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Masterfil

INSTALLATION, OPERATING INSTRUCTIONS &

MAINTENANCE MANUAL FOR MASTERFIL

MODEL: *D6250-S & Cubitainer Nozzle*

CUSTOMER: *Machinery World*

MACHINE NO: *2 6 5 6*

OPERATING, MAINTENANCE & FAULT FINDING MANUAL

Machine No:

This manual will assist you in the running and efficient operation of your MASTERFIL VOLUMETRIC FILLER. Please follow these instructions so that your filler can give you satisfactory operation.

Please consult MASTERFIL if you need further help.

INDEX

MASTERFIL LIMITED
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HEALTH AND SAFETY AT WORK ACT 1974

MASTERFIL fillers should be used in the manner and for the purpose for which we are advised they were intended and in accordance with the recommendations of our Technical Sales Department, product data sheets, catalogues and operating instructions.

Safety glasses should be worn by operators. The machine is guarded to protect users against danger when filling harmless liquids, unless the machine has been supplied explicitly to fill named liquids whose risks have been made known to MASTERFIL LIMITED.

Do not operate the machine without guards. In case of any malfunction or displacement of a container press emergency stop. Only a trained person should be allowed to realign containers or reset the machine, when not before, all movement has ceased.

Do not adjust the machine without guards or attempt to circumvent the guarding unless you have taken precautions to render the operation as safe as if the guards were in place. Any staff who adjust the machine with any guard removed should receive training which ensures that they are fully familiar with all possible motions within the machine under these conditions.

All interlock and safety equipment on machines must be fully maintained and regularly checked to ensure proper operation.

INSTALLATION INSTRUCTIONS

1. GENERAL DESCRIPTION & SAFETY NOTE

Your MASTERFIL machine is a precise volume filler, powered and controlled by compressed air. Please follow these operating instructions carefully so that you can get the best performance from your MASTERFIL filler. Refer to general arrangement drawings supplied. See safety at work note (section 1, page 2 of 2).

2. SETTING UP PROCEDURE

2.1 Set the MASTERFIL machine on a level surface where it is to be used. Make sure any wooden packing battens or travelling straps have been removed.

2.2 Fill the air lubricator to the indicated level with specified oil. [See section 8]

2.3 Connect the 3 meters air line between your closed and drained air supply and the MASTERFIL air inlet.

2.4 Before leaving the factory the air lubricator has been set to deliver one drip for every 4-6 cycles of the MASTERFIL. Check that this frequency of drip is maintained and not exceeded during operation of the filler.

2.5 The air pressure regulator was set at the required pressure of 4-5.5 bar [60-80 psi] when the filler was tested. Check that this pressure is maintained when the filler is operated.

2.6 Ensure that the liquid supply lines to the MASTERFIL and any liquid supply hopper, tank or suction assemblies are flushed clean. Keep from any foreign matter.

2.7 Where the filler is connected to a hand held nozzle, ensure that the nozzle supply pipe is connected and that the fittings are tight. Also check that the air lines from the filler to the nozzle and control valves are tight.

2.8 When the filler is supplied with a pallet nozzle stand, the pallet nozzle is normally fitted on arrival. This should be placed in its operating position at the side of the framework, making sure the liquid supply pipes to the nozzle are free to move. Extend and return the nozzle on its support tubes to full extent, also checking the movements through an arc of approximately 140°, at the same time raising and lowering the nozzle checking to see that the liquid supply pipes to the nozzle move freely at all times.

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2.9 Where a diving or above neck nozzle is fitted, the nozzle hose will be connected before despatch from MASTERFIL LIMITED .

2.10 Set the volume to be filled by operating the lever inside the cabinet. This lever is connected to the turret stops and any of the six positions can be selected. The seventh position is for full stroke of the machine for flushing purposes. The lever is held in position by a ball detent fitted to the turret.

Should the volume need adjusting when the filler is used, open the door and adjust the screws on top of the turret rods evenly. Adjust the screws clockwise to increase quantity and anti-clockwise to decrease quantity. Re-tighten the lock nuts and close the door, then recheck volume.

2.11 Connect the liquid to the inlet adaptor on the rotary or poppet valve body. Fill the liquid supply hopper or tank where supplied, or place the suction assembly in the feed tank as applicable. Ensure that all joints are free from leaks.

2.12 Set the counter [if fitted] to the required number of shots. Do not set the counter to zero even when it is switched 'off'.

2.13 Place the nozzle into a container. Set the stop on the pallet nozzle so that the end is 25mm off the bottom of container. Recheck the counter setting [point 2.12]. Press the green start button to prime the system. While priming, air in the filling system will be expelled, so the first container will be short filled. While priming the filler, check the filling speed and decrease or increase speed as necessary using the air flow regulators on the side of the base unit. Turn regulator clockwise to slow speed and anti-clockwise to increase speed. With foaming liquid set the fill speed of the first stroke slower than on the second [return] stroke, in order to achieve fastest fill.

2.14 On diving nozzles; position the raised nozzle 10-20mm above the container neck. Adjust the stroke of the nozzle by using the diving nozzle stroke stop to suit the container being filled, so that the bottom of the nozzle is 20mm above the bottom of the container. Ensure the container opening is central under the nozzle and adjust the vee neck locator to allow this position to be repeated. Press the start button to prime the filler as in 2.13. While operating the filler, check both the diving speed and retracting speed of the nozzle; use the nozzle speed regulators controlled by the knurled knobs on the side of the base for nozzle rise and inside the base for nozzle diving. [Red air line controls rising speed, blue air line controls diving speed]. Clockwise movement of a knob will decrease speed and anti-clockwise will increase speed. Re-tighten locknut after adjustment.

