



GKF 1505
Capsule Filling Machine
Replacement Spare Parts & Service

Custom Parts/Specialty Parts Available
On Request

INTERNATIONAL INVENTORY MANAGEMENT

456 MANNING AVENUE
ELON, NC 27244 USA
TEL 001 336 584 4777
sales@iimnc.com

www.iimnc.com

revised 7/8/2022

OEM names and part numbers are used to identify replacement parts. Our products are not affiliated with, sponsored or approved by the original equipment manufacturer.

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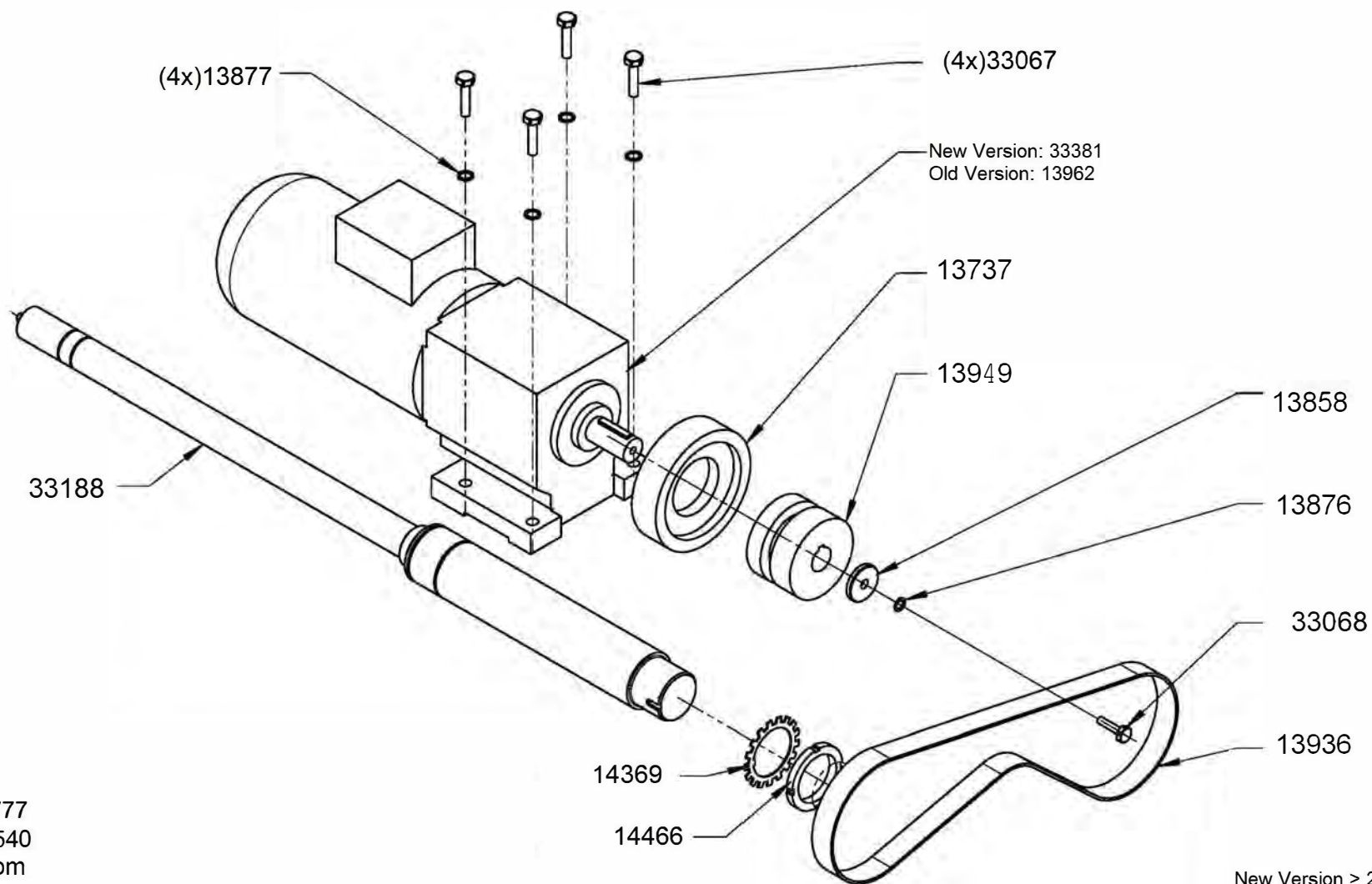
GKF 1505 - 11 COUNT

Section	Description
1	Main Drive (Motor & Drive Train & Shaft)
2	Tamping Cam
3	Sorting Cam
3	Separation Cam
3	Closing Cam
3	Faulty Capsule Ejection Cam
4	Ejection Cam
5	Belt Tensioner
6	Belt Tensioner
7	Segment Carrier/Turret/Gearbox
8	Sorting Drive
9	Separation Drive
10	Tamping Station
11	Dosing Station & Gearbox
12	Auger Motor & Gearbox
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14.2	Ejection Drive - Old Version - 2 Shaft
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16	Dosing Base with Disc
17	Vacuum Station
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30	Cleaning Station
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New Version > 2014
Old Version ≤ 2014

Section 1: Main Drive (Motor & Drive Train)

GKF1505 - revised 7/2/2021

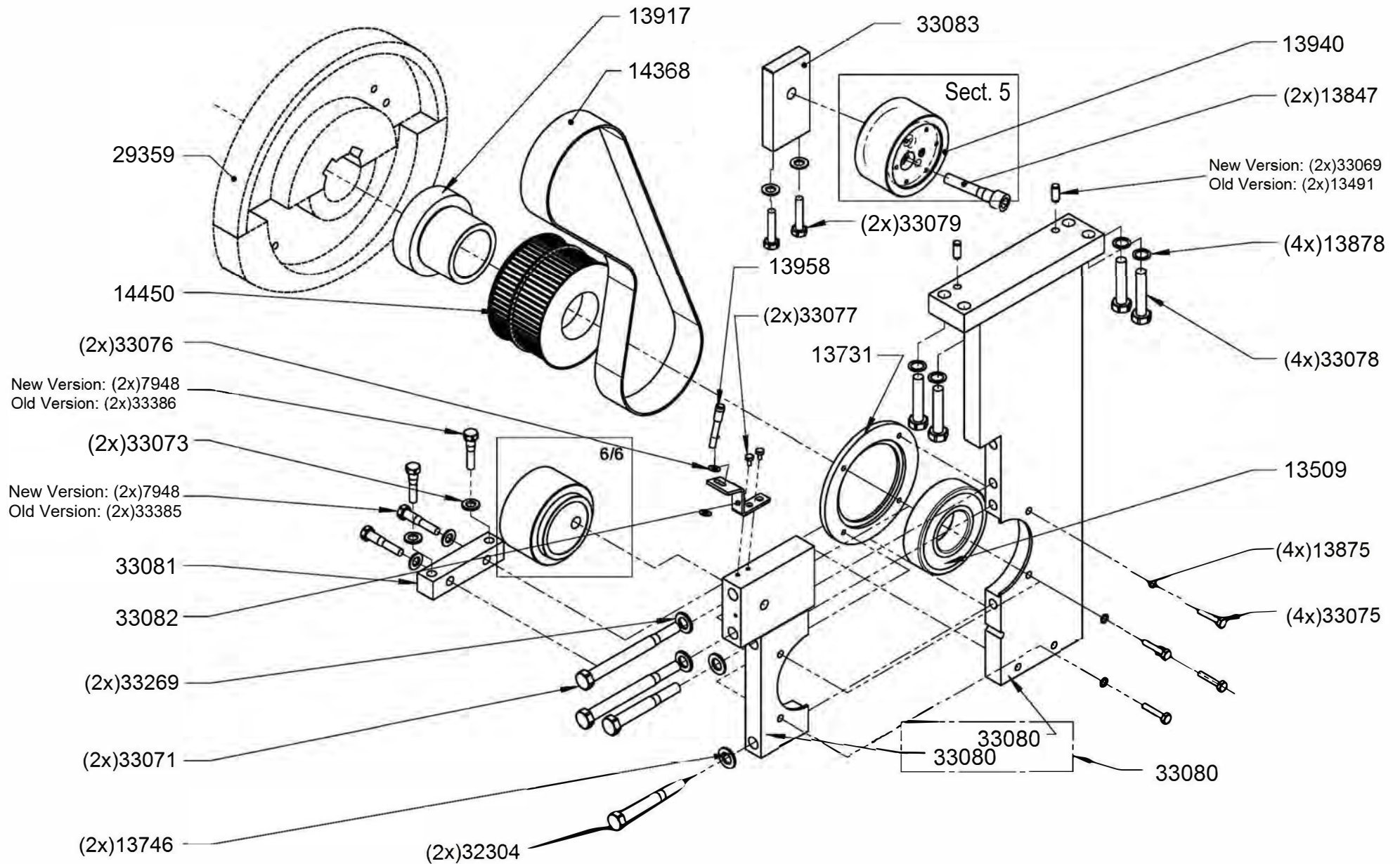


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New Version > 2014
Old Version ≤ 2014

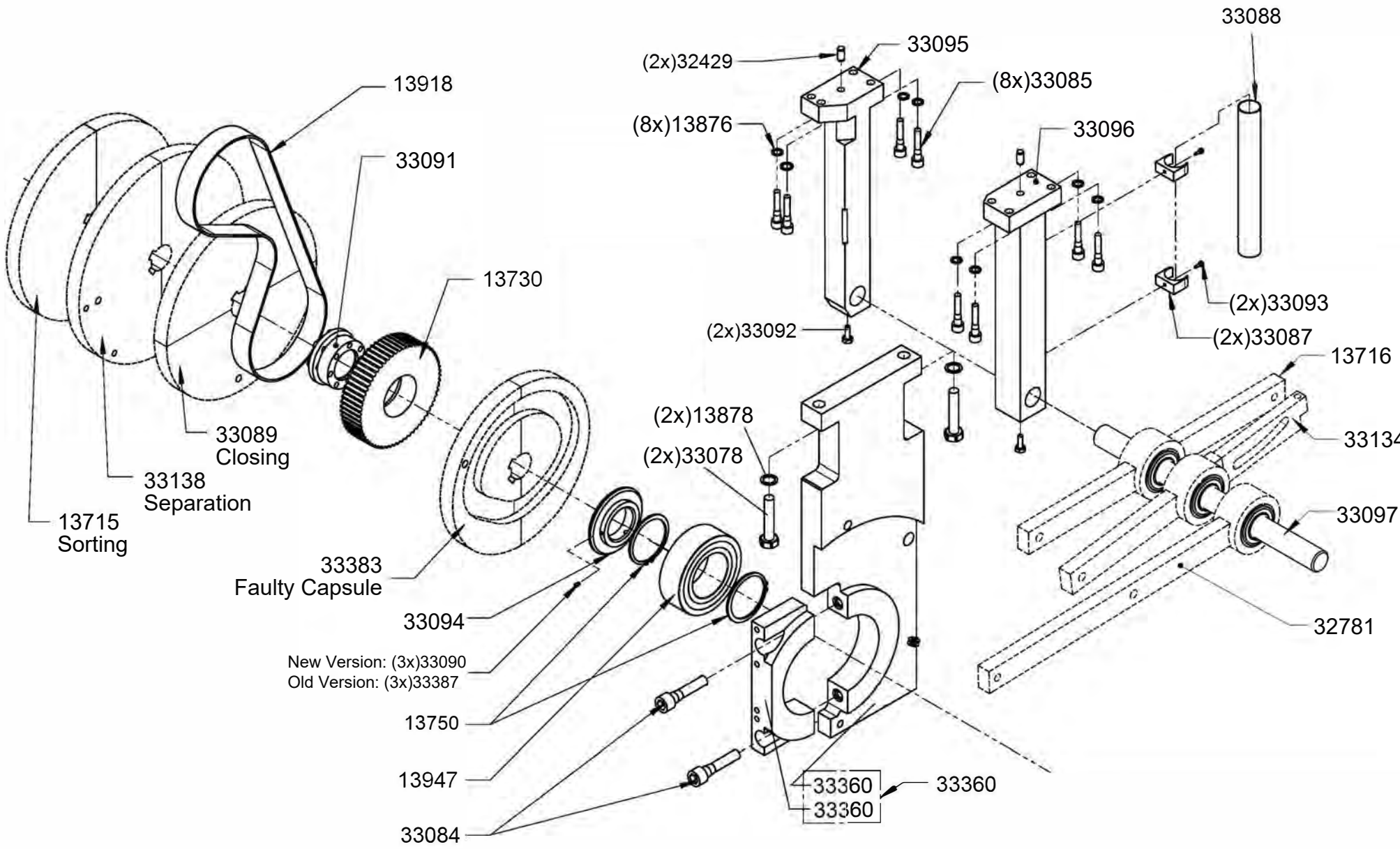
Section 2: Tamping Cam

GKF1505 - revised 8/5/2022



Section 3: Sorting Cam / Separation Cam / Closing Cam / Faulty Capsule Ejection Cam

GKF1505 - revised 12/1/2022



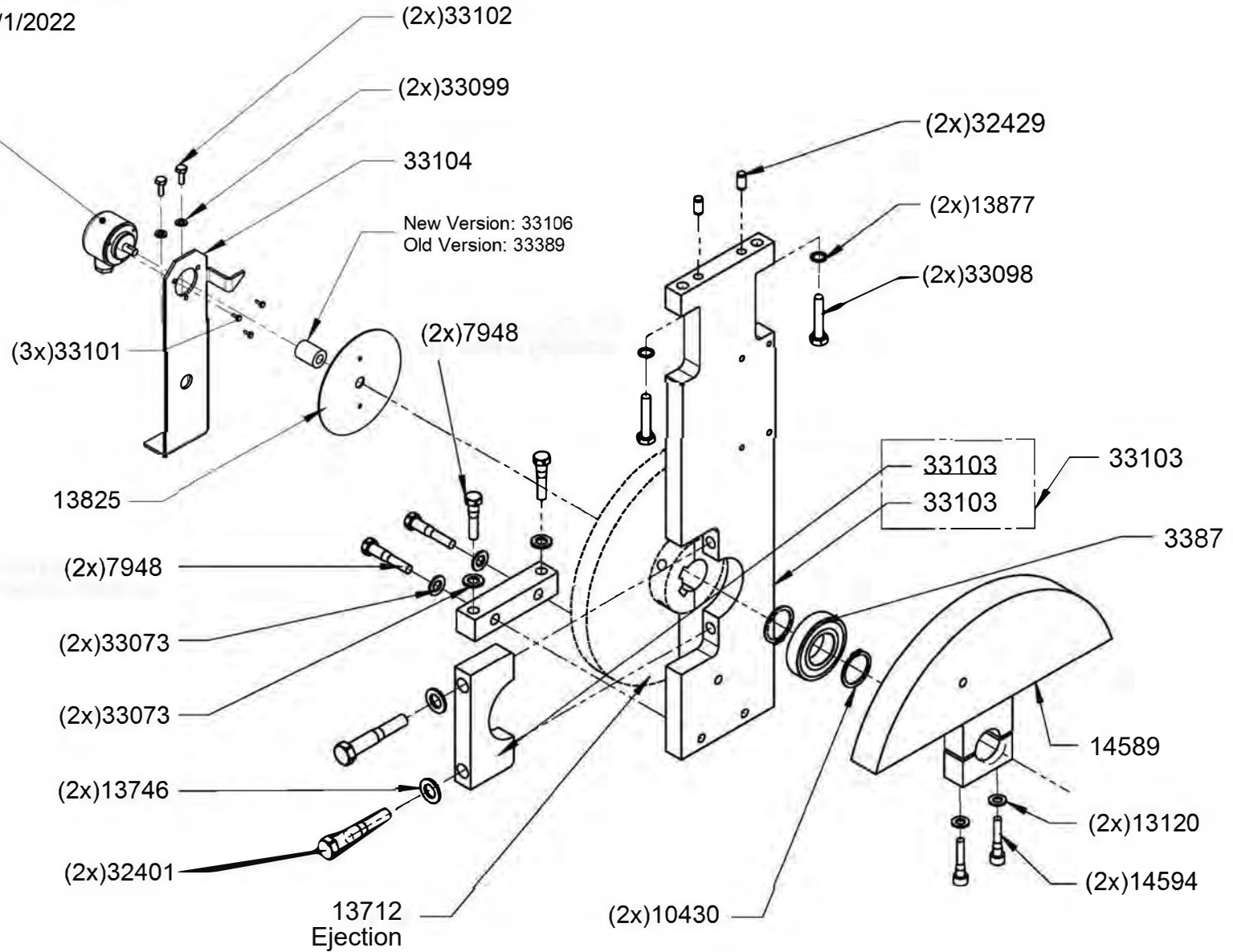
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New Version > 2014
 Old Version ≤ 2014

Section 4: Ejection Cam

GKF1505 - revised 12/1/2022

New Version: 33105
Old Version: 33388



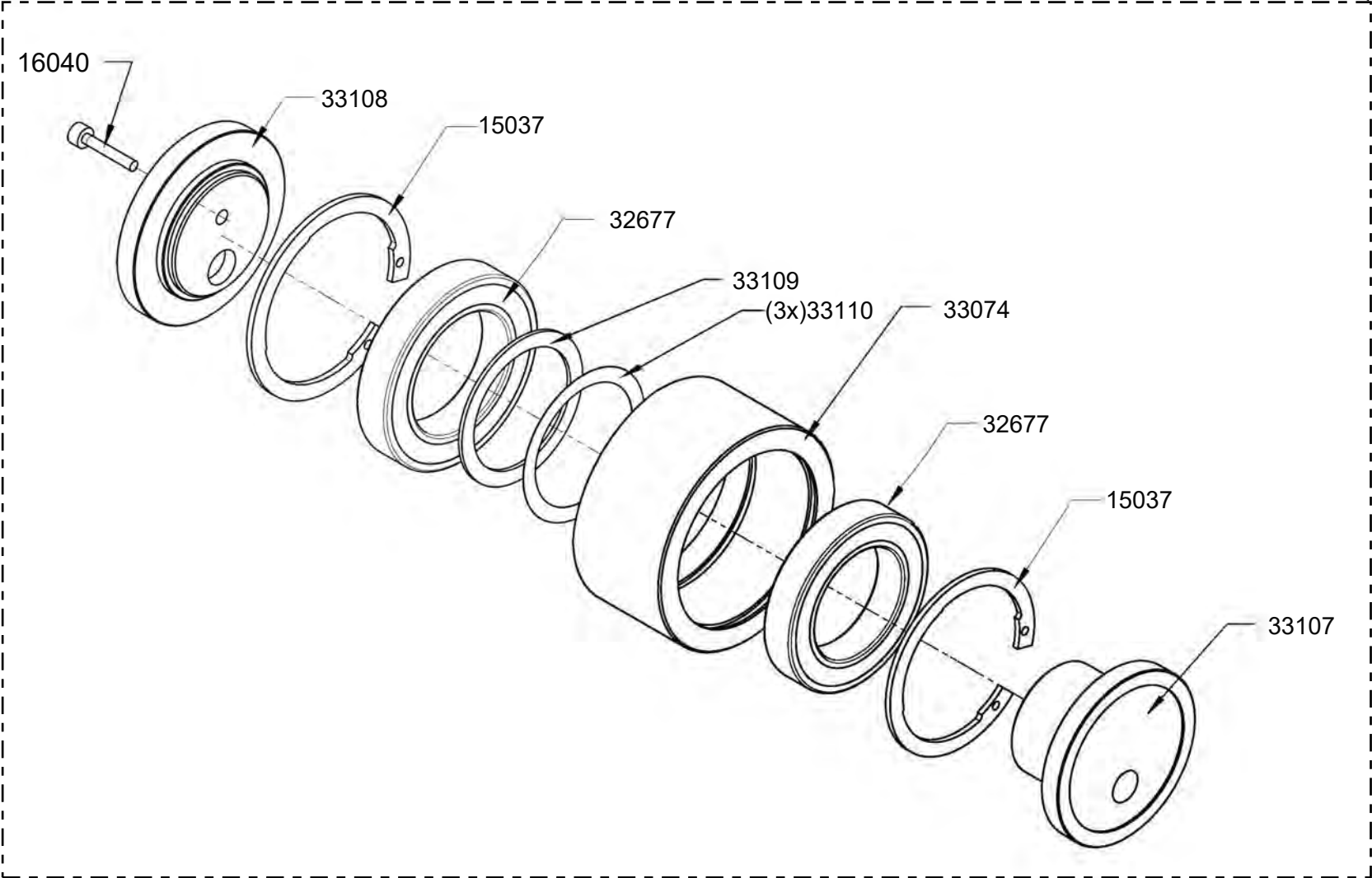
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New Version > 2014
Old Version ≤ 2014

