



WARNING

Allow only qualified personnel to perform the following tasks. Follow the safety instructions in this document and all other related documentation.

Remove the Packing Gland	
The air motor lockout valve is item 1 in Figure 1.	
Set the air motor lockout valve to . . .	Then . . .
ON	1. See Figure 1. Operate air motor until coupling (5) is accessible.
OFF	2. Place elevator in NEUTRAL position and shut off compressed air supply (1). 3. Depending upon your system, perform one of the following: <ul style="list-style-type: none"> • Open ball valve (2). • Open bleed valve (3) no more than three turns. 4. Bleed hydraulic pressure through valve and guns. Leave valve open. 5. Remove screws (4) securing coupling to plunger rod and coupling shaft. 6. Drain solvent chamber (6). 7. Set air motor regulator to 0 bar/psi.
ON	8. Using minimal air pressure, cycle air motor to push plunger rod down. 9. Cycle air motor to raise air motor shaft.
OFF	10. Remove solvent cup. 11. Remove upper collar screws (7). Pry upper collar (8) off of pump body (9). If you cannot remove the upper collar, perform the following: <ol style="list-style-type: none"> Insert two upper collar screws into threaded holes as shown. Alternate tightening upper collar screws to remove the upper collar. 12. Loosen set screws (10) and remove packing gland from upper collar. Discard packing gland.

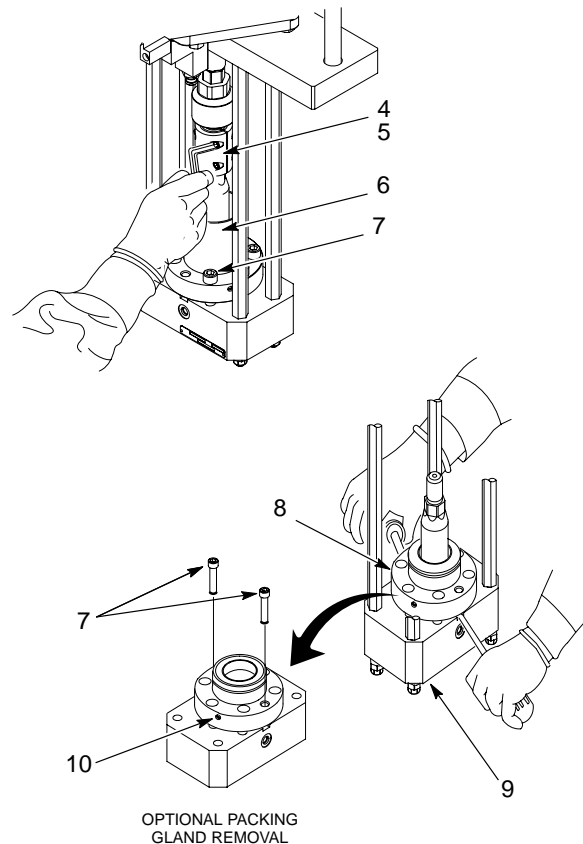
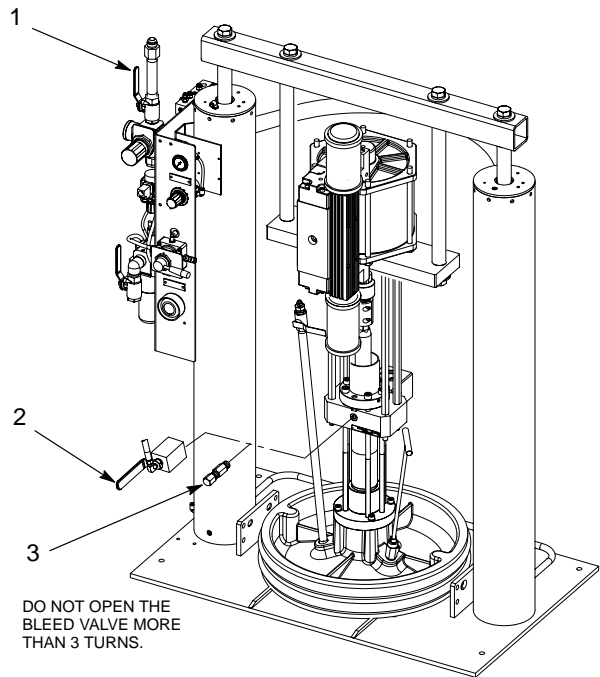