3. ITEMS SUPPLIED WITH YOUR MASTERFIL

3.1 3 meters air hose with coupling.

3.2 Special piston plate tools.

OPERATING INSTRUCTIONS

1. Check that the air supply in connected and 'ON' ,air pressure is correct, water separator clean and oil full.

2. Set counter to required number of counts.

3. With pallet nozzles place the nozzle into the container to be filled. On diving nozzles place the container under the nozzle locating the neck of the container in the vee neck locator.

4. Press the green start button on the pallet nozzle handle or press foot pedal. During the fill a brake on the pallet nozzle stand will stop the boom assembly rising.

5. Should any incident occur during fill, press the red emergency stop button on the nozzle handle. The fill will stop.

6. The counter will be reset [if it is in use].

7. The nozzle will close.

8. Since the filler will have stopped part way through a fill, the next shot will only be the residue of liquid. So before the emergency stop is released place a safety bucket under the nozzle.

9. Re-set emergency stop by twisting the red button in the direction of the arrow and let it spring forward.

10. Pressing the green reset switch will allow the filling cycle to be completed.

MAINTENANCE INSTRUCTIONS

1. CLEANING IN PLACE

Stop the supply of liquid. Operate the MASTERFIL until all the liquid has been pumped out of the liquid supply lines and into a suitable container. Keep the nozzle inside the container while the MASTERFIL is being pumped out, as air pockets trapped in the liquid may cause splutter from the nozzle. Connect a suitable cleaning liquid to the MASTERFIL inlet and pump it through the MASTERFIL for 3-4 minutes. Where liquid supply hoppers or suction assemblies are used the discharge from the nozzle can be connected to supply lines and cleaning liquid re-circulated. Change the cleaning fluid and then repeat the flushing sequence for 3-4 minutes. This is usually sufficient cleaning to change liquids.

CAUTION: Do not use a solvent which can attack the MASTERFIL seals. If in doubt consult MASTERFIL LIMITED.

2.1 CLEANING - COMPLETE STRIP DOWN

When carrying out the complete strip down, the Masterfil should be stopped in top position by operating the service switch inside the cabinet. Following dismantling procedure [item 2], lift off liquid cylinder to expose piston assembly.

2.2 To remove piston, unscrew piston front plate with special tool provided, lift off remaining back plate.

2.3 To dismantle piston seal discs, unscrew countersunk screws and remove clamp plate. Take care not to damage the cups.

2.4 As each item is removed, place it in a suitable cleaning liquid or detergent solution and wash thoroughly. Examine the piston cups, 'O' rings and sealing washers for defects before reassembling. Damaged items should be replaced to prevent inefficient operation.

3. RE-ASSEMBLY

To re-assemble, reverse the above procedure, see below for fitting instructions for the PTFE cup seals.

4. RE-ASSEMBLY OF PISTON ASSY. (See drawing)

4.1 Carry out instructions in section 4, items 1 & 3.

4.2 To assemble, fit seal disc - *item 1* [fig. 1] to piston back plate - *item 2* and secure by fitting piston clamp plate - *item 3* with M5 countersunk screws. Place sub assembly on to piston rod - *item 10*.

4.3 Holding the product cylinder - *item 5* [fig. 2] squarely over the sub assembly, push product cylinder over seal disc and fully down to cylinder bottom plate. [fig. 3].

4.4 Before assembling items 1a, 4, 6, 7 & 8 [fig. 4] tighten M4 set screw - *item 8* one turn. Fit seal disc - *item 1a* to piston front plate - *item 6*, secure by fitting piston clamp plate - *item 3* with M5 countersunk screws.

4.5 Place sub assembly on to piston rod - *item 10* and screw on by hand until resistance is felt [fig. 5]. Place Ø6mm 'Tommy Bar' into the hole in the opposite end of the piston rod inside the cabinet to prevent the piston head turning. With special tool - *item 9* provided, tighten sub assembly on to the piston rod.

4.6 Re-assemble as item 4.

5. SPARES

We recommend a basic list of minor spares for your filler. Have you ordered these yet ? If not, get in touch with us. To order replacements please quote:- machine number of the MASTERFIL, the item number required and its description. All spare parts are normally ex-stock.