Section 5: Belt Tensioner

GKF1505 - revised 7/2/2021

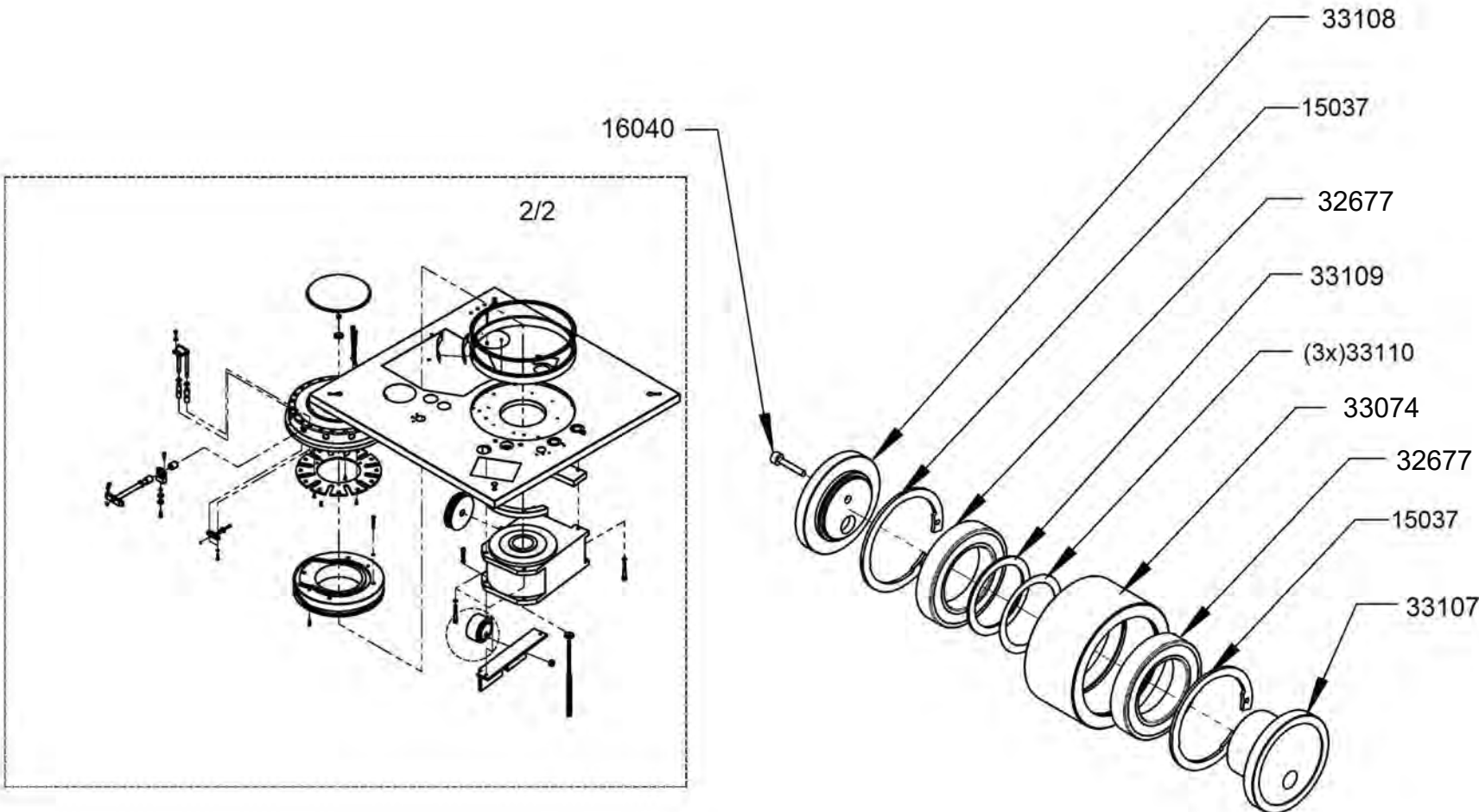
13940



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Section 6: Belt Tensioner

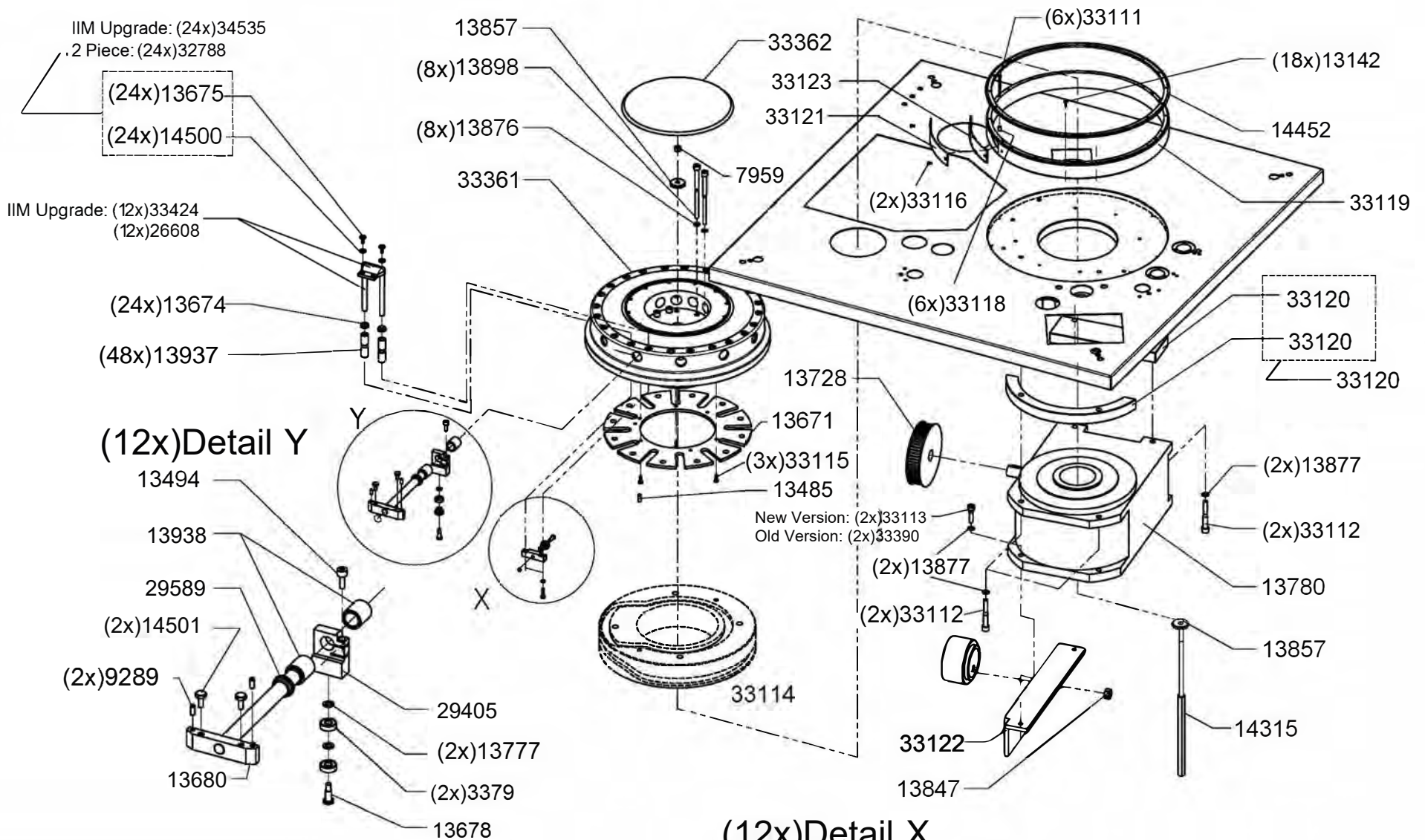
GKF1505 - revised 7/2/2021



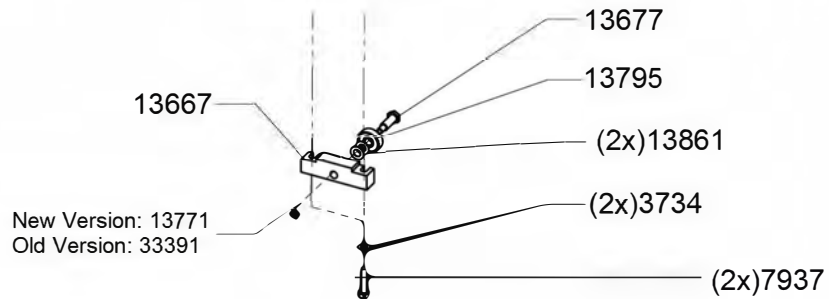
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Section 7: Segment Carrier/Turret/Gearbox

GKF1505 - revised 7/2/2021



(12x)Detail X

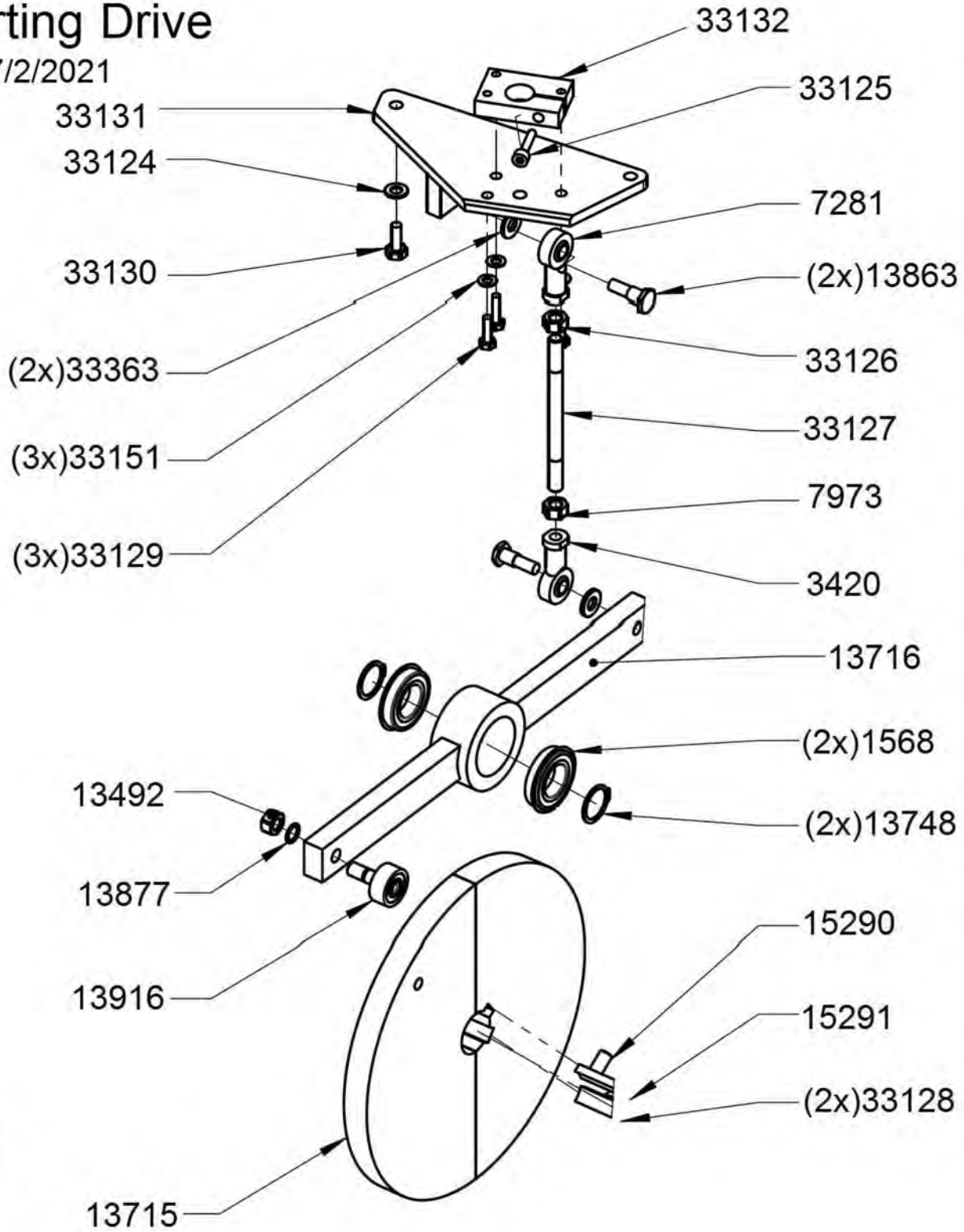


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New Version > 2014
 Old Version ≤ 2014

Section 8: Sorting Drive

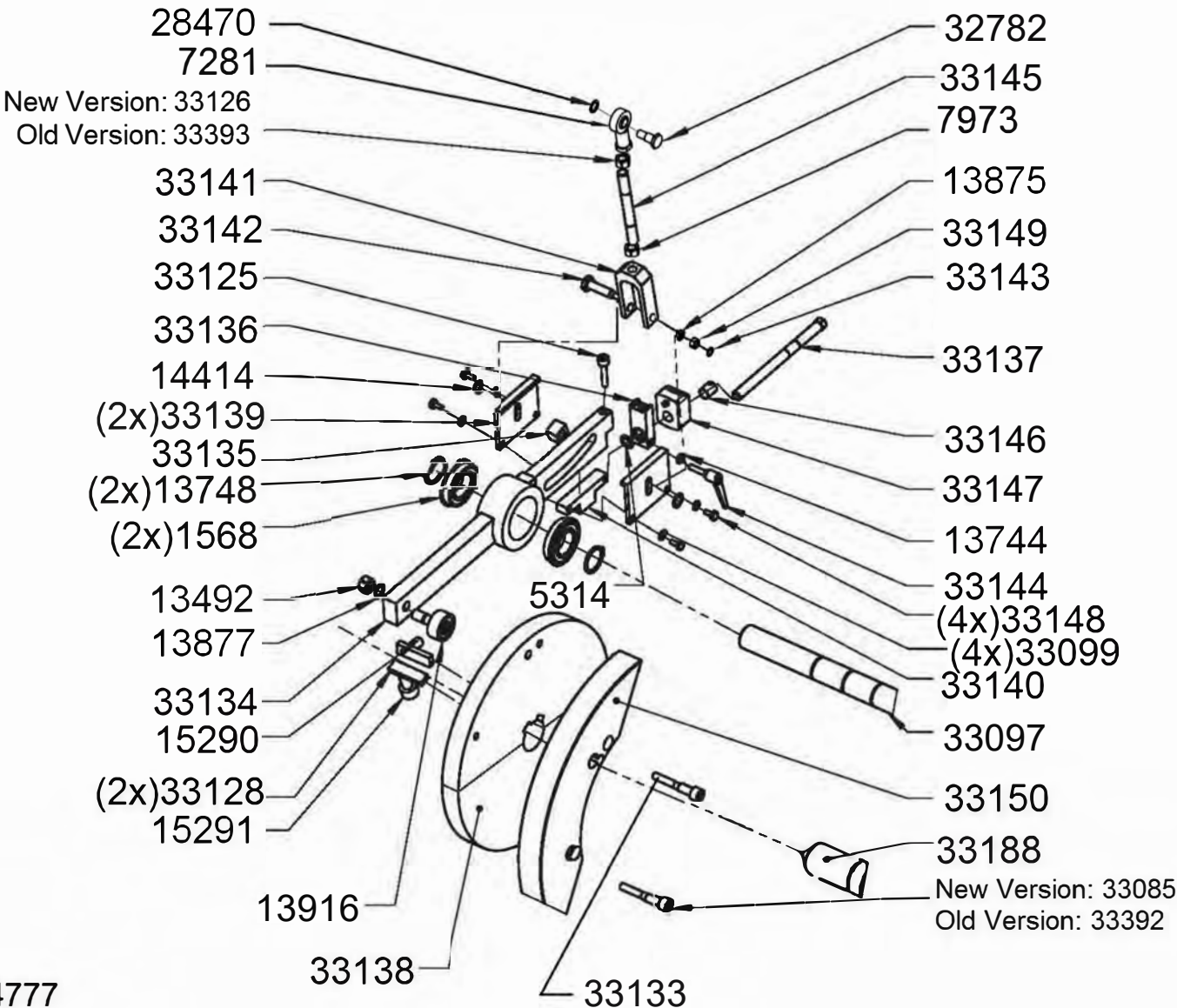
GKF1505 - revised 7/2/2021



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Section 9: Separation Drive

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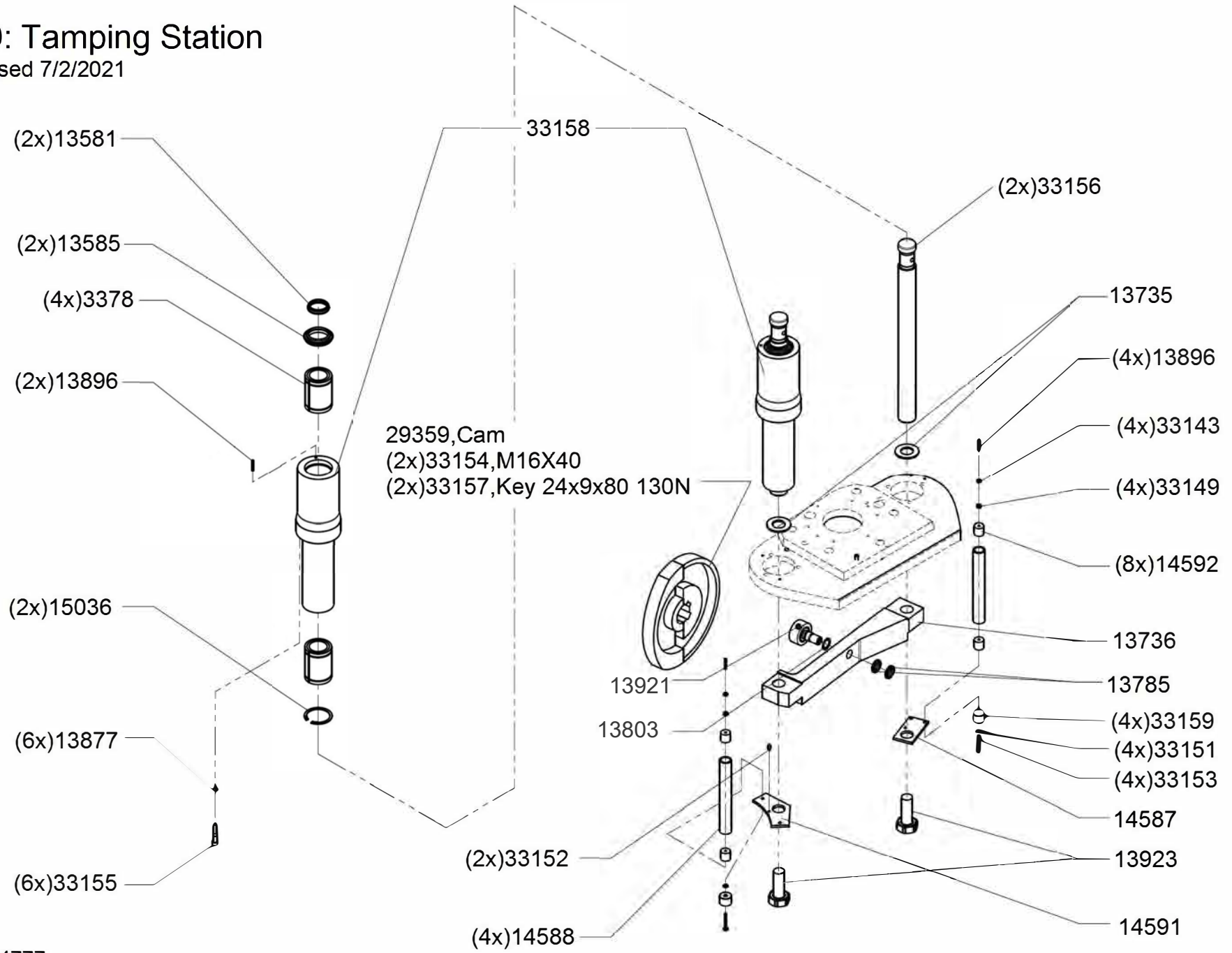


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New Version > 2014
 Old Version ≤ 2014

Section 10: Tamping Station

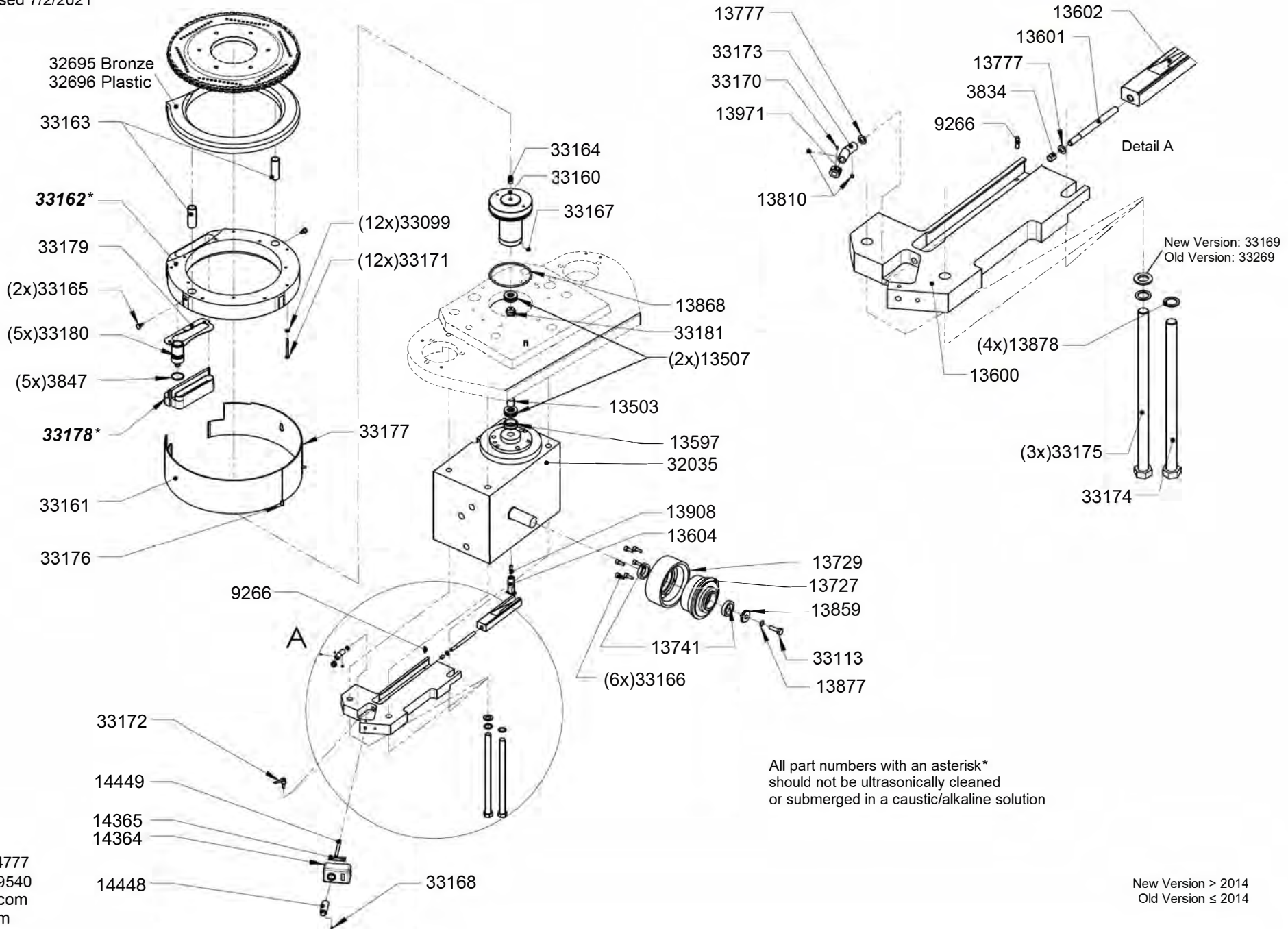
GKF1505 - revised 7/2/2021



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Section 11: Dosing Station & Gearbox

