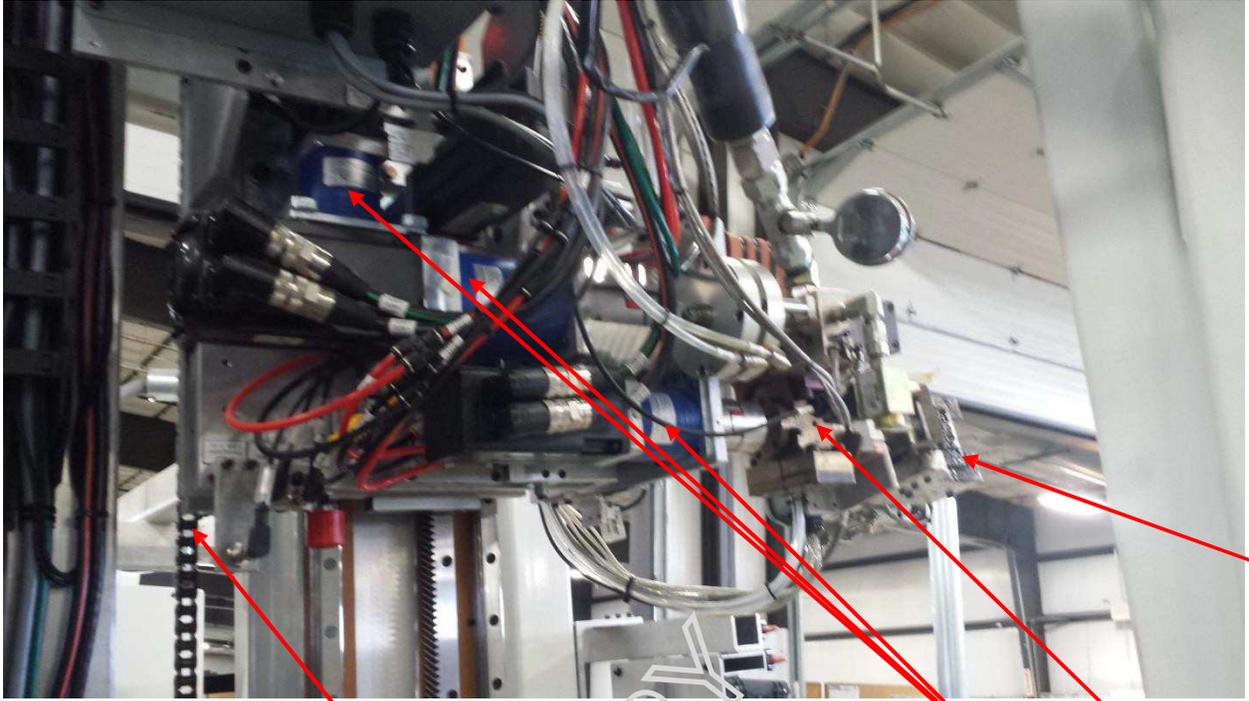


# 7500 TWO HEADED SEALER

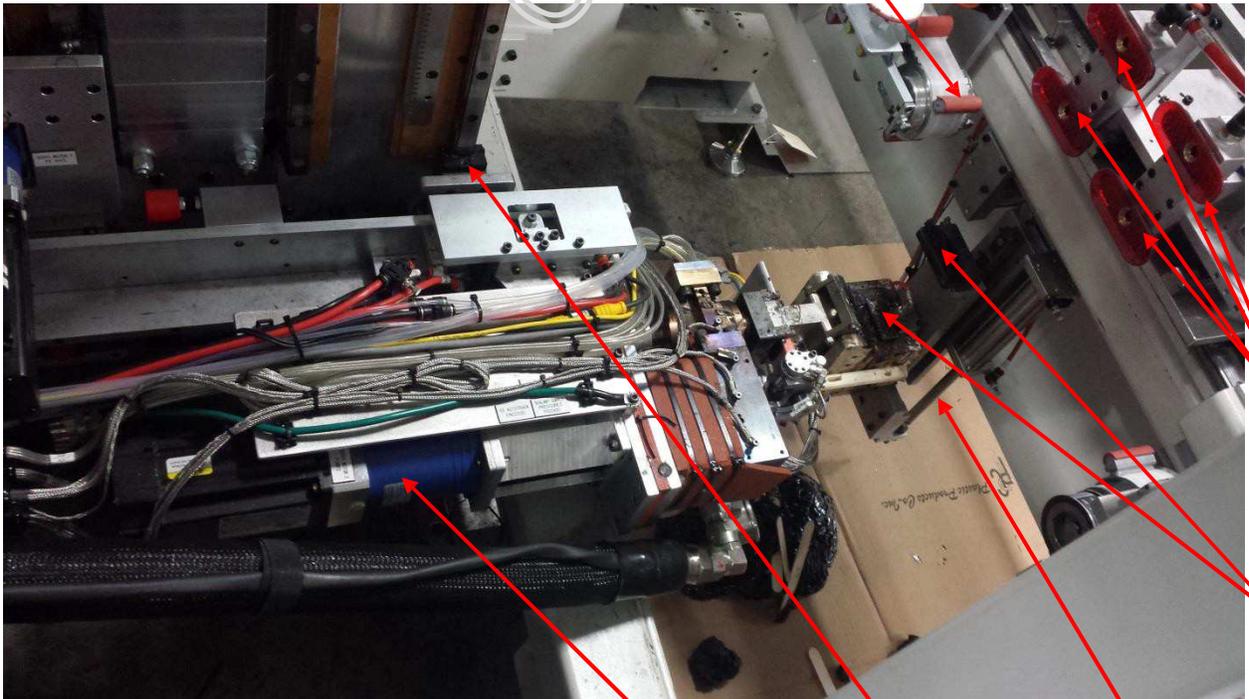
## MAINTENANCE INSTRUCTIONS



# Upper head



# Lower head



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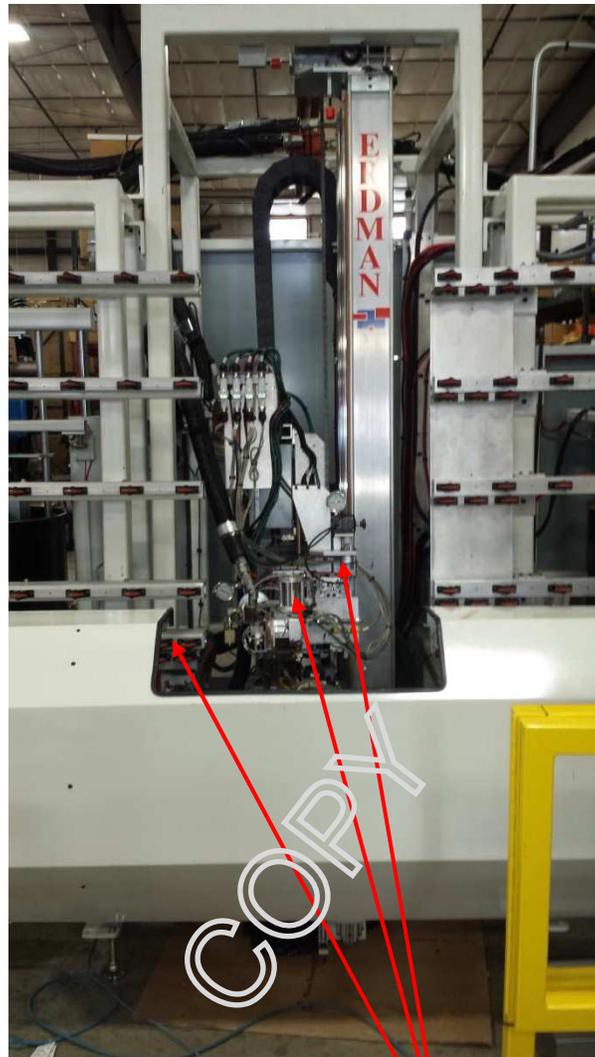


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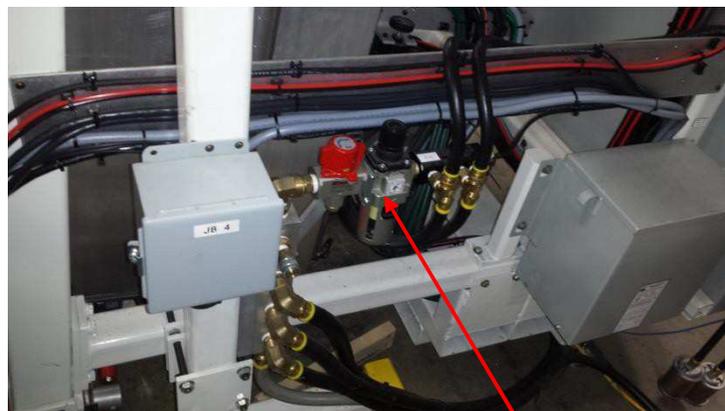
12

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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

Clean rollers with clean dry lint free rag (dampen rag with warm water if they need to be scrubbed)



### 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 or monthly



6. Spare nozzle heater box

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



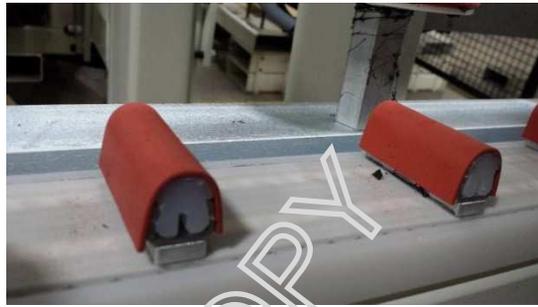
7. Air cylinder

- 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 or every 6 months



## 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



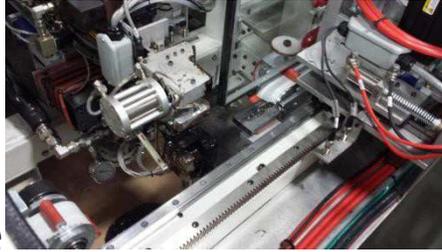
## 11. Pneumatic regulator

- 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.



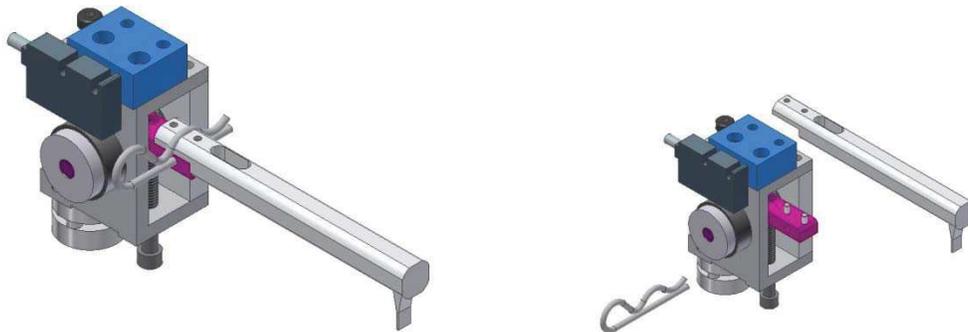
b. While hot use tongue depressor to wipe excess sealant off nozzle and corner wiper. Be careful to not get burned. The nozzle and wiper will be hot.

c. Should be done as needed or once per shift.