FITTING INSTRUCTIONS FOR PTFE 'O' RINGS

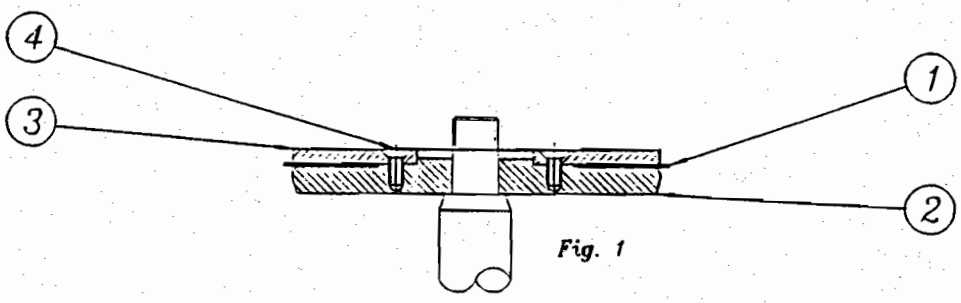


Fig. 1

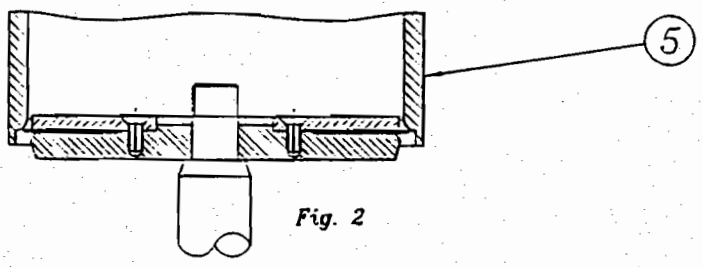


Fig. 2

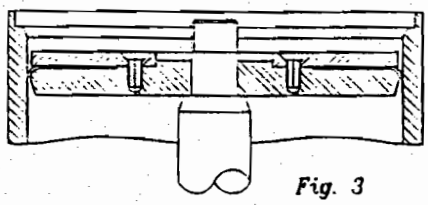


Fig. 3

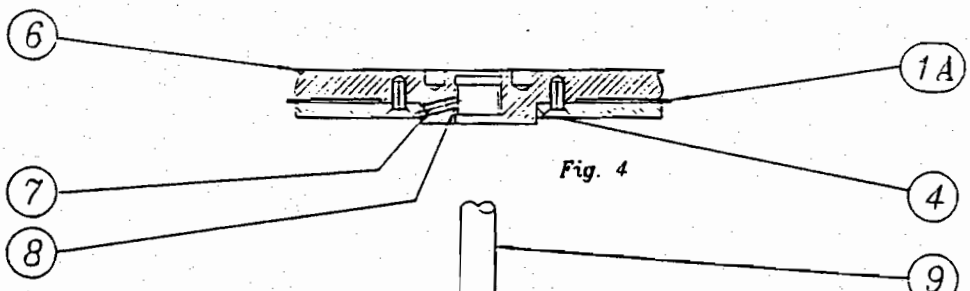


Fig. 4

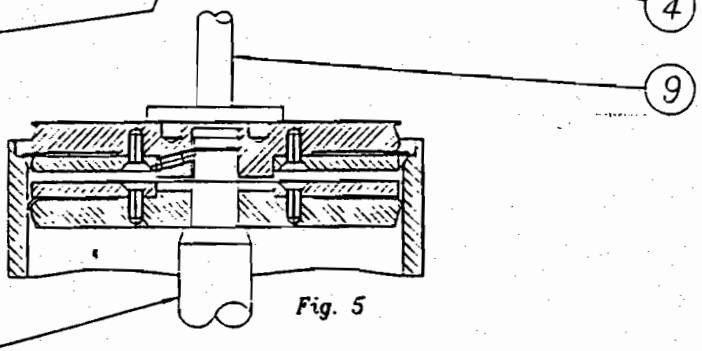
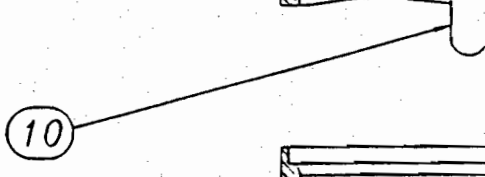


Fig. 5



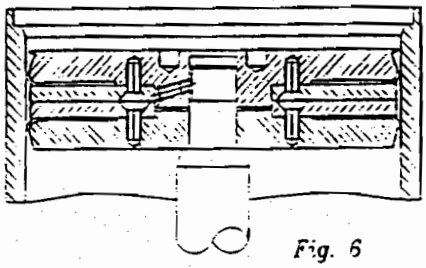


Fig. 6

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ROUTINE MAINTENANCE

6.1 DAILY

a) Inspect level of oil in air lubricator. Top up if necessary.

b) Open the water separator bowl, drain cock while air pressure is 'on' and drain any water off. In humid climates this must be done more often.

c) Check that there is no leakage from the piston rod gland on the cylinder support plate.

6.2 WEEKLY

a) Disconnect air, remove water separator bowl and filter element, clean with paraffin; ensure that the filter element is free from sediment.

b) Remove air lubricator bowl and clean with paraffin; re-assemble and fill with the correct grade of clean oil. Re-connect air.

7. STORAGE

If the MASTERFIL will not be used for a long period, clean it as described previous, then smear the piston cups lightly with clear grease or Vaseline before re-assembling to prevent them drying out or sticking to the cylinder walls.

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DOUBLE POPPET VALVE ASSEMBLY
(See drawing 3-55000)

1. DISMANTLING

1.1 Remove top cover - *item A.*

1.2 Remove valve outlet to nozzle and side transfer pipe.

1.3 Remove valve assembly from cylinder assembly.

1.4 Remove retaining pin - *item B* and withdraw valve plug - *item C* from valve body.

1.5 Air cylinder assembly can now be separated from the body by removing 2 bolts in *item D.*

1.6 Carefully remove seals - *items E & F* and bearing - *item C.*

2. ASSEMBLING

2.1 Replace 'O' Seal - *item E.*

2.2 Push seal 'F' into 'D', ensuring that the spring is facing towards the liquid. Take care that the seal lips are not damaged.

