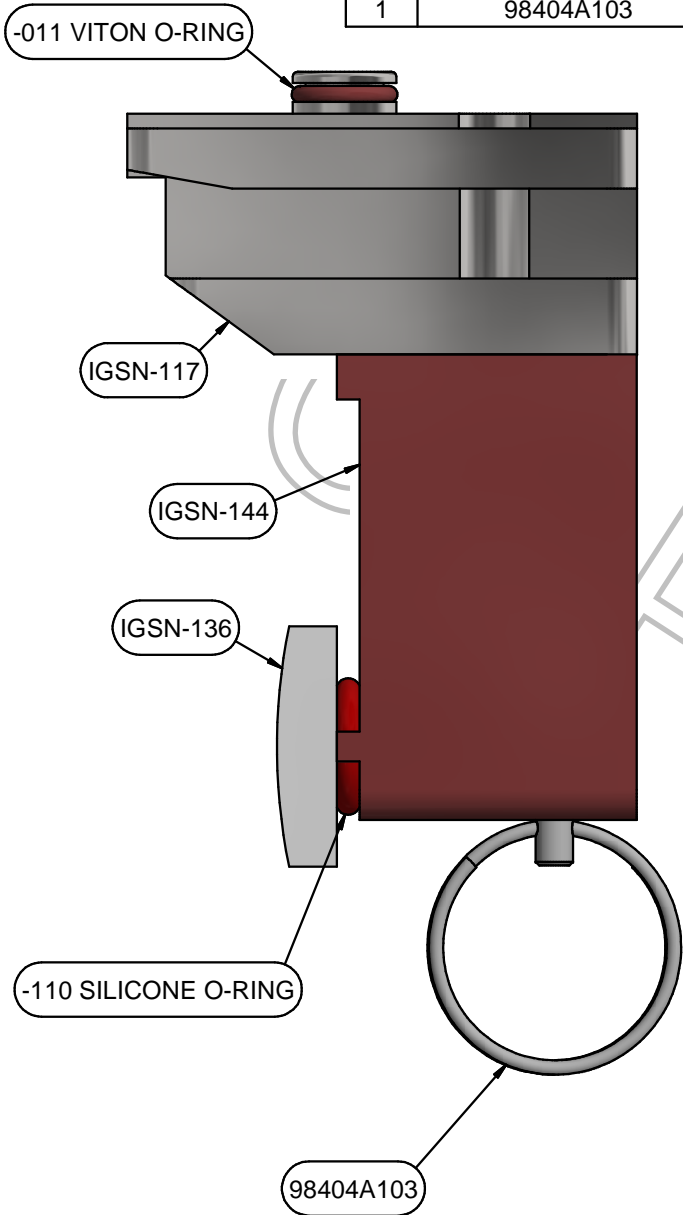
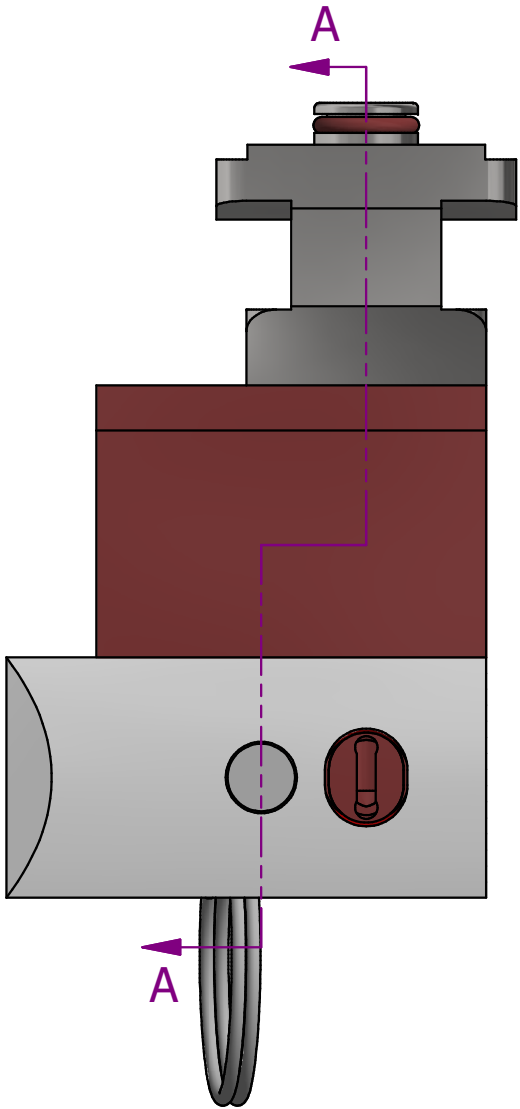
DRAWING SIZE