Figure 1 Removing the Packing Gland

Install the Packing Gland	
NOTE: A packing gland insertion tool (part 1035823) is required to perform this procedure.	
The air motor lockout valve is item 1 in Figure 1.	
Set the air motor lockout valve to . . .	Then . . .
OFF	<ol style="list-style-type: none"> See Figure 2. Clean upper collar (1). <p>NOTE: Some O-ring lubricants may react with your dispensing material. Contact your Nordson Corporation representative to determine the correct O-ring lubricant to use.</p> <ol style="list-style-type: none"> Lubricate packing gland O-ring (3), I.D. of packing gland V-rings, and bushing area with O-ring lubricant. Install upper collar onto packing gland (4). Tighten set screws (2) until they make contact with packing gland. Do not over tighten. Install upper collar into pump body (5). Place solvent chamber (7) onto upper collar. Place packing gland insertion tool (6) on top of solvent chamber.
ON	<ol style="list-style-type: none"> Use air motor, set at low air pressure and a slow stroke, to push assembly onto plunger rod. Using the manual override (9), raise air motor shaft to the top of its stroke.
OFF	<ol style="list-style-type: none"> Remove packing gland insertion tool (6) and solvent cup (7). Apply Never Seeze lubricant to threads of screws (8). Install screws into upper collar and tighten to 102–108 N•m (75–80 ft-lb). Refer to <i>Install the Coupling Halves</i> to complete the packing gland replacement procedure.