2.3 Replace air cylinder assembly.

2.4 Carefully push valve plug through seals - *items F & G.* Then retain with pin - *item B.*

2.5 Replace valve outlet and 'O' seal onto valve body.

2.6 Replace valve assembly onto cylinder.

2.7 Re-fit top cover - *item A.*

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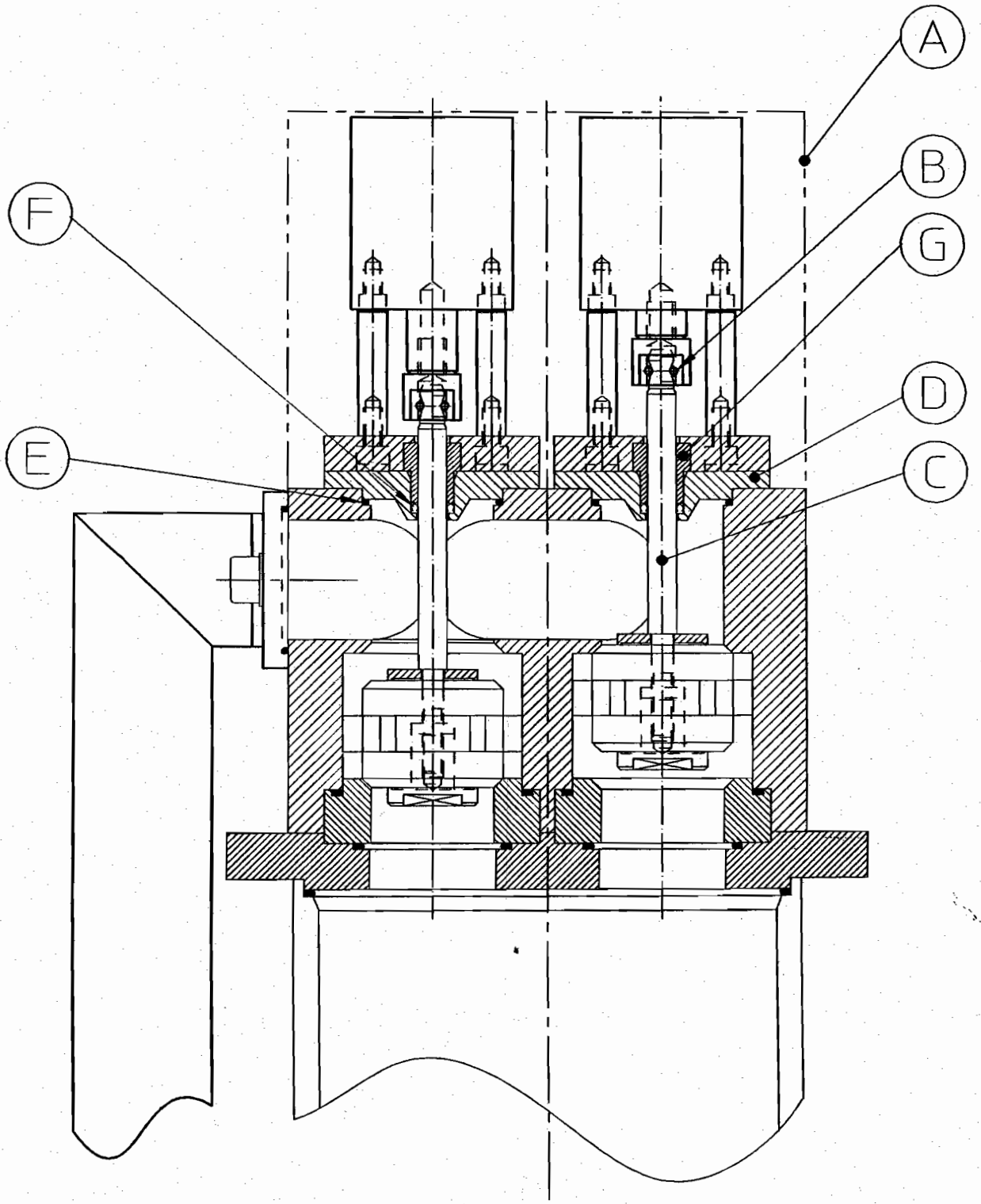
DOUBLE POPPET VALVE ASSEMBLY
(See drawing 3-55000)



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CLEANING - DISMANTLING ROTARY VALVE

1. In order to assist this cleaning operation, it is advisable to flush clean the MASTERFIL as cleaning in place before strip down commences. When the MASTERFIL has been flushed out, drain the air supply. The following procedure is for a strip down of the rotary valve assembly; never strip more than you need to satisfy standards of cleanliness required. Dismantle with care, especially the seals and piston cups as damage to these parts can spoil the MASTERFIL performance.

2. Clean as CIP. To strip the rotary valve, first disconnect the inlet and outlet adaptors and remove the cap screws holding the top plate to the tie rods. Lift the top plate complete with the actuator assembly clear or the rotary valve block. Remove rotary valve block assembly from the cylinder and the liquid transfer pipe from the top adaptor. On a cleans surface, push by hand the rotary valve plug from the block.

3. Take care during the operation and cleaning that the surface of the rotary valve plug is not damaged. DO NOT USE ABRASIVE MATERIALS TO CLEAN THE PLUG.

4. Inspect the seal in the rotary valve plug; change it if it shows any sign of wear or damage [if PTFE seals are fitted, see note 2 for dismantling rotary valve plug].

   Assemble in reverse order. Since the rotary valve plug is a very good fit, it must be carefully lined up and square before entering it into the rotary valve body. Do not use excessive force for this operation. Locating pins are fitted to ensure correct alignment of the assembly.

5. DISMANTLING ROTARY VALVE PLUG ASSEMBLY

   To dismantle the rotary valve plug, top cap and drive plate, the two lock nuts and washers must be removed and the two special bolts unscrewed. The three parts of the rotary valve plug assembly can now be separated, taking care not to damage the PTFE spring loaded seal. Reassemble in reverse order, refit seal with spring side facing the liquid cylinder and ensuring that the special bolts are lightly tightened on the valve plug.