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SHEET: 1 OF 1  
RETRO #

USED IN:



PARTS LIST			
QTY	PART NUMBER	DESCRIPTION	VENDOR
1	IGSN-117	NOZZLE BODY ADAPTER - DUAL PORT	
1	IGSN-136	NOZZLE TIP INSERT , 7/16" GLASS SPACER (WIDE SHOE)	
1	IGSN-140	NOZZLE SHOE RETAINING PIN	
1	IGSN-144	NOZZLE BLOCK WELDMENT, 7/16" GLASS SPACER	
1	LC-016C-02-M	LEE SPRING, .240 O.D., .016 WIRE DIA, .750 FREE LENGTH, ENDS ARE GROUND, MUSIC WIRE	LEE SPRING
1	-011 VITON O-RING	-011 VITON O-RING, 5/16" ID X 7/16" OD X 1/16" CS	LUTZ
2	-012 VITON O-RING	-012 VITON O-RING, 3/8" ID X 1/2" OD X 1/16" CS	LUTZ
1	-013 VITON O-RING	-013 VITON O-RING, 7/16" ID X 9/16" OD X 1/16" CS	LUTZ
1	-110 SILICONE O-RING	-110 SILICONE O-RING, 3/8" ID X 9/16" OD X 3/32" CS	LUTZ
1	98404A103	SS QUICK-RELEASE PIN, 5/32" DIA, 1" USEABLE LENGTH	MCMASTER CARR

REPLACES

STOCKING STATUS

MIN

MAX

STANDARD PART

TOLERANCES:  
UNLESS OTHERWISE  
SPECIFIED

$.X = \pm 0.1$   
 $.XX = \pm 0.02$   
ANGULAR  $\pm 1^\circ$

REMOVE ALL BURRS & SHARP  
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SAND RADIUS ALL CORNERS  
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UNLESS OTHERWISE SPECIFIED.

HOLES SPECIFIED MAX  $\varnothing$   
SHOULD BE TAPPED TO FULL  
DEPTH OF STANDARD TAP

DO NOT SCALE  
THIS DRAWING

DESIGNED BY: CLS

DRAWN BY: GWD

DRAWN DATE: 6/6/2016

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Automation  
Corp.

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PART NAME: IG NOZZLE ASSEMBLY, 7/16" GLASS  
SPACER, SINGLE PUMP, QUICK RELEASE  
PIN, PLASTIC SHOE.

REV:

FINISH: AS SPECIFIED

MATERIAL: AS SPECIFIED

PART #:

IGSN-A20

FAB Qty: 1

Erdman Job #: 150736

MFG By:

MFG Date:

MFG Quantity:

Diagram labels include: -011 VITON O-RING, IGSN-117, IGSN-147, IGSN-135, -013 VITON O-RING, LC-016C-02-M, IGSN-135, IGSN-140, -011 VITON O-RING, IGSN-117, -012 VITON O-RING, IGSN-147, -111 SILICONE O-RING, 98404A103.

PARTS LIST			
QTY	PART NUMBER	DESCRIPTION	VENDOR
1	IGSN-117	NOZZLE BODY ADAPTER - DUAL PORT	
1	IGSN-135	NOZZLE TIP INSERT , 11/16" GLASS SPACER (REGULAR WIDTH SHOE)	
1	IGSN-140	NOZZLE SHOE RETAINING PIN	
1	IGSN-147	NOZZLE BLOCK WELDMENT, 11/16" GLASS SPACER	
1	LC-016C-02-M	LEE SPRING, .240 O.D., .016 WIRE DIA, .750 FREE LENGTH, ENDS ARE GROUND, MUSIC WIRE	LEE SPRING
1	-011 VITON O-RING	-011 VITON O-RING, 5/16" ID X 7/16" OD X 1/16" CS	LUTZ
2	-012 VITON O-RING	-012 VITON O-RING, 3/8" ID X 1/2" OD X 1/16" CS	LUTZ
1	-013 VITON O-RING	-013 VITON O-RING, 7/16" ID X 9/16" OD X 1/16" CS	LUTZ
1	-111 SILICONE O-RING	-111 SILICONE O-RING, 7/16" ID X 5/8" OD X 3/32" CS	LUTZ
1	98404A103	SS QUICK-RELEASE PIN, 5/32" DIA, 1" USEABLE LENGTH	MCMASTER CARR