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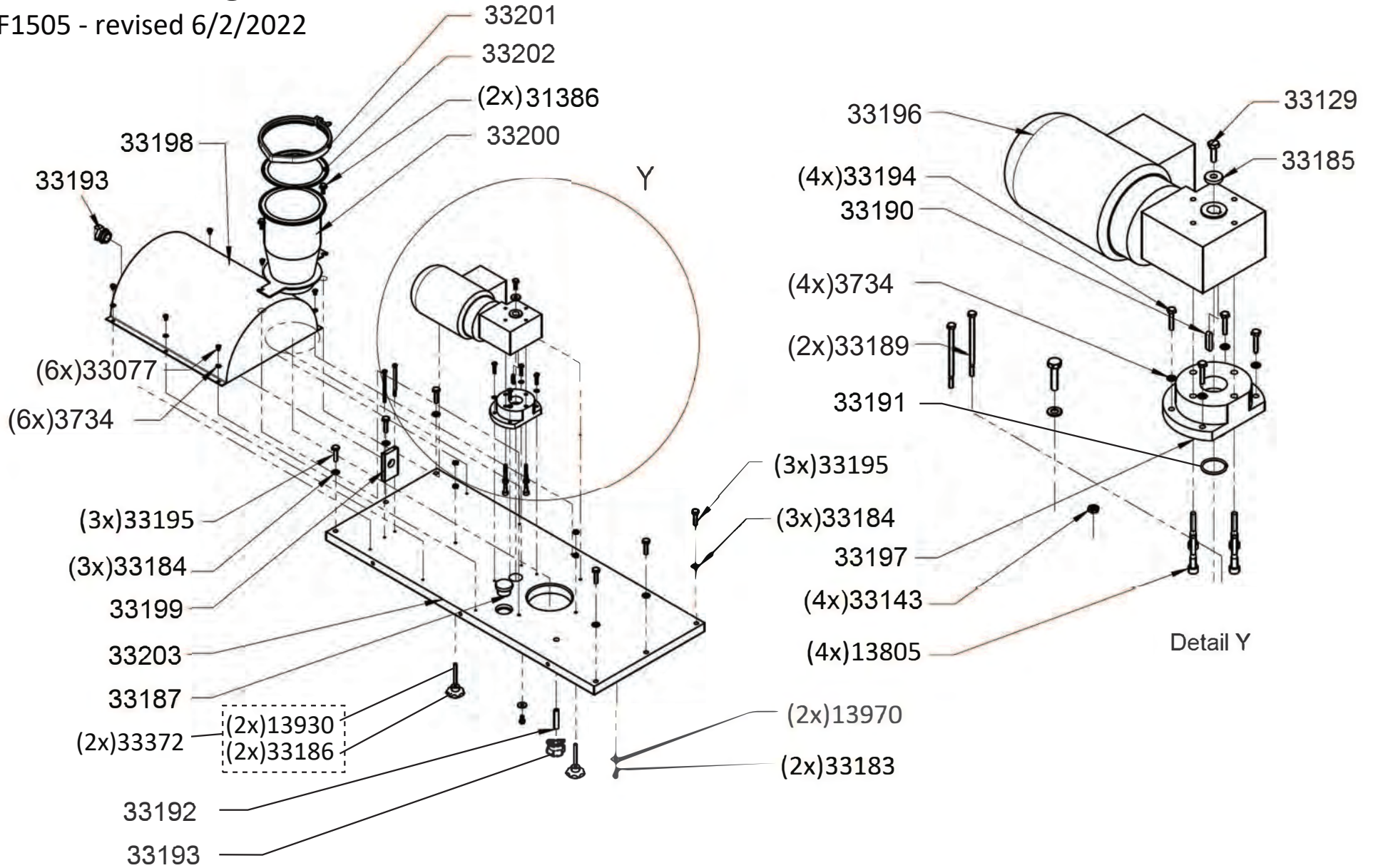
All part numbers with an asterisk* should not be ultrasonically cleaned or submerged in a caustic/alkaline solution

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New Version > 2014
 Old Version ≤ 2014

Section 12: Auger Motor & Gearbox

GKF1505 - revised 6/2/2022

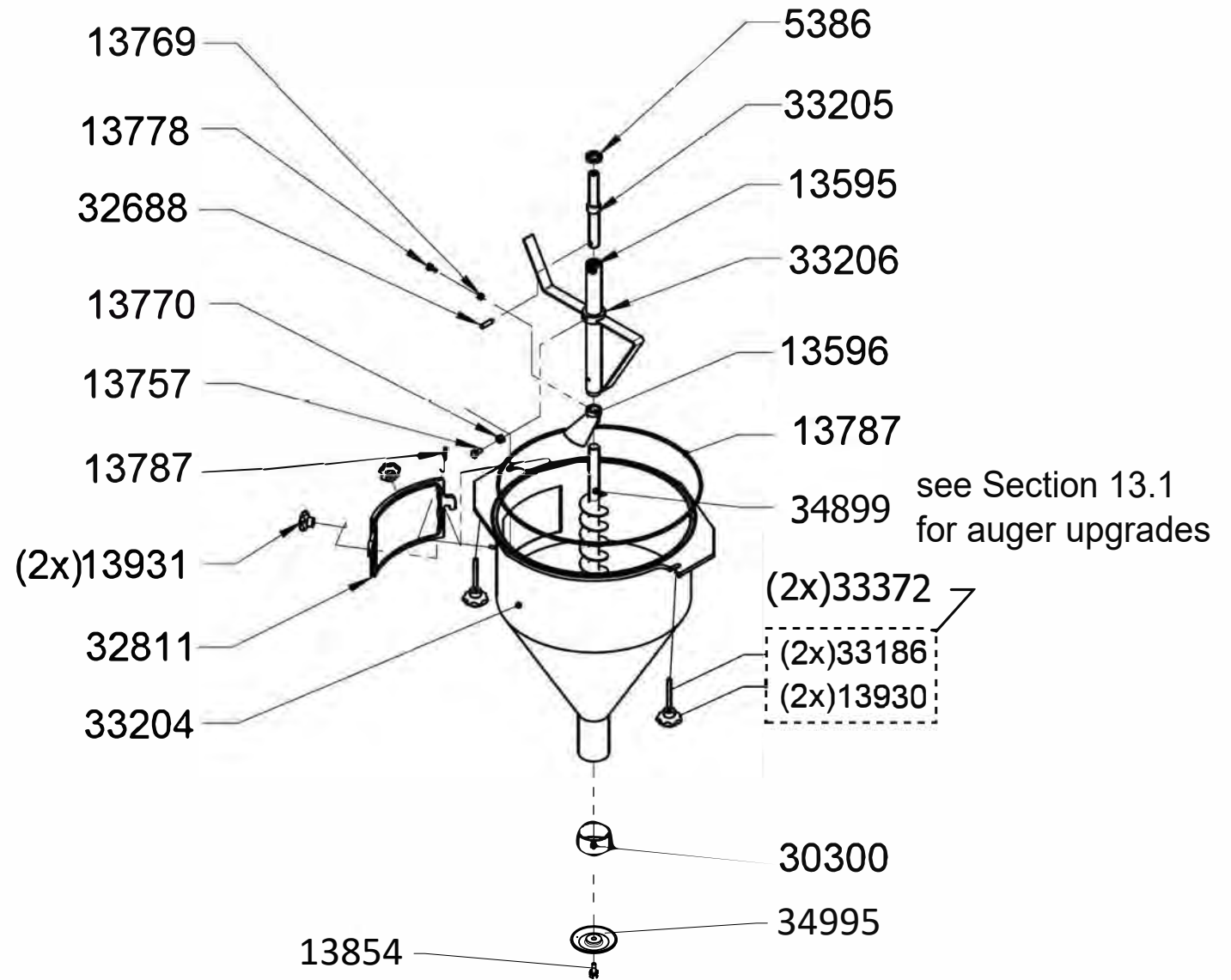


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Section 13: Powder Hopper & Auger

GKF1505 - revised 2/20/2023



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Section 13.1: Auger Upgrades

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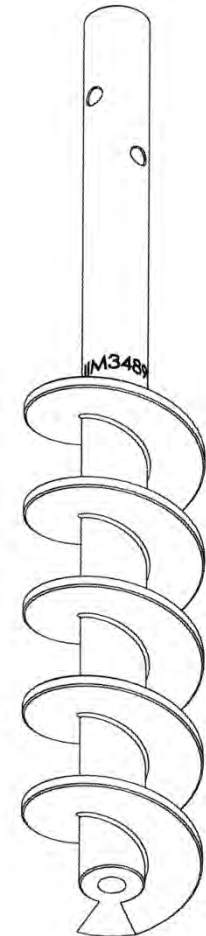
34900
¼ TWIST
152 PITCH



34996
3 TWIST
61.25 PITCH



34997
4 TWIST
46 PITCH



34899
5 TWIST
37 PITCH

IIM

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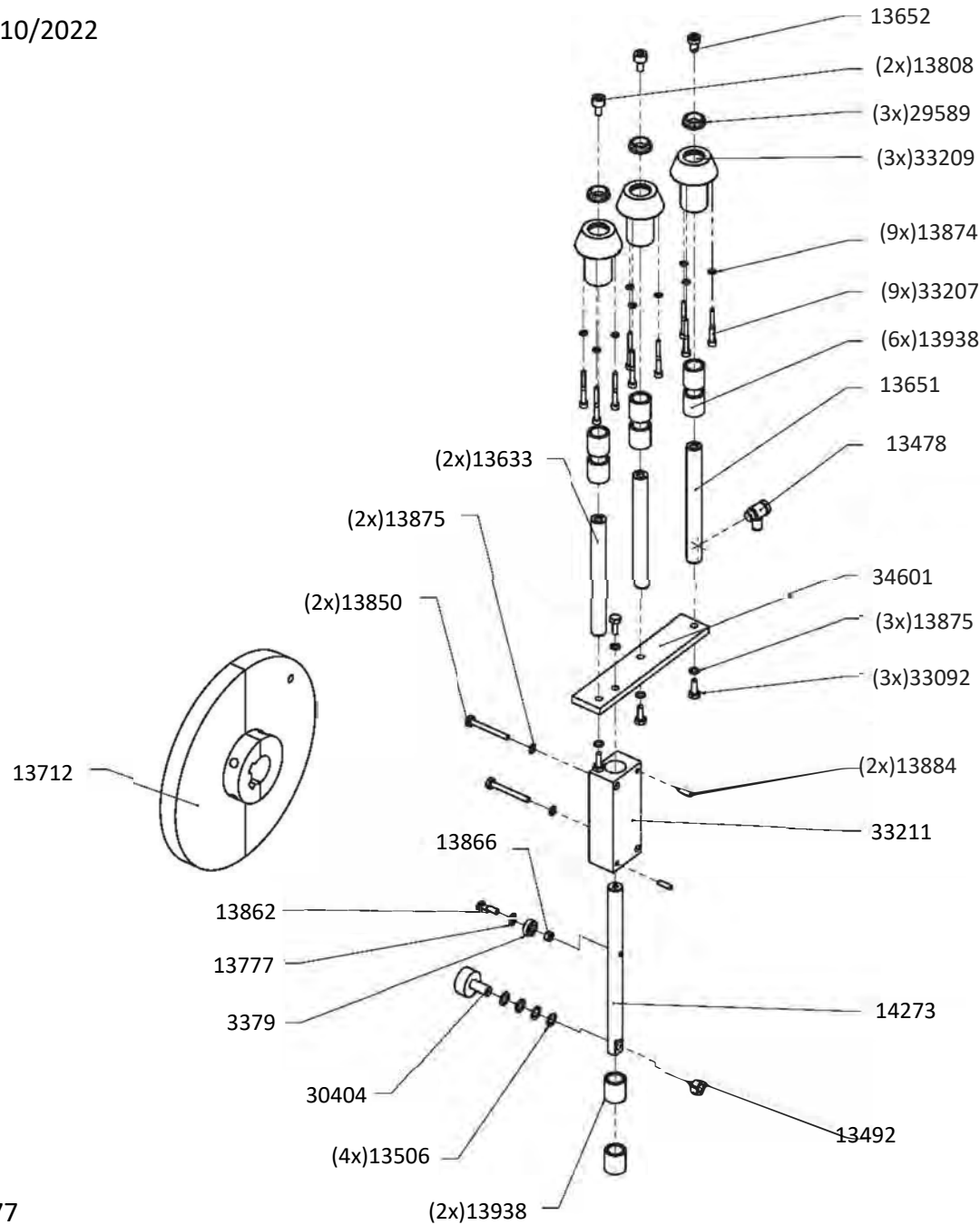
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Section 14.1: Ejection Drive - New Version - 3 Shaft

New Version > 2017

GKF1505 - revised 11/10/2022

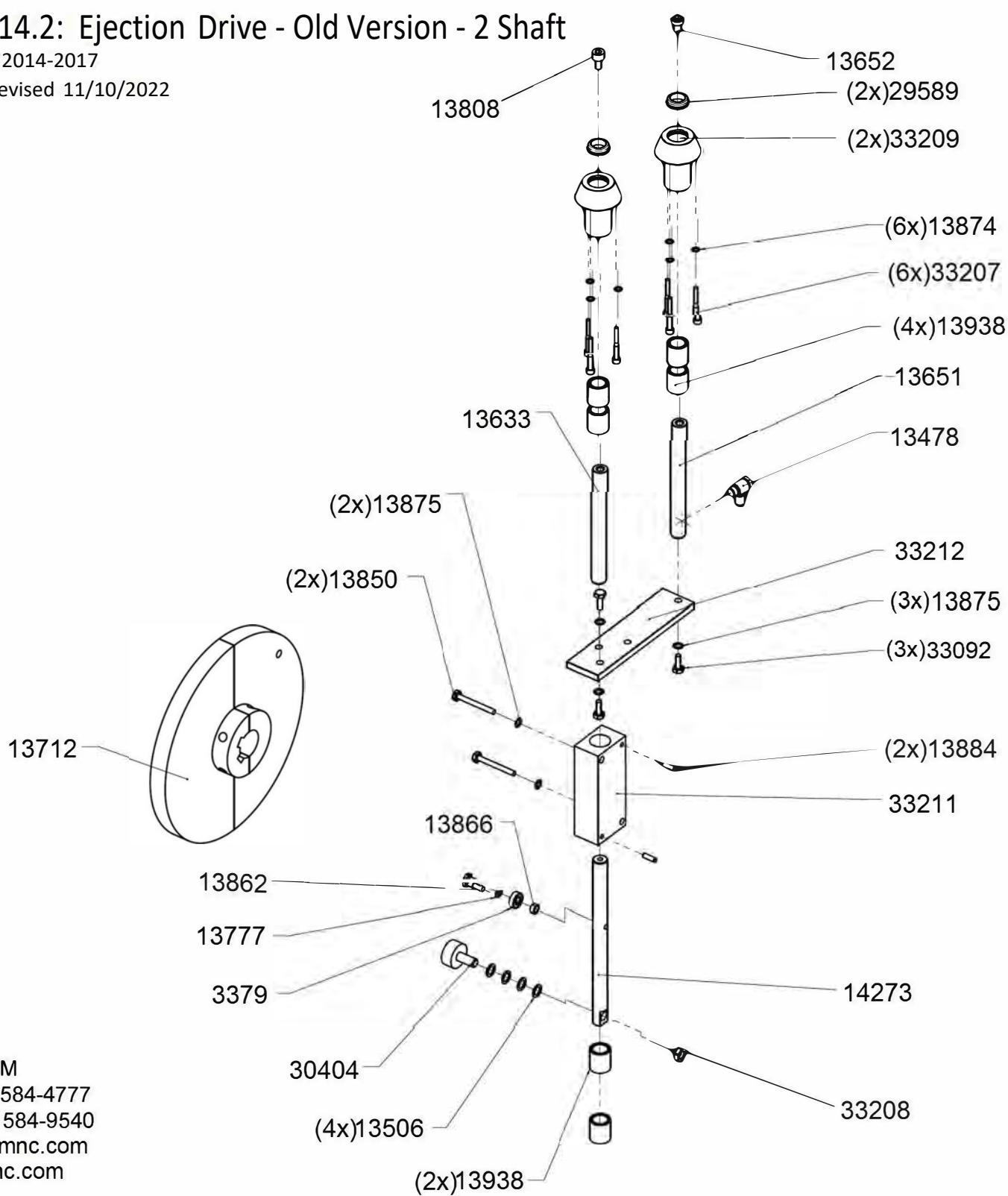


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Section 14.2: Ejection Drive - Old Version - 2 Shaft