FITTING INSTRUCTIONS FOR PTFE 'O' RINGS

Take extreme care when fitting PTFE seals.

All surfaces over which the seals have to be pressed and the grooves in which they finally rest, must be free from burrs and sharp edges. When expanding the seal over a lip or pushing the seal into a housing, place the seal in boiling water for a few moments before putting it into position. After fitting, heat again to speed the slow process of contraction of a seal which has been stretched. Avoid any excess pressure while fitting the seal or it may become a loose fit.

It is recommended that when PTFE seals are removed, or exposed in the course of partial dismantling of a MASTERFIL they should be replaced by new seals.

NOTE:- It is often easier to fit Nitrile seals; such seals can be used as replacements provided they will not be harmed by the liquids to be filled. If in doubt consult MASTERFIL LIMITED.

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ITEM No.	SCH	DRAWING/ CODE No.	No OFF	DESCRIPTION	X	REMARKS
				SEAL MATERIAL P.T.F.E.		
1	S	4-10546	2	Product Cyl. Assy. D 6250-S		
2	S	4-10522	2	Air Cyl. & Stop Assy.		
3		4-10044	2	Inlet Adaptor Dia. 1½" Bend		
4		4-10046	4	Outlet Adaptor Dia. 1" Bend		
5		4-10047	6	Clamp Plate		
6		3-17097	1	Manifold		
7		4-17098	1	Outlet Manifold		
8		4-10143	3	Nozzle Inlet		
9	S	4-10550	3	R.W.F. Nozzle		
10	S	4-10550/1	3	Dia. 25 Change Parts		
11	S	4-16645/3	1	Base Assy.		
12		3-17096	1	Nozzle Mtg. Frame		
13		4-17112	1	Stand Pipe		
14		4-17113	1	Manifold Rack		
15		4-10151	1	Nozzle Mtg. Frame		
16		4-10150	2	Vee Neck Locator		
16A		4-17608	1	Vee Neck Locator		Cubitainer
17		4-10149	1	Nozzle Guard		
18		4-10992	1	Clamp		
19		4-10148	2	Clamp		
20		4-10049/1	2	Volume Stop 6250cc.		A = 75
21		4-10049/5	2	Volume Stop 5000cc.		A = 125
22		4-10049/12	2	Volume Stop 3750cc.		A = 180
23	S	4-10516	1	Extra Parts Schedule		
24	S	4-10409/20	1	Air Circuit		

No. OF SETS		Masterfil Ltd.	X RECOMMENDED SPARE
ISSUE 1			SHEET 1 OF 2
DATE 07-03-88	TITLE TWIN D 6250-S + CUBITAINER NOZZLE		M/C No. 2 6 5 6
DRAWN C.P.	CLIENT ILFORD LIMITED		SCH. No. 1-10123/77

ITEM No.	SCH	DRAWING / CODE No.	No OFF	DESCRIPTION	X	REMARKS
25		32164000	3	P.V.C. Hose Dia. 1" x 1.4M. Long		
25A		32164000	2	P.V.C. Hose Dia. 1" x 0.3M. Long		
25B		32186003	10	Hose Clips		
26		32165000	1	P.V.C. Hose Dia. 1½" x 3M. Long		
26A		32165000	2	P.V.C. Hose Dia. 1½" x 0.3M. Long		
26B		32186004	6	Hose Clips		

No. OF SETS		Masterfil Ltd.	X RECOMMENDED SPARE
ISSUE 1			SHEET 2 OF 2
DATE 07-03-88.	TITLE TWIN D 6250-S + CUBITAINER NOZZLE		M/C No. 2 6 5 6
DRAWN C.P.	CLIENT ILFORD LIMITED		SCH. No. 1-10123/77

ITEM No.	PRODUCT NUMBER	QTY	DESCRIPTION	X
0001	4-10041	2	SEAL DISC	X
0002	54020011	1	BAL SEAL 305 (238) G / 316	X
0003	51320376	4	O SEAL PTFE 0376-24	X
0005	51331295	2	O SEAL PTFE 1295-30	X
0006	54020003	2	BAL SEAL 304 (25-2.5) G / 316	X
0007	51310371	1	O SEAL PTFE 0371-16	X
0008	4-10119	1	SEAL DISC 1" (25MM)	X
0009	4-10017	1	LOCKING PLUG (DIA.3 X 5 LONG)	X
0012A	35670750	1	ACTUATOR 050-100	
0012B	59105000	0	SEAL KIT ACTUATOR 050	X
0014	4-10002	1	AIR VALVE STRIKER	
0015	4-10005	1	AIR VALVE MOUNTING BRACKET	
0016	4-10006/1	1	GUARD	
0017	4-10007	0	LOCATING PIN	
0018	4-10008	1	ACTUATOR MOUNTING PLATE	
0019	4-12108	1	DRIVE PLATE	
0020	4-12109	1	VALVE PLUG (FLUOROSINT) D6250	
0021	4-12110	1	FLUOROSINT SPACER O/D=95 I/D=75 X 12	
0022	4-11306	1	WASHER	
0023	4-11307	1	ROTARY VALVE BLOCK	
0024	4-10047	2	CLAMP PLATE	
0025	F4-11165	1	TRANSFER PIPE	
			RECOMMENDED SPARE	X

DATE 09/03/99	Masterfil	ISSUE 4	
DRAWN LMS		SHEET 1 OF 3	
TITLE PRODUCT CYLINDER ASSY D6250-S MK.3		M/C No.	
CLIENT		SCH.No. S4-10546/P	

