



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 the air motor until the coupling (5) is accessible.
OFF	2. Place the elevator in the NEUTRAL position and shut off the compressed air supply (1). 3. Depending upon your system, perform one of the following: <ul style="list-style-type: none"> • Open the ball valve (2). • Open the bleed valve (3) no more than three turns. 4. Bleed the hydraulic pressure through the valve and guns. Leave the valve open. 5. Remove the screws (4) securing the coupling to the plunger rod and coupling shaft. 6. Drain the solvent chamber (6). 7. Set the air motor regulator to 0 bar/psi.
ON	8. Using minimal air pressure, cycle the air motor to push the plunger rod down. 9. Cycle the air motor to raise the air the motor shaft.
OFF	10. Remove the solvent chamber cup (8) from the upper collar (9). 11. Remove the packing gland screws (7) from the upper collar (9). 12. Insert two of the packing gland screws (7) into the upper collar threaded holes (10) as shown. Alternate tightening the packing gland screws (7) to remove the packing gland assembly.

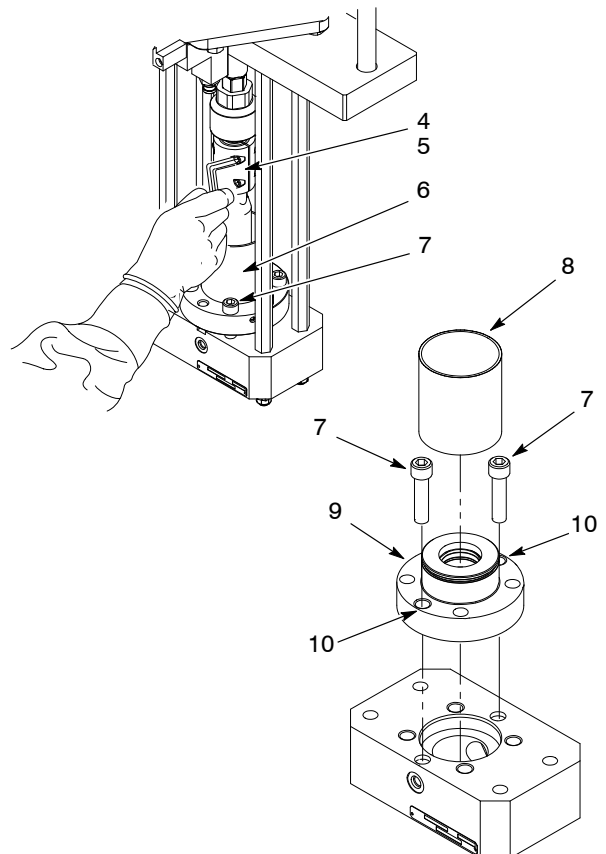
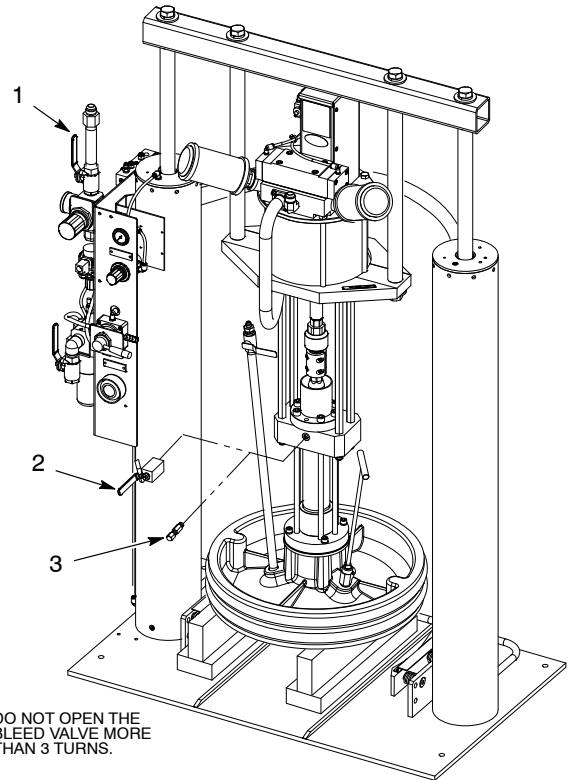


Figure 1 Removing the Packing Gland

Rebuild the Packing Gland

NOTE: This procedure requires the use of either a hydraulic or an arbor press to remove the internal parts of the packing gland.