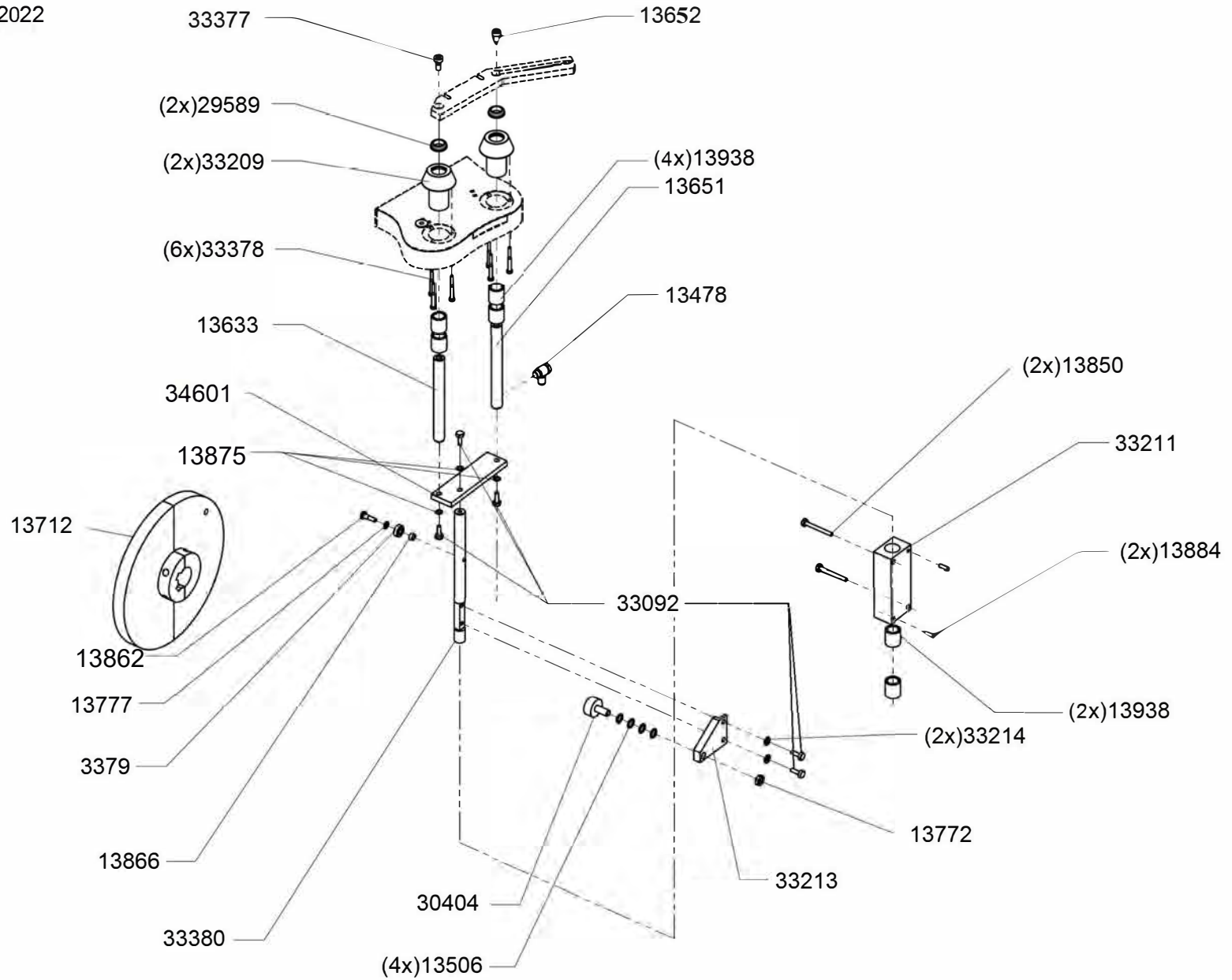
Old Version 2014-2017

GKF1505 - revised 11/10/2022



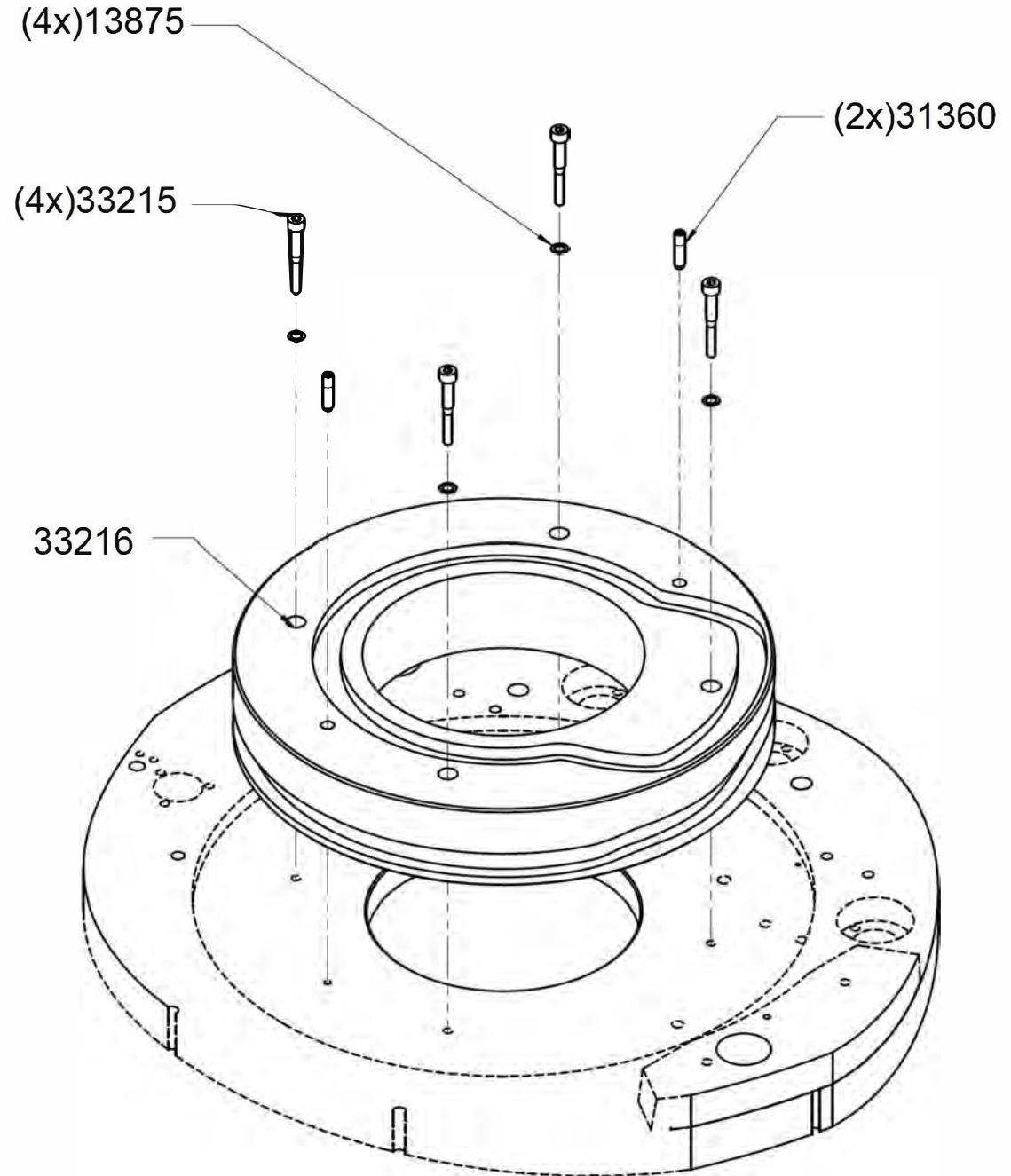
Section 14.3: Ejection Drive - Old Version - 2 Shaft

Old Version < 2014
GKF1505 - revised 11/10/2022



Section 15: Segment Cam

GKF1505 - revised 7/2/2021

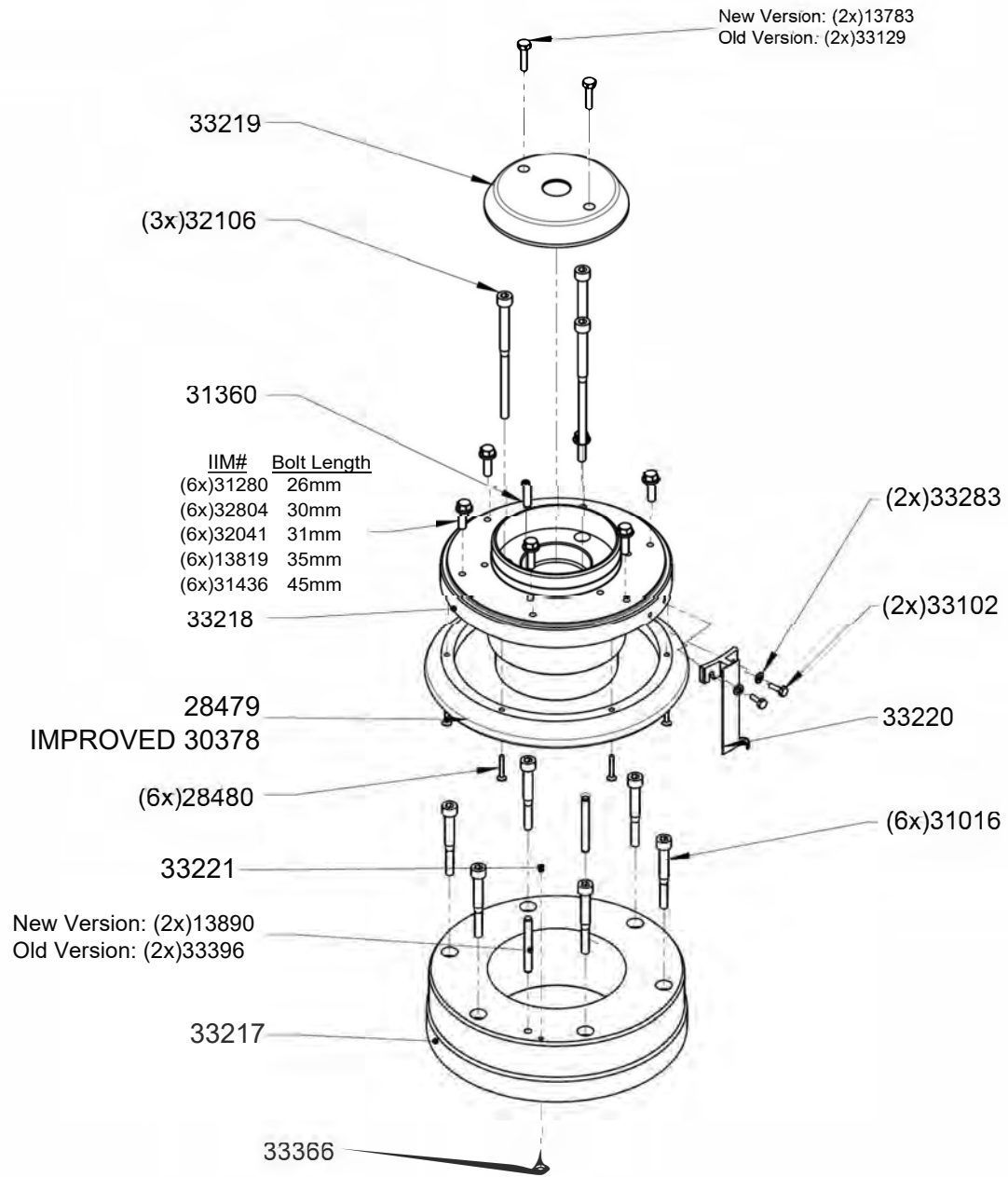


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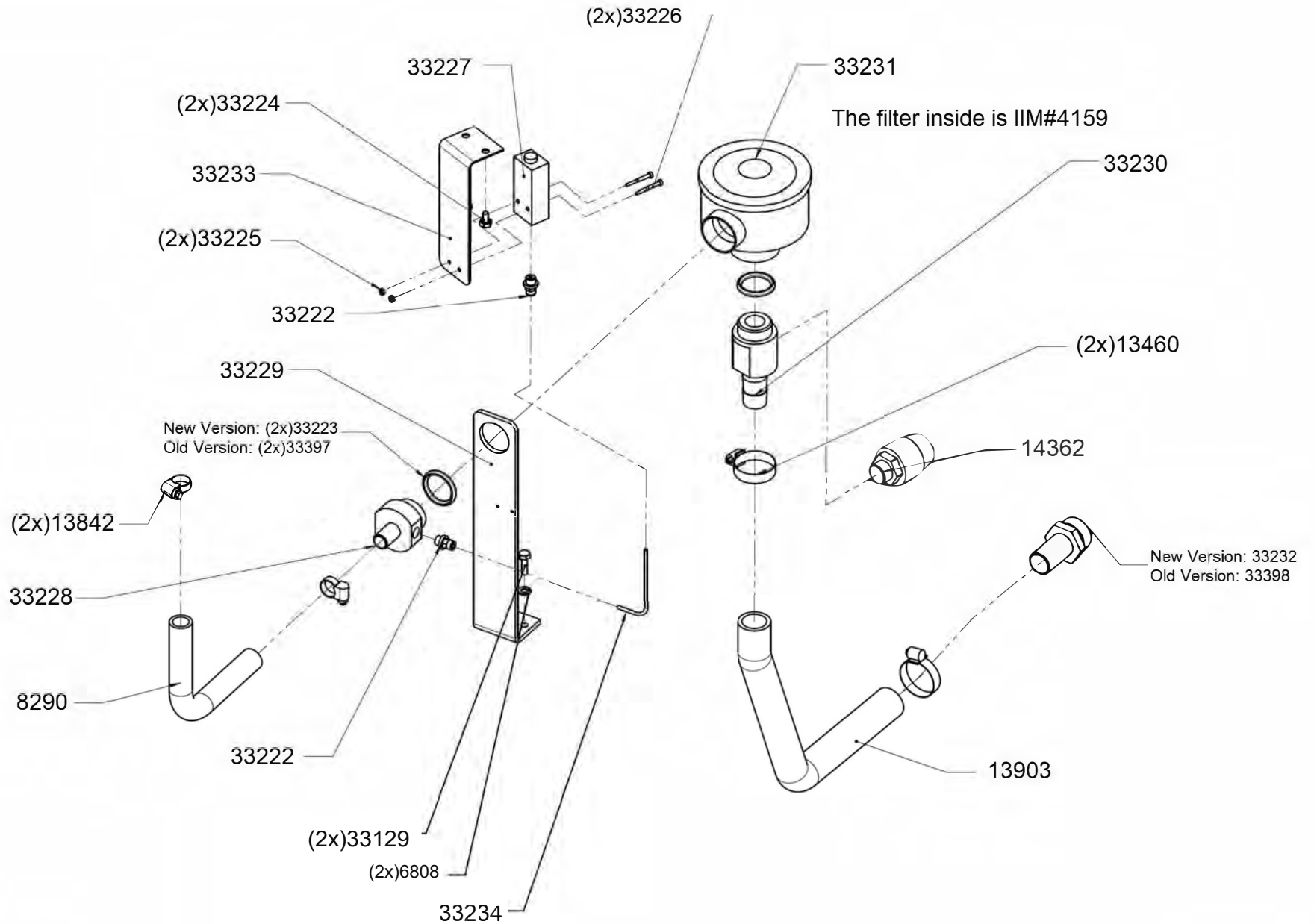
Section 16: Dosing Base with Disc

GKF1505 - revised 2/11/2022



Section 17: Vacuum Station

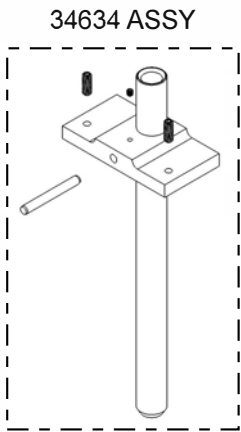
GKF1505 - revised 1/6/2022



Section 18: Capsule Separation Station

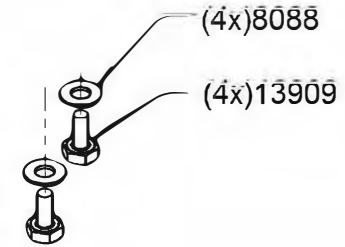
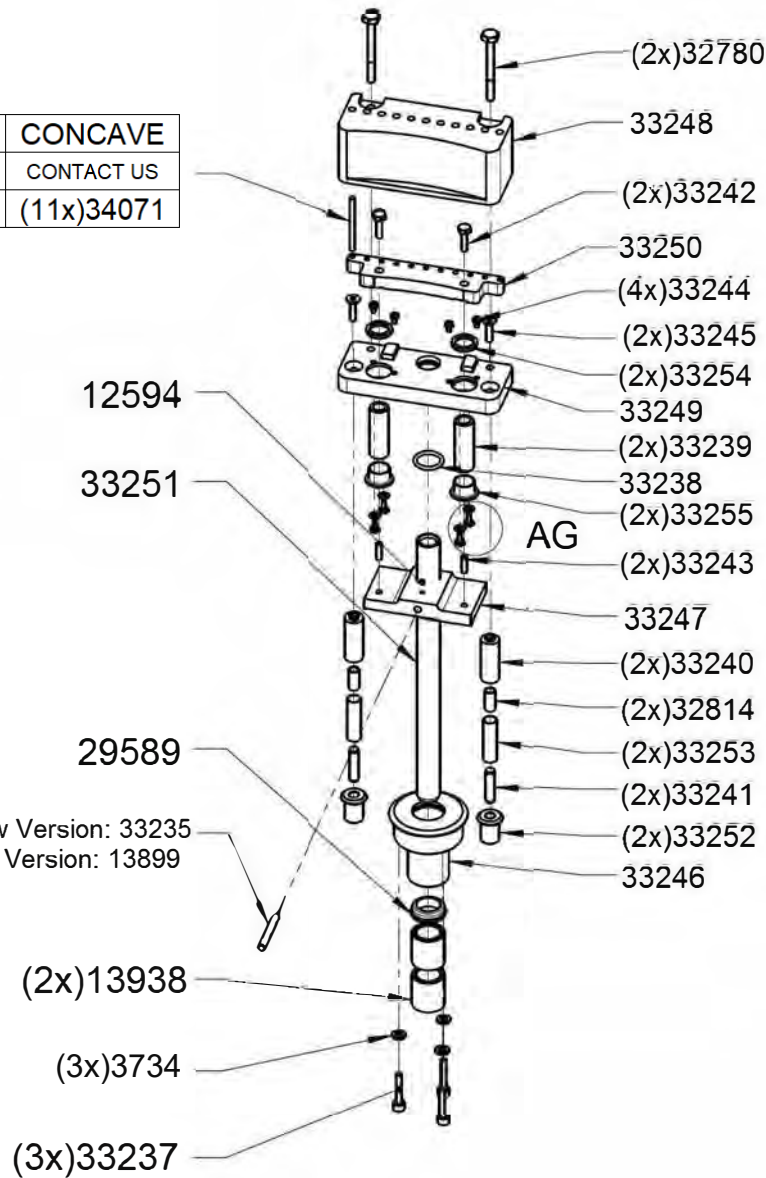
GKF 1505 - revised 2/15/23

	FLAT TOP	CONCAVE
46mm	(11x)34793	CONTACT US
53mm	(11x)31122	(11x)34071



part numbers with an asterisk* are included in this assembly

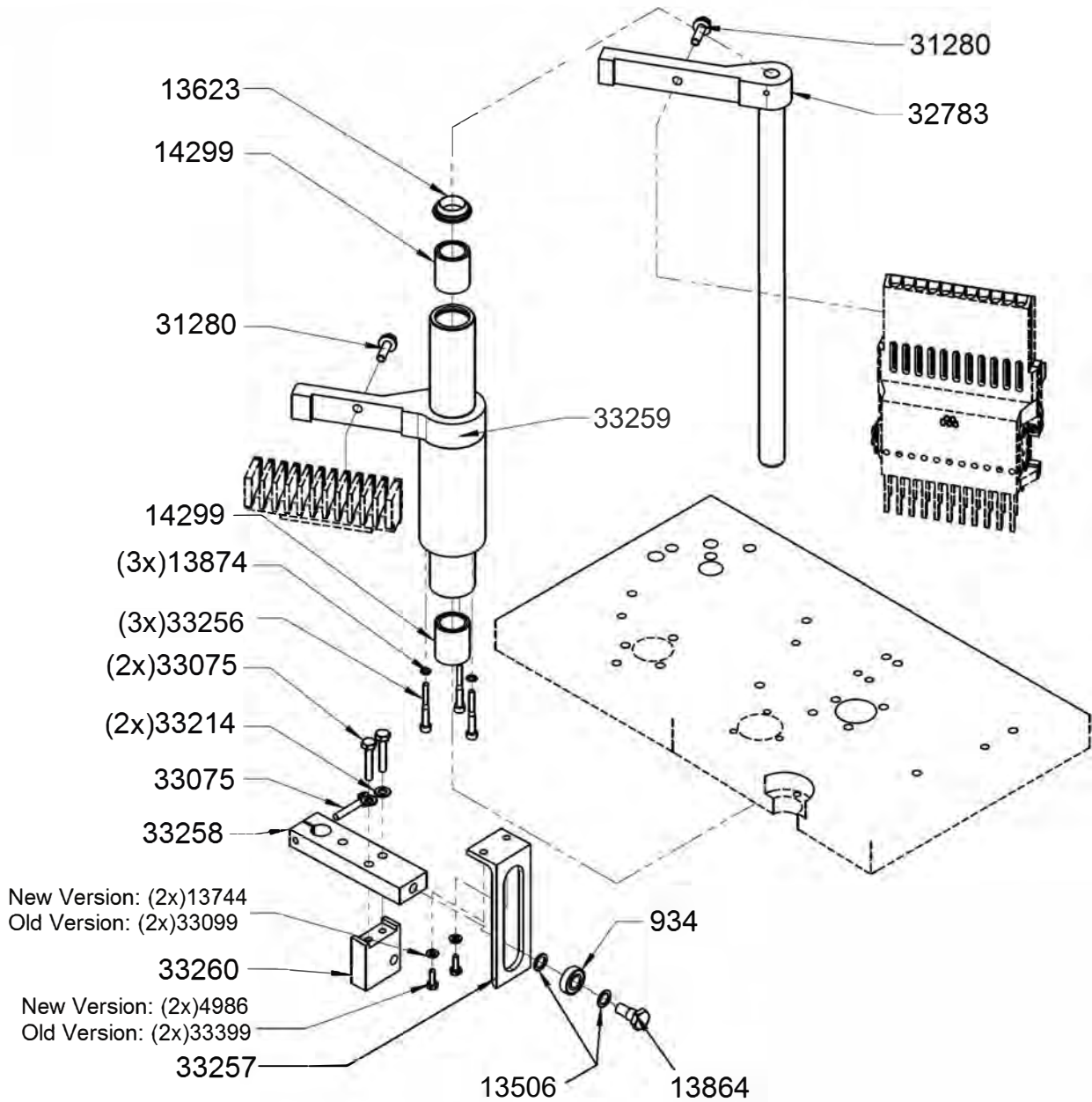
New Version: 33235
Old Version: 13899



Detail AG

Section 19: Capsule Orientation Station

GKF1505 - revised 7/2/2021



New Version: (2x)13744
Old Version: (2x)33099

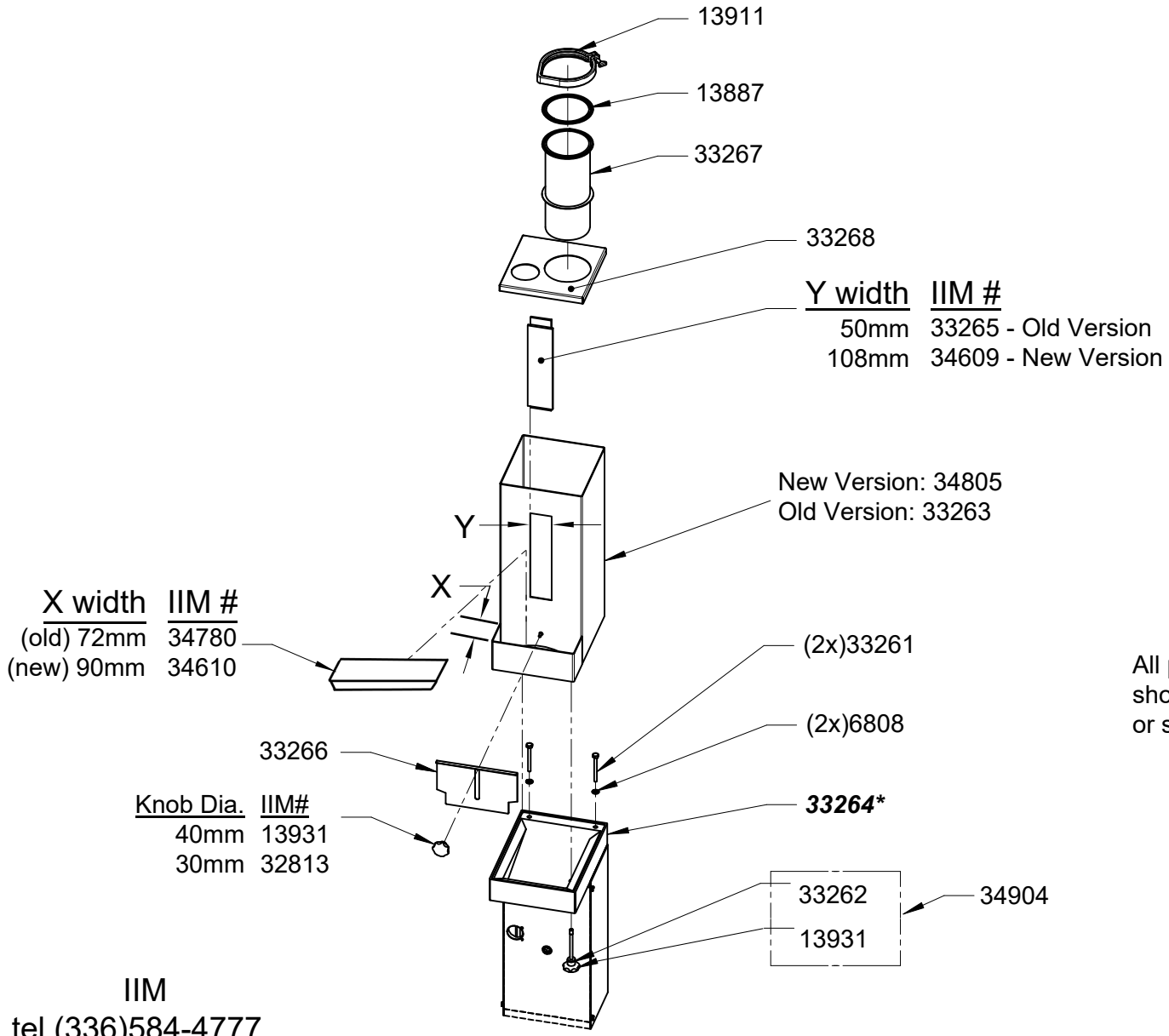
33260
New Version: (2x)4986
Old Version: (2x)33399