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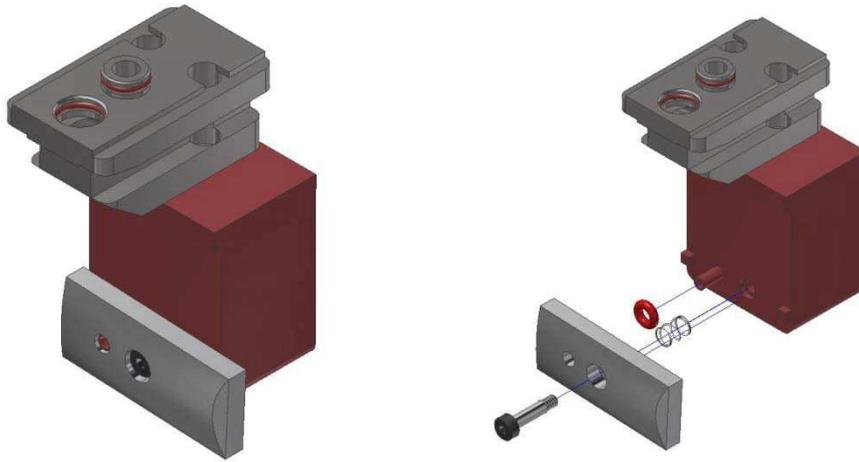


## 15. Upper and lower depth probe change out.



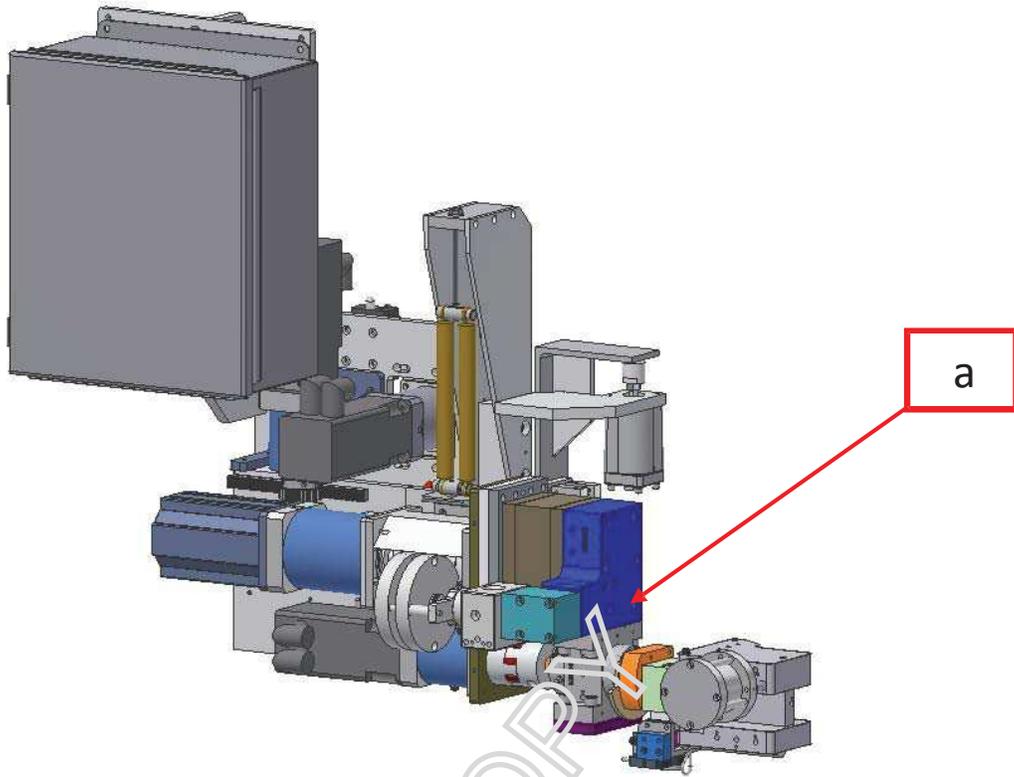
- a. Place machine into purge mode.
- b. Once in purge mode. Open the safety gate.
- c. Locate the desired probe to be changed out (upper or lower head)
- d. Remove the hitch pin clip.
- e. Lift depth probe off of dowel pins.
- f. Replace with new depth probe. (Be sure that new probe is located properly 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.

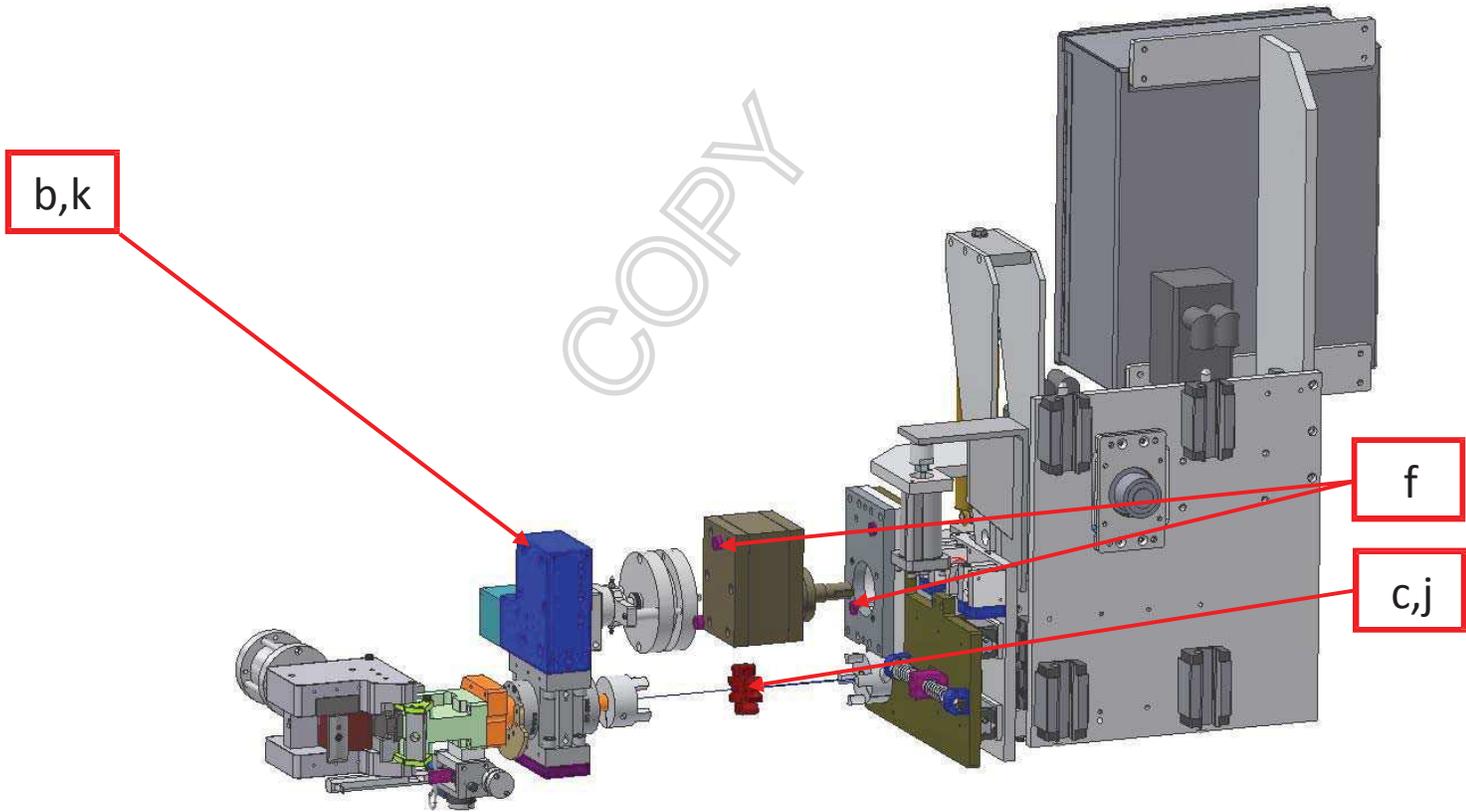
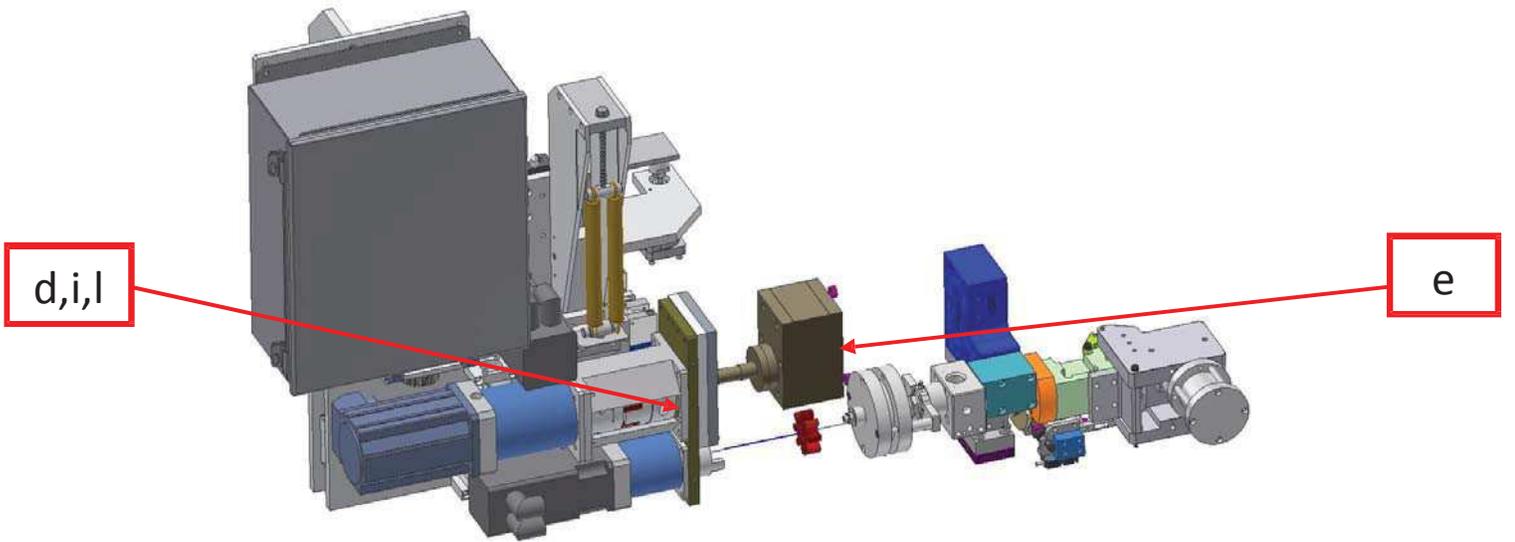
## 16. Nozzle pad change out



- 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.

