

Universal Applicator Cordset Rebuild

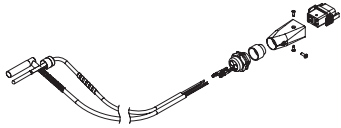
Issued 1/08

This instruction sheet provides the procedures for rebuilding a Universal applicator (UA) T-style, M-style, or C-style cordset. To rebuild a cordset, order the individual cordset parts that need to be replaced and follow the procedures in this instruction sheet. Nordson Corp. recommends referring to the cordset documentation as you perform this procedure.

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.

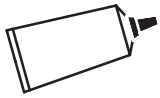
Required Tools:

- Soldering iron
- Solder
- Ohmmeter
- Pin extraction tool (for T-style terminals), P/N 100586
- Pin crimping tool (for T-style terminals), P/N 139671
- Crimp tool (for M-style terminals), P/N 225158
- Pin locator (for M-style terminals), P/N 225161
- Removal tool (for M-style terminals), P/N 1084094



Applicable cordset parts

NOTE: Refer to the cordset documentation to order the cordset parts that need to be replaced.



Heater lubricant, P/N 165415

Prepare for Cordset Rebuild

- 1.** To rebuild a cordset, refer to the parts lists in the cordset documentation and order the individual cordset parts that need to be replaced. You will also need to refer to these parts lists when performing the action steps in this instruction sheet.

WARNING: Risk of electrocution! Disconnect electrical power to the applicator before removing a cordset or cordset component. Failure to properly disconnect power can result in personal injury, including death.

- 2.** Relieve system pressure and disable the applicator. Refer to the applicator manual as needed.
- 3.** If you have not done so already, remove the cordset to be rebuilt. Refer to the cordset documentation as needed.

Disassemble the Cordset

NOTE: Refer to the parts lists and illustrations in the cordset documentation for illustrations specific to your cordset.

- 1.** Carefully remove the plug from its housing (hood/shell, adapters, etc.).
- 2.** Remove the pins for the failed component as follows:
 - for crimp-style cordsets, use a pin extraction tool
 - for solder-style cordsets, de-solder the pins
- 3.** Loosen the strain relief, cable gland, or clamp, remove the wire-end crimp (if present), and remove the failed component.

Reassemble the Cordset

Refer to the following table to determine what type of cordset you are rebuilding, then refer to the appropriate reassembly procedure on page 2 of this instruction sheet. Return here to continue.

Cordset Type	Refer to this procedure on page 2:
T-style low power	Reassemble a Low-Power Crimp-Style Cordset
T-style high power	Reassemble a High-Power Crimp-Style Cordset
M- or C-style adhesive, low power	Reassemble a Low-Power Crimp-Style Cordset
M- or C-style adhesive, high power	Reassemble a High-Power Crimp-Style Cordset
M- or C-style air, low power	Reassemble a Low-Power Solder-Style Cordset
M- or C-style air, high power	Reassemble a High-Power Solder-Style Cordset

Test and Reinstall the Cordset

- 1.** After you have reassembled the cordset, test the cordset for the correct resistance and continuity. Refer to the procedures for checking a heater or a sensor in the cordset documentation.
- 2.** Install the rebuilt cordset as needed. Refer to the cordset documentation for the cordset installation procedure.

Reassemble a Low-Power Crimp-Style Cordset

1. Use a pin crimping tool to crimp the terminals on the new component.
2. Route the leads through the strain relief/cable gland/clamp, any adapters, and then through the housing to the appropriate pin positions in the plug. Cordset pin position diagrams are provided on page 2 of this instruction sheet.
3. Reassemble the plug housing and any adapters.
4. Tighten the strain relief/cable gland/clamp.