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New Version > 2014
Old Version ≤ 2014

Section 20: Capsule Hopper

GKF1505 - revised 3/11/22



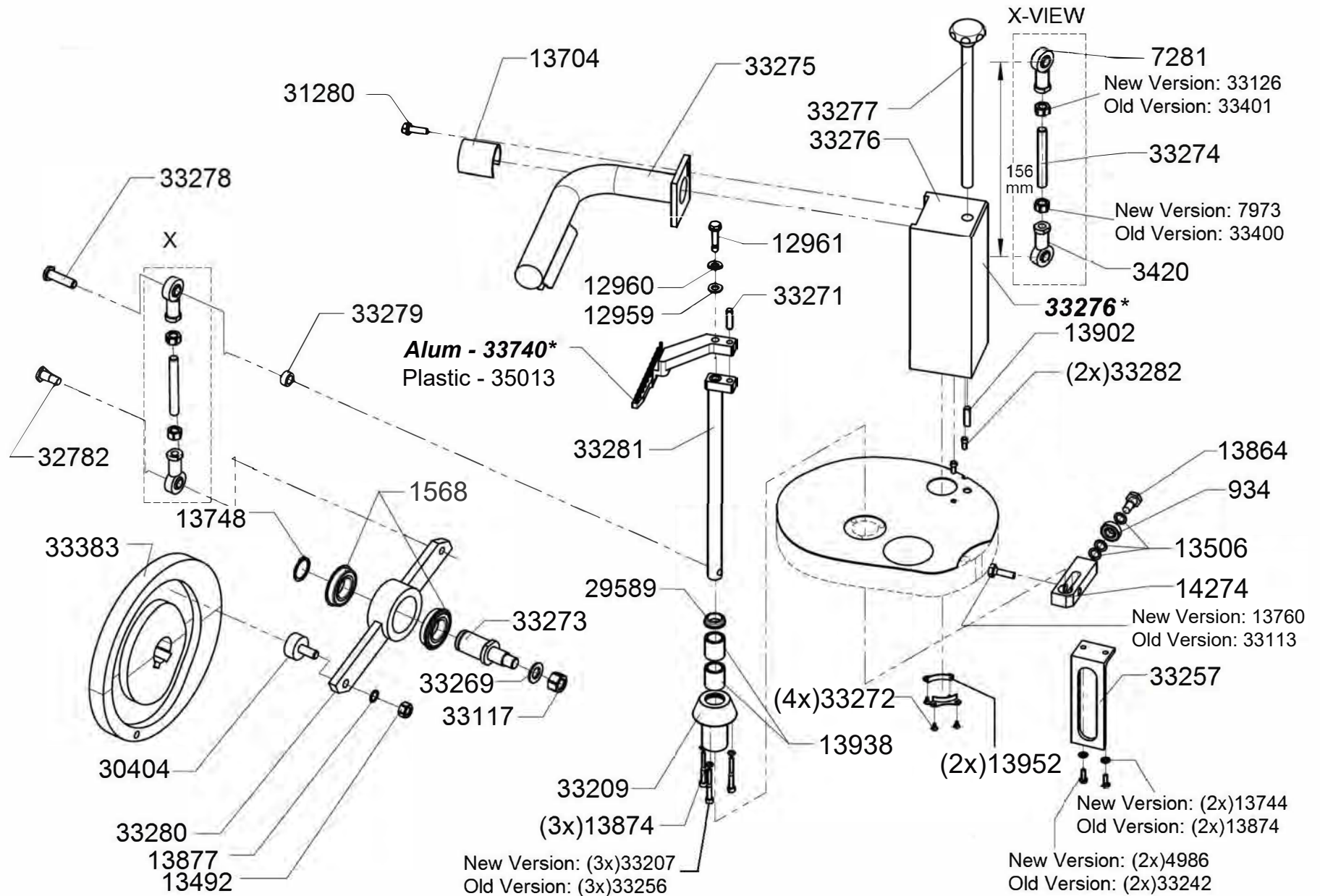
All part numbers with an asterisk* should not be ultrasonically cleaned or submerged in a caustic/alkaline solution

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New Version ≥ 2017
 Old Version < 2017

Section 21: Faulty Capsule Ejection 11CT

GKF1505 - revised 7/2/2021



IIM

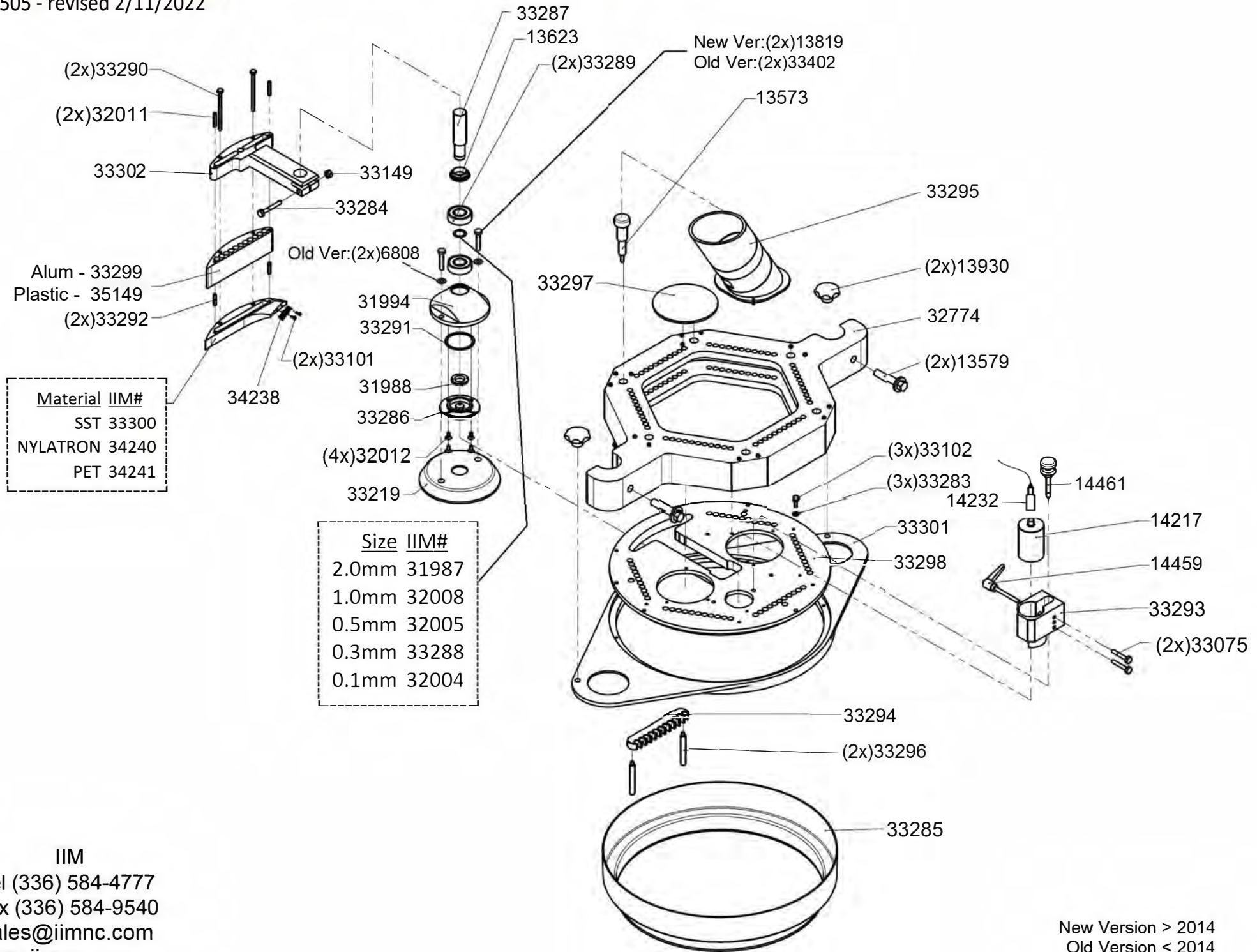
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All part numbers with an asterisk*
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New Version > 2014
 Old Version ≤ 2014

Section 22: Powder Dosing / Guide Ring / Wiper Block

GKF1505 - revised 2/11/2022

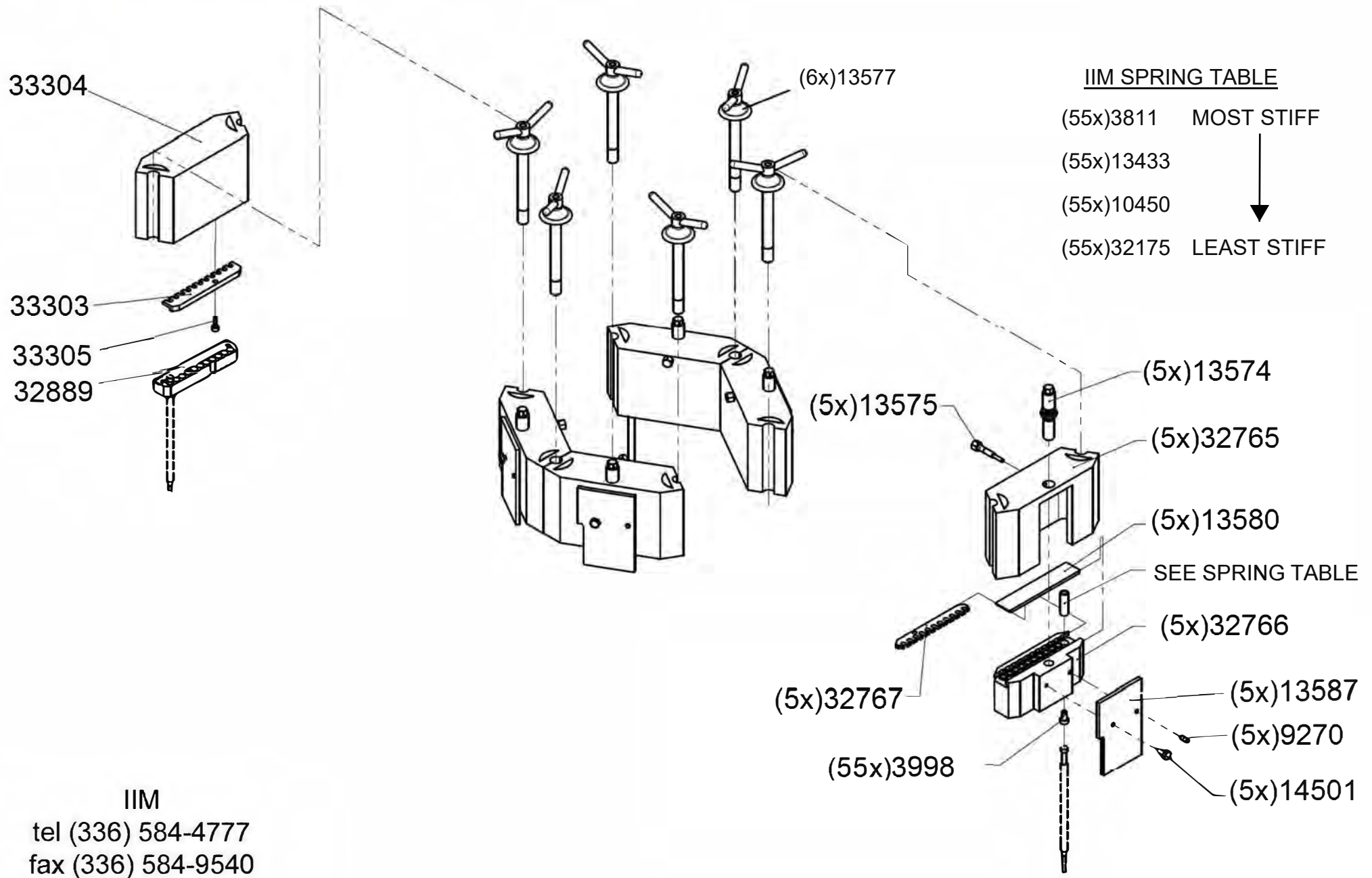


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New Version > 2014
 Old Version ≤ 2014

Section 23: Tamping Station

GKF1505 - revised 7/2/2021



IIM SPRING TABLE

(55x)3811	MOST STIFF	↓
(55x)13433		
(55x)10450		
(55x)32175	LEAST STIFF	

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Section 24: Powder Tamping Ring / Dosing Disc

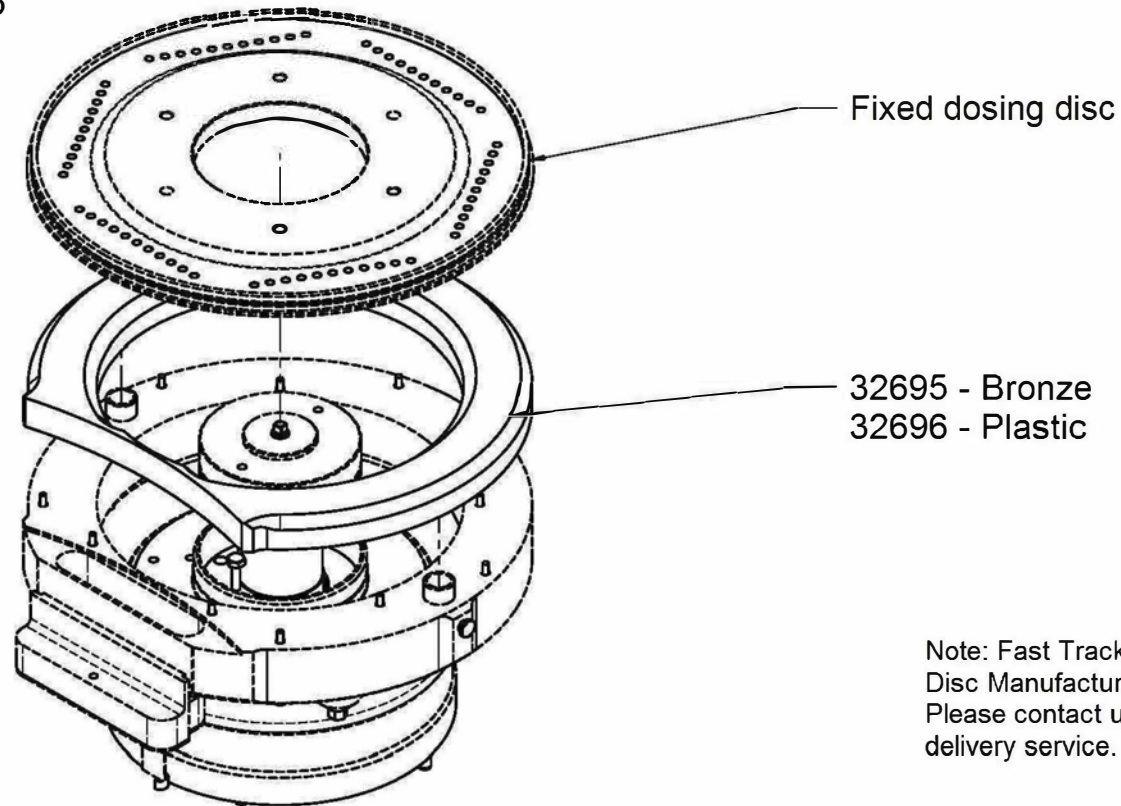
GKF1505 - revised 7/2/2021

Dosing Disc Bolts

(6x)31280 - M8x26

(6x)32041 - M8x32

(6x)13819 - M8x36



<u>IIM#</u>	<u>Description</u>
32338	Fixed Dosing Disc Size 00
33025	Fixed Dosing Disc Size 0
33026	Fixed Dosing Disc Size 1
33027	Fixed Dosing Disc Size 2
33028	Fixed Dosing Disc Size 3
33029	Fixed Dosing Disc Size 4
33369	Fixed Dosing Disc Size 5

Note: Fast Track Dosing Disc Manufacturing available. Please contact us for speedy delivery service.

Dosing Disc Storage Box

Fixed: IIM# 32165

Adjustable: IIM# 31281

IIM

tel (336) 584-4777

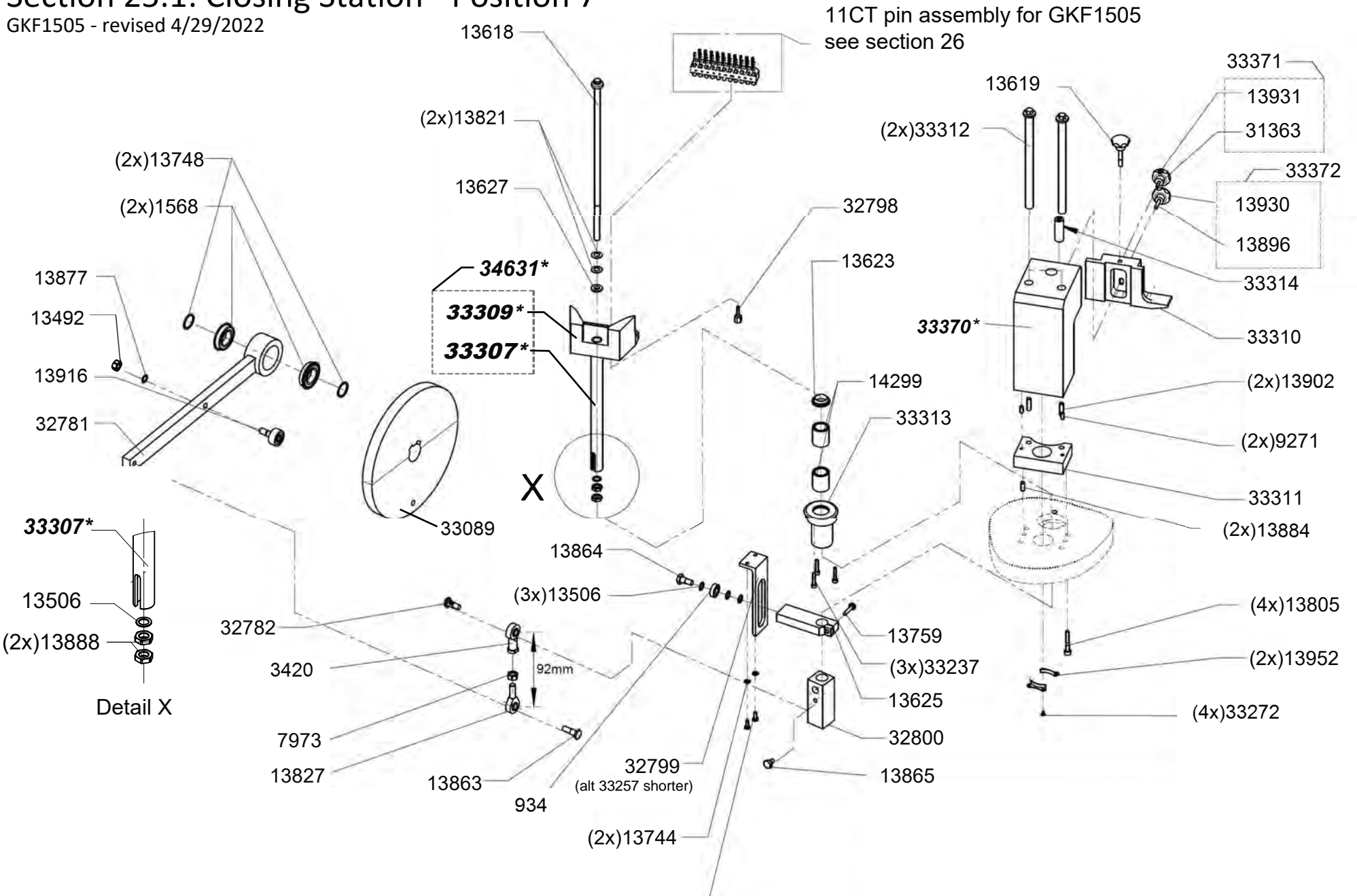
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Section 25.1: Closing Station - Position 7