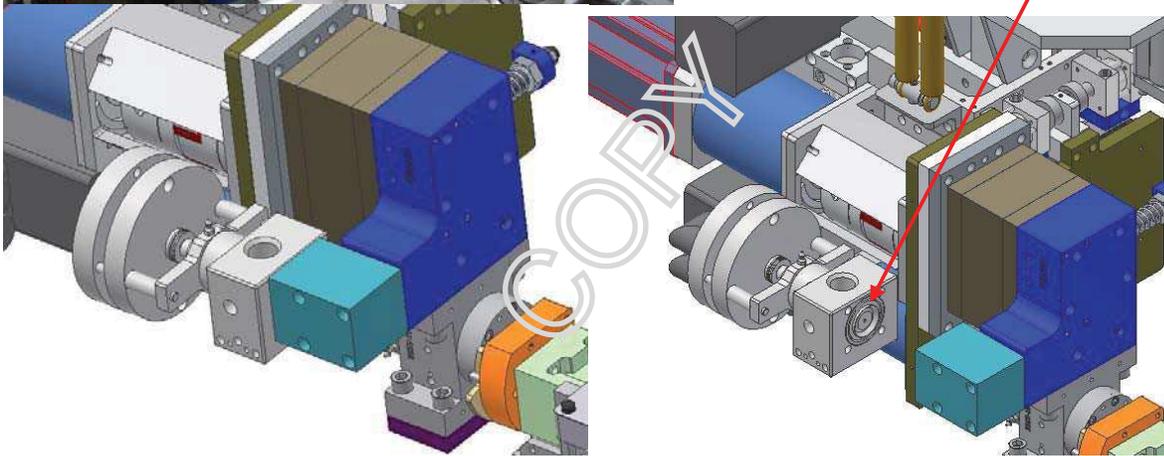


- a. With machine powered down. Determine which heater has failed by using an ohm meter to check resistance.(consult your wiring diagram for proper wattage and resistance)
- b. After locating faulty heater remove it by removing the retaining shoulder bolt.
- c. Gently pull the heater element out of the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

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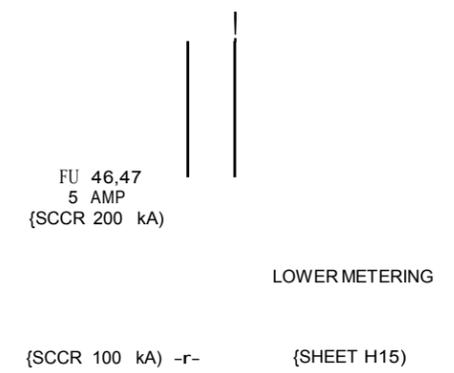
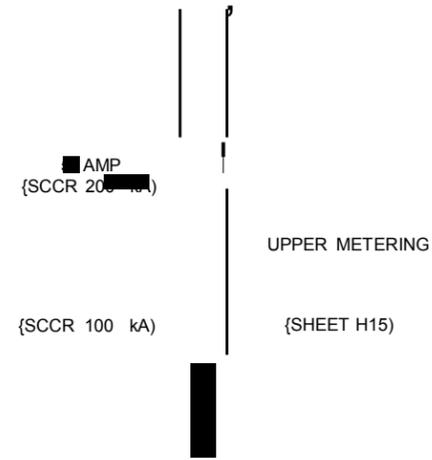
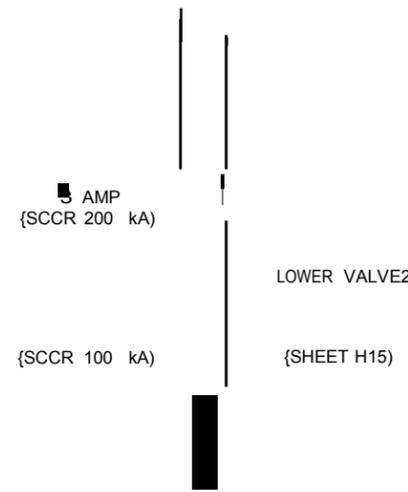
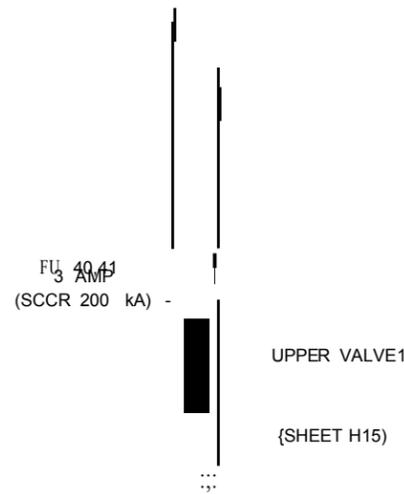
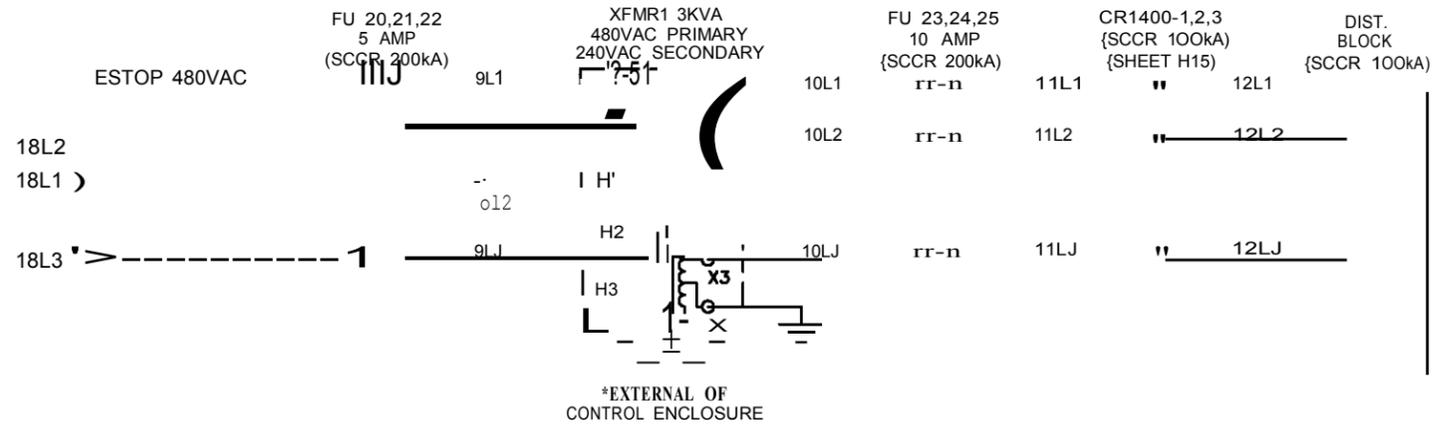
## 19. FMS valve replacement.



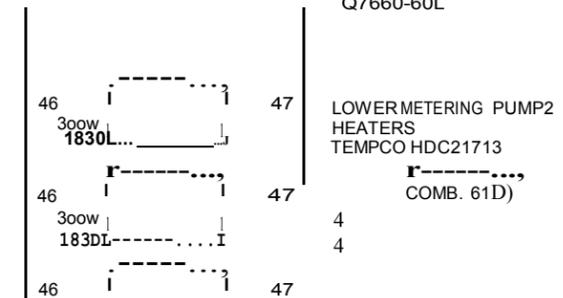
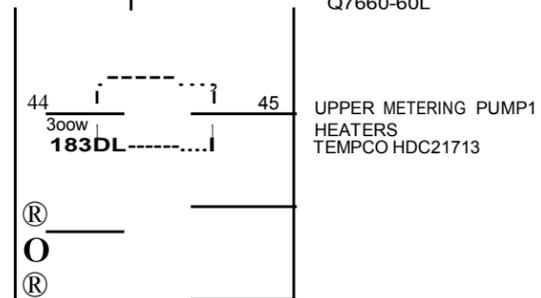
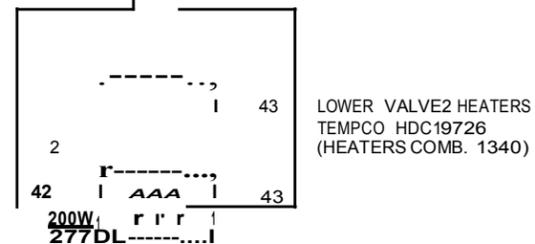
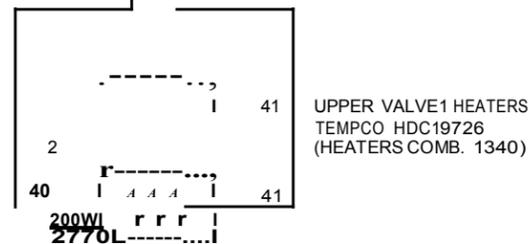
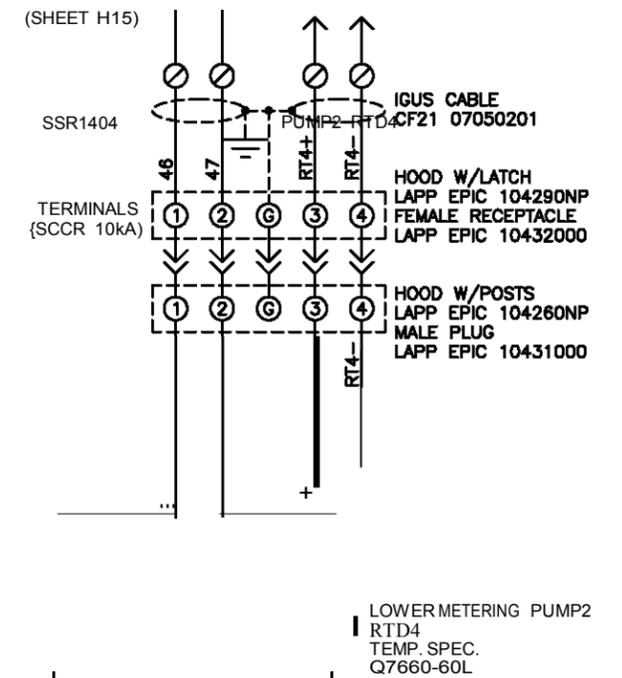
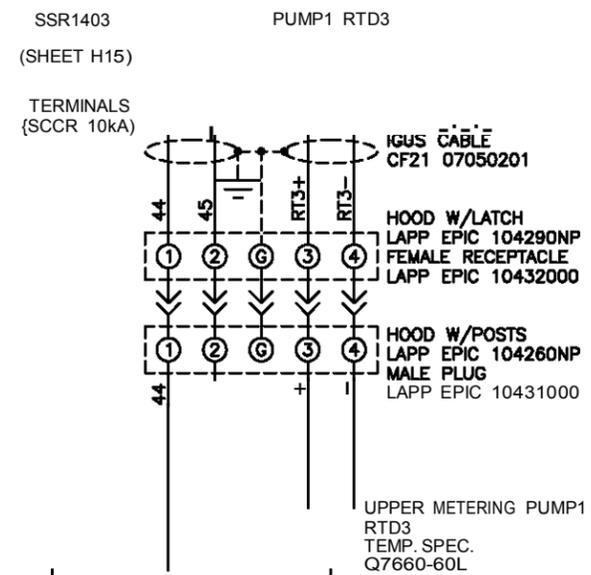
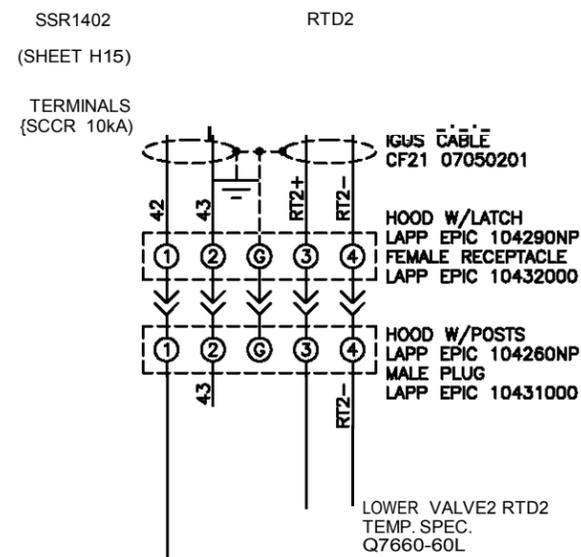
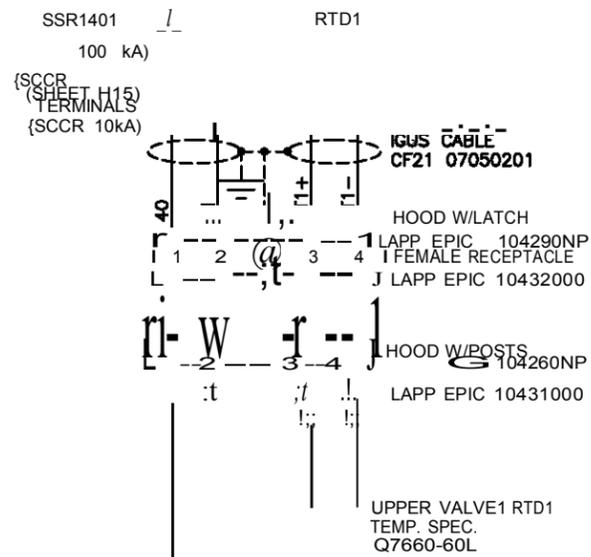
- a. With the machine cool and shut down locate the FMS valve that needs to be replaced.
- b. Remove the supply hose and pressure switch fittings and airlines.
- c. Remove heaters and RTD by removing the retaining shoulder bolts.
- d. Remove the 4 valve mounting bolts and remove valve. Take care to make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