REPLACES

STOCKING STATUS

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MAX

**STANDARD PART**

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SPECIFIED**  
  
X = ± 0.1  
.XX = ± 0.02  
XXX = ± 0.005  
.XXXX = ± 0.0005  
ANGULAR ± 1°

REMOVE ALL BURRS &  
SHARP EDGES  
SAND RADIUS ALL  
CORNERS (1/8"-1/4")  
UNLESS NOTED  
ALL DIMENSIONS ARE IN  
INCHES UNLESS  
OTHERWISE SPECIFIED.  
**DO NOT SCALE  
THIS DRAWING**

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DRAWN BY: GWD  
DRAWN DATE: 6/6/2016

**ERDMAN**  
Automation  
Corp.  
1603 So. 14th Street, Princeton, MN 55371

**PART NAME:** IG NOZZLE ASSEMBLY, 11/16" GLASS  
SPACER, SINGLE PUMPQUICK RELEASE  
PIN, PLASTIC SHOE.

**REV:**

FINISH: AS SPECIFIED  
MATERIAL: AS SPECIFIED

**PART #:**  
**IGSN-A21**

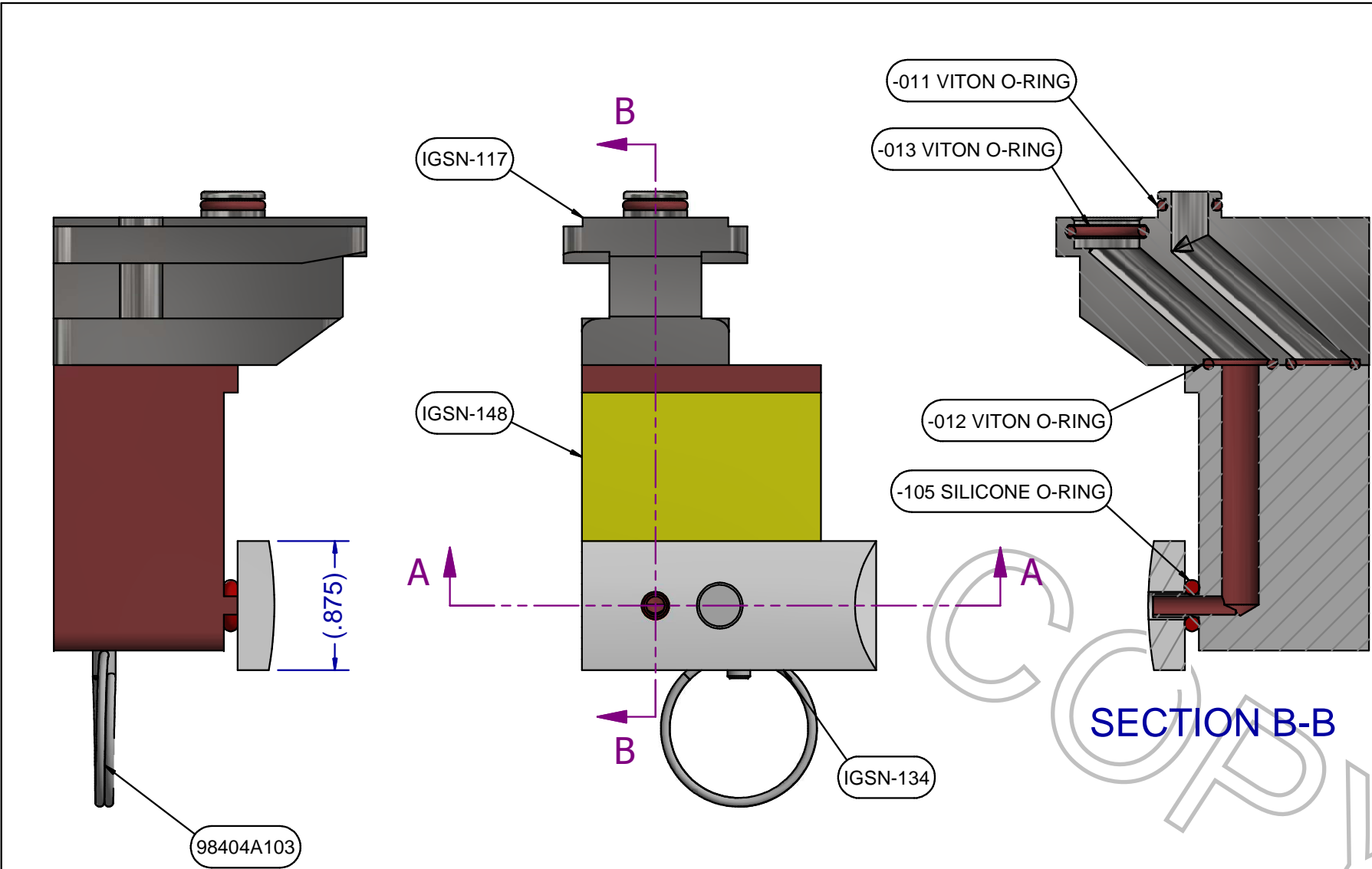
FAB Qty: 1  
Erdman Job #: 150736

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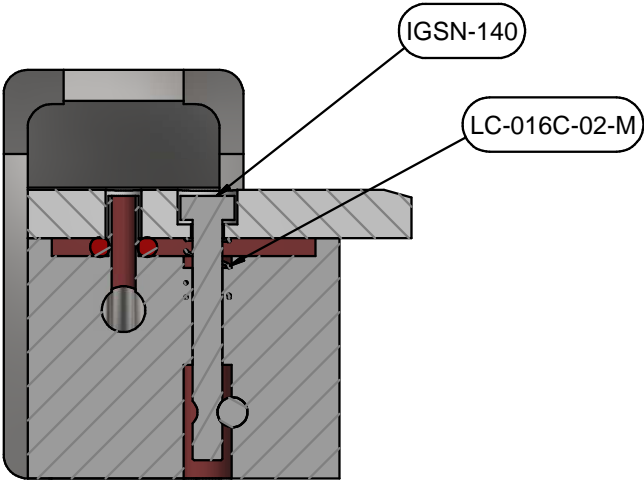
**DRAWING  
SIZE  
B**

SHEET:  
1 OF 1  
RETRO #

USED IN:



PARTS LIST			
QTY	PART NUMBER	DESCRIPTION	VENDOR