GKF1505 - revised 4/29/2022

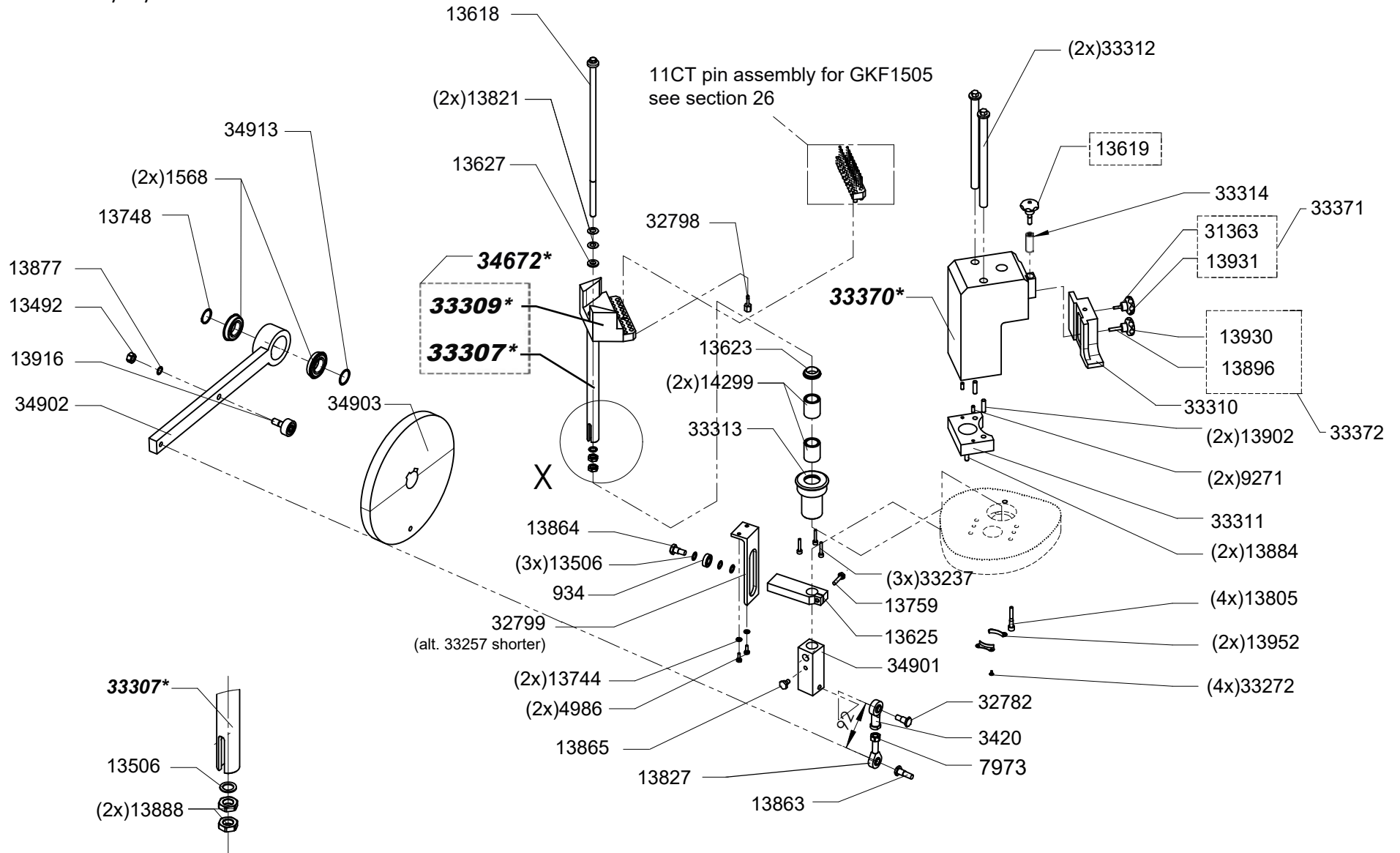


New Version: (2x)4986
Old Version: (2x)33404

All part numbers with an asterisk *
should not be ultrasonically cleaned
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Section 25.2: Closing Station - Position 9

GKF1505 - revised 5/25/2022

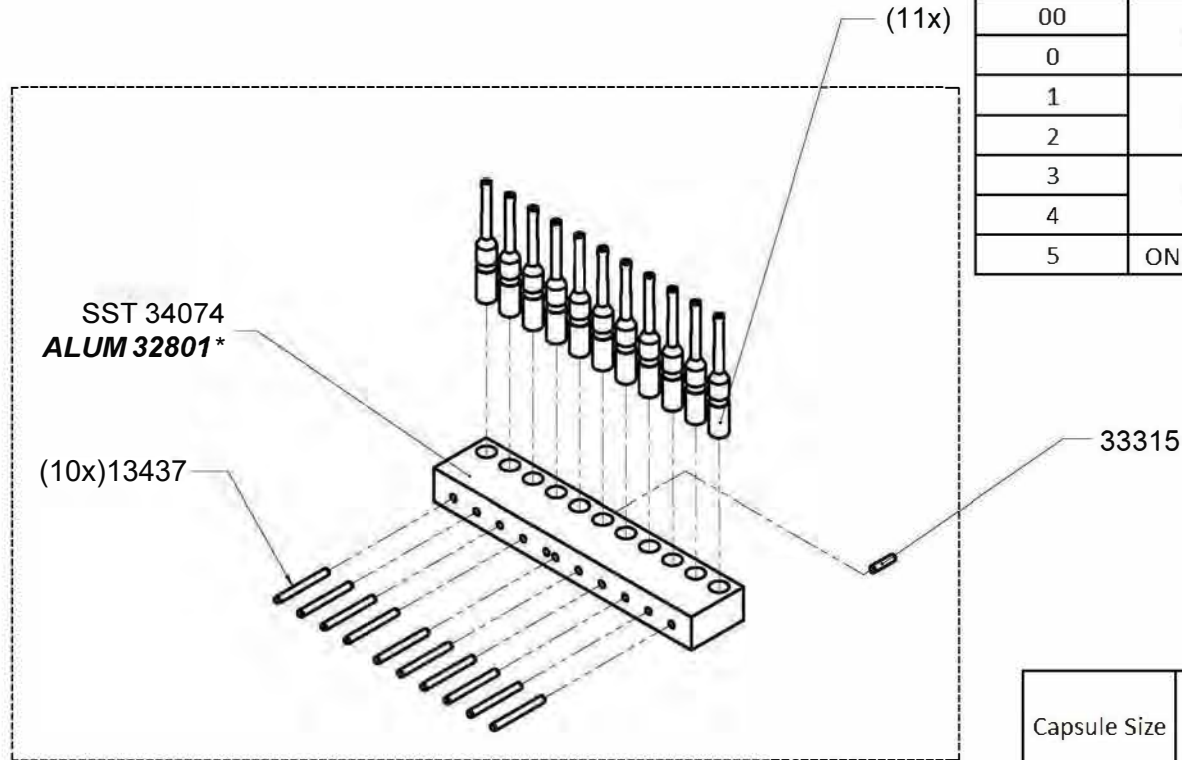


Detail X

All part numbers with an asterisk * should not be ultrasonically cleaned or submerged in a caustic/alkaline solution

Section 26: Closing Pins

GKF1505 - revised 7/2/2021



Lower Closing Pins

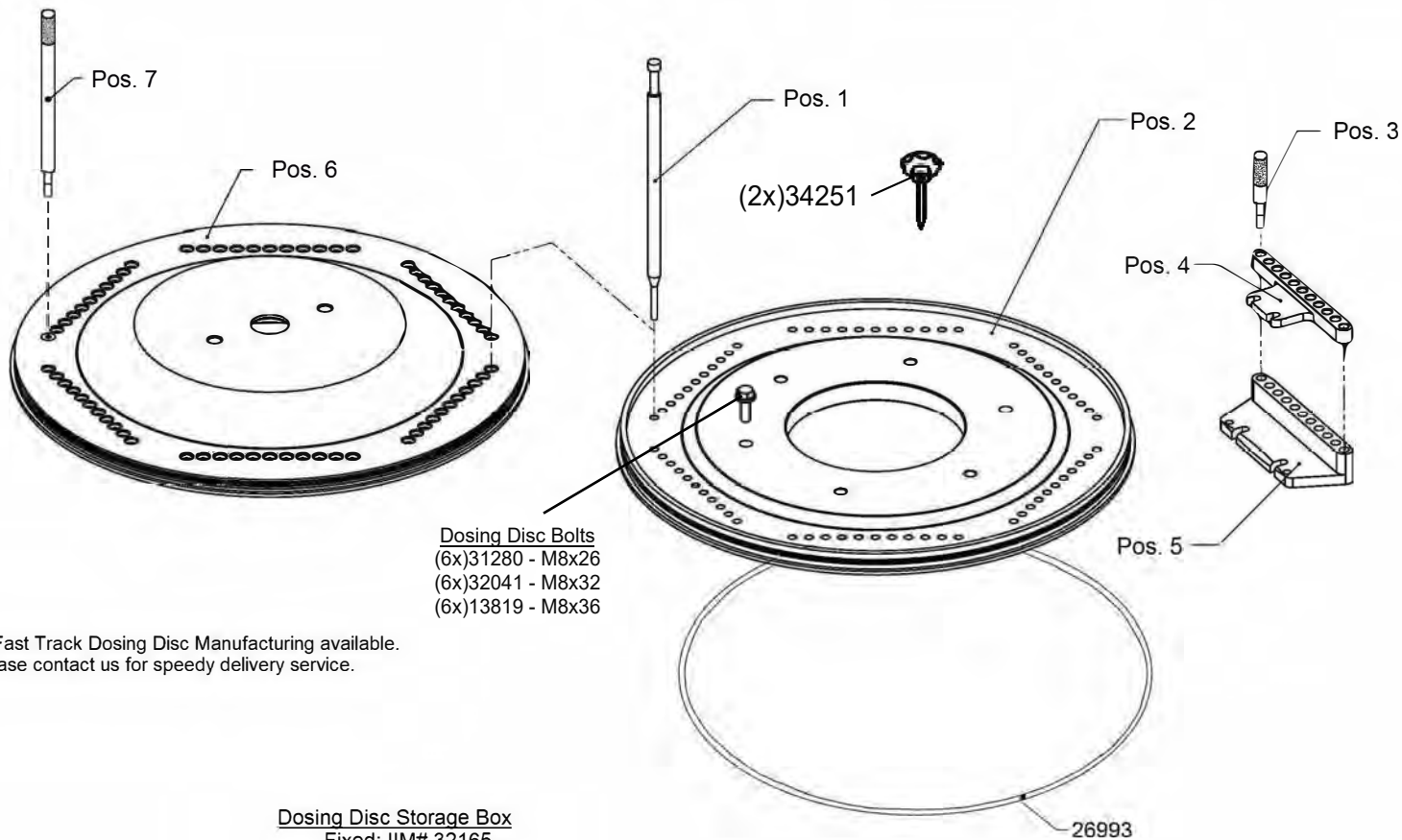
Capsule Size	IIM# Material: Stainless Steel	IIM# Material: Aluminum	IIM# Material: Stainless Steel
000	ON REQUEST	ON REQUEST	29580
00	16228	28121	
0	16230	32634	29581
1			
2	16232	32635	33316
3			
4			
5	ON REQUEST	ON REQUEST	

Complete Assembly

Capsule Size	IIM# Material: Stainless Steel	IIM# Material: Aluminum	IIM# Material: Stainless Steel
000	ON REQUEST	ON REQUEST	33436
00	33306	33433	
0	33432	33434	33437
1			
2	33431	33435	33438
3			
4			
5	ON REQUEST	ON REQUEST	

Section 27: Size Change Parts 11CT

GKF1505 - revised 7/2/2021

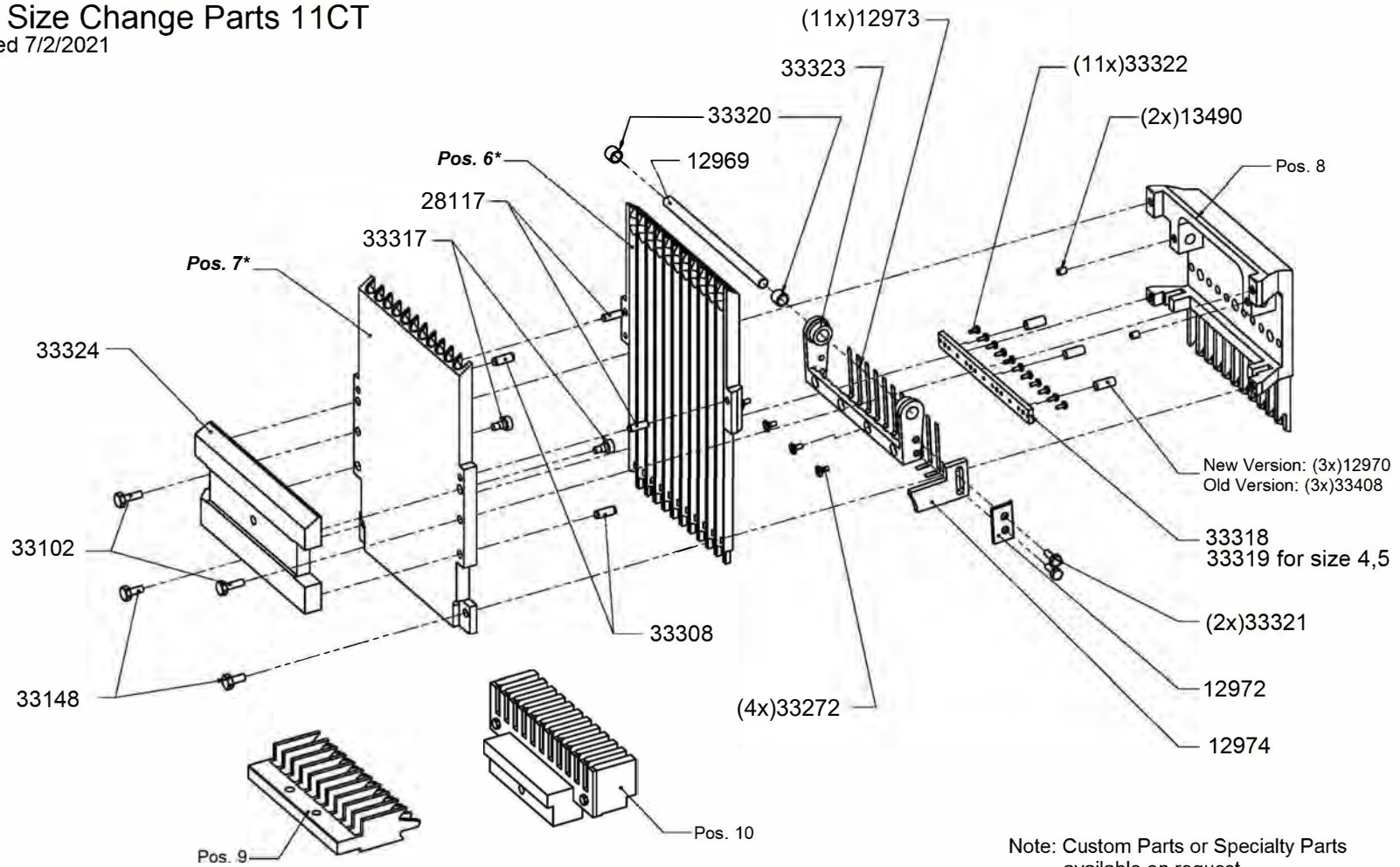


Note: Fast Track Dosing Disc Manufacturing available.
 Please contact us for speedy delivery service.

Dosing Disc Storage Box
 Fixed: IIM# 32165
 Adjustable: IIM# 31281

	Description	Capsule Size					
		00/elong	0/elong	1/elong	2/elong	3	4
Pos. 1	Tamping Pin for Fixed Disc Powder	13066	12953	13062	13067	13068	13069
	Tamping Pin for Adjustable Disc Powder	13061	13062	13063	13064	13071	13072
	Transfer Pin for Adjustable Disc Pellet	30780	30758	30757	30759	30781	30782
Pos. 2	Fix Dosing Disc	32338	33025	33026	33027	33028	33029
Pos. 3	Segment Alignment Pin	4923	8185	4924	5190	5191	13361
Pos. 4	Upper Segment Block	32339	32341	32343	32344	32345	32346
Pos. 5	Lower Segment Block	32340	32342	32347	32348	32349	32350
Pos. 6	Adjustable Dosing Disc	33030	33031	33032	33033	33034	33035
Pos. 7	Dosing Disc Alignment Pin	3539	7291	4925	5188	5189	7293

Section 28: Size Change Parts 11CT
GKF1505 - revised 7/2/2021



Note: Custom Parts or Specialty Parts
available on request.
Storage Boxes available.

All part numbers with an asterisk*
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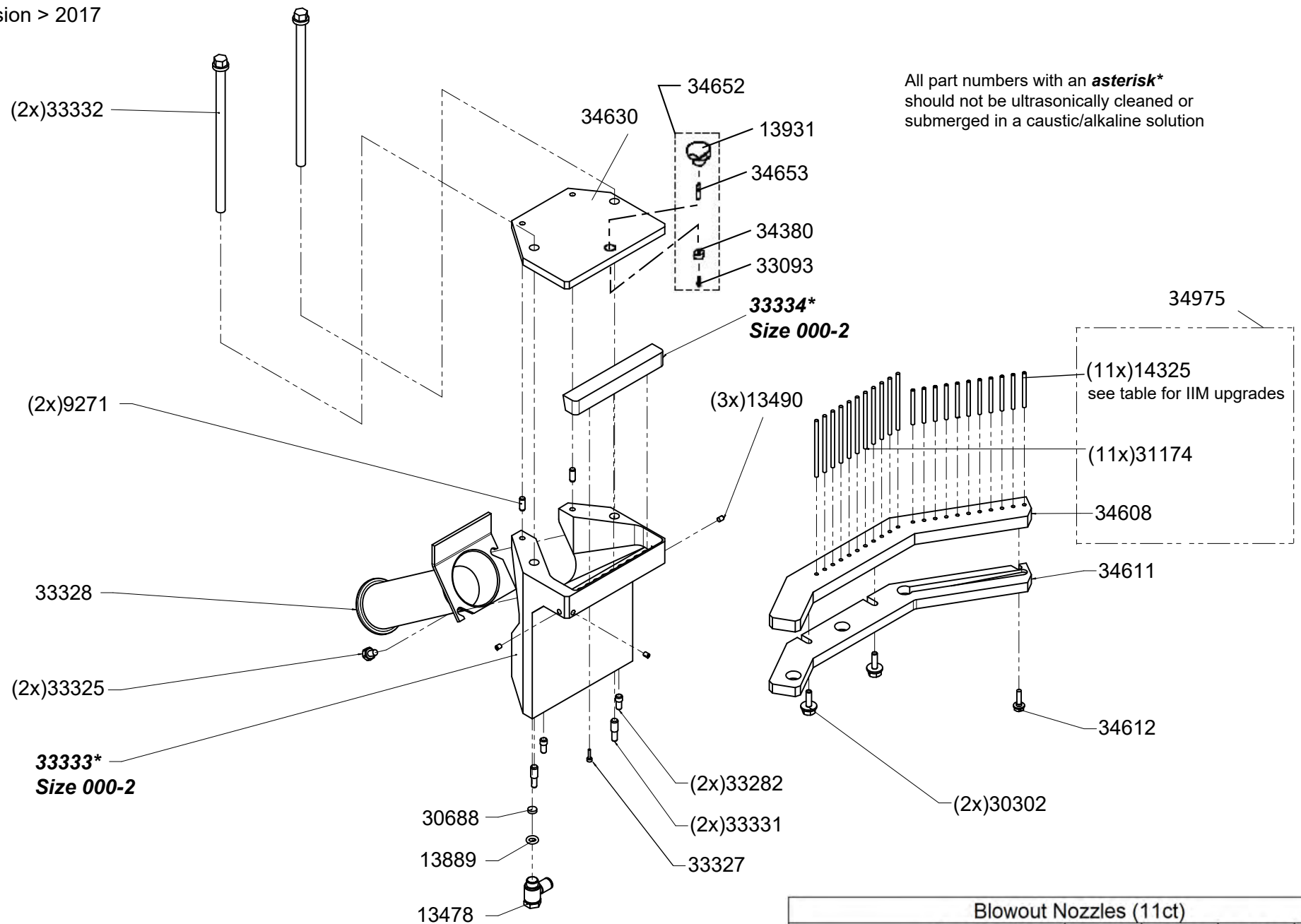
New Version > 2014
Old Version ≤ 2014

		Capsule Size					
	Description	00/00el	0/0el	1/1el	2/2el	3	4
Pos. 6	Magazine	33042	33041	33040	33039	33038	33037
Pos. 7							
Pos. 8	Vertical Fingers	33043	33044	33045	33046	33047	33048
Pos. 9	Orientation Fingers	33049	33050	33051	33052	33053	33054
Pos. 10	Sorting Block	33055	33056	33057	33058	33059	33060