Reassemble a Low-Power Solder-Style Cordset

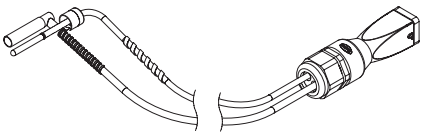
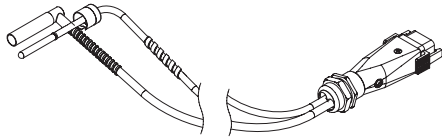
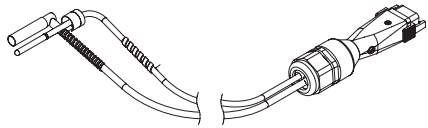
1. Route the leads through the strain relief/cable gland/clamp, any adapters, and then through the housing.
2. Solder the terminals to the appropriate locations in the plug. Cordset pin position diagrams are provided on page 2 of this instruction sheet.
3. Reassemble the plug housing and any adapters.
4. Tighten the strain relief/cable gland/clamp.

Reassemble a High-Power Crimp-Style Cordset

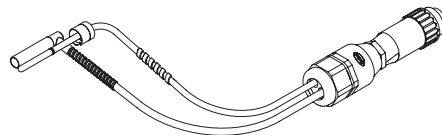
1. Use a pin crimping tool to crimp the wire-end crimp on the new component leads as shown in the cordset pin position diagram. Cordset pin position diagrams are provided on page 2 of this instruction sheet.
2. Route the leads through the strain relief/cable gland/clamp, any adapters, and then through the housing to the appropriate pin positions in the plug.
3. Reassemble the plug housing and any adapters.
4. Tighten the strain relief/cable gland/clamp.

Reassemble a High-Power Solder-Style Cordset

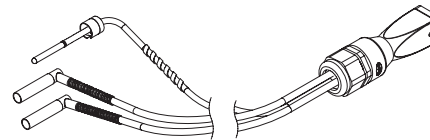
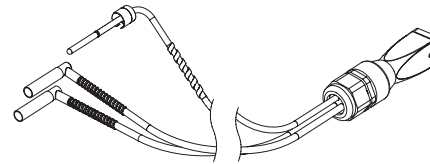
1. Use a pin crimping tool to crimp the wire-end crimp on the new component leads as shown in the cordset wiring diagram. Cordset pin position diagrams are provided on page 2 of this instruction sheet.
2. Route the leads through the strain relief/cable gland/clamp, any adapters, and then through the housing.
3. Solder the terminals to the appropriate locations in the plug. Cordset pin position diagrams are provided on page 2 of this instruction sheet.
4. Reassemble the plug housing and any adapters.
5. Tighten the strain relief/cable gland/clamp.