COPY

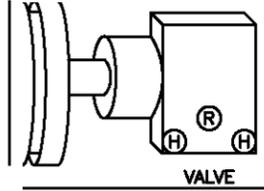
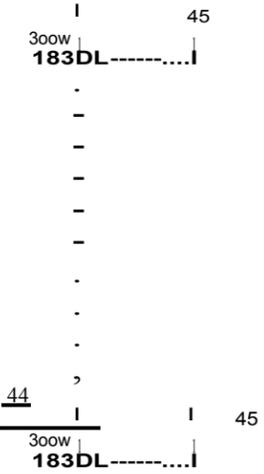


> 12L1  
> 12L2  
> 12L3



(HEATERS)

(HEATERS COMB. 6HI)



- @ RTD TEMPERATURE SENSOR
- @ HEATER
- O UNUSED HOLE

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**Automation**  
**Corp.**  
 1603 S 14TH ST, Princeton, MN 55371

Description: IG GLAZER  
 HEATER CONNECTIONS  
 Drawn By: JPP      Dwg: 131522 H5  
 Date: 3 / 2014      Sheet 5 of 17

COPY


3 AMP  
(SCCR 200 IeA) -

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(SCCR 200 IeA)

3 AMP  
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(SCCR 200 IeA)

(SHEET H13)

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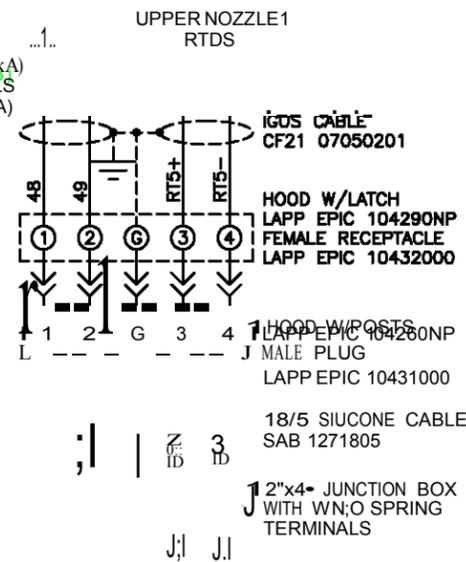
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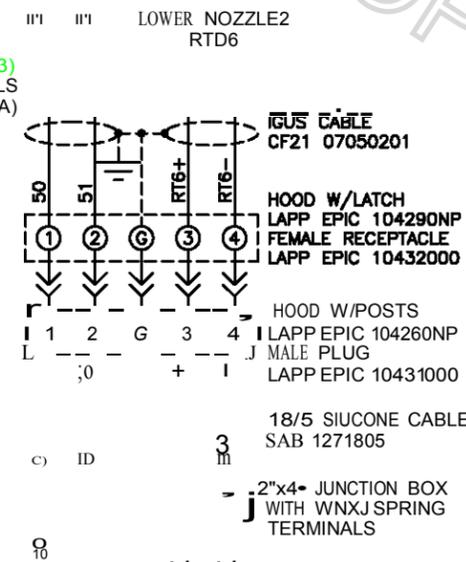
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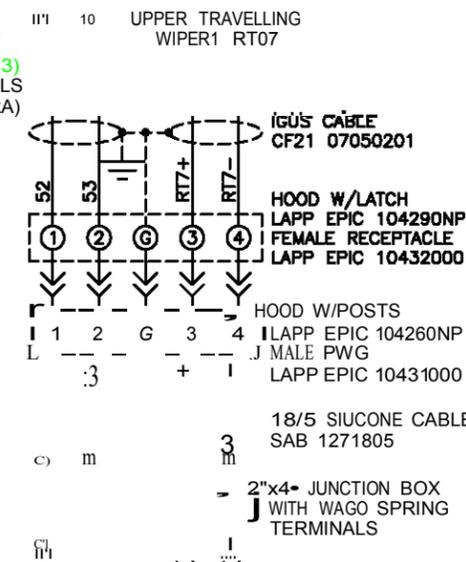
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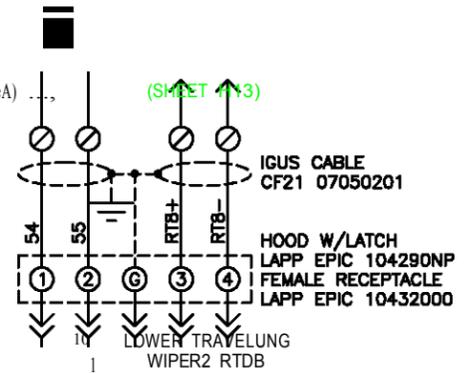
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SSR1407  
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(SCCR 10kA)



(SHEET H13)  
TERMINALS  
(SCCR 10kA)



49 UPPER NOZZLE1  
HEATERS  
TEMPCO HDC19726  
(HEATERS COMB, 920)

51 LOWER NOZZLE2  
HEATERS  
TEMPCO HDC19726  
(HEATERS COMB, 920)

53 UPPER TRAVELWNG  
WIPER1 HEATERS  
TEMPCO HDC19726  
(HEATERS COMB, 1340)

55 LOWER TRAVELWNG  
WIPER2 HEATERS  
TEMPCO HDC19726  
(HEATERS COMB, 1340)

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@ RTD TEMPERATURE SENSOR  
@HEATER

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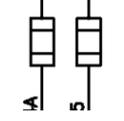
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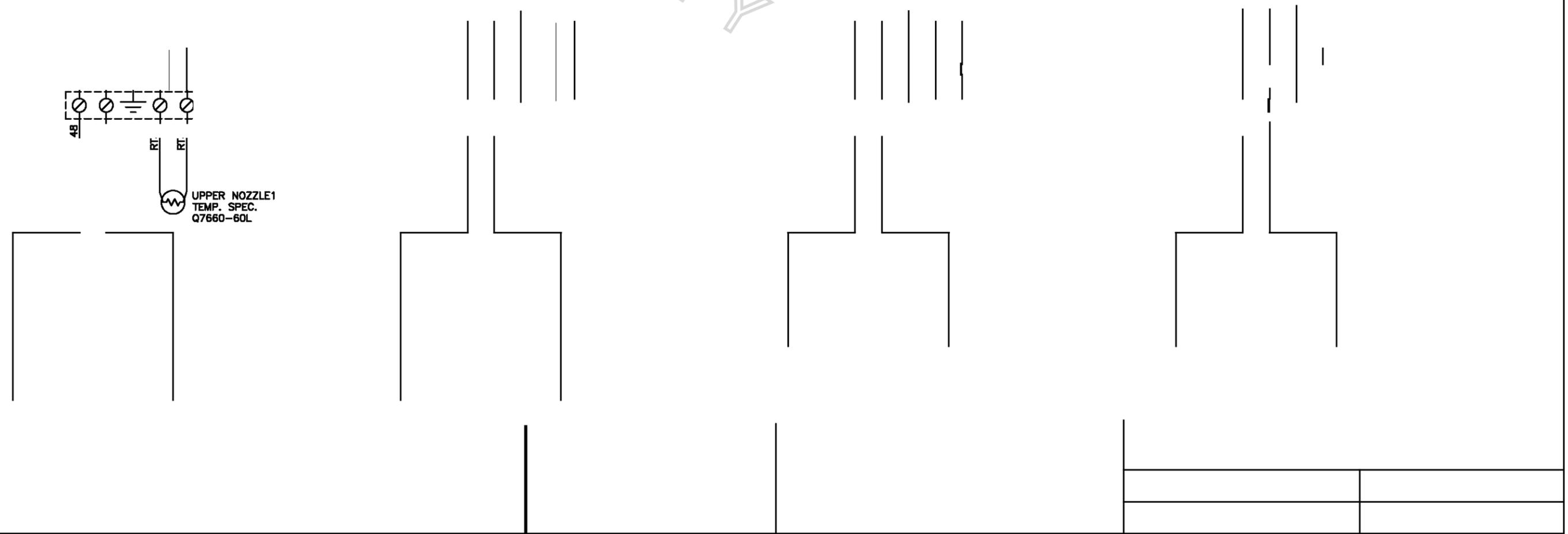
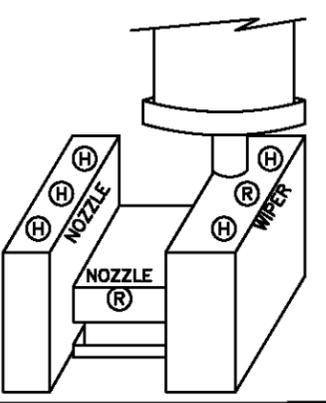
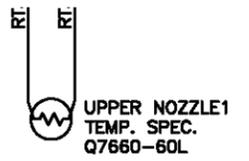
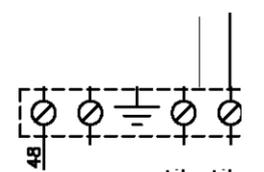
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1603 S 14TH ST, Princeton, MN 55371