Section 29.1: Capsule Ejection Station - New Version - 3 Shaft

GKF1505 - revised 1/14/2022

New Version > 2017

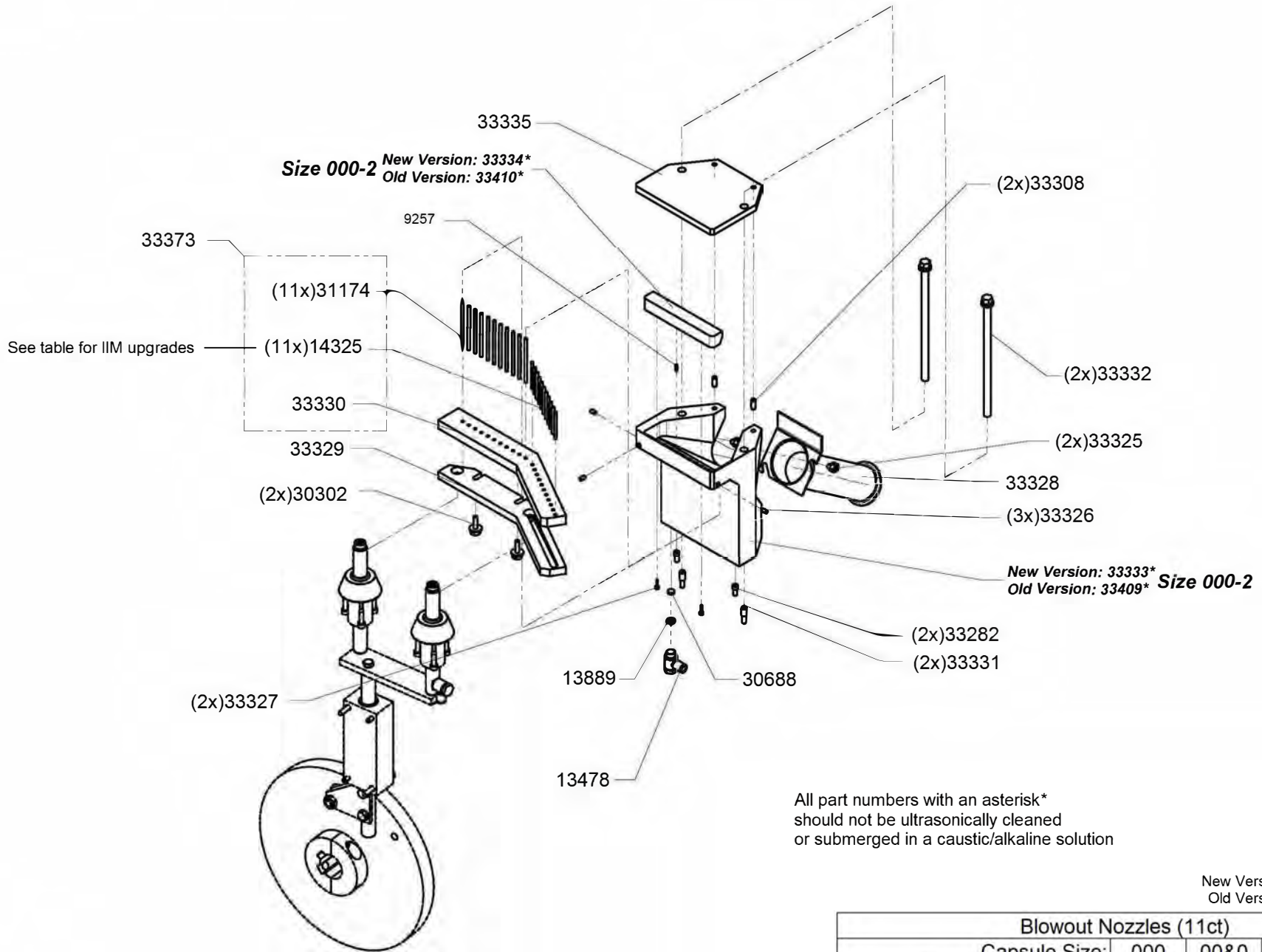


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Blowout Nozzles (11ct)					
		Capsule Size:			
		000	00&0	1&2	3&4
Standard	Nozzle	14325			
for Brush	Improved Nozzle, accepts Brush	33828			
	Brush	33759	31837	33776	34924

Section 29.2: Capsule Ejection Station - Old Version - 2 Shaft

GKF1505 - revised 3/25/2022
 Old Version < 2017

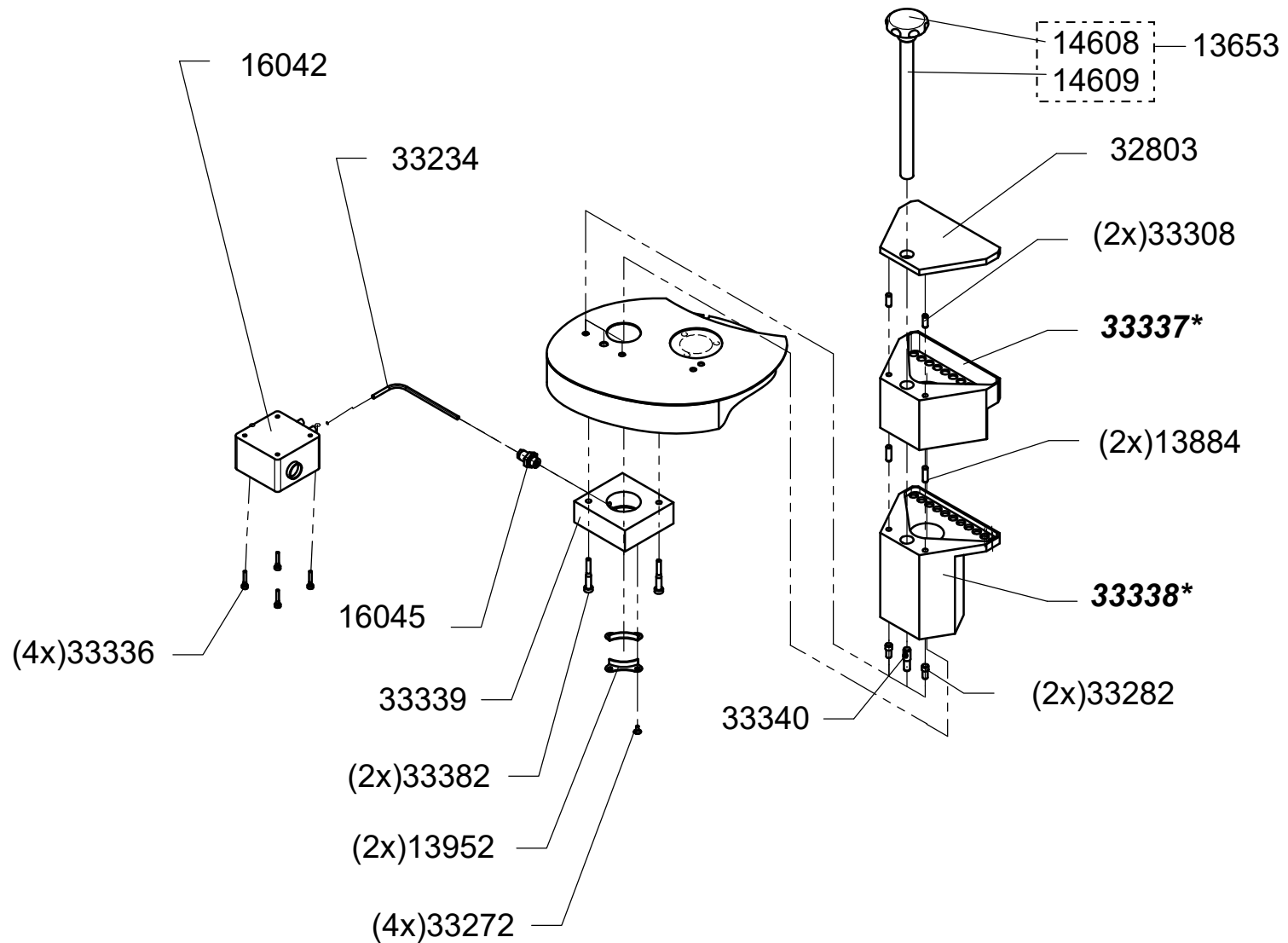


New Version > 2014
 Old Version ≤ 2014

Blowout Nozzles (11ct)					
Capsule Size:		000	00&0	1&2	3&4
Standard	Nozzle	14325			
for Brush	Improved Nozzle, accepts Brush	33767			
	Brush	33759	31837	33776	34924

Page 30: Cleaning Station

GKF1505 - revised 7/2/2021

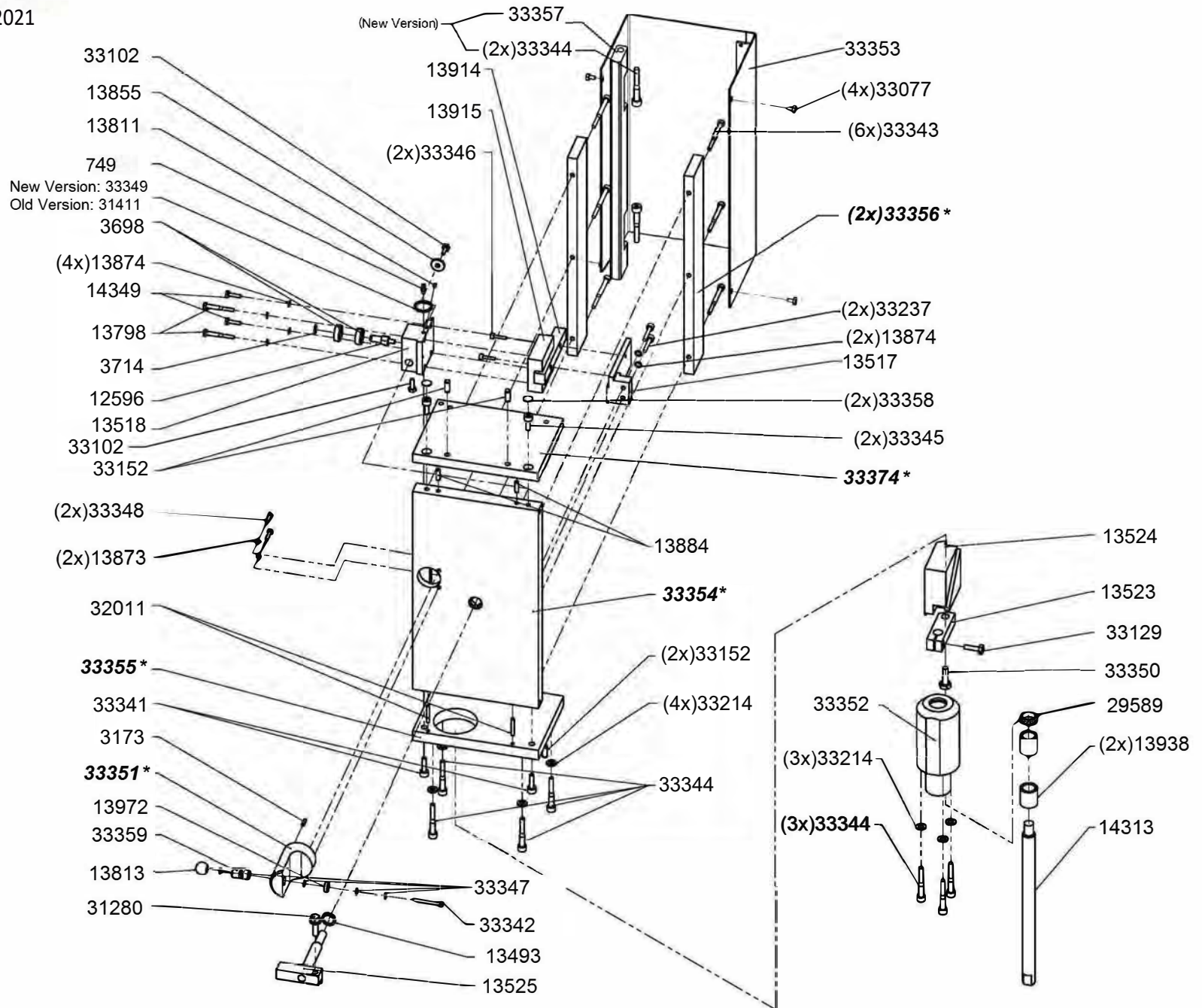


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All part numbers with an ***asterisk**** should not be ultrasonically cleaned or submerged in a caustic/alkaline solution.

Section 31: Capsule Sorting Device

GKF1505 - revised 7/2/2021



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All part numbers with an asterisk*
 should not be ultrasonically cleaned
 or submerged in a caustic/alkaline solution

New Version > 2014
 Old Version ≤ 2014

IIM #	Description	Section
934	BEARING	19
934	BEARING	21
934	BEARING	25.1
934	BEARING	25.2
1568	BEARING	8
1568	BEARING	9
1568	BEARING	21
1568	BEARING	25.1
1568	BEARING	25.2
3173	SPRING PLUNGER	31
3378	LINEAR BEARING	10
3379	RADIAL BEARING	7
3379	RADIAL BEARING	14.1
3379	RADIAL BEARING	14.2
3379	RADIAL BEARING	14.3
3387	BEARING	4
3420	ROD END,RIGHT M12	8
3420	ROD END,RIGHT M12	21
3420	ROD END,RIGHT M12	25.1
3420	ROD END,RIGHT M12	25.2
3698	BEARING	31
3714	SNAP RING	31
3734	WASHER M6	4
3734	WASHER M6	7
3734	WASHER M6	9
3734	WASHER M6	11
3734	WASHER M6	12
3734	WASHER M6	18
3834	SPLIT BUSHING	11
3847	O-RING	11
3998	PLASTIC CAP	23
4159	FILTER	17
4986	SCREW,HEX M6	19
4986	SCREW,HEX M6	21
4986	SCREW,HEX M6	25.1
4986	SCREW,HEX M6	25.2
5314	RETAINING RING	9
5341	SCREW,HEX	7
5386	WASHER M8	13
6808	WASHER M8	10
6808	WASHER M8	17
6808	WASHER M8	20
6808	WASHER M8	22
7281	ROD END,LEFT M12	8

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7281	ROD END,LEFT M12	21
7937	SCREW,HEX M6	7
7948	SCREW,HEX	2
7948	SCREW,HEX	4
7959	NUT M10	7
7973	NUT M12	8
7973	NUT M12	9
7973	NUT M12	21
7973	NUT M12	25.1
7973	NUT M12	25.2
8088	WASHER M4	18
8290	VACUUM HOSE	17
9257	DOWEL PIN	29
9266	DOWEL PIN	11
9270	DOWEL PIN	23
9271	PIN	25.2
9271	DOWEL PIN	29.1
9289	DOWEL PIN	7
10430	RETAINING RING	4
12594	SCREW,SET	18
12596	SCREW	31
12959	SPACER 3MM	21
12960	SPACER 2MM	21
12969	MAG MOUTHPIECE SHAFT	28
12970	SPRING	28
12972	PLATE	28
12973	LAEF SPRING FINGERS	28
12974	MAG MOUTHPIECE CAM	28
13120	WASHER	4
13142	SCREW,HEX M4	7
13433	SPRING	23
13437	DOWEL PIN	26
13460	HOSE CLAMP	17
13478	SWIVEL FITTING	14.1
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13478	SWIVEL FITTING	14.3
13478	SWIVEL FITTING	29
13478	SWIVEL FITTING	29.1
13485	DOWEL PIN	7
13490	SET SCREW	28
13490	PIN,DOWEL	29.1
13492	NUT M12	8
13492	NUT M12	9

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13492	NUT M12	21
13492	NUT M12	25.1
13492	NUT M12	25.2
13493	SEAL	31
13494	SCREW,SHC	7
13503	BUSHING	11
13506	SHIM	14.1
13506	SHIM	14.2
13506	SHIM	14.3
13506	SHIM	19
13506	SHIM	21
13506	SHIM	25.1
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13507	THRUST BEARING	11
13509	ROLLER BEARING	2
13517	ORIENT FINGERS BLOCK	31
13518	SORTING DRIVE BLOCK	31
13523	CLAMPING BLOCK	31
13524	GUIDE BLOCK	31
13525	SHAFT	31
34899	POWDER AUGER	13
13573	SCREW	22
13574	GUIDE SCREW	23
13575	SCREW	23
13577	SCREW	23
13579	SCREW	22
13580	TOP PLATE,TAMPING	23
13581	SEAL	10
13585	FLANGE	10
13587	RETAINING PLATE	23
13595	SHAFT,POWDER AUGER	13
13596	CHOPPER,POWDER AUGER	13
13597	LOCK NUT	11
13600	ADJ BLOCK,DOSING	11
13601	SHAFT,DOSING	11
13602	GUIDE BLOCK	11
13604	POST	11
13618	SCREW,HEX	25.1
13618	SCREW,HEX	25.2
13619	HAND KNOB	25.1
13619	HAND KNOB	25.2
13623	SEAL	19
13623	SEAL	22

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13623	SEAL	25.2
13625	BLOCK,LOW CLOSING	25.1
13625	BLOCK,LOW CLOSING	25.2
13627	SPACER	25.1
13627	SPACER	25.2
13633	SHAFT	14.1
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13633	SHAFT	14.3
13651	SHAFT	14.1
13651	SHAFT	14.2
13651	SHAFT	14.3
13653	HAND KNOB	30
13665	UPPER SEGMENT BLOCK MOUNT	7
13666	SHAFT	7
13667	UPPER SEG CAM FOLLOW BLOCK	7
13671	SEG TURRET GENEVA	7
13674	SEAL	7
13675	SCREW,HEX	7
13677	SCREW,HEX	7
13678	SCREW,HEX	7
13680	SHAFT	7
13704	COLLAR	21
13712	EJECTION CAM	4
13712	EJECTION CAM	14.1
13712	EJECTION CAM	14.2
13712	EJECTION CAM	14.3
13715	SORTING CAM	3
13715	SORTING CAM	8
13716	LEVER ARM,SORTING	3
13716	LEVER ARM,SORTING	8
13727	SLIP CLUTCH	11
13728	TIMING PULLEY	7
13729	TIMING PULLEY	11
13730	TIMING PULLEY	3
13731	COVER PLATE	2
13735	WASHER	10
13736	CROSS MEMBER ARM	10
13737	TIMING PULLEY	1
13741	COLLAR	11
13744	WASHER M6	9
13744	WASHER M6	19

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13744	WASHER M6	21
13744	WASHER M6	25.1
13744	WASHER M6	25.2
13746	WASHER M6	2
13746	WASHER M6	4
13748	CIRCLIP	8
13748	CIRCLIP	9
13748	CIRCLIP	21
13748	CIRCLIP	25.1
13748	CIRCLIP	25.2
13750	CIRCLIP	3
13757	SCREW,HEX M8	13
13759	SCREW,SHC M8	25.1
13759	SCREW,SHC M8	25.2
13760	SCREW,HEX M10	21
13769	NUT M6	13
13770	NUT	13
13771	NUT	7
13777	SHIM	7
13777	SHIM	11
13777	SHIM	14.1
13777	SHIM	14.2
13777	SHIM	14.3
13778	SCREW,HEX M6	13
13780	GEARBOX	7
13783	SCREW	16
13785	NUT	10
13787	SEAL	13
13795	BEARING	7
13798	SCREW	31
13803	SHIM	10
13805	SCREW,SHC M8	25.1
13805	SCREW,SHC M8	25.2
13808	SCREW,SHC	14.1
13808	SCREW,SHC	14.2
13808	SCREW,SHC	14.3
13810	SET SCREW	11
13811	SET SCREW	31
13813	KNOB	31
13819	SCREW M8	16
13819	SCREW M8	22
13821	WASHER	25.1
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13827	ROD END,MALE	25.2
749	GREASE FITTING	31
13842	HOSE CLAMP	17
13847	SCREW,SHC M16	2
13847	SCREW,SHC M16	7
13850	SCREW,HEX M8	14.1
13850	SCREW,HEX M8	14.2
13850	SCREW,HEX M8	14.3
13855	WASHER	31
13857	WASHER	7
13858	WASHER	1
13859	SPACER	11
13861	SHIM	7
13862	SCREW	14.1
13862	SCREW	14.2
13862	SCREW	14.3
13863	SCREW	8
13863	SCREW	25.1
13863	SCREW	25.2
13864	SCREW,HEX	19
13864	SCREW,HEX	21
13864	SCREW,HEX	25.1
13864	SCREW,HEX	25.2
13865	SCREW,HEX	25.1
13865	SCREW,HEX	25.2
13866	SPACER	14.1
13866	SPACER	14.2
13866	SPACER	14.3
13868	O-RING	11
13873	WASHER M5	31
13874	WASHER M6	14.1
13874	WASHER M6	14.2
13874	WASHER M6	14.3
13874	WASHER M6	19
13874	WASHER M6	21
13874	WASHER M6	31
13875	WASHER M8	2
13875	WASHER M8	9
13875	WASHER M8	14.1
13875	WASHER M8	14.2
13875	WASHER M8	14.3
13875	WASHER M8	15
13876	WASHER M10	1

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13876	WASHER M10	7
13877	WASHER M12	1
13877	WASHER M12	4
13877	WASHER M12	7
13877	WASHER M12	8
13877	WASHER M12	9
13877	WASHER M12	10
13877	WASHER M12	11
13877	WASHER M12	21
13877	WASHER M12	25.1
13877	WASHER M12	25.2
13878	WASHER M16	2
13878	WASHER M16	3
13878	WASHER M16	11
13884	DOWEL PIN	14.1
13884	DOWEL PIN	14.2
13884	DOWEL PIN	14.3
13884	DOWEL PIN	25.1
13884	DOWEL PIN	25.2
13884	DOWEL PIN	30
13884	DOWEL PIN	31
13887	GASKET	20
13888	NUT	25.1
13888	NUT	25.2
13889	O-RING	29
13889	O-RING	29.1
13890	DOWEL PIN	16
13896	STUD	10
13896	STUD	25.1
13896	STUD	25.2
13898	SCREW,SHC M10	7
13902	STUD	21
13902	STUD	25.1
13902	STUD	25.2
13903	WIRE TUBING	17
13908	THREADED ROD	11
13909	SCREW,HEX	18
13911	CLAMP	20
13914	BEARING GUIDE	31
13915	LINEAR BEARING	31
13916	CAM FOLLOWER	8
13916	CAM FOLLOWER	9
13916	CAM FOLLOWER	25.1