1. See Figure 2. Place the packing gland housing (2) on a fixture (5) with the solvent cup end facing up.

NOTE: During removal of the internal parts, the retainer groove will break the O-ring (4).

2. Insert the removal arbor (1) into the packing gland housing. Using the press, push out the internal parts (3).
3. Thoroughly clean the packing gland housing in a compatible solvent to remove all sealant material and O-ring debris.

NOTE: Some O-ring lubricants may react to your dispensing material. Contact your Nordson Corporation representative to determine the correct O-ring lubricant to use.

4. Coat the bore (8) of the packing gland housing with O-ring lubricant (9).
5. Insert the scraper ring (7), sharp edge down, into the the packing gland (2).
6. Using the insertion tool (6) and press, insert the new internal parts into the packing gland housing (2). Make sure that the brass seal retainer is flush or slightly below the packing gland housing as shown.

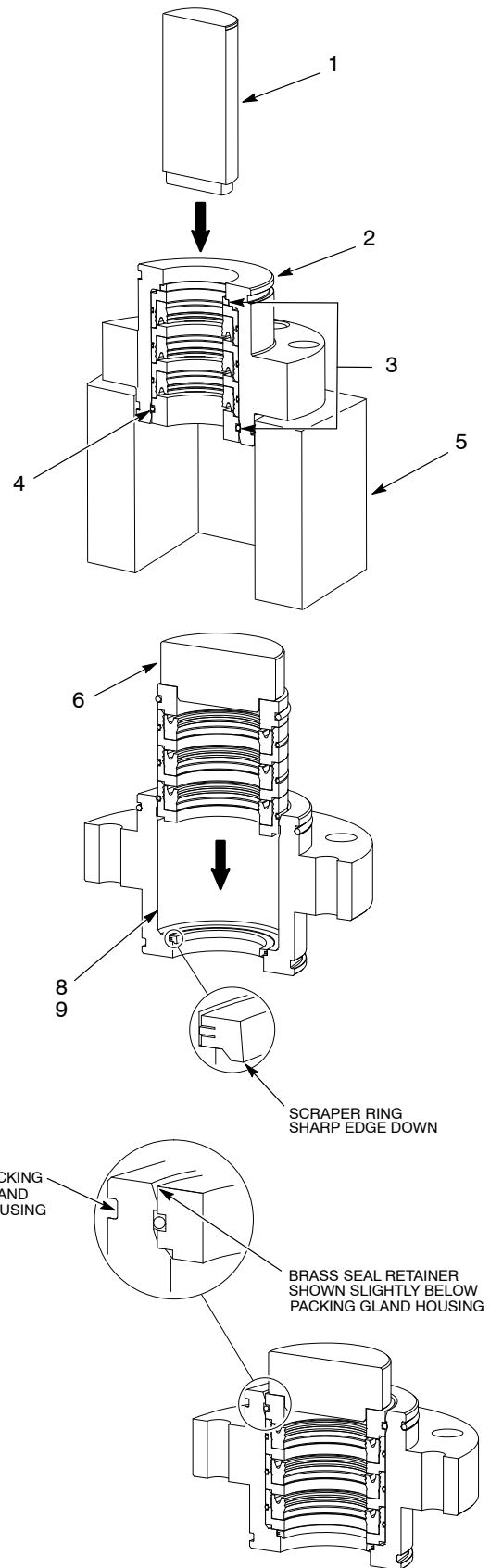


Figure 2 Replacing the Packing Gland Internal Parts

Install the Packing Gland

NOTE: A packing gland insertion tool is required to perform this procedure:

Pump	Insertion Tool
5.8 cubic inch	1073589
8.1 cubic inch	1035823
5.8 and 8.1 cubic inch pump with flared solvent cup	1609505

The air motor lockout valve is item 1 in Figure 1.	
Set the air motor lockout valve to . . .	Then . . .
OFF	<p>NOTE: Some O-ring lubricants may react to your dispensing material. Contact your Nordson Corporation representative to determine the correct O-ring lubricant to use.</p> <ol style="list-style-type: none"> See Figure 3. Make sure that the packing gland O-ring (1) and the bore of the packing gland (2) is lubricated with O-ring lubricant. Install the packing gland (3) into the pump body (4). Install the solvent chamber cup (6) onto the packing gland. Place the packing gland insertion tool (5) on top of the solvent chamber cup (6).
ON	<ol style="list-style-type: none"> Make sure that the air motor is set to a low pressure and a slow stroke. Using the air motor, push the assembly onto the plunger rod. Using the manual override (8), raise the air motor shaft to the top of its stroke.
OFF	<ol style="list-style-type: none"> Remove the packing gland insertion tool (5) and the solvent chamber cup (6). Apply Never Seeze lubricant to the threads of the screws (7). Install the screws into the packing gland collar and tighten to 102–108 N•m (75–80 ft-lb). Refer to the <i>Install the Coupling Halves</i> section to complete the packing gland replacement procedure.

