

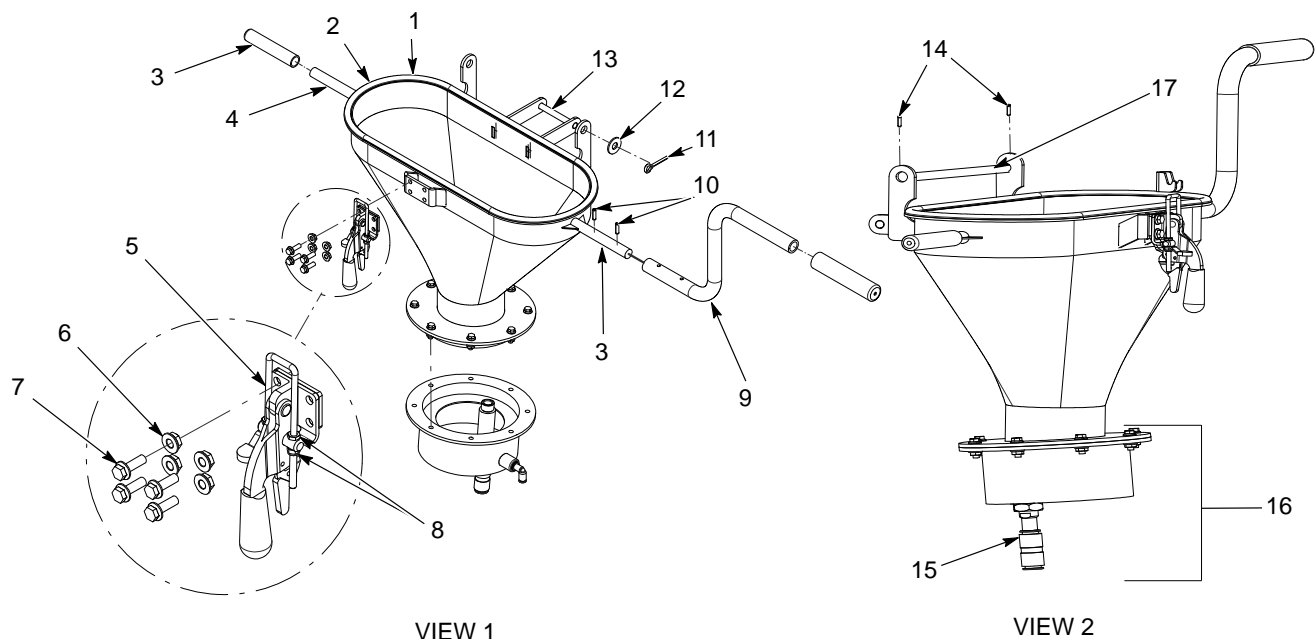
# HDLV<sup>®</sup> Cyclone Transfer Pan Replacement



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

This document provides instruction to remove and replace the HDLV<sup>®</sup> cyclone transfer pan and its hardware. Note the orientation of the old transfer pan and its components before disassembly to ensure the proper installation of the handles and other components onto the new transfer pan.

## Replacing HDLV Cyclone Transfer Pan



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Figure 1 HDLV Cyclone Transfer Pan Assembly

- |                        |                          |                             |
|------------------------|--------------------------|-----------------------------|
| 1. Transfer pan        | 7. Latch bolts           | 13. Hinge rod               |
| 2. Transfer pan gasket | 8. Latch adjustment nuts | 14. Set screws              |
| 3. Rubber grip         | 9. Handle                | 15. Bulkhead union          |
| 4. Handle shaft        | 10. Coil pins            | 16. Fluidizing pan assembly |
| 5. Latch assembly      | 11. Cotter pin           | 17. Axle shaft              |
| 6. Latch nuts          | 12. Flat washer          |                             |

## ***Removing HDLV Cyclone Transfer Pan***

See Figure 1.

1. Disconnect the bulkhead union (15) from the fluidizing pan assembly (16), noting its orientation relative to the system.

**NOTE:** Some fluidizing pan assemblies have two bulkhead unions.

2. Unbolt the fluidizing pan assembly (16) from the transfer pan (1). Set aside the eight nuts and bolts for reuse upon assembly.
3. Remove the axle shaft (17) that connects the transfer pan (1) to the lower shell. Set aside the set screws (14), flat washer (12), and cotter pin (11) for reuse upon assembly.
4. Remove the latch assembly (5) and its hardware, saving the latch nuts (5) and latch bolts (7) for reuse on the new transfer pan.

## ***Installing HDLV Cyclone Transfer Pan***

See Figure 1.

1. The handle (9) will go on either the left or right side of the new transfer pan (1) depending upon the direction of the ColorMax® system.
2. Use a rubber mallet to tap the handle (9) onto the appropriate handle shaft (3) on the transfer pan. Rotate the handle to appear as shown in Figure 1.
3. Using a punch, tap two coil pins (10) through the handle (9) into the holes in the handle shaft (4) to secure the handle.
4. Use a rubber mallet to tap rubber grips (3) onto the handle and the unused handle shaft.
5. Install the axle shaft (17), set screws (14), flat washer (12), and cotter pin (11) to attach the new transfer pan to the lower shell.
6. Mount the latch assembly (5) onto the new transfer pan using the latch nuts (6) and latch bolts (7).
7. The set screws (14) are used to raise and lower the hinge rod (13) and must be adjusted during the assembly of the cyclone. Adjust the axle shaft set screws (14) so that each mating surface between the new transfer pan (1) and the lower cyclone extension are parallel and have even contacting surfaces.

**NOTE:** Ensure the transfer pan gasket (2) is properly seated between the mating surfaces.

8. Once the axle shaft (17) has been adjusted, the axle shaft set screws (14) are used to lock the hinge rod (13) in place.
9. Use the latch adjustment nuts (8) on the clamp adjust for final positioning on the transfer pan.
10. Reinstall fluidizing pan assembly (16) using the original hardware, ensuring that the bulkhead union (15) is toward the back of the transfer pan (1) and aligned with the back of the completed pan assembly.

## Parts

To order parts, contact Nordson Industrial Coating Systems Customer Support at (800) 433-9319 or contact a local Nordson representative.

Refer to the following parts list.

Part	Description	Quantity	Note
1617482	KIT, replacement, pan, cyclone, HDLV	1	
- - - - -	• PAN, cyclone, HDLV	1	
1609782	• GASKET, EPDM, flange trim	4	
- - - - -	• HANDLE, grip, transfer pan, 7/8, black	1	
- - - - -	• PIN, coil, medium, 188 x 0.875, steel	2	

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