1	IGSN-117	NOZZLE BODY ADAPTER - DUAL PORT	
1	IGSN-134	NOZZLE TIP INSERT , 7/32" GLASS SPACER (REGULAR WIDTH SHOE)	
1	IGSN-140	NOZZLE SHOE RETAINING PIN	
1	IGSN-148	NOZZLE TIP BASE, 7/32" GLASS SPACER (FOR OPPOSITE-HAND HEAD)	
1	LC-016C-02-M	LEE SPRING, .240 O.D., .016 WIRE DIA, .750 FREE LENGTH, ENDS ARE GROUND, MUSIC WIRE	LEE SPRING
1	-011 VITON O-RING	-011 VITON O-RING, 5/16" ID X 7/16" OD X 1/16" CS	LUTZ
2	-012 VITON O-RING	-012 VITON O-RING, 3/8" ID X 1/2" OD X 1/16" CS	LUTZ
1	-013 VITON O-RING	-013 VITON O-RING, 7/16" ID X 9/16" OD X 1/16" CS	LUTZ
1	-105 SILICONE O-RING	-105 SILICONE O-RING, 5/32" ID X 11/32" OD X 3/32" CS	LUTZ
1	98404A103	SS QUICK-RELEASE PIN, 5/32" DIA, 1" USEABLE LENGTH	MCMASTER CARR



SECTION A-A

SECTION B-B

REPLACES

STOCKING STATUS

MIN

MAX

STANDARD PART

TOLERANCES:  
UNLESS OTHERWISE  
SPECIFIED

$.X = \pm 0.1$

$.XX = \pm 0.02$

$.XXX = \pm 0.005$

$.XXXX = \pm 0.0005$

ANGULAR  $\pm 1^\circ$

REMOVE ALL BURRS & SHARP  
EDGES

SAND RADIUS ALL CORNERS  
(1/8"-1/4") UNLESS NOTED

ALL DIMENSIONS ARE IN INCHES  
UNLESS OTHERWISE SPECIFIED.