ITEM No.	PRODUCT NUMBER	QTY	DESCRIPTION	X
0027	4-10024	2	TIE ROD	
0028	4-10016	1	PRODUCT CYLINDER 5"	
0029	22220510	6	SCREW COUNTERSUNK SLOTTED SS M5 X 10	
0030	22250406	0	SCREW SET SOCKET SS M4 X 6	
0031	4-10018	1	PISTON FRONT PLATE	
0032	4-10019	2	PISTON CLAMP PLATE	
0033	4-10020	1	PISTON BACK PLATE	
0034	4-10120	1	CYLINDER BOTTOM PLATE	
0035	4-10121	1	HOUSING SEAL & CLAMP	
0036	4-10103	1	BACK BEARING	X
0037	4-10025	0	LOCATING PIN	
0038	4-10028	1	CLAMP PLATE	
0039	4-30166	1	PISTON ROD	
0041	22230316	0	SCREW CAP SOCKET SS M3 X 16	
0042	22230510	0	SCREW CAP SOCKET SS M5 X 10	
0043	22230612	0	SCREW CAP SOCKET SS M6 X 12	
0044	22230630	0	SCREW CAP SOCKET SS M6 X 30	
0045	22230825	0	SCREW CAP SOCKET SS M8 X 25	
0047	22231230	0	SCREW CAP SOCKET SS M12 X 30	
0048	22250506	0	SCREW SET SOCKET SS M5 X 6	
0049	23422003	0	HALF NUT SS M3	
0050	23422008	0	HALF NUT SS M8	
			RECOMMENDED SPARE	X

DATE 09/03/99	Masterfil	ISSUE 4	
DRAWN LMS		SHEET 2 OF 3	
TITLE PRODUCT CYLINDER ASSY D6250-S MK.3		M/C No.	
CLIENT		SCH.No. S4-10546/P	

ITEM No.	PRODUCT NUMBER	QTY	DESCRIPTION	X
0051	24022005	0	SPRING WASHER SS M5	
0052	24022006	0	SPRING WASHER SS M6	
0053	24022008	0	SPRING WASHER SS M8	
0054	24022012	0	SPRING WASHER SS M12	
			RECOMMENDED SPARE	X

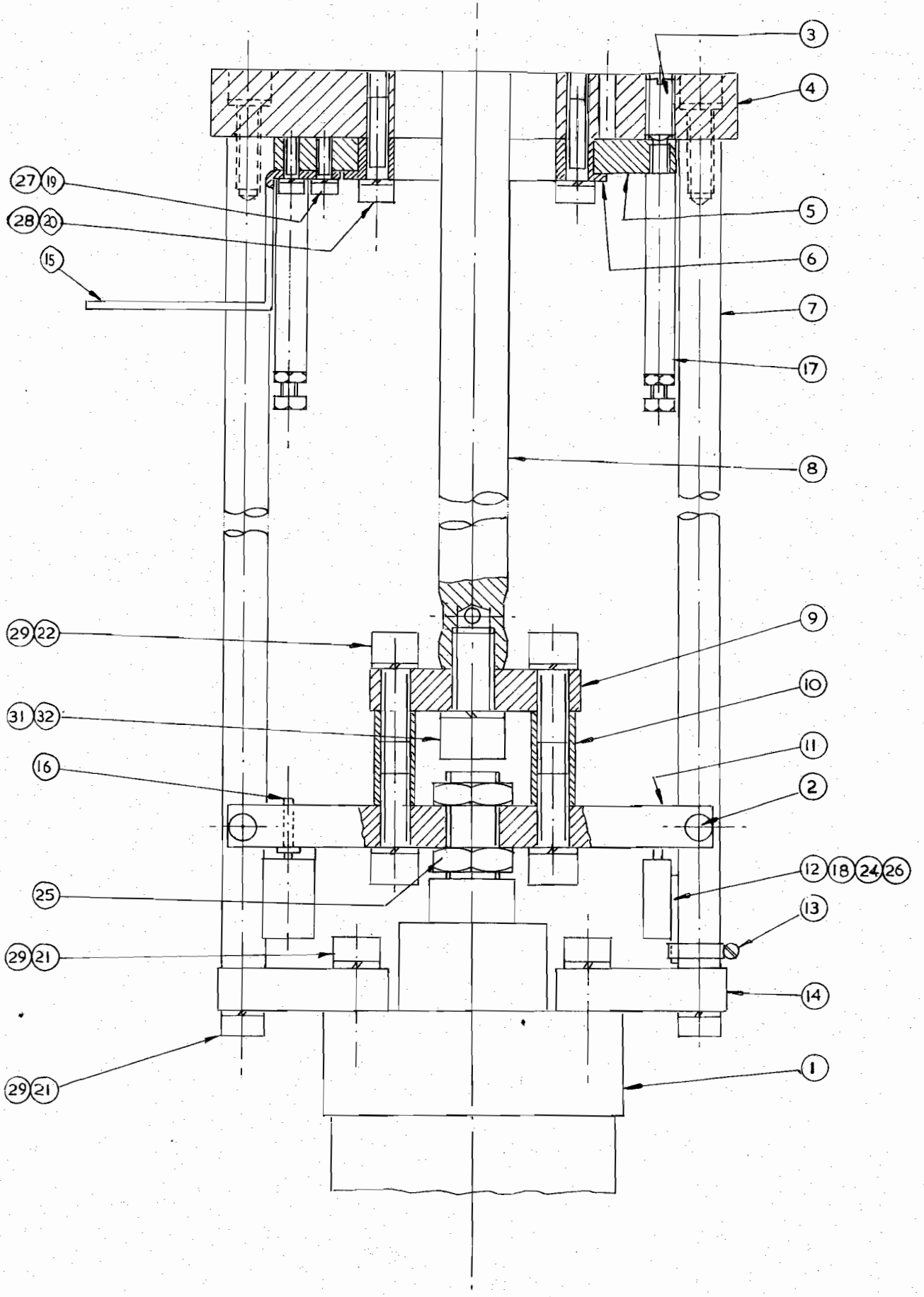
DATE 09/03/99	Masterfil	ISSUE 4	
DRAWN LMS		SHEET 3 OF 3	
TITLE PRODUCT CYLINDER ASSY D6250-S MK.3		M/C No.	
CLIENT		SCH.No. S4-10546/P	

