Motor Coupling Service Kit for AltaBlue TT Melters - P/N 7403781

This instruction sheet describes the replacement of the motor coupling on an AltaBlue adhesive melter.

WARNING: Risk of personal injury or equipment damage! Refer to the safety information provided in the melter manual before servicing the melter. Failure to comply with the safety information provided can result in personal injury, including death.

Required Tools:
- Flat-tip screwdriver
- 13-mm open-end wrench
- 1/8-in. hex wrench

Motor coupling assy, P/N 7403781

Machine key, P/N 1033445
Feather key, P/N 314699

**Remove the Drive Assembly**

1. Allow the melter to heat up to Ready status. Refer to the operation section of the melter product manual for information about operating the melter.

2. For D4 melters, operate the melter until the tank is completely empty. For D10 and D16 melters, close the tank shut-off valve (position 2 is closed; position 1 is open.).

3. Switch the melter off.

   **WARNING:** Risk of electrocution! The control switch does not remove high-voltage power from the melter. Before opening the electrical compartment door, ensure that the local power disconnect switch is in the off position and locked. Failure to properly disconnect the power from the melter can result in personal injury, including death.

4. Disconnect power to the melter at the local power disconnect switch.

5. Disconnect all hoses from the manifold.

6. Remove the right-side coupling cover.

7. Remove the RTD and the heater from the pump body. Save the screws, washer, and, if applicable, the RTD retaining clip.

   **Note:** On some melters, a retaining clip is not present because the RTD is housed in a slot between the pump housing and the manifold.

8. Remove the four M8 pump screws and matching washers that attach the pump to the bottom of the tank.

   **Note:** When reassembling the drive assembly to the tank, tighten the M8 pump screws to 17.6–19 Nm (13–14 ft-lb.).

9. Disconnect the motor cable from underneath the melter and then slide the drive assembly out of the chassis.

Continue
**Replace the Motor Coupling**

1. Loosen the set screw on each coupling half (E).

2. Remove the four pump bracket screws (A) and then separate the pump/manifold assembly (C) from the coupling components (E, F) and the motor (D). Discard the coupling components.

3. Using the machine key, install the pump shaft coupling half on the pump shaft, but DO NOT tighten the set screw.

4. Install the motor shaft coupling half and the bronze star on the motor shaft.

5. While aligning both halves of the coupling assembly, including the bronze center star (F), position the pump/manifold assembly, the pump bracket, and the motor; then loosely install the four pump bracket screws.

6. Check the initial alignment of the drive assembly by sliding the coupling halves and star back and forth over the motor and pump shafts. The coupling components should move freely without binding. If they do not, adjust the position of the motor until free movement is achieved.

7. Once the coupling assembly is sliding freely over the shafts, center the assembly over the shafts such that the star is above the gap between the two shafts and then set a 2-mm (0.080 in) gap between the two coupling halves.

8. Tighten all the coupling set screws and then tighten the four pump bracket screws to the torque specification indicated in the illustration.

9. Complete the coupling replacement by reversing steps 2–9 of *Remove the Drive Assembly*.

10. Restore power to the melter and then switch the melter on. Verify that the melter operates normally.

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Spur gear pump drive assembly