HOLES SPECIFIED MAX  $\varnothing$   
SHOULD BE TAPPED TO FULL  
DEPTH OF STANDARD TAP

DO NOT SCALE  
THIS DRAWING

DESIGNED BY: BLH

DRAWN BY: BLH

DRAWN DATE: 6/6/2016

ERDMAN  
Automation  
Corp.

1603 So. 14th Street, Princeton, MN 55371

PART NAME: IG NOZZLE ASSEMBLY, 7/32" GLASS  
SPACER, SINGLE PUMP (FOR  
OPPOSITE-HAND HEAD)QUICK RELEASE  
PIN, PLASTIC SHOE.

REV:

FINISH: AS SPECIFIED

MATERIAL: AS SPECIFIED

PART #:

IGSN-A22

FAB Qty: 1

Erdman Job #: 150736

DRAWING  
SIZE

B

SHEET:  
1 OF 1

USED IN:

RETRO #

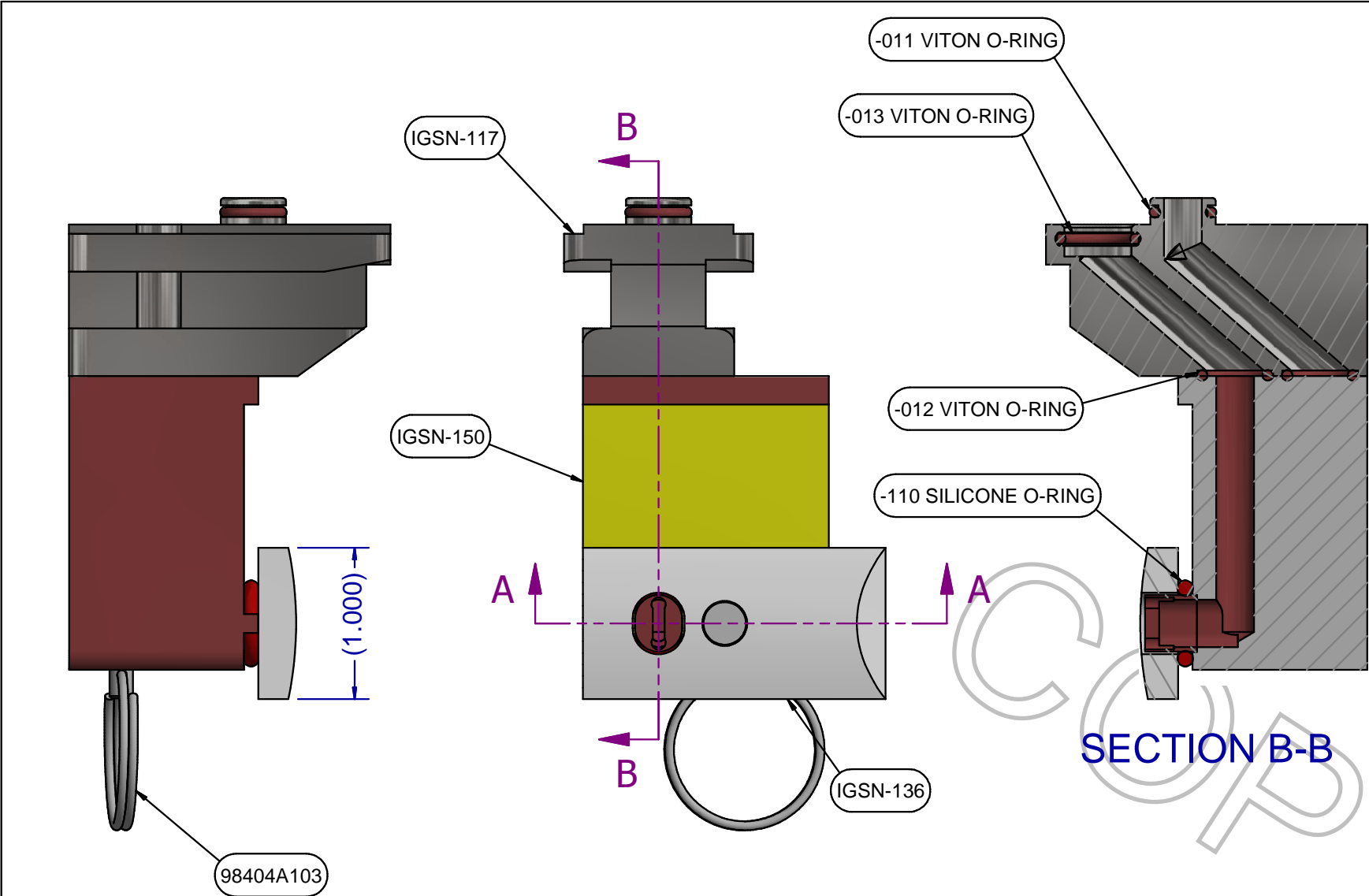
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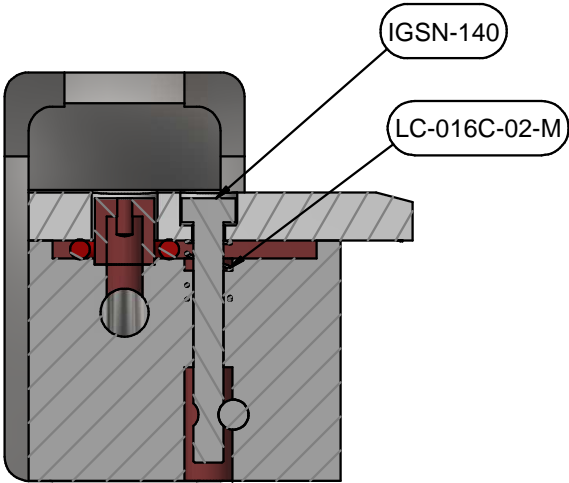
MFG By:

MFG Date:

MFG Quantity:



PARTS LIST			
QTY	PART NUMBER	DESCRIPTION	VENDOR
1	IGSN-117	NOZZLE BODY ADAPTER - DUAL PORT	
1	IGSN-136	NOZZLE TIP INSERT , 7/16" GLASS SPACER (WIDE SHOE)	
1	IGSN-140	NOZZLE SHOE RETAINING PIN	
1	IGSN-150	NOZZLE BLOCK WELDMENT, 7/16" GLASS SPACER (FOR OPPOSITE-HAND HEAD)	
1	LC-016C-02-M	LEE SPRING, .240 O.D., .016 WIRE DIA, .750 FREE LENGTH, ENDS ARE GROUND, MUSIC WIRE	LEE SPRING
1	-011 VITON O-RING	-011 VITON O-RING, 5/16" ID X 7/16" OD X 1/16" CS	LUTZ
2	-012 VITON O-RING	-012 VITON O-RING, 3/8" ID X 1/2" OD X 1/16" CS	LUTZ
1	-013 VITON O-RING	-013 VITON O-RING, 7/16" ID X 9/16" OD X 1/16" CS	LUTZ
1	-110 SILICONE O-RING	-110 SILICONE O-RING, 3/8" ID X 9/16" OD X 3/32" CS	LUTZ
1	98404A103	SS QUICK-RELEASE PIN, 5/32" DIA, 1" USEABLE LENGTH	MCMASTER CARR



SECTION A-A

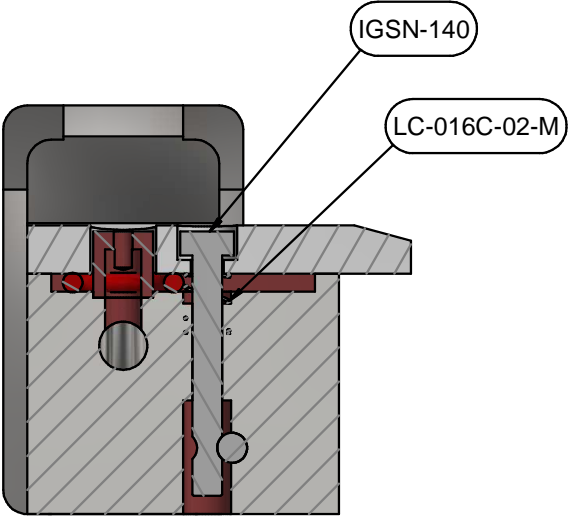
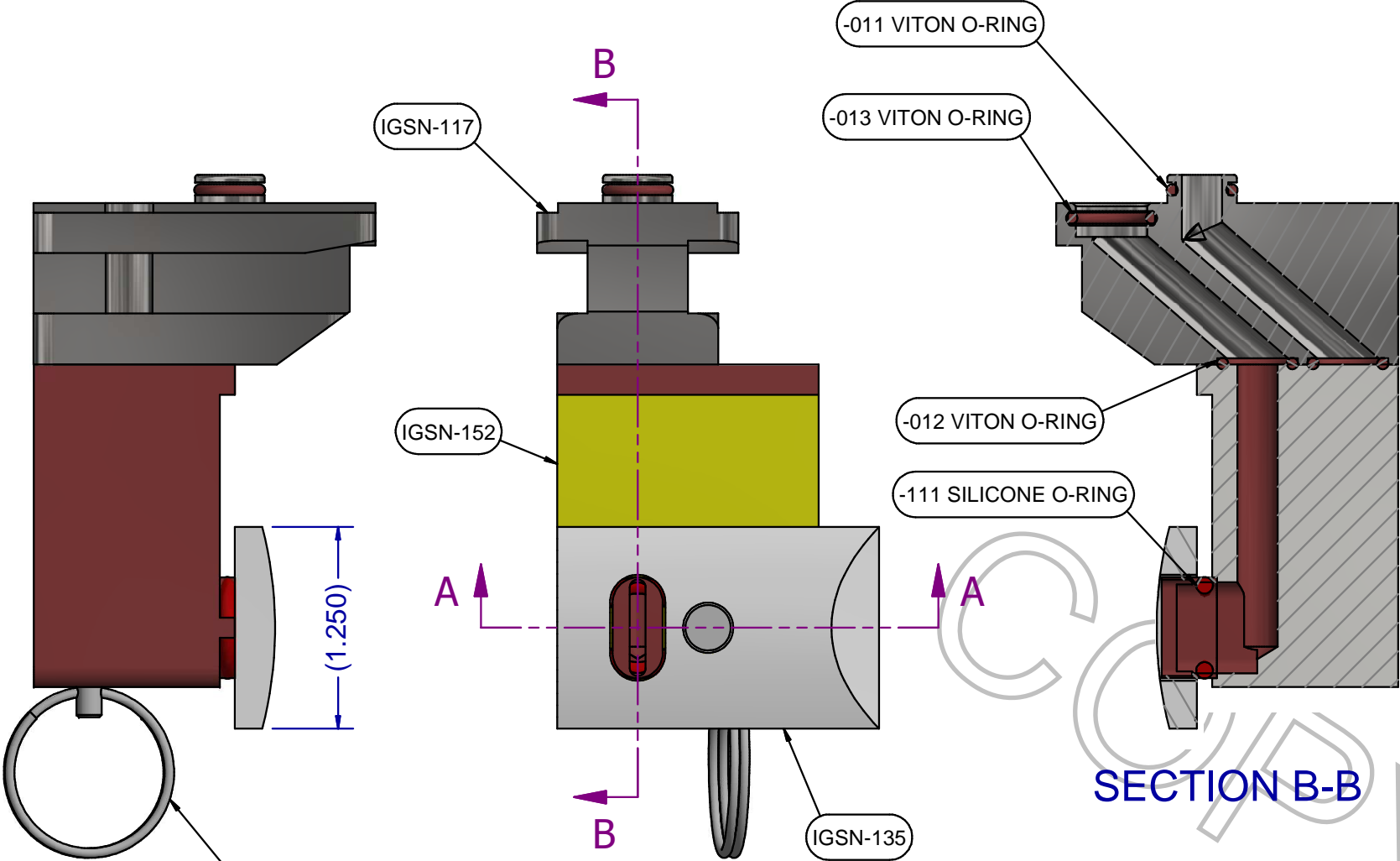
SECTION B-B

REPLACES	STOCKING STATUS	
	MIN	MAX

STANDARD PART

<b>TOLERANCES: UNLESS OTHERWISE SPECIFIED</b>  X = ± 0.1    .XXX = ± 0.005 .XX = ± 0.02    .XXXX = ± 0.0005 ANGULAR ± 1°		DESIGNED BY: BLH DRAWN BY: BLH DRAWN DATE: 6/6/2016		<b>ERDMAN</b> Automation Corp. 1603 So. 14th Street, Princeton, MN 55371	
<b>CONFIDENTIAL</b> - THE INFORMATION IN THIS DOCUMENT IS STRICTLY PROPRIETARY TO ERDMAN AUTOMATION CORP. AND MAY NOT BE DISCLOSED TO NON-EMPLOYEES OF THE COMPANY WITHOUT THE EXPRESS WRITTEN CONSENT OF ERDMAN AUTOMATION CORP. UNAUTHORIZED USE, REPRODUCTION, DISCLOSURE, OR RETENTION OF ANY INFORMATION CONTAINED HEREIN IS EXPRESSLY PROHIBITED. ALL PATENT, COPYRIGHT, AND MANUFACTURING RIGHTS ARE RESERVED.  COPYRIGHT ERDMAN AUTOMATION CORPORATION ALL RIGHTS RESERVED		PART NAME: IG NOZZLE ASSEMBLY, 7/16" GLASS SPACER, SINGLE PUMP (FOR OPPOSITE-HAND HEAD)QUICK RELEASE PIN, PLASTIC SHOE.		REV: 1	
SHEET: 1 OF 1 RETRO #		FINISH: AS SPECIFIED MATERIAL: AS SPECIFIED		PART #: IGSN-A23	
FAB Qty: 1		Erdman Job #: 150736			

PARTS LIST			
QTY	PART NUMBER	DESCRIPTION	VENDOR
1	IGSN-117	NOZZLE BODY ADAPTER - DUAL PORT	
1	IGSN-135	NOZZLE TIP INSERT , 11/16" GLASS SPACER (REGULAR WIDTH SHOE)	
1	IGSN-140	NOZZLE SHOE RETAINING PIN	
1	IGSN-152	NOZZLE BLOCK WELDMENT, 11/16" GLASS SPACER (FOR OPPOSITE-HAND HEAD)	
1	LC-016C-02-M	LEE SPRING, .240 O.D., .016 WIRE DIA, .750 FREE LENGTH, ENDS ARE GROUND, MUSIC WIRE	LEE SPRING
1	-011 VITON O-RING	-011 VITON O-RING, 5/16" ID X 7/16" OD X 1/16" CS	LUTZ
2	-012 VITON O-RING	-012 VITON O-RING, 3/8" ID X 1/2" OD X 1/16" CS	LUTZ
1	-013 VITON O-RING	-013 VITON O-RING, 7/16" ID X 9/16" OD X 1/16" CS	LUTZ
1	-111 SILICONE O-RING	-111 SILICONE O-RING, 7/16" ID X 5/8" OD X 3/32" CS	LUTZ
1	98404A103	SS QUICK-RELEASE PIN, 5/32" DIA, 1" USEABLE LENGTH	MCMASTER CARR



SECTION A-A

SECTION B-B

DRAWING  
SIZE  
B

REPLACES		<b>STANDARD PART</b>		STOCKING STATUS	
				MIN	MAX
<b>TOLERANCES: UNLESS OTHERWISE SPECIFIED</b>  X = ± 0.1 .XX = ± 0.02 XXX = ± 0.005 .XXXX = ± 0.0005 ANGULAR ± 1°		DESIGNED BY: BLH DRAWN BY: BLH DRAWN DATE: 6/6/2016		<b>ERDMAN</b> Automation Corp. 1603 So. 14th Street, Princeton, MN 55371	
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SHEET: 1 OF 1 RETRO #		FINISH: AS SPECIFIED MATERIAL: AS SPECIFIED		PART #: <b>IGSN-A24</b>	
		FAB Qty: 1		Erdman Job #: <b>150736</b>	