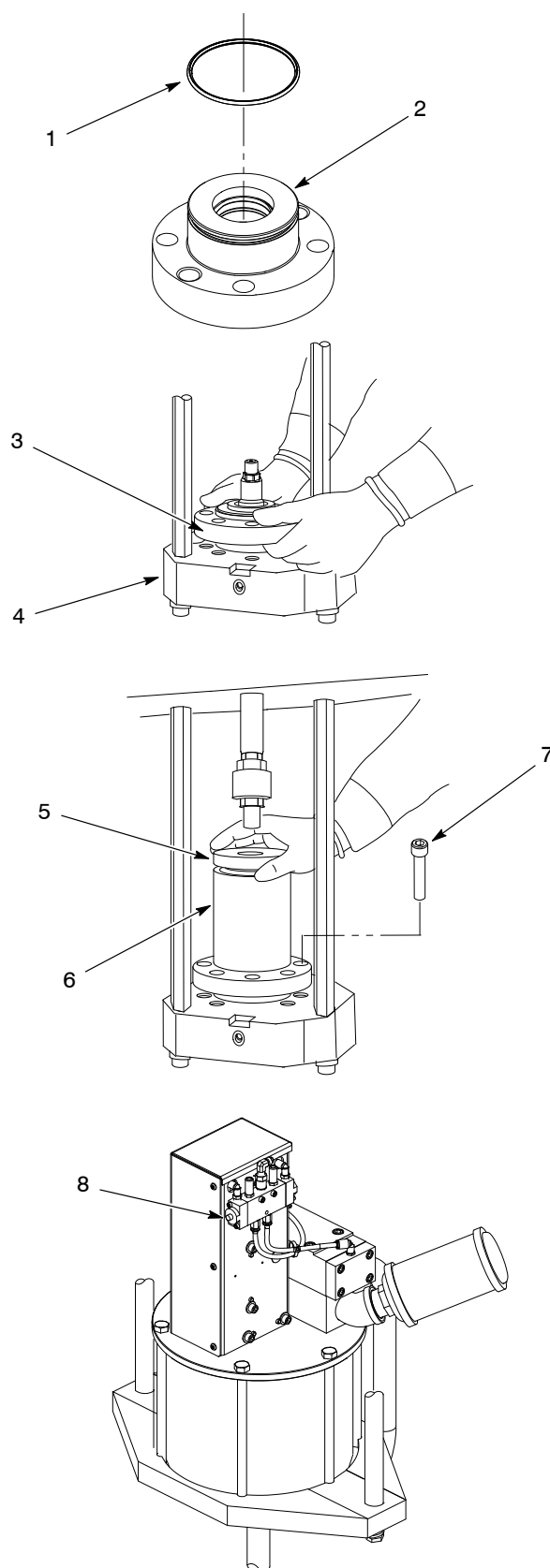


Figure 3 Installing the Packing Gland

Install the Coupling Halves

NOTE: This procedure requires the use of Type-K solvent:

1 Quart: Order 900255

1 Gallon: Order 900256

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 the air motor regulator to 0 bar/psi. Using minimal pressure, cycle the 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 4. Make sure that the grooved end of each half is facing upward. Position both halves (2) over the coupling shaft (1) and the plunger rod (4) as shown. Make sure that three threads of the coupling shaft and the plunger rod are engaged in coupling. Secure coupling the halves with coupling screws (3). Make sure that the bleed valve on the pump body is open and not plugged.
ON	<ol style="list-style-type: none"> Using minimal air pressure at the air motor regulator, apply pressure to the air motor until the air motor is at the top of its stroke.
OFF	<ol style="list-style-type: none"> Remove the coupling screws securing the coupling halves. Lubricate the solvent cup O-ring. Install the solvent chamber O-ring and the solvent chamber (5).
ON	<ol style="list-style-type: none"> Using minimal air pressure, cycle the air motor slowly until the coupling shaft almost touches the plunger rod.

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 the coupling shaft to obtain a 0.76–2.54 mm (0.030–0.100 in.) gap between the coupling shaft and the plunger rod. Install the remaining coupling half. Make sure that the gaps between the sides of the coupling halves are equal. Apply Loctite 242 to the threads of the screws. Install the coupling screws and tighten to 10–21 N•m (14–16 ft.-lb.). Using Type-K solvent, fill the solvent chamber to 0.75 in. from the top. See Figure 1. Depending upon your system, close either the ball valve (2) or the bleed valve (3).

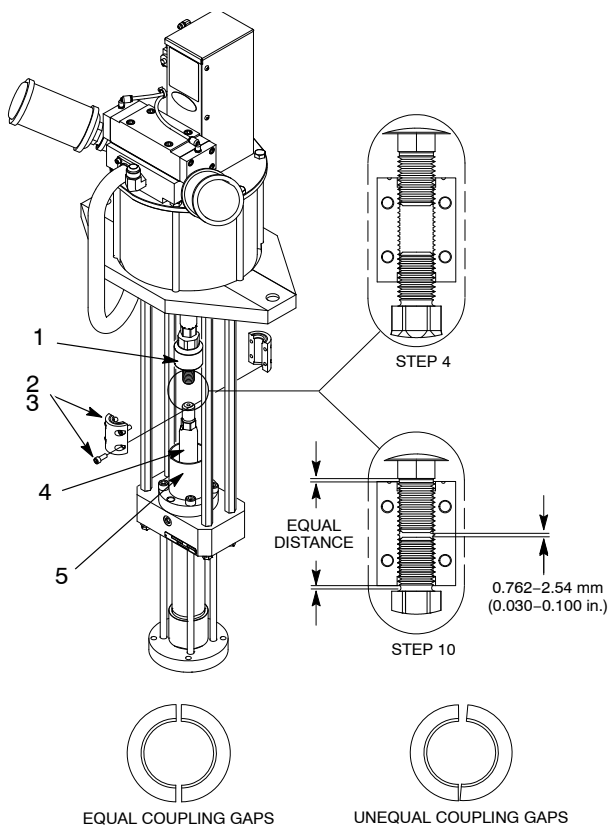


Figure 4 Installing the Coupling Halves

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