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13918	TIMING BELT	3
13921	SCREW	10
13923	SCREW	10
13930	HAND KNOB	12
13930	SCREW	22
13930	HAND KNOB	25.1
13930	HAND KNOB	25.2
13931	HAND KNOB	13
13931	HAND KNOB	20
13931	HAND KNOB	25.1
13931	HAND KNOB	25.2
13936	BELT,MAIN DRIVE	1
13937	BEARING	7
13938	BEARING	7
13938	BEARING	14.1
13938	BEARING	14.2
13938	BEARING	14.3
13938	BEARING	18
13938	BEARING	21
13938	BEARING	31
13947	BEARING	3
13949	TORQUE LIMITER	1
13952	SPLIT RING	21
13952	SPLIT RING	25.1
13952	SPLIT RING	25.2
13952	SPLIT RING	30
13958	SENSOR	2
13970	WASHER M12	12
13971	COLLAR	11
13972	BEARING	31
14217	SENSOR	22
14232	CABLE,5M	22
14273	LINEAR SHAFT	14.1
14273	LINEAR SHAFT	14.2
14273	LINEAR SHAFT	14.3
14274	BRACKET	21
14299	LINEAR BEARING	19
14299	LINEAR BEARING	25.1
14299	LINEAR BEARING	25.2
14313	OREINT DRIVE SHAFT	31
14315	THREADED ROD	7
14325	BLOWOUT NOZZLE	29

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14362	VACUUM VALVE	17
14364	COUNTER	11
14365	COUNTER PLATE	11
14368	TIMING BELT	2
14369	WASHER	1
14414	SHIM	9
14448	SHAFT	11
14449	PIN	11
14450	TIMER	2
14452	TURRET SEAL	7
14459	LOCKING HANDLE	22
14461	KNOB	22
14466	NUT	1
14500	WASHER	7
14501	SCREW,HEX	7
14501	SCREW,HEX	23
14587	BRACKET	10
14588	SPRING	10
14589	COUNTERWEIGHT,SHAFT	4
14591	BRACKET	10
14592	THREADED INSERT	10
15036	RETAINING RING	10
15037	RETAINING RING	5
15290	SET SCREW	8
15290	SET SCREW	9
15291	SCREW,SHC	8
15291	SCREW,SHC	9
16040	SCREW,SHC M6	5
16042	CONTROLLER	30
16045	FITTING	30
16228	CLOSING PIN SZ00/0	26
16230	CLOSING PIN SZ1/2	26
16232	CLOSING PIN SZ3/4	26
26608	UPPER SEGMENT CARRIER	7
26993	O-RING	27
28117	DOWEL PIN	28
28470	WASHER	9
28479	POWDER GUARD	16
28480	SCREW	16
29359	TAMPING CAM	2
29359	TAMPING CAM	10
29405	CLAMP	7

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29580	CLOSING PIN SZ000/00	26
29581	CLOSING PIN SZ0/1	26
29589	SEAL	7
29589	SEAL	14.1
29589	SEAL	14.2
29589	SEAL	14.3
29589	SEAL	18
29589	SEAL	21
29589	SEAL	31
30300	CAP	13
30302	SCREW,HEX	29
30302	SCREW,HEX	29.1
30378	POWDER GUARD IMPROVED	16
30404	CAM FOLLOWER	14.1
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30404	CAM FOLLOWER	14.3
30404	CAM FOLLOWER	21
30688	DISC,FILTER	29
30688	DISC,FILTER	29.1
31016	SCREW,SHC	16
31122	SEPARATION PIN	18
31122	PIN,SEPARATION,53MM,FLAT	18
31174	EJECTION PIN	29
31174	EJECTION PIN	29.1
31280	SCREW M8	16
31280	SCREW M8	19
31280	SCREW M8	21
31280	SCREW M8	31
31360	DOWEL PIN	15
31360	DOWEL PIN	16
31363	THREADED STUD	25.1
31363	THREADED STUD	25.2
31386	SCREW M8	12
33740	FAULTY CAP EJECTION ARM	21
31987	SHIM	22
31988	NUT	22
31994	WIPER BLOCK CENTER CONE	22
32004	SHIM	22
32005	SHIM	22
32008	SHIM	22
32011	DOWEL PIN	22
32011	DOWEL PIN	31
32012	SCREW	22
32035	GEARBOX	11

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32106	SCREW M10	16
32304	SCREW,HEX M16	2
32401	SCREW,HEX	4
32429	DOWEL PIN	3
32429	DOWEL PIN	4
32520	SCREW,SHC	12
32677	BEARING	5
32688	SCREW	13
32695	TAMPING RING	11
32695	TAMPING RING	24
32696	TAMPING RING	24
32765	HOLDING BLOCK	23
32766	TAMPING BLOCK	23
32767	RETAINING FINGER PLATE	23
32774	GUIDE RING 11CT	22
32780	SCREW,HEX M6	18
32781	LOWER CLOSING LEVER	3
32781	LOWER CLOSING LEVER	25.1
32782	SCREW, HEX M12	9
32782	SCREW, HEX M12	21
32782	SCREW, HEX M12	25.1
32782	SCREW, HEX M12	25.2
32783	MAGAZINE LIFT ARM	19
32798	SCREW M6	25.1
32798	SCREW M6	25.2
32799	BRACKET	25.1
32799	BRACKET	25.2
32800	CLOSING ADJ BLOCK,ASSY	25.1
32801	LOWER CLOSING BLOCK ALUM	26
32803	CLEANING STATION COVER	30
32811	SIGHT GLASS	13
32814	SPRING	18
32889	GUIDE,UPPER,TRANSFER BLOCK,11CT	23
33067	SCREW	1
33068	SCREW	1
33069	PIN,DOWEL	2
33071	SCREW	2
33073	WASHER	2
33073	WASHER	4
33074	ROLLER,TENSION	2
33074	ROLLER	5
33075	SCREW,HEX	2
33075	SCREW,HEX	19

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33075	SCREW,HEX	22
33076	WASHER	2
33077	SCREW	2
33077	SCREW	12
33077	SCREW	31
33078	SCREW,HEX	2
33078	SCREW,HEX	3
33079	SCREW	2
33080	PLATE,MAIN SHAFT SUPPORT,CENTER	2
33081	BLOCK	2
33082	BRACKET	2
33083	BLOCK	2
33084	SCREW,SHC	3
33085	SCREW,SHC	3
33085	SCREW,SHC	9
33086	LEVER	3
33087	CLIP	3
33088	TUBE	3
33089	CAM,SORTING,GKF1505	3
33089	CAM,SORTING,GKF1505	25.1
33090	SCREW,SET	3
33091	BEARING	3
33092	SCREW,HEX M8X20	3
33092	SCREW,HEX M8X20	14.1
33092	SCREW,HEX M8X20	14.2
33092	SCREW,HEX M8X20	14.3
33093	SCREW M4	3
33094	FLANGE	3
33095	BRACKET	3
33096	BRACKET	3
33097	SHAFT,MAIN	3
33097	SHAFT,MAIN	9
33098	SCREW,HEX	4
33100	SCREW,SHC	4
33101	SCREW	4
33101	SCREW	22
33102	SCREW,HEX	4
33102	SCREW,HEX	16
33102	SCREW,HEX	22
33102	SCREW,HEX	28
33102	SCREW,HEX	31
33103	BRACKET,SPLIT	4
33104	BRACKET	4

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33105	ENCODER	4
33106	BUSHING	4
33107	CAP,END	5
33108	CAP,END	5
33109	WASHER	5
33110	WASHER,SHIM	5
33111	SCREW	7
33112	SCREW,SHC	7
33113	SCREW,HEX	7
33113	SCREW,HEX	11
33114	SEGMENT TRAVERSING CAM	7
33115	SCREW	7
33116	SCREW	7
33117	NUT,HEX	7
33117	NUT,HEX	21
33118	SCREW	7
33119	SEAL,TURRET	7
33120	BLOCK,SPACER	7
33121	GASKET	7
33122	BRACKET	7
33123	GASKET	7
33124	WASHER	8
33125	SCREW	8
33125	SCREW,SHC	9
33126	NUT,HEX	8
33126	NUT,HEX	9
33126	NUT,HEX	21
33127	ROD,THREADED	8
33128	KEY	8
33128	KEY	9
33129	SCREW,HEX M8	8
33129	SCREW,HEX M8	12
33129	SCREW,HEX M8	17
33129	SCREW,HEX M8	31
33130	SCREW,HEX	8
33131	PLATE	8
33132	BRACKET	8
33133	SCREW,SHC	9
33134	LEVER,SEPARATION	9
33135	NUT,SQUARE	9
33136	BLOCK	9
33137	ROD	9
33138	CAM	9
33139	BRACKET	9

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33141	BRACKET	9
33142	SCREW,HEX	9
33143	NUT,HEX	9
33143	NUT,HEX	10
33143	NUT,HEX	12
33144	HANDLE	9
33145	SHAFT	9
33146	BUSHING	9
33147	BLOCK	9
33148	SCREW,HEX	9
33148	SCREW,HEX	28
33149	NUT,HEX	9
33149	NUT,HEX	10
33149	NUT,HEX	22
33150	COUNTERWEIGHT,CAM	9
33152	SCREW,SET	10
33152	SCREW,SET	31
33153	SCREW	10
33154	M16X40	10
33155	SCREW	10
33156	SHAFT,TAMPING,ASSY	10
33157	KEY,24X9X80 130N	10
	HOUSING,TAMPING SHAFT	
33158	COLUMN	10
33159	SPACER	10
33160	POST	11
33161	COVER	11
33162	HOUSING	11
	SCREW,LEVELING,TAMPING	
33163	HOUSING	11
33164	PIN,DOWEL	11
33165	SCREW	11
33166	SCREW	11
33167	SCREW,SET	11
33168	SCREW,SET	11
33169	WASHER	11
33170	SCREW,SET	11
33171	SCREW	11
33172	HANDLE	11
33173	UNIVERSAL JOINT	11
33174	SCREW	11
33175	SCREW,LONGER	11
33176	PIN	11

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33177	HOUSING	11
33178	HOUSING	11
33179	GASKET	11
33180	STUD	11
33181	BUSHING	11
33183	SCREW	12
33184	WASHER	12
33185	WASHER	12
33186	PIN,DOWEL	12
33187	PLUG	12
33188	SHAFT,MAIN	1
33188	SHAFT,MAIN	9
33189	SCREW	12
33190	KEY	12
33191	O-RING	12
33192	PIN,DOWEL	12
33193	CONNECTOR	12
33194	SCREW	12
33195	SCREW	12
33196	MOTOR	12
33197	HUB,GEAR	12
33198	HOUSING	12
33199	BRACKET	12
33200	CUP,POWDER	12
33201	RING,CLAMP	12
33202	RING	12
33203	PLATE,AUGER DRIVE BASE	12
33204	HOPPER,POWDER	13
33205	SHAFT,DRIVE, POWDER AUGER	13
33206	SHAFT	13
33207	SCREW,SHC M6X50	14.1
33207	SCREW,SHC M6X50	14.2
33207	SCREW,SHC M6X50	14.3
33207	SCREW,SHC M6X50	21
33208	NUT,HEX	14.2
33208	NUT,HEX	14.3
33209	HOUSING,LINEAR BEARING	14.1
33209	HOUSING,LINEAR BEARING	14.2
33209	HOUSING,LINEAR BEARING	14.3
33209	HOUSING,LINEAR BEARING	21
33210	NOZZLE,AIR	14.1
33210	NOZZLE,AIR	14.2
33210	NOZZLE,AIR	14.3

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33211	BLOCK,GUIDE,BEARING	14.1
33211	BLOCK,GUIDE,BEARING	14.2
33211	BLOCK,GUIDE,BEARING	14.3
33214	WASHER	19
33214	WASHER	31
33215	SCREW,SHC	15
33216	CAM, SEGMENT, TRAVERSING	15
33217	HOUSING	16
33218	HOUSING,TURRET	16
33219	CENTERCONE FLANGE	16
33219	CENTERCONE FLANGE	22
33220	BRACKET	16
33221	SCREW	16
33222	CONNECTOR	17
33223	O-RING	17
33224	SCREW	17
33225	NUT	17
33226	SCREW,SHC	17
33227	VALVE	17
33228	VALVE	17
33229	BRACKET	17
33230	VALVE	17
33231	HOUSING,FILTER	17
33232	CONNECTOR	17
33233	BRACKET	17
33234	TUBE	17
33234	TUBE,ANGLED	30
33235	PIN,DOWEL	18
33237	SCREW,SHC M6	18
33237	SCREW,SHC M6	25.1
33237	SCREW,SHC M6	25.2
33237	SCREW,SHC M6	31
33238	O-RING	18
33239	SPACER	18
33240	SPRING SLEEVE	18
33241	STRAIGHT PIN	18
33242	SCREW	18
33243	PIN	18
33244	SCREW M4	18
33245	SCREW,SHC M6	18
33246	BEARING HOUSING	18
33247	BRACKET	18
33248	SHOE, SUCTION, 11CT, SEPARATION	18

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33249	PLATE, MOUNT, SUCTION SHOE	18
33250	BLOCK, 11CT, ORIENTATION	18
33251	SHAFT DRIVE, SEPARATION	18
33252	SEPARATION BUSHING	18
33253	INSERT	18
33254	O-RING	18
33255	BUSHING	18
33256	SCREW,SHC	19
33257	BRACKET	19
33257	BRACKET	21
33258	BLOCK	19
33259	HOLDER, SORTING BLOCK	19
33260	BLOCK	19
33261	SCREW	20
33262	STUD,THREADED,M8	20
33263	HOPPER,CAPSULE BODY	20
33264	HOPPER,CAPSULE BASE	20
33265	SIGHT GLASS,CAP HOP 50mm	20
33266	GATE, FLOW CONTROL, CAPSULE HOPPER	20
33267	TUBE	20
33268	PLATE	20
33269	WASHER	2
33269	WASHER	21
33270	SCREW	21
33271	PIN,DOWEL	21
33272	SCREW	21
33272	SCREW	25.1
33272	SCREW	25.2
33272	SCREW	28
33272	SCREW	30
33273	INSERT,THREADED	21
33274	ROD,THREADED	21
33275	TUBE,ANGLED	21
33276	BRACKET	21
33277	SCREW	21
33278	SCREW	21
33279	SPACER	21
33280	FAULTY CAPSULE EJECTION LEVER ARM	21
33281	SHAFT,VERTICAL	21
33282	SCREW	21
33282	SCREW	29

IIM #	Description	Section
33282	SCREW	29.1
33282	SCREW	30
33283	WASHER	16
33283	WASHER	22
33284	SCREW	22
33285	DOSING BOWL,SIDERING	22
33286	CENTERCONE FLANGE	22
33287	AXIS FOR WIPER CONE	22
33288	SHIM	22
33289	BEARING	22
33290	SCREW	22
33291	O-RING	22
33292	PIN,DOWEL	22
33293	HOLDER,SENSOR	22
33294	PLATE,FINGER	22
33295	TUBE,POWDER,TRANSFER	22
33296	POST,M6	22
33297	SIGHT GLASS, LEVEL SENSOR PLATE	22
33298	PLATE,LEVEL SENSOR,INNER	22
33299	BLOCK, WIPER, 11CT GKF1505	22
33300	SHOE, WIPER BLOCK, GKF1505, SST	22
33301	PLATE, LEVEL SENSOR, OUTER	22
33302	ARM FOR TRANSFER BLOCK	22
33303	PLATE, TAMPING PIN RETAINER	23
33304	BLOCK,TRANSFER,11CT	23
33305	SCREW	23
33306	PIN,CLOSING, ASSY, 11CT, GKF1505	25.1
33307	LOWER CLOSING SHAFT	25.1
33307	LOWER CLOSING SHAFT	25.2
9271	PIN	25.1
33308	PIN	28
33308	PIN	29
33308	PIN,DOWEL	30
33309	LOWER CLOSING HEAD	25.1
33309	LOWER CLOSING HEAD	25.2
33310	BLOCK, UPPER CLOSING, CAPS STOP	25.1
33310	BLOCK, UPPER CLOSING, CAPS STOP	25.2
33311	PLATE	25.1

IIM #	Description	Section
33311	PLATE	25.2
33312	SCREW	25.1
33312	SCREW	25.2
33313	GUIDE	25.1
33313	GUIDE	25.2
33314	SPRING	25.1
33314	SPRING	25.2
33315	PIN,DOWEL	26
33316	PIN,CLOSING,GKF1505	26
33317	SCREW	28
33318	PLATE,SPRING FINGER CAPTURE,11CT	28
33319	PLATE, SPRNG FNGR CAPTURE, 11CT, SZ4/5	28
33320	BUSHING	28
33321	SCREW	28
33322	SCREW,CHEESEHEAD	28
33323	MOUHPIECE, MAGAZINE, 11CT	28
33324	BLOCK, REAR MOUNT, ALIGN, MAG 11CT	28
33325	SCREW	29
33325	SCREW	29.1
33326	PIN	29
33327	SCREW	29
33327	SCREW	29.1
33328	TUBE, DISCHARGE, EJECT STATION	29
33328	TUBE, DISCHARGE, EJECT STATION	29.1
33329	PLATFORM, EJECTION & BLOWOUT	29
33330	PLATE, BASE, EJECT & BLOWOUT	29
33331	SCREW	29
33331	SCREW	29.1
33332	SCREW	29
33332	SCREW	29.1
33333	HOUSING, EJECTECTION STATION	29
33333	HOUSING, EJECTECTION STATION	29.1
33334	SPACER, EJECTION STATION	29
33334	SPACER, EJECTION STATION	29.1
33335	PLATE, COVER ,EJECTION, OLD	29

IIM #	Description	Section
33335	PLATE, COVER, EJECTION, OLD	29.1
33336	SCREW	30
33337	MANIFOLD, UPPER CLEANING	30
33338	MANIFOLD, BASE, CLEANING STATION	30
33339	PLATE	30
33340	STUD,SET SCREW	30
33341	SCREW	31
33342	SCREW	31
33343	SCREW,SHC	31
33344	SCREW,SHC	31
33345	SCREW	31
33346	SCREW	31
33347	WASHER	31
33348	SCREW	31
33349	O-RING	31
33350	SCREW	31
33351	HOLDER,PLUNGER	31
33352	HOUSING	31
33353	PLATE	31
33354	PLATE	31
33355	PLATE,BASE	31
33356	BRACKET	31
33357	BRACKET	31
33358	O-RING	31
33359	PLUNGER, SPRING LOADED	31
33360	BRACKET,SPLIT	3
33361	TURRET,SEGMENT	7
33362	COVER	7
33363	WASHER	8
33366	O-RING	16
33370	BLOCK, UPPER CLOSING	25.1
33370	BLOCK, UPPER CLOSING	25.2
33371	ASSY, KNOB, STUD	25.1
33371	ASSY, KNOB, STUD	25.2
33372	HAND KNOB ASSY	12
33372	ASSY, KNOB, STUD	25.1
33372	ASSY, KNOB, STUD	25.2
33373	PLATE, PIN ,EJECT & BLOWOUT ,ASSY	29
33373	PLATE,PIN,EJECT & BLOWOUT,ASSY	29.1
33374	PLATE	31
33379	PLATE,EJECT DRIVE	14.2

IIM #	Description	Section	IIM #	Description	Section
33381	MOTOR + GEARBOX, MAIN DRIVE, GKF1505	1			
33382	SCREW,SHC	30			
33383	CAM,SEPARATION	3			
33383	CAM,SEPARATION	21			
33406	HAND KNOB	25.1			
33406	HAND KNOB	25.2			
33424	UPPER SEGMENT CARRIER	7			
34071	PINS, CONCAVE	18			
34071	PIN,SEPARATION,53MM, CONCAVE	18			
34074	LOWER CLOSING BLOCK SST	26			
34238	SCRAPER	22			
34240	SHOE, WIPER BLOCK, 1505, NYLATRON	22			
34241	SHOE, WIPER BLOCK, 1505, PET	22			
34251	KNOB,ASSY DOSING DISC LIFT	27			
34601	PLATE, EJECT DRIVE	14.1			
34601	PLATE, EJECT DRIVE	14.3			
34608	BOOMERRANG, NEW STYLE	29.1			
34609	SIGHT GLASS, CAP HOP 108mm	20			
34610	DUST COVER 90mm	20			
34611	PLATE, EJECTION & CLEANING	29.1			
34612	SCREW	29.1			
34630	PLATE, COVER, EJECTION, NEW	29			
34630	PLATE, COVER, EJECTION, NEW	29.1			
34634	ASSY,SHAFT,CAPS SEPARATION, 11CT	18			
34672	CLOSING ADJ BLOCK, ASSY	25.2			
34631	CLOSING ASSY, POS. 7	25.1			
34780	DUST COVER 72mm	20			
34793	PIN,SEPARATION,46MM, FLAT	18			
34805	HOPPER, CAPSULE, BODY, NEW	20			
34901	CLOSING ADJ BLOCK, ASSY	25.2			
34902	LOWER CLOSING LEVER, POS. 9	25.2			
34903	CAM, SORTING, POS.9	25.2			
34904	HAND KNOB ASSY	20			
34913	SHIM	25.2			