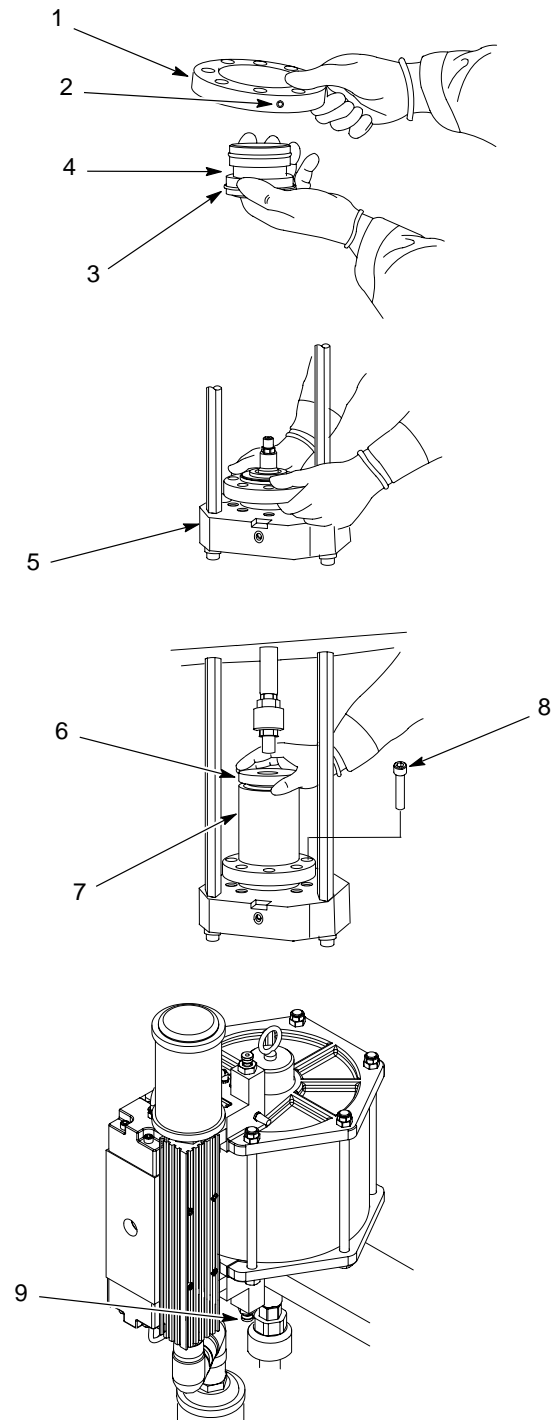


Figure 2 Installing the Packing Gland

Install the Coupling Halves	
The air motor lockout valve is item 1 in Figure 1.	
Set the air motor lockout valve to . . .	Then . . .
ON	<ol style="list-style-type: none"> Adjust air motor regulator to 0 bar/psi. Using minimal pressure, cycle air motor until it is at the beginning of its up stroke.
OFF	<p>NOTE: The coupling halves are a matched set. Each half is stamped with the same serial number.</p> <ol style="list-style-type: none"> See Figure 3. Make sure that the grooved end of each half is facing upward. Position both halves (2) over coupling shaft (1) and plunger rod (4) as shown. Make sure that three threads of coupling shaft and plunger rod are engaged in coupling. Secure coupling halves with coupling screws (3). Make sure that bleed valve on pump body is open and not plugged.
ON	<ol style="list-style-type: none"> Using minimal air pressure at air motor regulator, apply pressure to air motor until air motor is at the top of its stroke.
OFF	<ol style="list-style-type: none"> Remove coupling screws securing coupling halves. Lubricate solvent cup O-ring. Install solvent chamber O-ring and solvent chamber (5).
ON	<ol style="list-style-type: none"> Using minimal air pressure, cycle air motor slowly until coupling shaft almost touches plunger rod.

Install the Coupling Halves (contd)	
Set the air motor lockout valve to . . .	Then . . .
OFF	<ol style="list-style-type: none"> Install one coupling half as shown. Using a $\frac{15}{16}$-in. wrench, adjust coupling shaft to obtain a 0.76–2.54 mm (0.030–0.100 in.) gap between coupling shaft and plunger rod. Install remaining coupling half. Make sure that gaps between sides of coupling halves are equal. Apply Loctite 242 to threads of screws. Install coupling screws and tighten to 10–21 N•m (14–16 ft.-lb). Using Type-K solvent, fill solvent chamber to 0.75 in. from the top. See Figure 1. Depending upon your system, close either the ball valve (2) or bleed valve (3).

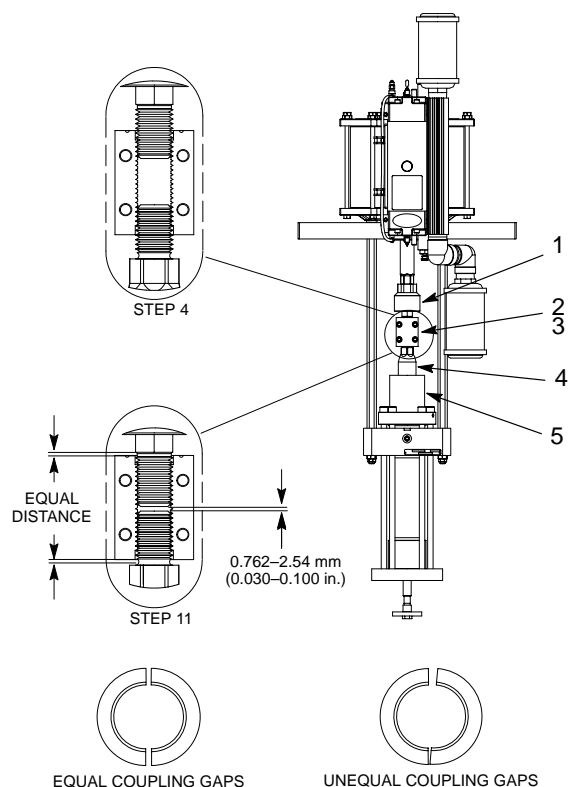


Figure 3 Installing the Coupling Halves

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