ITEM No.	DRG./CODE No.	QTY	DESCRIPTION	X
0001A	35675401	1	ATR CYLINDER SM12100/260	
0001B	59300019	0	SEAL KIT QM13100/00	X
0002	4-10036	4	BEARING PLUG	
0003	22484012	1	SPRING PLUNGER 303-12	
0004	4-10026	1	TOP STOP PLATE	
0005	4-10030	1	STOP MOUNTING PLATE	
0006	4-10029	1	STOP PLATE LOCATOR	
0007	4-10031	4	SUPPORT ROD	
0009	4-10113	1	PISTON ROD MOUNTING PLATE	
0010	4-10114	2	SPACER	
0011	4-10037	1	STOP BAR	
0012	4-10610	1	ATR VALVE MOUNTING BRACKET	
0014	4-10122	2	ATR CYLINDER MOUNTING PLATE	
0015	4-10027	1	STOP ADJUSTING ARM	
0016	4-10040	1	STRIKER PIN	
0017	4-10049	2	VOLUME STOP - FLUSHING	
0018	22230316	0	SCREW CAP SOCKET SS M3 X 16	
0019	22230612	0	SCREW CAP SOCKET SS M6 X 12	
0020	22230825	0	SCREW CAP SOCKET SS M8 X 25	
0021	22231030	0	SCREW CAP SOCKET SS M10 X 30	
0022	22231230	0	SCREW CAP SOCKET SS M12 X 30	
0023	22231630	0	SCREW CAP SOCKET SS M16 X 30	
			RECOMMENDED SPARE	X

DATE 05/06/92	Masterfil	ISSUE 4	
DRAWN LMS		SHEET 1 OF 2	
TITLE ATR CYLINDER & STOP ASSY D6250-S		M/C No.	
CLIENT		SCH.No. S4-10522	

ITEM No.	DRG./CODE No.	QTY	DESCRIPTION	X
0024	23412003	0	FULL NUT SS M3	
0025	23322020	2	HALF NUT SS M20 (ME 20021/35)	
0026	24022003	0	SPRING WASHER SS M3	
0027	24022006	0	SPRING WASHER SS M6	
0028	24022008	0	SPRING WASHER SS M8	
0029	24022010	0	SPRING WASHER SS M10	
0030	24022012	0	SPRING WASHER SS M12	
0031	24022016	0	SPRING WASHER SS M16	
0032	4-10444	1	AIR CYLINDER BRACKET D6250-S	
0033	4-10138	1	CLAMP PLUG	
			RECOMMENDED SPARE	X

DATE 05/06/92	Masterfil	ISSUE 4	
DRAWN LMS		SHEET 2 OF 2	
TITLE AIR CYLINDER & STOP ASSY D6250-S		M/C No.	
CLIENT		SCH.No. S4-10522	



MATL.	GENERAL TOL ±	SCALE 1-2	Masterfil Ltd.	DATE. 24-4-82	M/C No.
FINISH. ·125 ·25 R. ON ALL CORNERS		DRAWN CLR	TITLE D 6250 AIR CYLINDER & STOP ASSY		DRG. No. 4-10522

ITEM No.	PRODUCT NUMBER	QTY	DESCRIPTION	X
0001	54020001	1	BAL SEAL 300 (8-2) G / 316	X
0002	51320246	1	O SEAL PTFE 0246-24	X
0003	54010003	1	BAL SEAL 304 (25-2.5) / 316	X
0005	35672503	1	AIR CYLINDER PRA/182032/350	
0006	35672201	1	AIR CYLINDER M6025/25	X
0008	4-10052	1	AIR CYLINDER MOUNTING PLATE	
0009	4-10036	12	BEARING PLUG	
0010	4-10053	1	GUIDE PLATE	
0011	4-10054	2	AIR CYLINDER MOUNTING BRACKET	
0012	4-10055	4	TIE BAR (A=170)	
0013	4-10056	1	SPECIAL NUT	
0014	4-10057	1	RETAINING CLIP	X
0015	4-10058	1	BEARING CLAMP PLATE	
0016	4-10059	1	BEARING	X
0017	4-10060	1	NOZZLE BODY 25MM	
0018	4-10061	1	RETAINING CLIP	
0019	4-10062	1	STOP STROKE	
0020	4-10063	2	GUIDE BAR	
0021	4-10064	1	GUIDE PLATE	
0040	23322010	1	HALF NUT SS M10 X 1.25 (FINE)	
0041	4-10138	2	CLAMP PLUG	
			RECOMMENDED SPARE	**X**