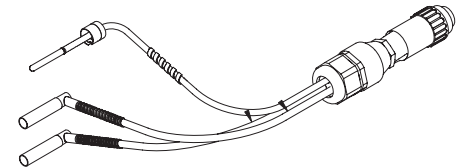
Low power crimp-style cordsets



Low power solder-style cordsets



High-power crimp-style cordsets

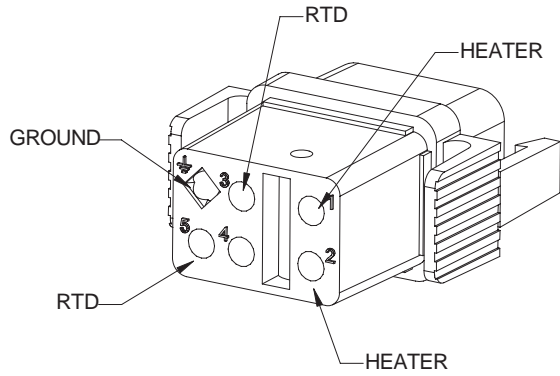


High-power solder-style cordsets

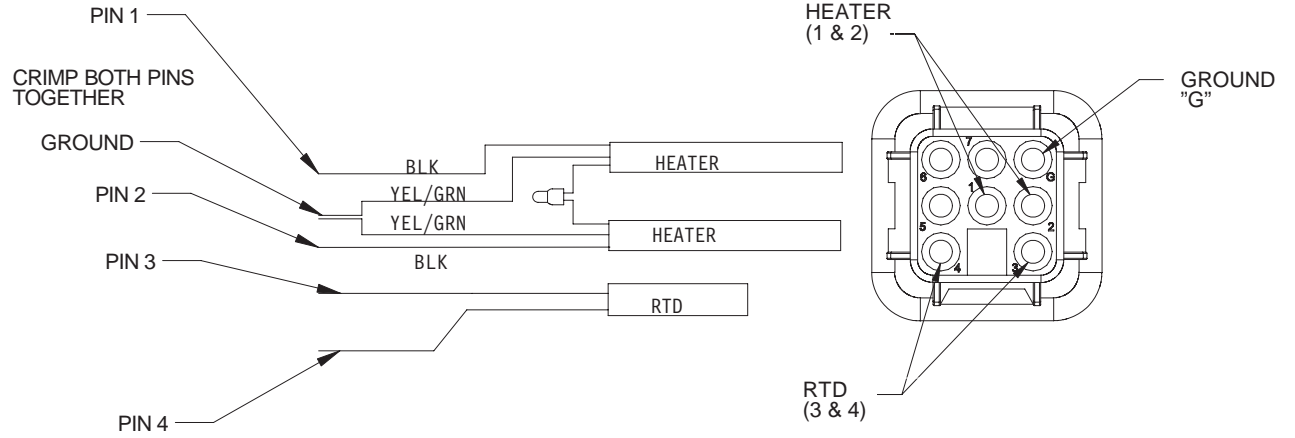
Continue



T-Style Cordset Pin Positions

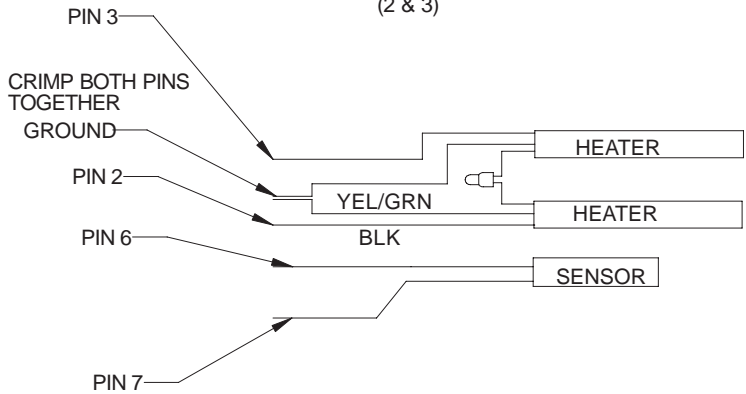
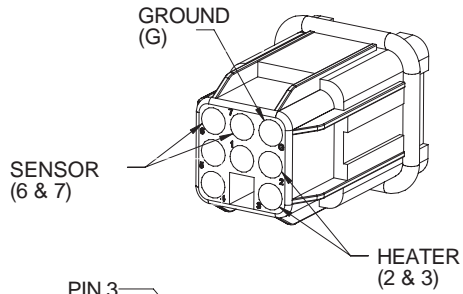


T-style cordset, low power

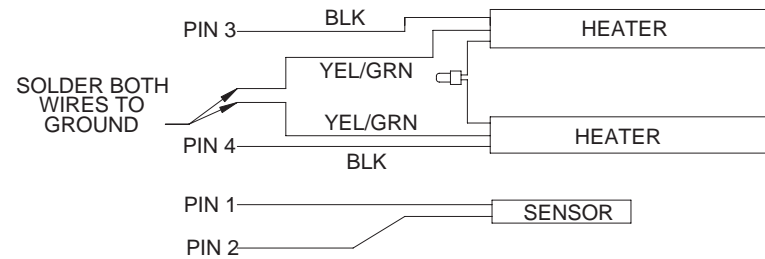
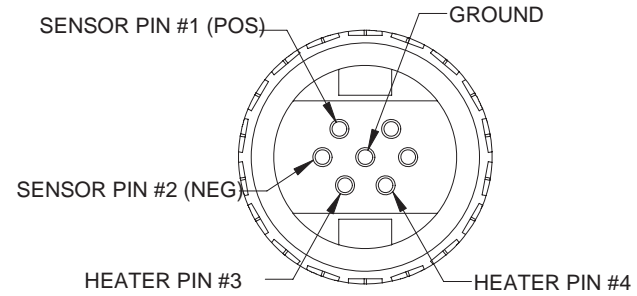


T-style cordset, high-power

M- or C-Style Cordset Pin Positions



M- or C-style cordset, adhesive



M- or C-style cordset, air