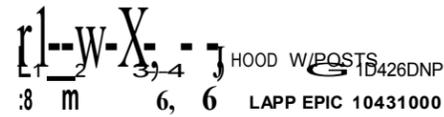
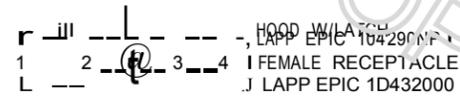
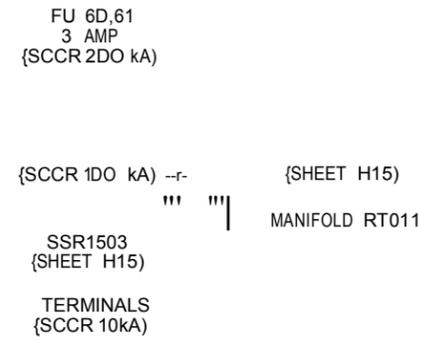
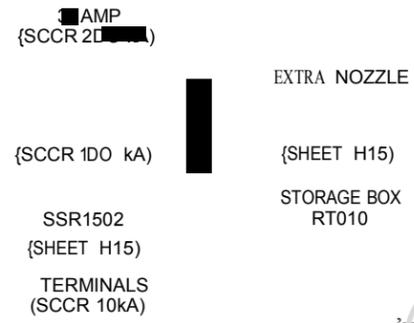
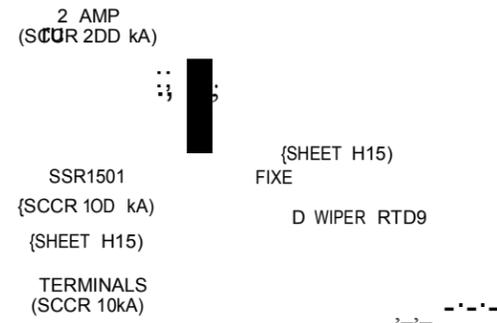
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HEATER CONNECTIONS

Drawn By: JPP Dwg: 131522 H6  
Date: 3 / 2014 Sheet 6 of 17

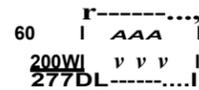
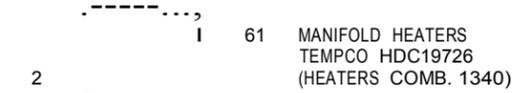
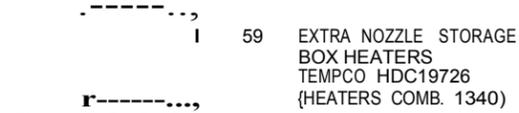


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Machining Time:

Welding Time:

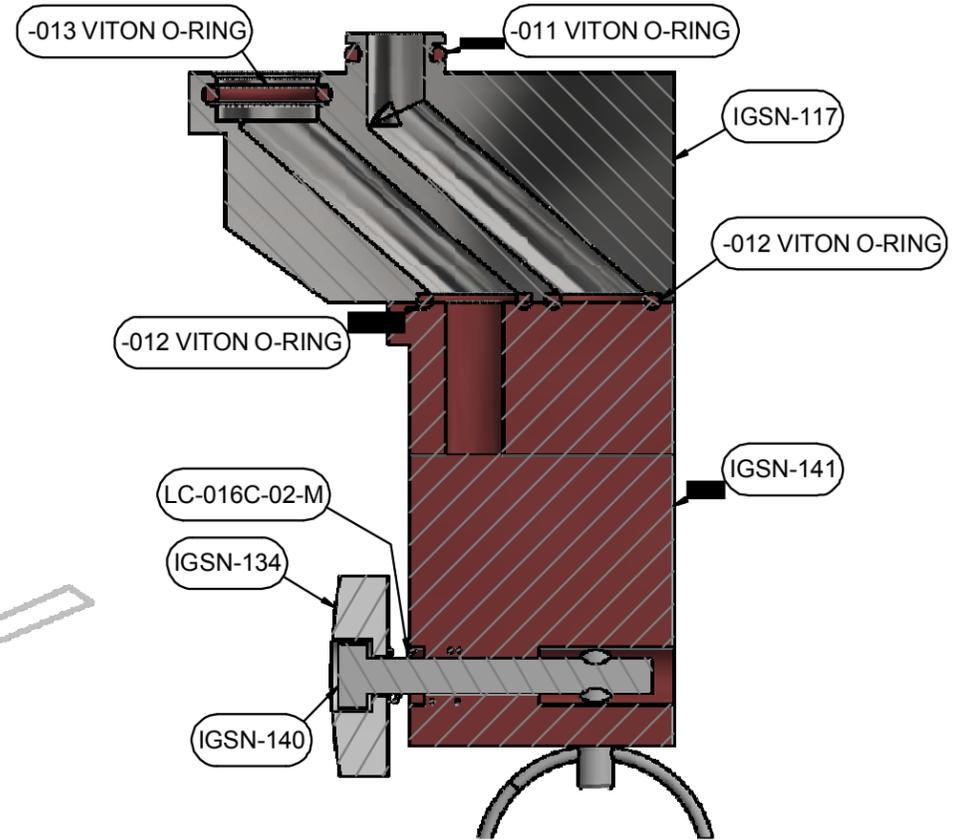
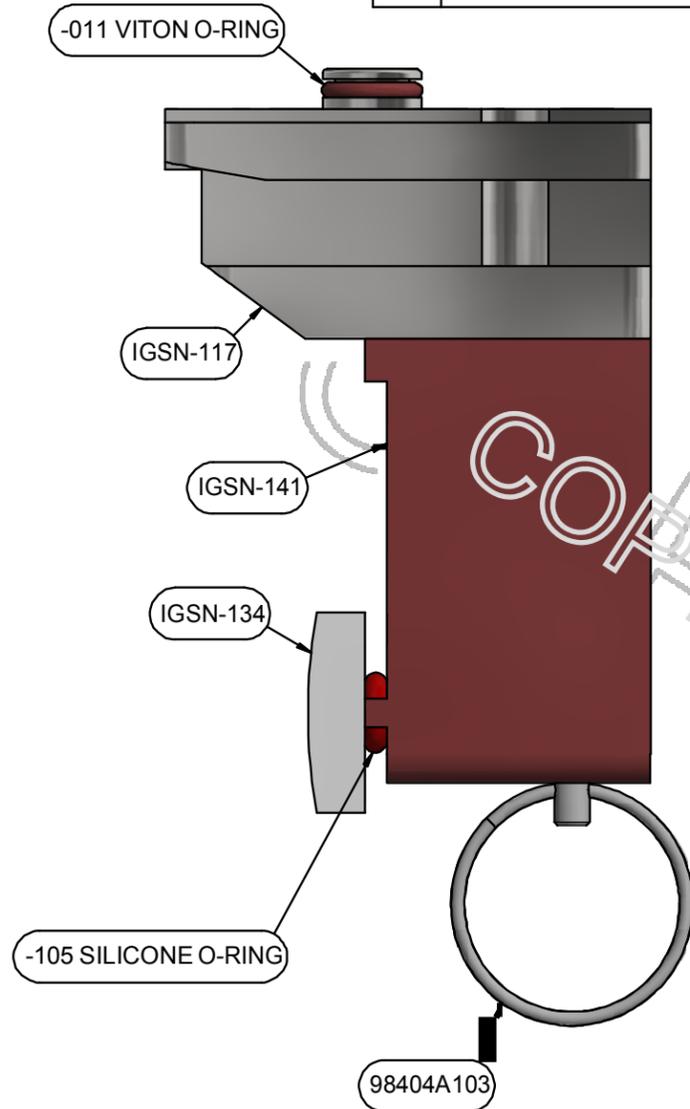
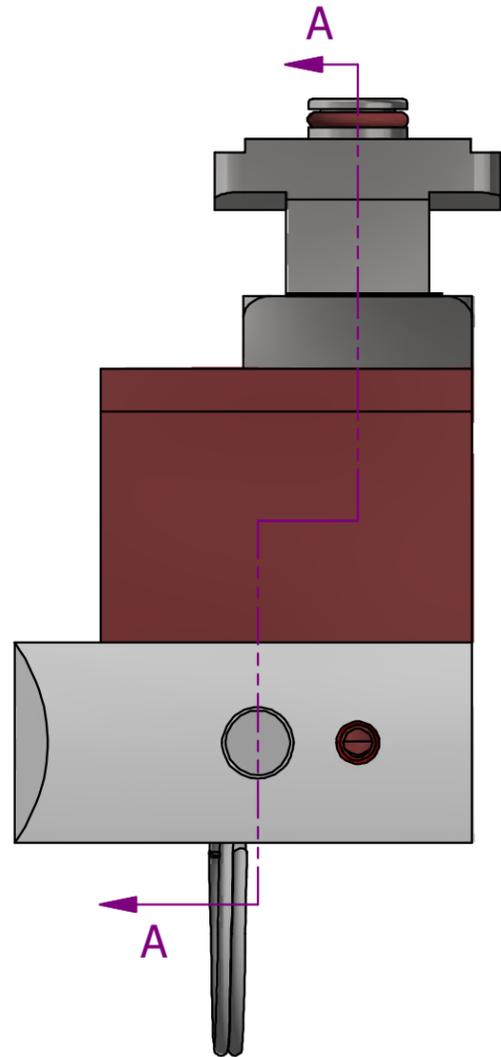
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Finishing:

Misc. Time/Cost:

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 SS	LUTZ
1	98404A103	QUICK-RELEASE PIN, 5/32" DIA, 1" USEABLE LENGTH	MCMaster CARR



REPLACES	<b>STANDARD PART</b>	STOCKING STATUS	
		MIN	MAX

<p><b>TOLERANCES: UNLESS OTHERWISE SPECIFIED</b></p> <p>X = ±0.1    .XXX = ±0.005          .XX = ±0.02    .XXXX = ±0.0005          ANGULAR ±1°</p> <p><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.</p> <p><small>COPYRIGHT ERDMAN AUTOMATION CORPORATION ALL RIGHTS RESERVED</small></p>	<p>DESIGNED BY: GWD          Y: GWD          DRAWN B: 6/6/2016          DRAWN DATE:</p>	<p><b>ERDMAN</b> Automation Corp. 1603 So. 14th Street, Princeton, MN 55371</p>
	<p>REMOVE ALL BURRS &amp; SHARP EDGES          SAND RADIUS ALL CORNERS (1/8"-1/4") UNLESS NOTED          ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.          HOLES SPECIFIED MAX T SHOULD BE TAPPED TO FULL DEPTH OF STANDARD TAP  <b>DO NOT SCALE THIS DRAWING</b></p>	
<p>DRAWING SIZE: <b>B</b></p> <p>SHEET: 1 OF 1          MFG By:                      MFG Date:                      MFG                      Quantity:</p>	<p>FINISH: AS SPECIFIED          MATERIAL: AS SPECIFIED</p>	<p>REV:                      PART #:  <b>IGSN-A19</b>  <b>RETRO #</b></p>

\*150736+A19+1+1\*

Sawing Time:

Machining Time:

Welding Time:

Paint Time:

Finishing:

Misc. Time/Cost:

Erdman Job #:

**150736**

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Sawing Time:

Machining Time:

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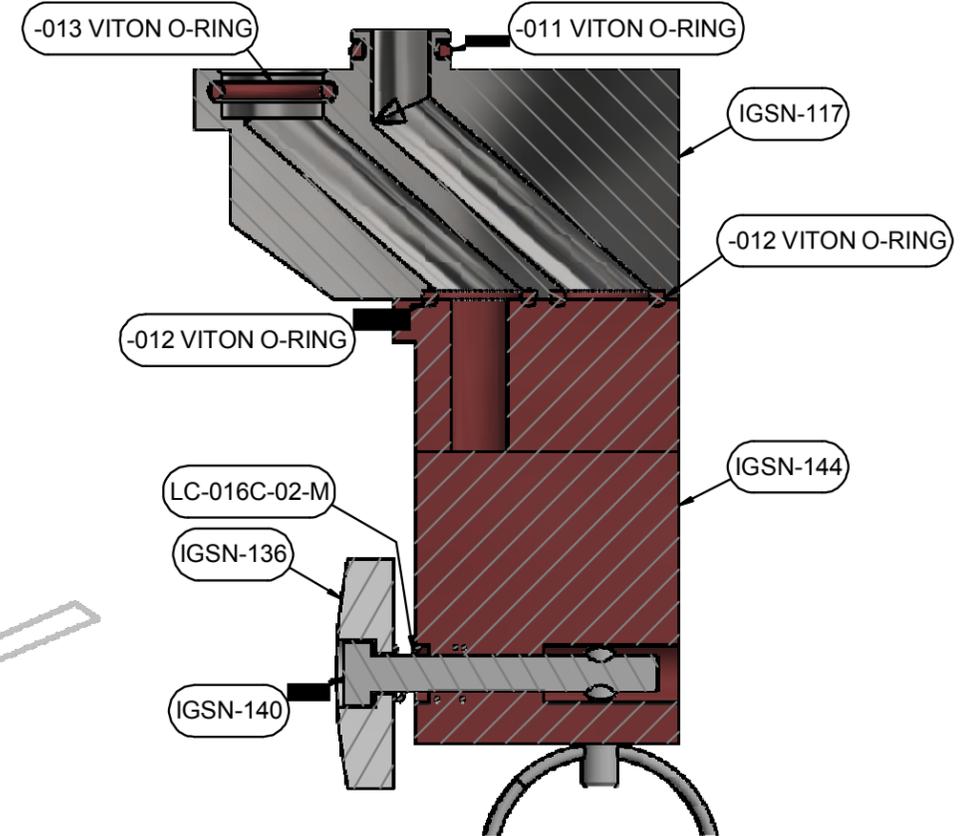
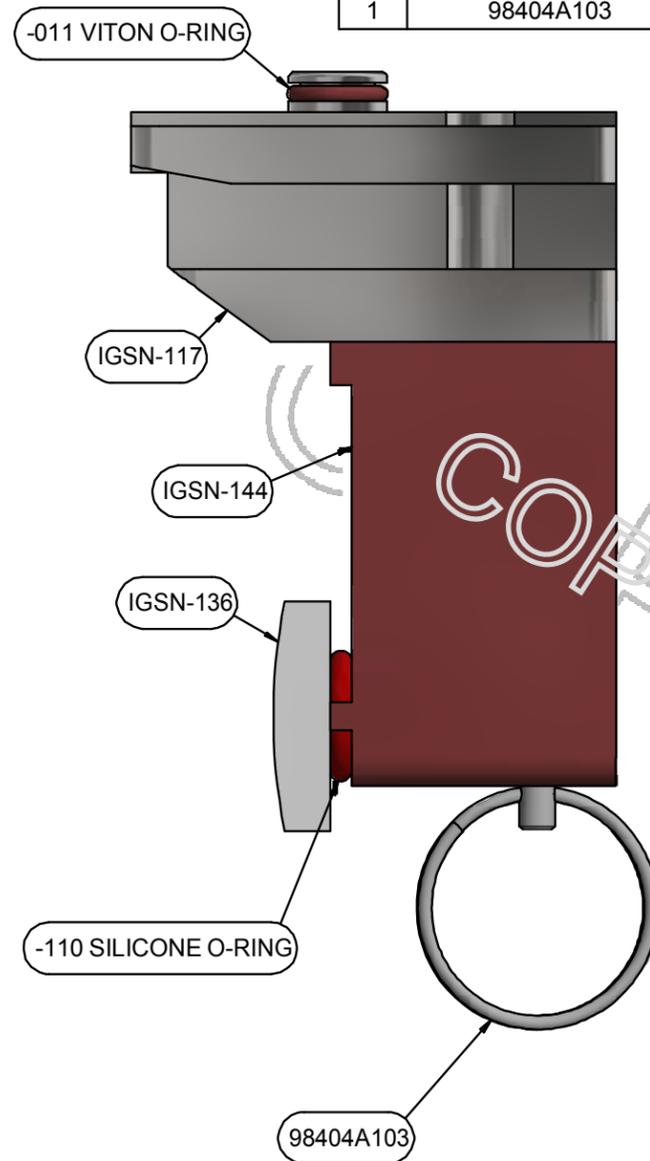
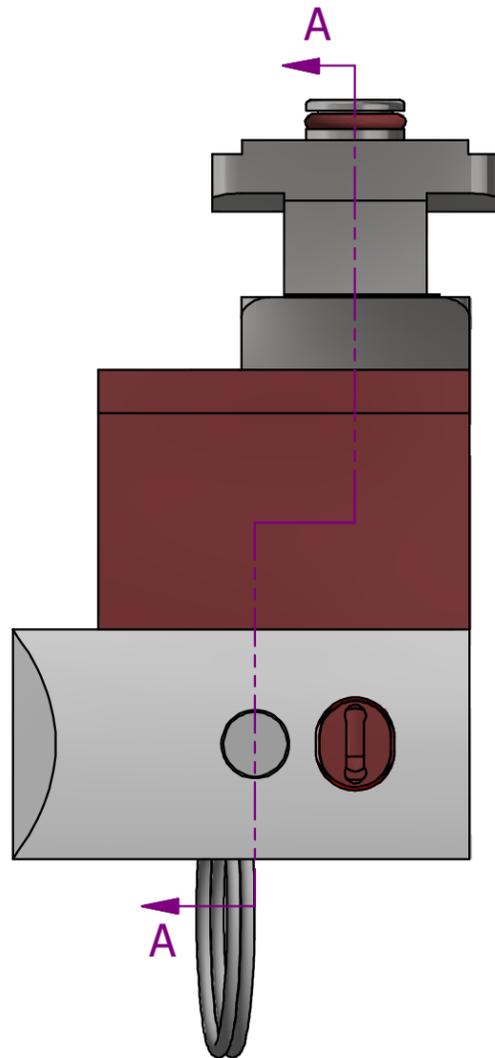
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Finishing:

Misc. Time/Cost:

PARTS LIST

QTY	PART NUMBER	DESCRIPTION	VENDOR
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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	<b>STANDARD PART</b>	STOCKING STATUS	
		MIN	MAX

<b>TOLERANCES: UNLESS OTHERWISE SPECIFIED</b>  X = ± 0.1    .XXX = ± 0.005 .XX = ± 0.02    .XXXX = ± 0.0005 ANGULAR ± 1'	<small>REMOVE ALL BURRS &amp; SHARP EDGES</small> <small>SAND RADIUS ALL CORNERS (1/8"-1/4") UNLESS NOTED</small> <small>ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.</small> <small>HOLES SPECIFIED MAX T SHOULD BE TAPPED TO FULL DEPTH OF STANDARD TAP</small> <b>DO NOT SCALE THIS DRAWING</b>	DESIGNED BY: CLS Y: GWD DRAWN B 6/6/2016 DRAWN DATE:	<b>ERDMAN</b> Automation Corp. 1603 So. 14th Street, Princeton, MN 55371		
	<small>CONFIDENTIAL - 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.</small> <small>COPYRIGHT ERDMAN AUTOMATION CORPORATION ALL RIGHTS RESERVED</small>	PART NAME: IG NOZZLE ASSEMBLY, 7/16" GLASS SPACER, SINGLE PUMP, QUICK RELEASE PIN, PLASTIC SHOE.		<b>REV:</b> PART #:	
DRAWING SIZE <b>B</b>	FINISH: AS SPECIFIED MATERIAL: AS SPECIFIED	SHEET: 1 OF 1 MFG By:	MFG Date:	MFG Quantity:	<b>IGSN-A20</b> <b>RETRO #</b>

\*150736+A20+1+1\*

Sawing Time:

Machining Time:

Welding Time:

Paint Time:

Finishing:

Misc. Time/Cost:

Erdman Job #:

**150736**

COPY

Sawing Time:

Machining Time:

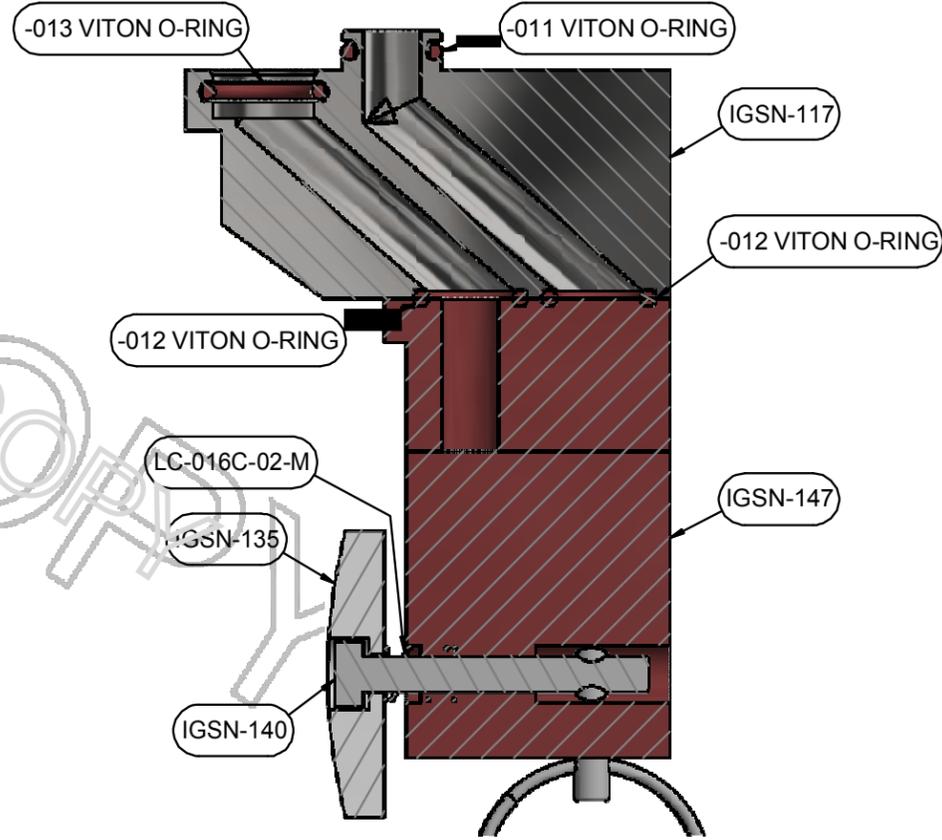
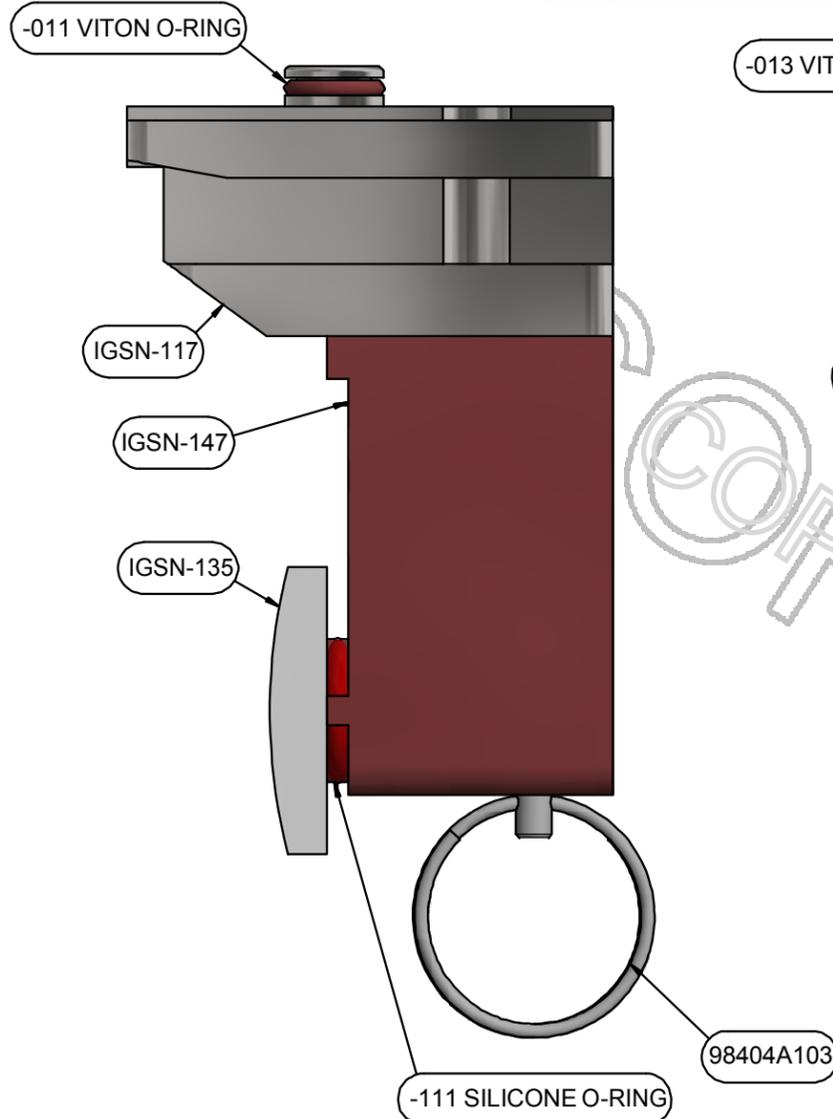
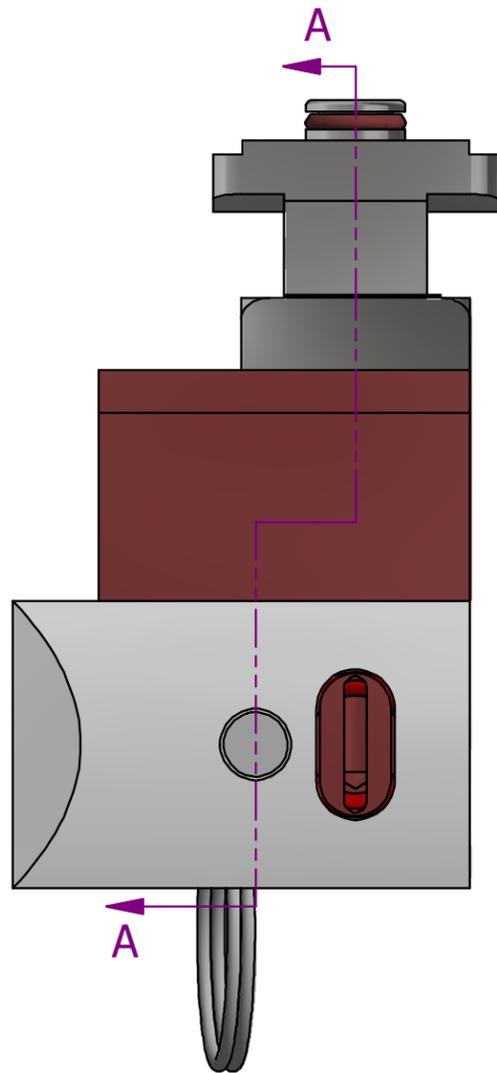
Welding Time:

Paint Time:

Finishing:

Misc. Time/Cost:

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	<b>STANDARD PART</b>	STOCKING STATUS	
		MIN	MAX

<b>TOLERANCES: UNLESS OTHERWISE SPECIFIED</b>  X = ±0.1    XXX = ±0.005 .XX = ±0.02    .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.	DESIGNED BY: GWD DRAWN BY: GWD DRAWN DATE: 6/6/2016	<b>ERDMAN</b> Automation Corp. <small>1603 So. 14th Street, Princeton, MN 55371</small>
	<b>DO NOT SCALE THIS DRAWING</b>	PART NAME: IG NOZZLE ASSEMBLY, 11/16" GLASS SPACER, SINGLE PUMPQUICK RELEASE PIN, PLASTIC SHOE.	
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DRAWING SIZE <b>B</b>	SHEET: 1 OF 1 <b>RETRO #</b>	USED IN:	<b>FAB Qty: 1</b> Erdman Job #: <b>150736</b>

MFG By:

MFG Date:

MFG Quantity:

\*150736+A21+1+1\*

Sawing Time:

Machining Time:

Welding Time:

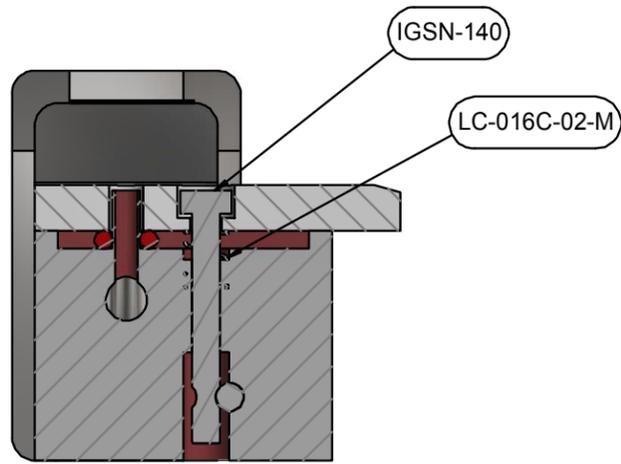
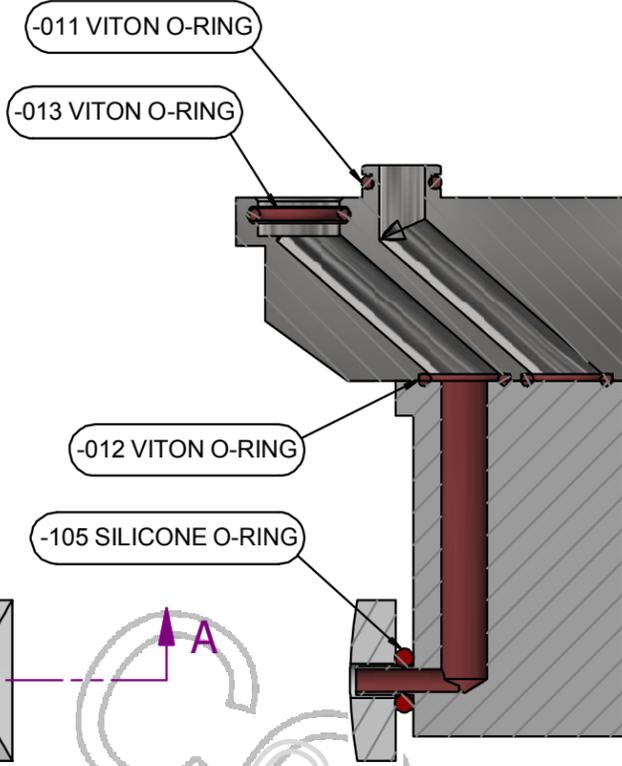
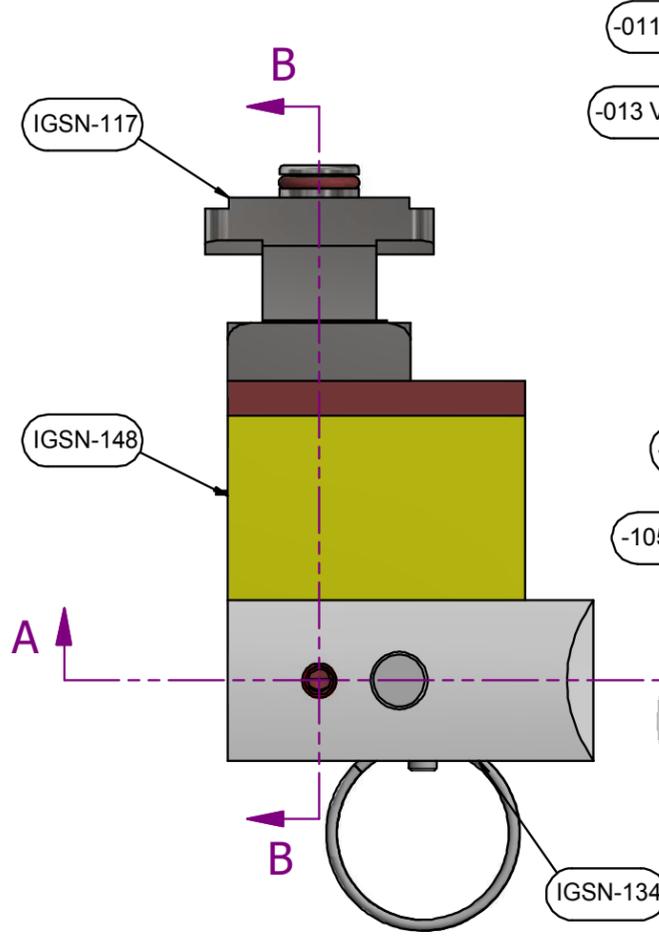
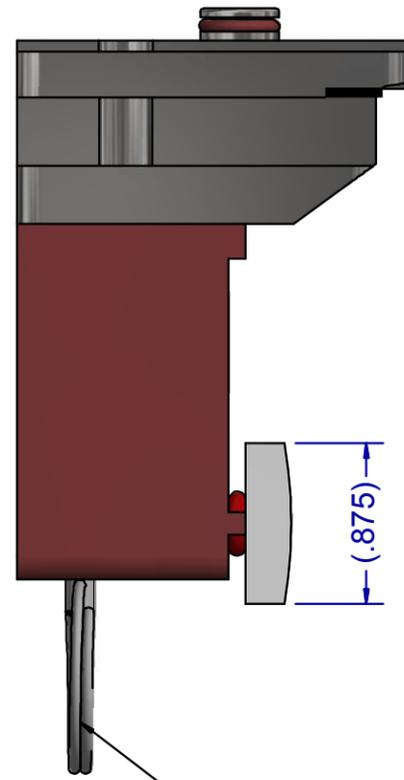
Paint Time:

Finishing:

Misc. Time/Cost:

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	<b>STANDARD PART</b>	STOCKING STATUS	
		MIN	MAX

**TOLERANCES: UNLESS OTHERWISE SPECIFIED**

.X = ±0.1    .XXX = ±0.005  
 .XX = ±0.02    .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  $\nabla$  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.