DATE 09/12/04	Masterfil	**ISSUE** 5	
DRAWN M.H.		**SHEET** 1 OF 1	
TITLE RWF NOZZLE - SEMI (PTFE)		**M/C No.**	
CLIENT		**SCH.No.** 53-10550/P	

ITEM No.	SCH	DRAWING/ CODE No.	No OFF	DESCRIPTION	X	REMARKS
45		51320186	1	'O' Seal 0186-24 P.T.F.E.	X	
46		4-10069	1	Bar		
47		23422004	0	St. St. Lock Nut M4 [1 off]		
48		4-10070	1	Rod		
49		4-10072	1	Dia. 25.4 Nozzle Tube		
50		4-10078	1	25.4 Wiper	X	
51		4-10084	1	25.4 Nozzle Plug		

No. OF SETS		Masterfil Ltd.	X RECOMMENDED SPARE
ISSUE 1	T/F 4-10550/P/1		SHEET 1 OF 1
DATE 22-04-88.	TITLE DIA. 25.4 CHANGE PARTS (NOZZLE)		M/C No.
DRAWN D.E.	CLIENT X 350 STROKE		SCH. No. 4-10550/G25

ITEM No.	SCH	DRAWING/ CODE No.	No OFF	DESCRIPTION	X	REMARKS
1		1-10050/8	1	Base Unit		
1A		4-11289/5L	0	Twin Base Unit (Mods to Base)		
2		4-10144	1	Air Panel		
3		4-10147	2	Support Tube		
4						
5		4-11066	1	Nozzle Guard		
6		4-10150	2	Vee Neck Locator		
7		4-17095	1	Nozzle Mounting Frame		
8		4-11156	1	Air Valve Box		
9		4-11055	2	Spacer		
10						
11						
12		4-14039/2	1	Foot Pedal Mounting Plate [M/c. With Feet]		
13		4-12433	1	Cover Plate 6250 D/A Twin		
14						
15						
16		4-11311	1	Valve Mtg. Bkt.		
17		4-10995	8	Spacer (Air Panel & Service Unit)		
18		4-10993	1	Hand Screw		
19		4-18160/1	1	Handle Ref. 1601 Key No. 92-240 Sq. Drive Straight Cam 'B' Long 40mm C/w. Single Clamp [Iss. 2] (24-02-83).		Southern L & F.
20		4-15578	1	Cam (Door Interlock)		
21		4-17273	1	Valve Mtg. Bkt.		
22		4-17274	1	Spacer		
				NOTE: NOZZLE CENTRES = 138.0		

No. OF SETS		Masterfil Ltd.	X RECOMMENDED SPARE
ISSUE 2			SHEET 1 OF 1
DATE 07-03-88.	TITLE BASE ASSEMBLY D 6250 D/A TWIN		M/C No.
DRAWN C.P.	CLIENT SPECIAL		SCH. No. 4-16645/3

ITEM No.	DRG./CODE No.	QTY	DESCRIPTION	X
0001	32162000	0	PVC BRAIDED HOSE (NON-TOXIC) 1/2"	
0001A	31121112	1	CONNECTOR BARBER 12MM 3122-12-62-85	
0002	4-10407	1	SERVICE TOOL	
0003	4-10447	1	SS LABEL MASTERFIL BLACK ON NATURAL	
0004	4-10448	1	ADDRESS LABEL	
0005	4-10490	1	PALLET (SEMI AUTO)	
			RECOMMENDED SPARE	X

DATE	27/07/90	Masterfil	ISSUE 1
DRAWN	MH		SHEET 1 OF 1
TITLE	EXTRA PARTS SCHEDULE (FEET)		M/C No.
CLIENT			SCH.No. S4-10516/F

ITEM No.	SCH	DRAWING/ CODE No.	No OFF	DESCRIPTION	X	REMARKS
1		3317 1501	1	Valve 5/3 Press/Press .5 BSP		S 29104 P2
1-1		3310 3200	1	Base for Above .5 BSP		S 29703
2		3316 7529	2	Valve 5/2 Press/Diff Dia. 8mm.		M 1702/33
3		3316 7528	8	Valve 5/2 Press/Diff Dia. 6mm.		M 1701/33
4		3312 3512	11	Valve 3/2 Plunger/Spring M5.		M 1553/14
5		3318 5108	11	Valve 'OR'		815-40-001
6		3318 5102	6	Valve 'And'		815-41-001
7		3316 2202	1	Valve 5/2 Toggle Switch .125 BSP		43004LS
8		3316 1305	2	Valve 5/2 Push Button Red Latching		M 50550/388
9		3312 1514	3	Valve 3/2 Push Button Green		M 1553/51/G
10		3312 2303	1	Valve 3/2 Toggle Switch .125 BSP		43603L BS14
11		3318 4105	4	Valve A.F.R. .5 BSP		M S 639
12		3318 4207	3	Valve A.F.R. .125 BSP		L 7780 06 10
14		3318 4108	3	Valve A.F.R. .125 BSP		M 677
15		3612 7202	1	Counter		0497-486
16		3616 0102	1	Air Service Unit .5 BSP		T4H 408 M3ED
17		3616 4901	1	Filter Regulator 5 Micron		B06 101 MIED
18		3612 2002	1	Gauge		18-013-990
19		2902 0201	1	Mtg. Bkt.		18-001-053

No. OF SETS		Masterfil Ltd.	X RECOMMENDED SPARE
ISSUE 1			SHEET 1 OF 1
DATE 27-04-88.	TITLE AIR CIRCUIT TWIN D 6250		M/C No.
DRAWN C.L.R.	CLIENT		SCH. No. 2-10409/20