FINISH: AS SPECIFIED  
 MATERIAL: AS SPECIFIED

REVISIONS:  
 REV: **IGSN-A22**

SHEET: 1 OF 1  
 USED IN: **RETRO #**

FAB Qty: **1**    Erdman Job #: **150736**

MFG By:                      MFG Date:                      MFG Quantity:

\*150736+A22+1+1\*

Sawing Time:

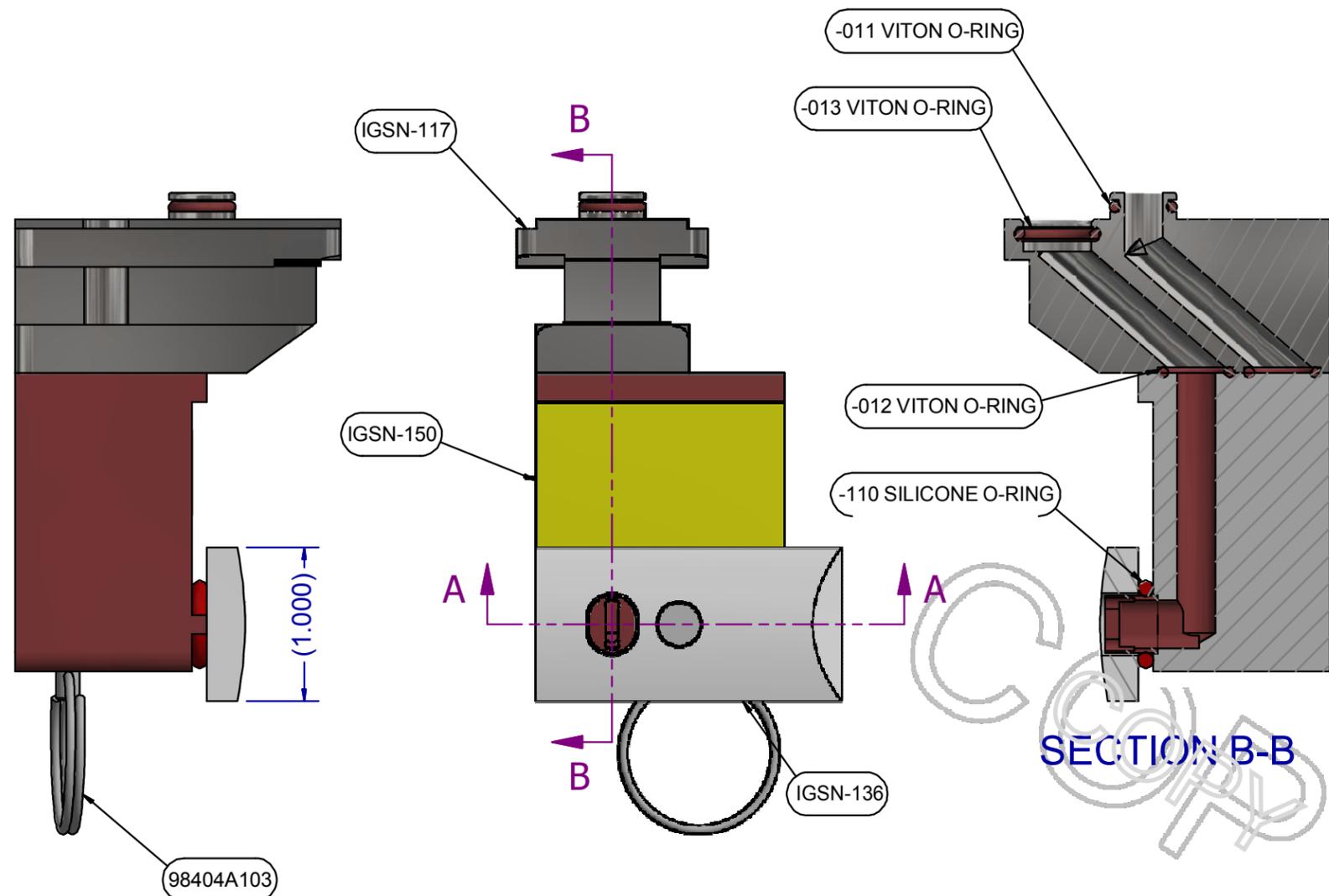
Machining Time:

Welding Time:

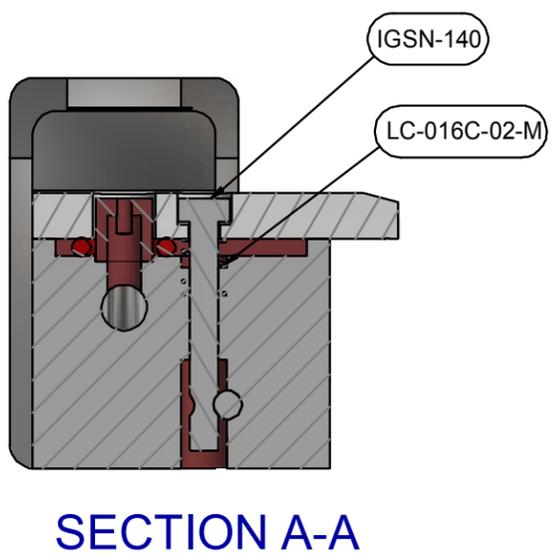
Paint Time:

Finishing:

Misc. Time/Cost:



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 B-B

SECTION A-A

REPLACES	<b>STANDARD PART</b>	STOCKING STATUS	
		MIN	MAX

**TOLERANCES: UNLESS OTHERWISE SPECIFIED**

.X = ±0.1    .XXX = ±0.005  
 .XX = ±0.02    .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  $\nabla$  SHOULD BE TAPPED TO FULL DEPTH OF STANDARD TAP

**DO NOT SCALE THIS DRAWING**

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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, 7/16" GLASS SPACER, SINGLE PUMP (FOR OPPOSITE-HAND HEAD) QUICK RELEASE PIN, PLASTIC SHOE.  
 REV: **PART #:**

FINISH: AS SPECIFIED  
 MATERIAL: AS SPECIFIED

DRAWING SIZE  
**B**

SHEET: 1 OF 1  
 USED IN:  
**RETRO #**

**FAB Qty: 1**    Erdman Job #: **150736**

MFG By:                      MFG Date:                      MFG Quantity:

\*150736+A23+1+1\*

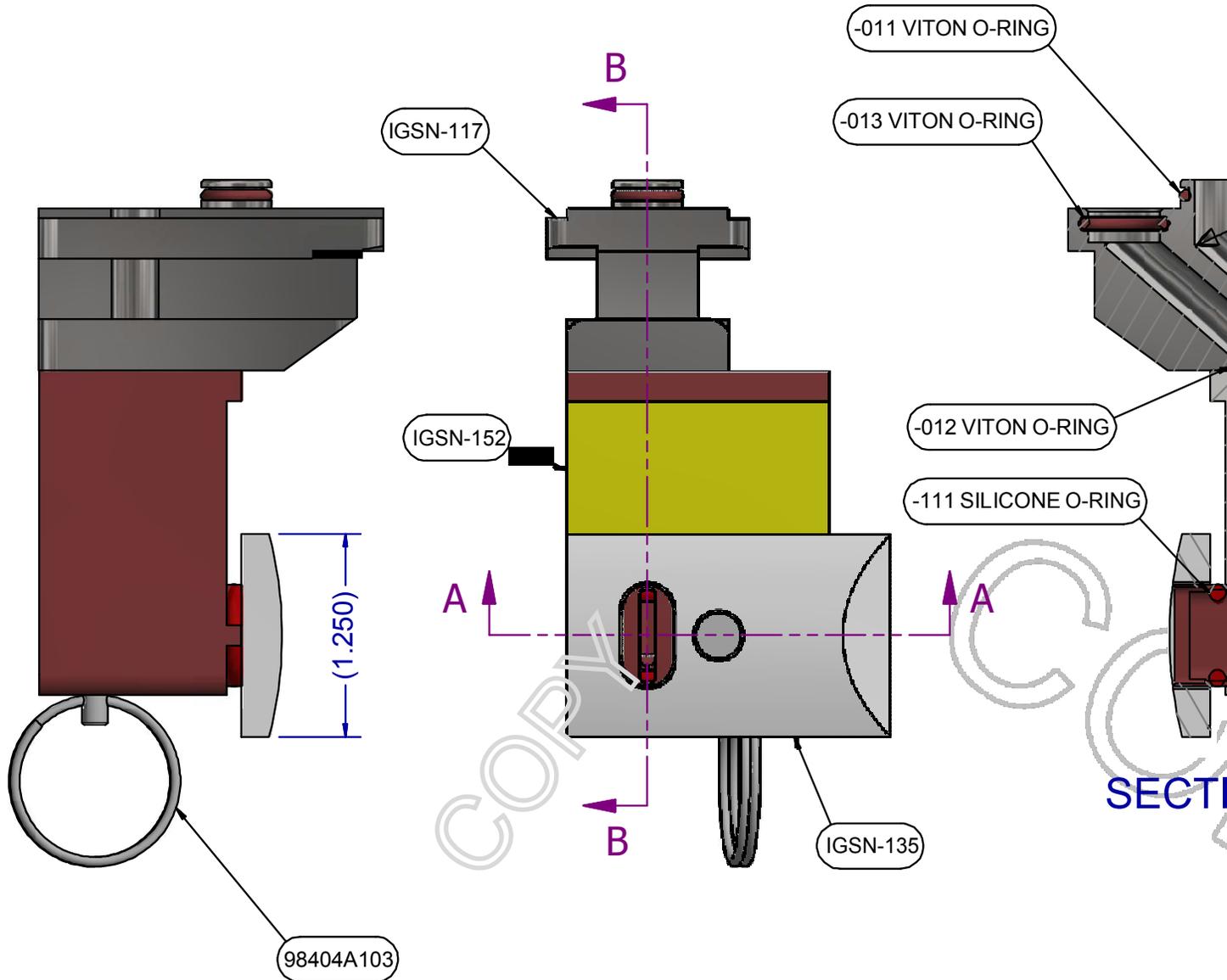
Sawing Time:

Machining Time:

Welding Time:

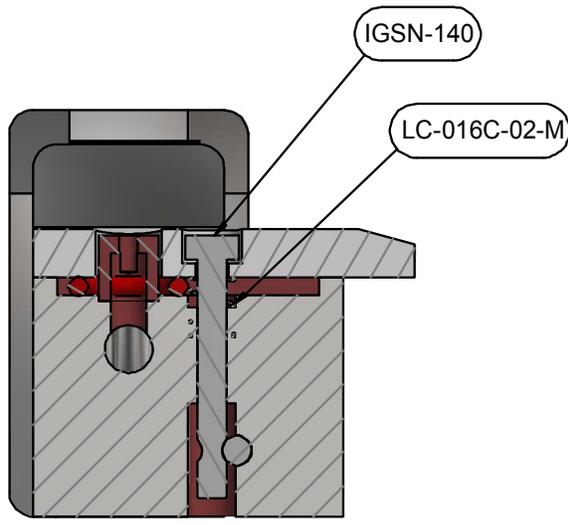
Paint Time:

Fi



COPY

SECTION



SECTION A-A

MFG By:

MFG Date:

MFG Quantity: