



IIM 2100

Capsule filling machine
Replacement spare parts

INTERNATIONAL INVENTORY MANAGEMENT

456 MANNING AVENUE
ELON, NC 27244 USA
TEL 001 336 584 4777
FAX 001 336 584 4950

www.iimnc.com

Table of Contents

Below table

Section	Description
1	Main drive motor, infinite speed
2	Support, main shaft
3	Segment geneva
4	Drive cam, segment geneva, single yoke
5	Dosing geneva, double yoke
6	Drive cam, dosing geneva, double yoke
7	Drive, sorting mechanism
8	Drive, capsule separation
9	Drive, tamping unit
10	Shafts for tamping unit
11	Drive, faulty capsule ejection
12	Drive, upper closing
13	Drive, upper and lower closing
14	Drive, ejection station
15	Station 4 pellet drive
16	Station 6 pellet drive
17	Segment geneva

Above table

Section	Description
18	Segment carriers: surrounding parts
19	Segment doughnut
20	Segment carriers: complete
21	Segment top cam
22	Tamping ring, bronze
22.1	Tamping ring support - IIM 2100
23	Dosing disc drive
24	Magazine housing components
25	Capsule separation
26	Level sensor in empty capsule container
27.1	Dosing device, tamping station
27.2	New style 16 count tamping block
27.3	Fixed/transfer tamping block - IIM 2100
27.4	Adjustable tamping block - IIM 2100
28	Tamping guide ring
29	Powder level sensing
29.1	Powder level sensing - IIM 2100
30	Lifting for dosing device
31	Powder infeed, vertical

Section	Description
32	Gearmotor, powder infeed
33	Faulty capsule ejection, new style
34	Faulty capsule ejection, old style
35	Upper closing, counter holder
36	Lower closing, final
37.1	Ejection station, with blowing air
37.2	Breakaway ejection
38	Blowout station and cleaning
39	Cam box
40	Compressed air unit, without oiler
41	Vacuum system with Mann filter
42	House vacuum with vacuum valve 24v
43	Pellet filling with dosing disc
44	Pusher for pellet filling with dosing disc
45	Cam plan

46	Change parts: segment blocks, alignment pins
47	Change parts: tamping pins
48	Change parts: sorting fingers, magazines, orientation blocks, complete size change kits

	Upright safety guards
--	-----------------------

Automatic lubrication system

This system delivers constant lubrication over a set period of months (from 1 month up to 12 months) to specific points in the drive of the machine.

Prior to installing new lubrication canisters, the lines must be primed, or pre-filled with lubricant using an appropriate device.

Each 125mL lubrication canister (**IIM p/n 28922**) is activated first by snipping off the small protrusion on the yellow cap, which exposes a tiny orifice through which the oil flows. Then screw the lubricator fully into the manifold plate, and adjust the dispensing dial using a 3mm hex wrench, which can be altered at any time.

Below is a chart to accompany the manifold in this machine, detailing distribution and time period of lubrication.

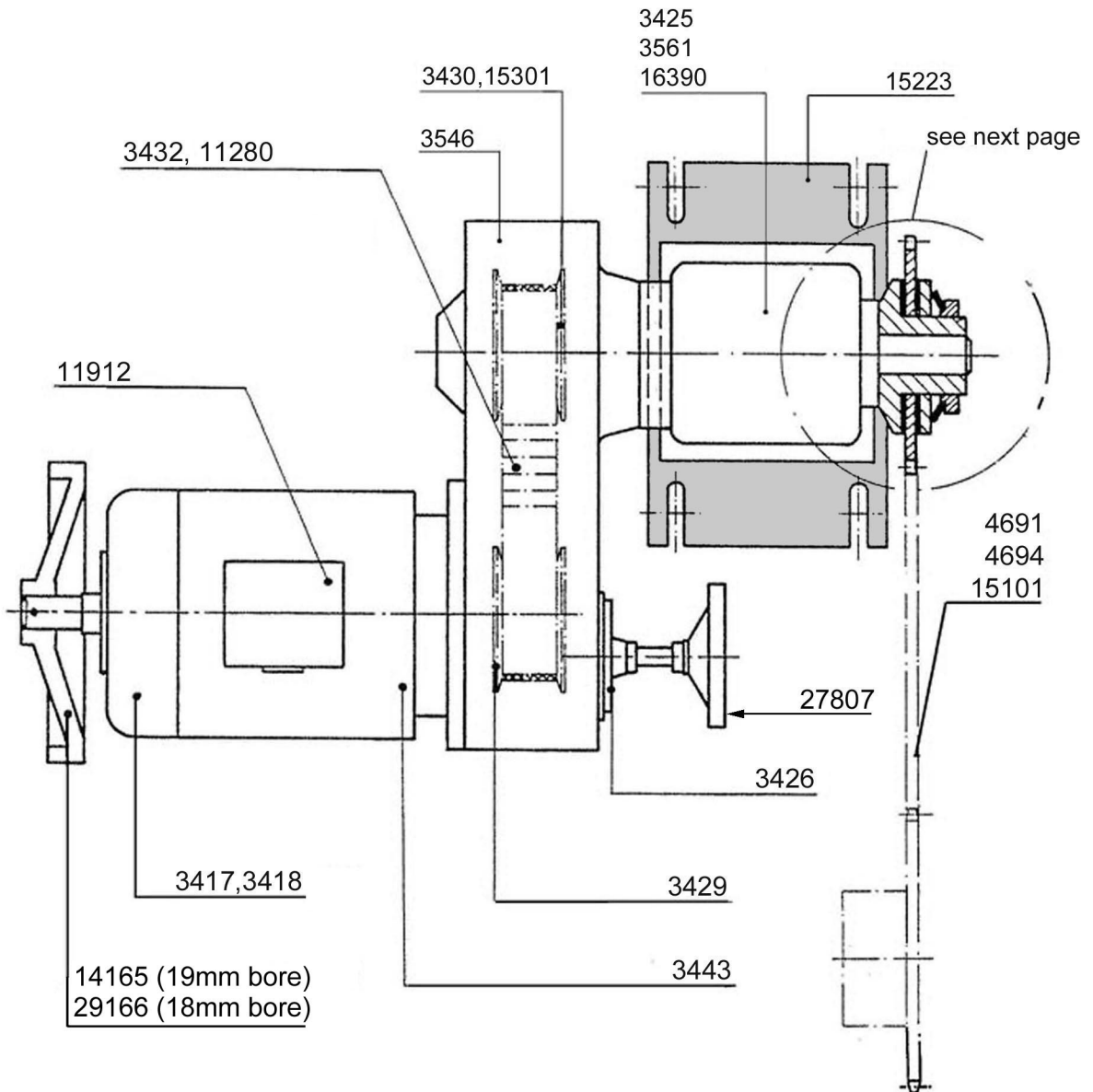
Position	Function	Time to empty (months)	Date activated	Due for replacement
1	Peanut Cam, Dosing	12		
2	Brush, Ratchet Cam, Dosing	12		
3	Bevel Gears, Double Yoke	12		
4	End Bearing, Double Yoke	12		
5	Double Yoke – Center Bearing	12		
6	Large bearing, Main Shaft, Double Yoke	12		
7	Cam Follower, Tamping Cam	12		
8	Cam Follower, Tamping Cam	12		
9	Cam Follower, Upper Closing Cam	12		
10	Large Bearing, Main Shaft, Single Yoke	12		
11	Brush, Segment Geneva	12		
12	Peanut Cam, Segment	12		
13	Bevel Gears, Single Yoke	12		
14	Single yoke – Center Bearing	12		
15	Cam Follower, Sorting Cam	12		
16	Cam Follower, Faulty Capsule Cam	12		
17	Cam Follower, Separation Cam	12		
18	Cam Follower, Lower Closing Cam	12		
19	Cam follower, Ejection Cam	12		
20	Brush, Separation Cam	12		
21	Ejection Guide	12		
22	Dosing Shaft	12		
23	Bead Feed Pos. 4, Drive Gear under Table	12		
24	Bead Feed Pos. 6, Drive Gear under Table	12		

Diagram of manifold indicating lubricator positions (seen from inside machine)

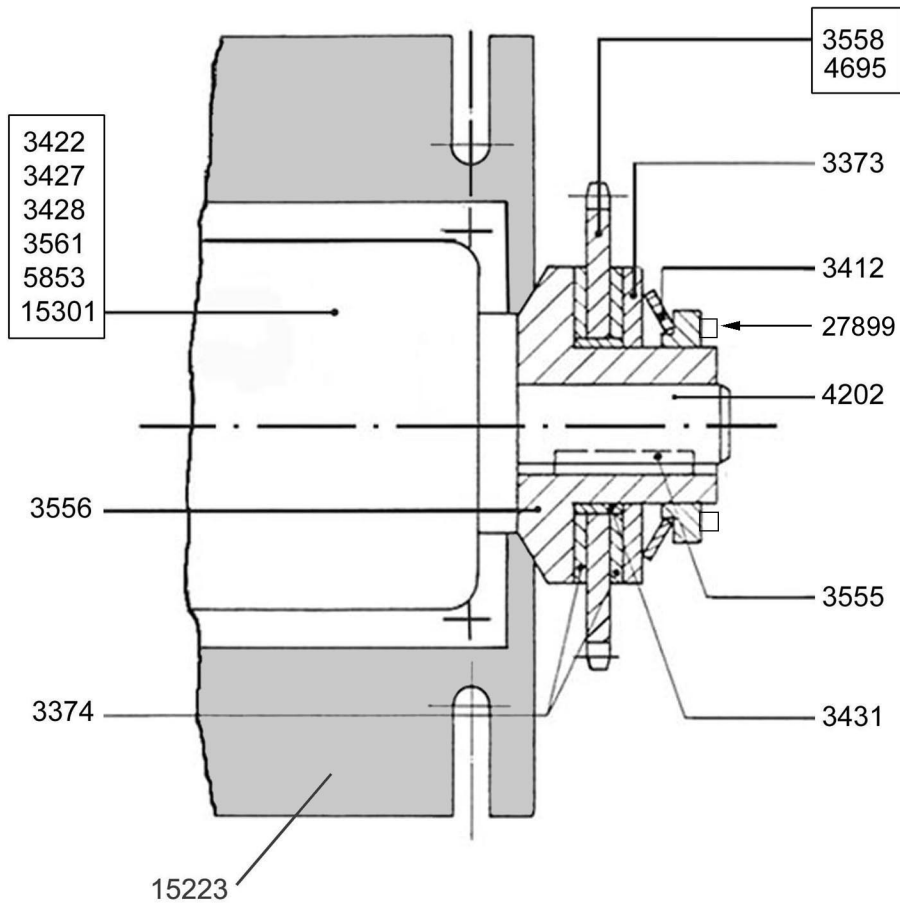
4	3	2	1
8	7	6	5
12	11	10	9
16	15	14	13
20	19	18	17
24	23	22	21

Section 1.1: main drive

3424: main drive complete



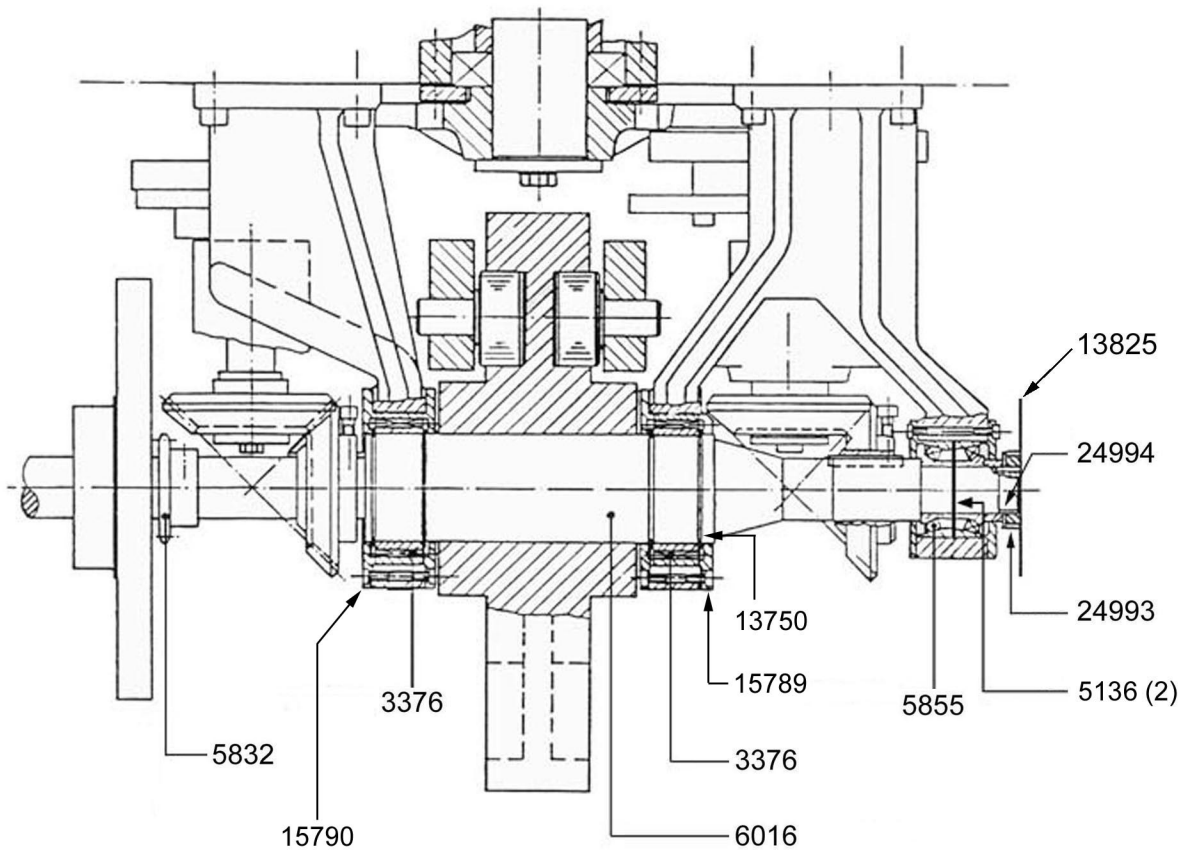
Section 1.2: main drive



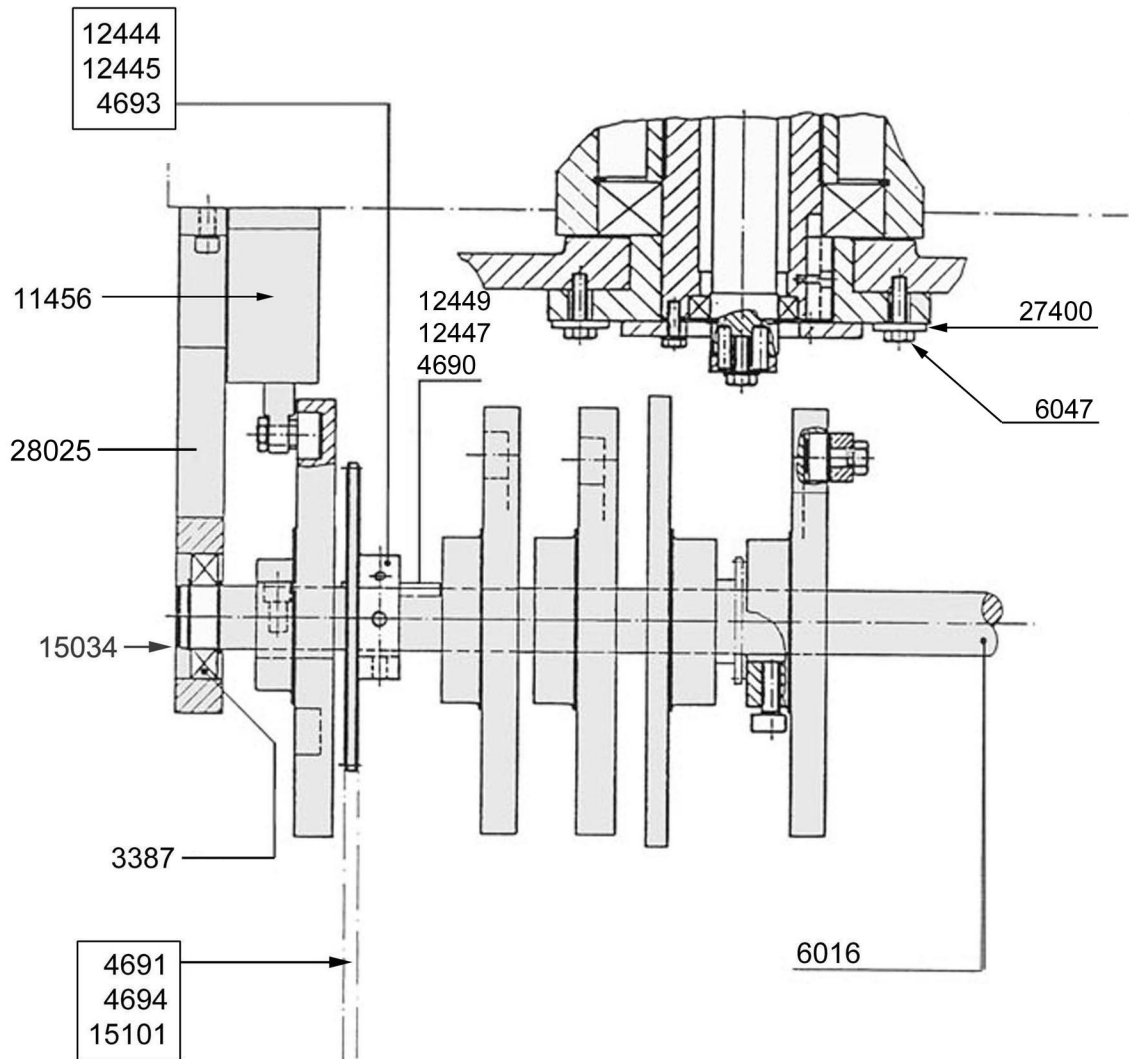
Section 1: Main drive

IIM No.	Description
3417	BRAKE COMPLETE
3424	MAIN DRIVE COMPLETE
3425	GEARBOX, MAIN DRIVE
3443	MOTOR, MAIN DRIVE, W/BRAKE
3546	HOUSING, TRANSMISSION
3556	SLIP CLUTCH, 500-1, 30MM BORE
29387	SLIP CLUTCH, 500-1, 35MM BORE
3561	GEARBOX OVERHAUL KIT
11327	GEARBOX,COMPLETE,OLD STYLE
15807	MOTOR, MAIN DRIVE, H&K 2400
16390	GEARBOX REPAIR (EXCHANGE)
25924	GEARBOX, MAIN DRIVE, NEW STYLE (SQUARE)
27807	HANDWHEEL, SPEED ADJUSTMENT
3373	DISC, PRESSURE
3374	LINING, FRICTION
3412	SPRING, DISC
3418	DISC, FOR BRAKE IIM 3417
3422	SEAL, SHAFT, LENZE
3426	ADJUSTMENT MECHANISM
3427	BEARINGS, KIT OF 2, LENZE
3428	SPUR GEAR, LENZE
3429	PULLEY, MECHANICAL ADJUSTMENT
3430	PULLEY, SPRING LOADED, DRIVEN
3431	BUSHING
3432	V-BELT, MAIN DRIVE, 28 X 750, NEW STYLE
3555	KEY, SHAFT, MAIN DRIVE
3558	SPROCKET, MAIN DRIVE, 40 TEETH, DIA 30
4202	SHAFT,30MM OUTPUT,FOR GEARBOX
4691	CHAIN,MAIN DRIVE,H&K 1500
4694	MASTER LINK FOR 1500 CHAIN
4695	SPROCKET, MAIN DRIVE, 45 TEETH, DIA 30,STANDARD VERSION
5853	SHAFT, DRIVE, OVERHAUL, LENZE
11280	V-BELT, MAIN DRIVE, 37 X 900, OLD STYLE
11912	RECTIFIER, BRAKE
14165	HANDWHEEL, 19mm BORE
15101	CHAIN,MAIN DRIVE,OLD STYLE, H&K 1200
15223	BASE PLATE,MOUNTS GEARBOX TO FRAME OF MACHINE
15301	KEY,SHAFT,MAIN DRIVE,INPUT SHAFT
15808	PULLEY, VARIABLE SPEED, H&K 2400
15809	V-BELT, MAIN DRIVE, H&K 2400
16473	ALIGNMENT GUIDE,MAIN DRIVE GEARBOX
29166	HANDWHEEL, 18mm BORE

Section 2.1: main shaft support



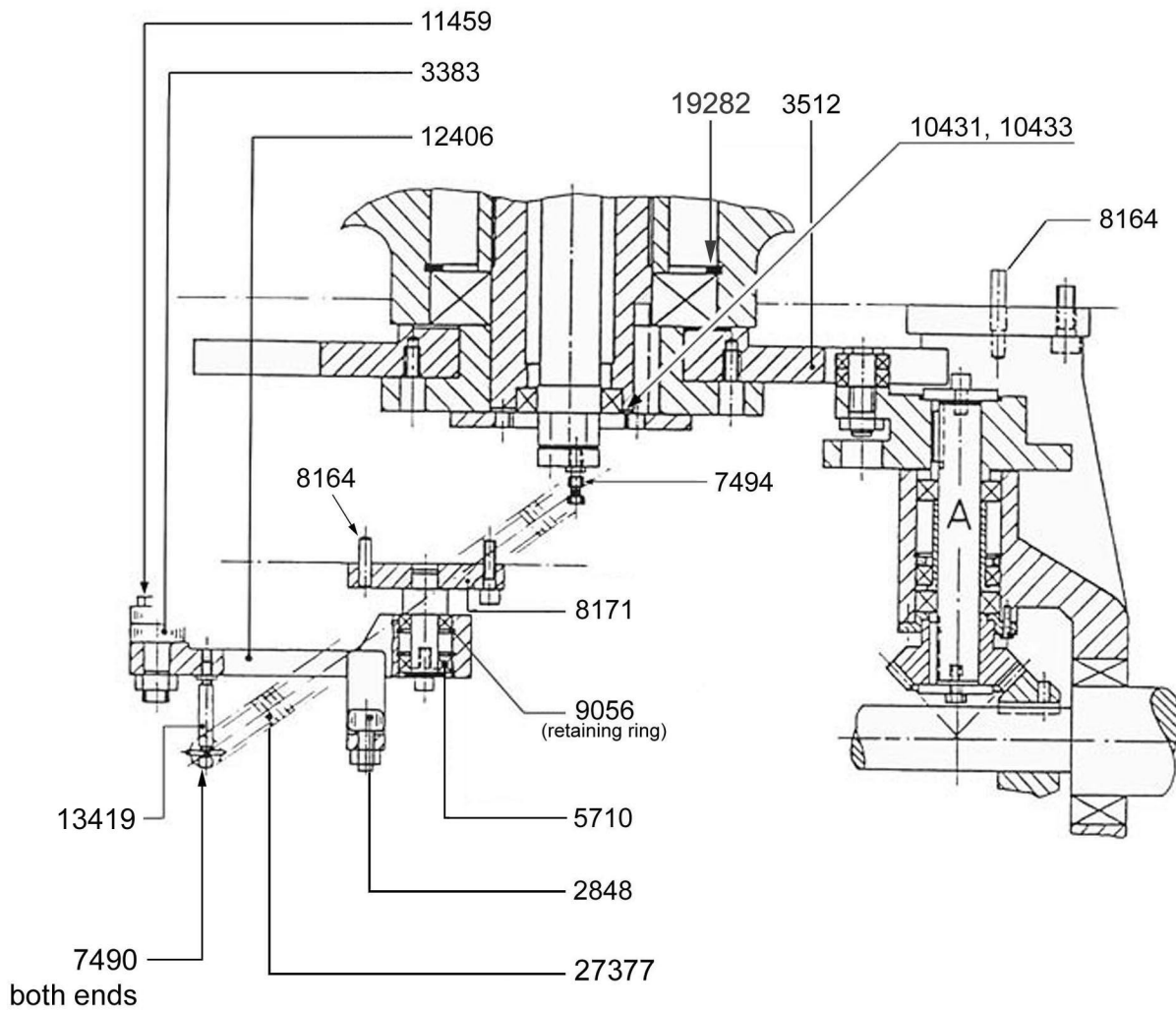
Section 2.2: main shaft support



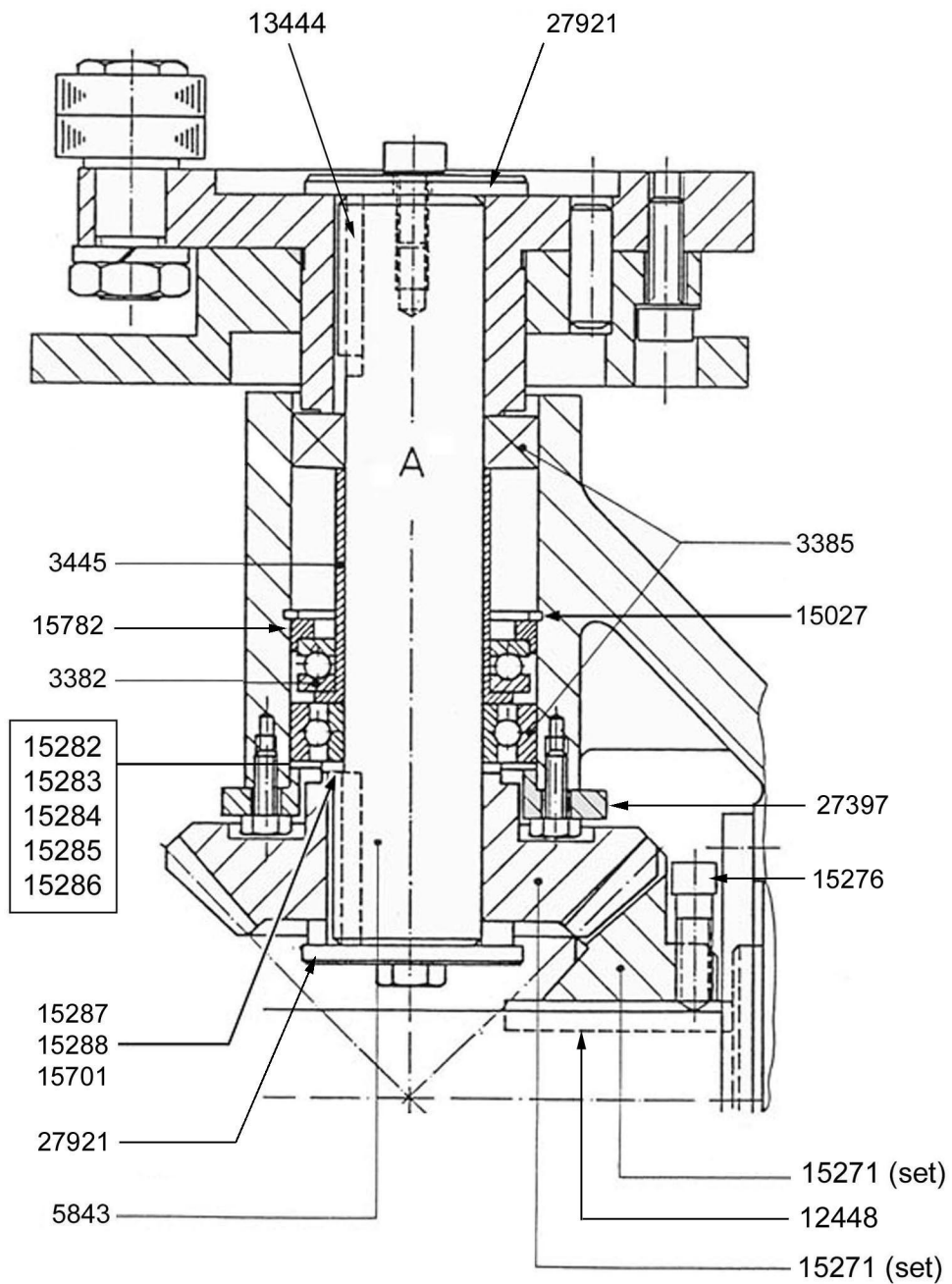
Section 2: Support, main shaft

IIM No.	Description
3376	BEARING, NEEDLE
3387	BEARING, BALL
4690	KEY
4691	CHAIN, 1500
4693	SPROCKET,DRIVEN,38 TEETH,8MM KEY
4694	MASTER LINK
5136	SHIM,50 X 62 X 1
5832	WHEEL, CHAIN
5855	BEARING W/ROLLER
6016	SHAFT, MAIN DRIVE
6047	HEX BOLT
11456	HOUSING, EJECTION SHAFT
12444	SPROCKET,DRIVEN,40 TEETH,12MM KEYS (2)
12445	SPROCKET,DRIVEN,38 TEETH,WITH COMPRESSION HUB
12446	KEY, MAIN DRIVE SPROCKET
12447	KEY, FRICTION, MAIN DRIVE SPROCKET
12448	KEY,BEVEL GEAR,MAIN SHAFT,8X12X50
13750	RETAINING RING, EXTERNAL
13825	TIMING DIAL,MAIN SHAFT
14091	WHEEL, CHAIN
15034	SNAP RING
15101	CHAIN, 1200
24993	SHAFT NUT
27400	WASHER
28025	END SUPPORT, MAIN SHAFT
24994	KEYED WASHER

Section 3.1: segment geneva



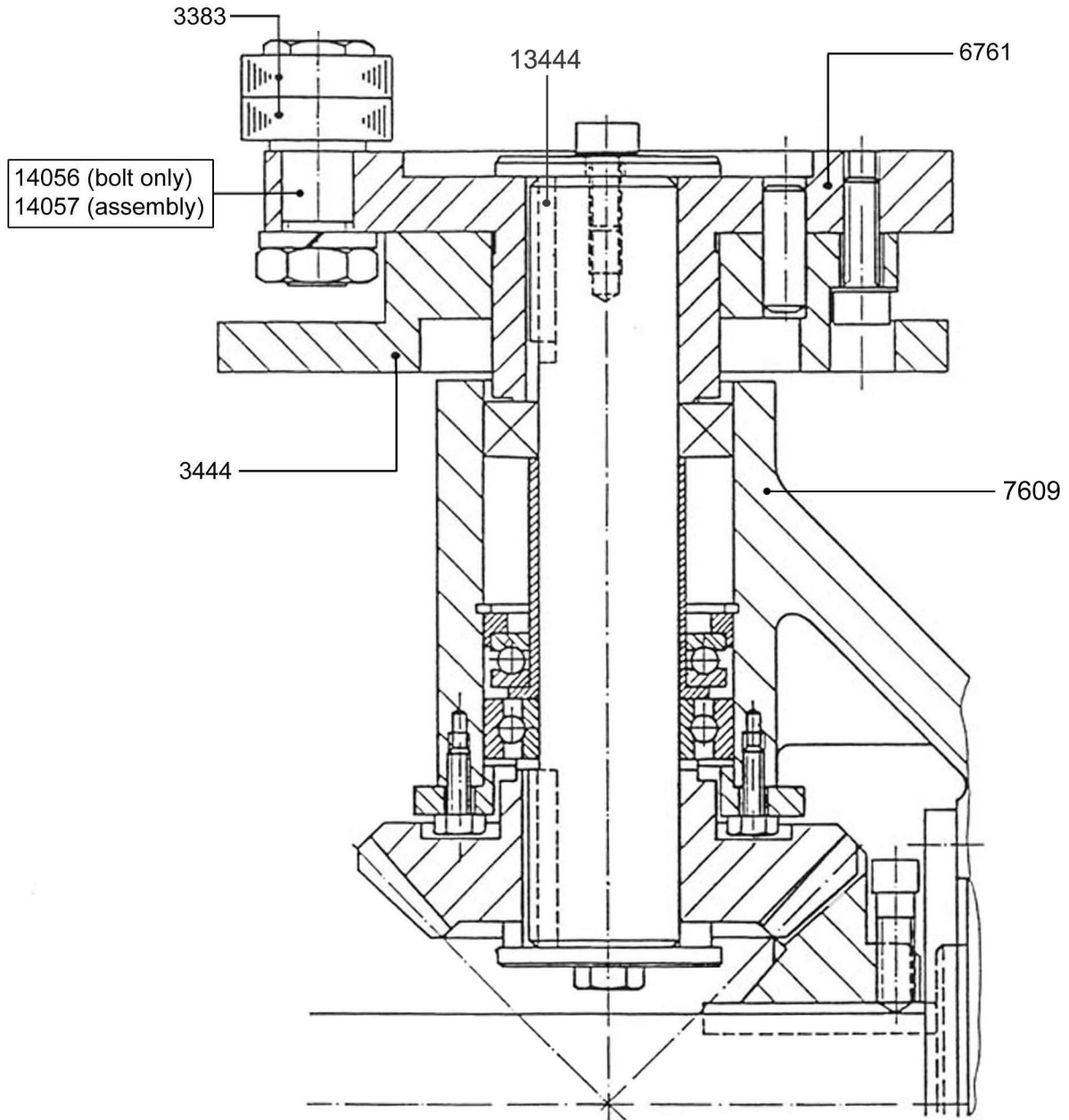
Section 3.2: segment geneva



Section 3: segment geneva

IIM No.	Description
2848	CAM FOLLOWER
3382	BEARING, BALL
3383	BEARING, BALL, DEEP GROOVE
3385	BEARING, BALL
3445	BUSHING
3512	GENEVA,LARGE,SEGMENT STATION
5710	BEARING
5837	BEVEL GEAR - USE P/N 15271 FOR SET OF 2
5838	BEVEL GEAR - USE P/N 15271 FOR SET OF 2
5843	SHAFT,PEANUT CAM DRIVE,WITH 2 KEYS,SCREWS
13419	ROD,SPRING FASTENER,HEX,SHORT,32MM
7494	ROD,SPRING FASTENER,BOLT
8164	PIN,ALIGNMENT,THREADED TAPER,8 X 55
8171	PIVOT BLOCK, LOCKING ARMS
9056	SNAP RING INTERNAL
10431	SHIM,STEEL,40 X 50 X 0.1
10432	SHIM,STEEL,40 X 50 X 0.2
10433	SHIM,STEEL,40 X 50 X 0.3
10434	SHIM,STEEL,40 X 50 X 0.5
10435	SHIM,STEEL,40 X 50 X 1.0
11459	BOLT,SHOULDER,FOR SEGMENT GENEVA LOCKING ARM
12406	LOCKING ARM
12448	KEY, BEVEL GEAR
13444	KEY
15027	SNAP RING INTERNAL
15271	BEVEL GEAR SET,30MM AND 40MM,WITH SCREWS AND KEYS
15276	SOCKET HEAD CAP SCREW, MODIFIED
15283	SHIM,STEEL,45X55X0.01 - USE P/N 15092 FOR SET
15284	SHIM,STEEL,45X55X0.05 - USE P/N 15092 FOR SET
15287	SHIM,STEEL,30X42X0.1 - USE P/N 15092 FOR SET
15288	SHIM,STEEL,30X42X0.3 - USE P/N 15092 FOR SET
15701	SHIM
15782	SPACER, DOSING GENEVA
19282	SNAP RING 180MM
27377	SPRING, EXTENSION
27397	CAP, YOKE HOUSING, 4 HOLE VERSION
27921	WASHER

Section 4: drive cam, segment geneva, single yoke

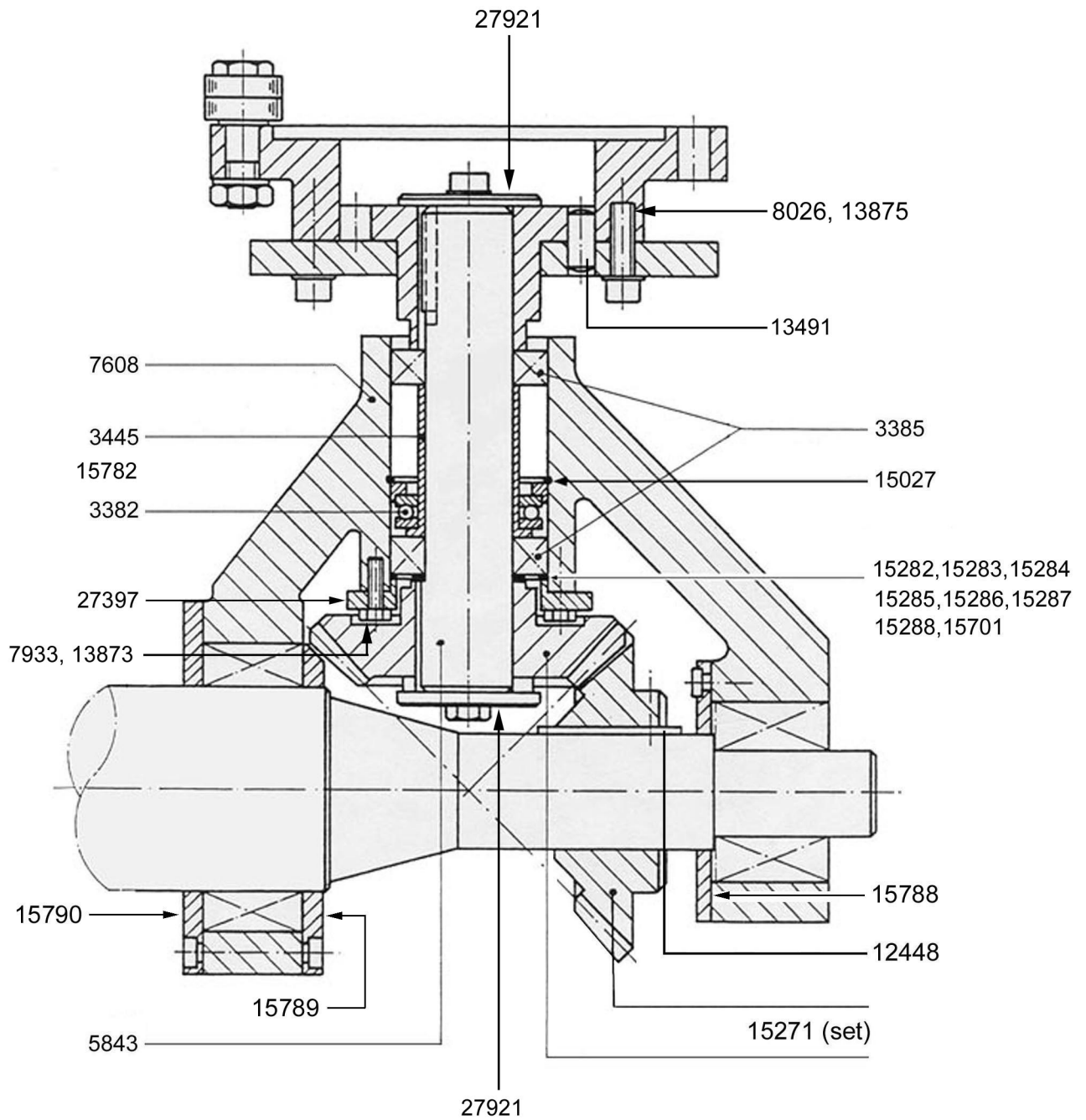


Assembly 25407 includes Peanut Cam (3444), Hub (6761) & Geneva Drive Bolt w/ bearings(14057).
Parts come pre-assembled with 4 mount screws and alignment dowel.

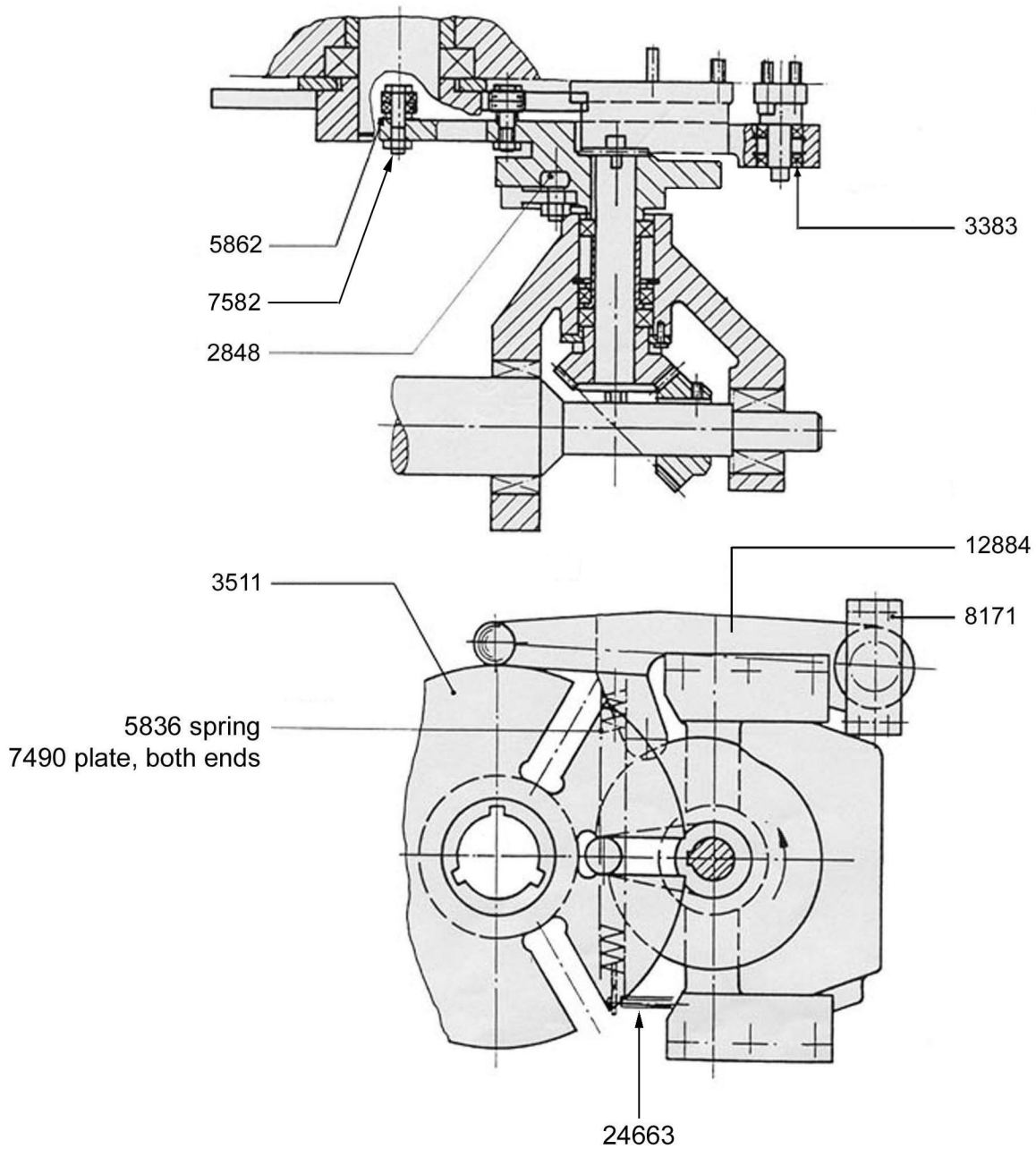
Section 4: Drive cam, segment drive, single yoke

IIM No.	Description
3383	BEARING,BALL,DEEP GROOVE
3444	CAM,PEANUT,LARGE GENEVA,SEGMENT STATION
6761	CAM,DRIVE RATCHET,LARGE GENEVA,SEGMENT
7609	SINGLE YOKE HOUSING
13444	KEY
14056	BOLT ONLY
14057	CAM ROLLER ASSY
25407	PEANUT CAM/RATCHET ASSEMBLY - comes assembled with 4 mount screws and alignment dowel.

Section 5.1: dosing geneva, double yoke



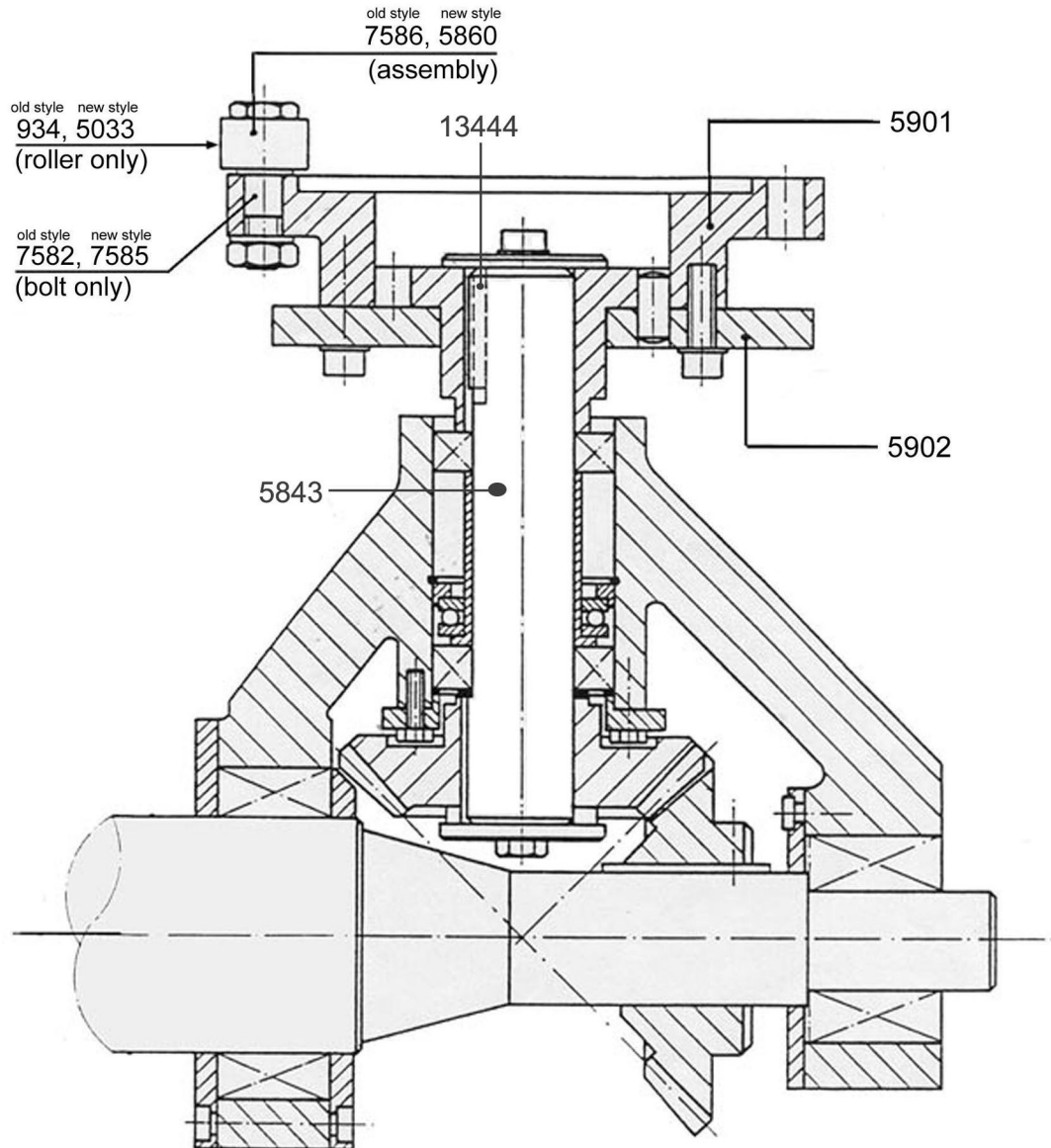
Section 5.2: dosing geneva, double yoke



Section 5: Dosing geneva, double yoke

IIM No.	Description
2848	CAM FOLLOWER
3382	BEARING,BALL
3383	BEARING,BALL,DEEP GROOVE
3385	BEARING,BALL
3445	BUSHING
3511	GENEVA,DOSING
5836	SPRING,EXTENSION
5837	GEAR,BEVEL - SEE 15271
5838	GEAR,BEVEL - SEE 15271
5843	SHAFT
5862	BEARING,BALL,DEEP GROOVED
7490	PLATE,SPRING HOLDING - BOTH ENDS OF SPRING 5836
7608	DOUBLE YOKE HOUSING
7933	SCREW,HEX CAP
8026	SOCKET HEAD CAP SCREW
8171	PIVOT BLOCK,LOCKING ARMS
12448	KEY,BEVEL GEAR
12884	DOSING LOCKING ARM
13491	DOWEL PIN
13873	WASHER M5 SERRATED
13875	WASHER M8 SERRATED
15027	INTERNAL RETAINING RING
15271	BEVEL GEAR KIT
15271	SET OF BEVEL GEARS: INCL. GEARS, SCREWS, KEYS
15282	SHIM,STEEL,45X55X0.1
15283	SHIM,STEEL,45X55X0.01
15284	SHIM,STEEL,45X55X0.05
15285	SHIM,STEEL,45X55X0.3
15286	SHIM,45X55X0.5
15287	SHIM,STEEL,30X42X0.1
15288	SHIM,STEEL,30X42X0.3
15701	SHIM,STEEL,30X42X0.5
15782	SPACER
15788	PLATE, BEARING RETAINING
15789	PLATE, BEARING RETAINING
15790	PLATE, BEARING RETAINING
24663	ROD,HEX,SPRING MOUNT,64MM
27397	CAP, YOKE HOUSING, 4 HOLE VERSION
27921	WASHER 10 X 50 X 5

Section 6: dosing geneva drive, double yoke

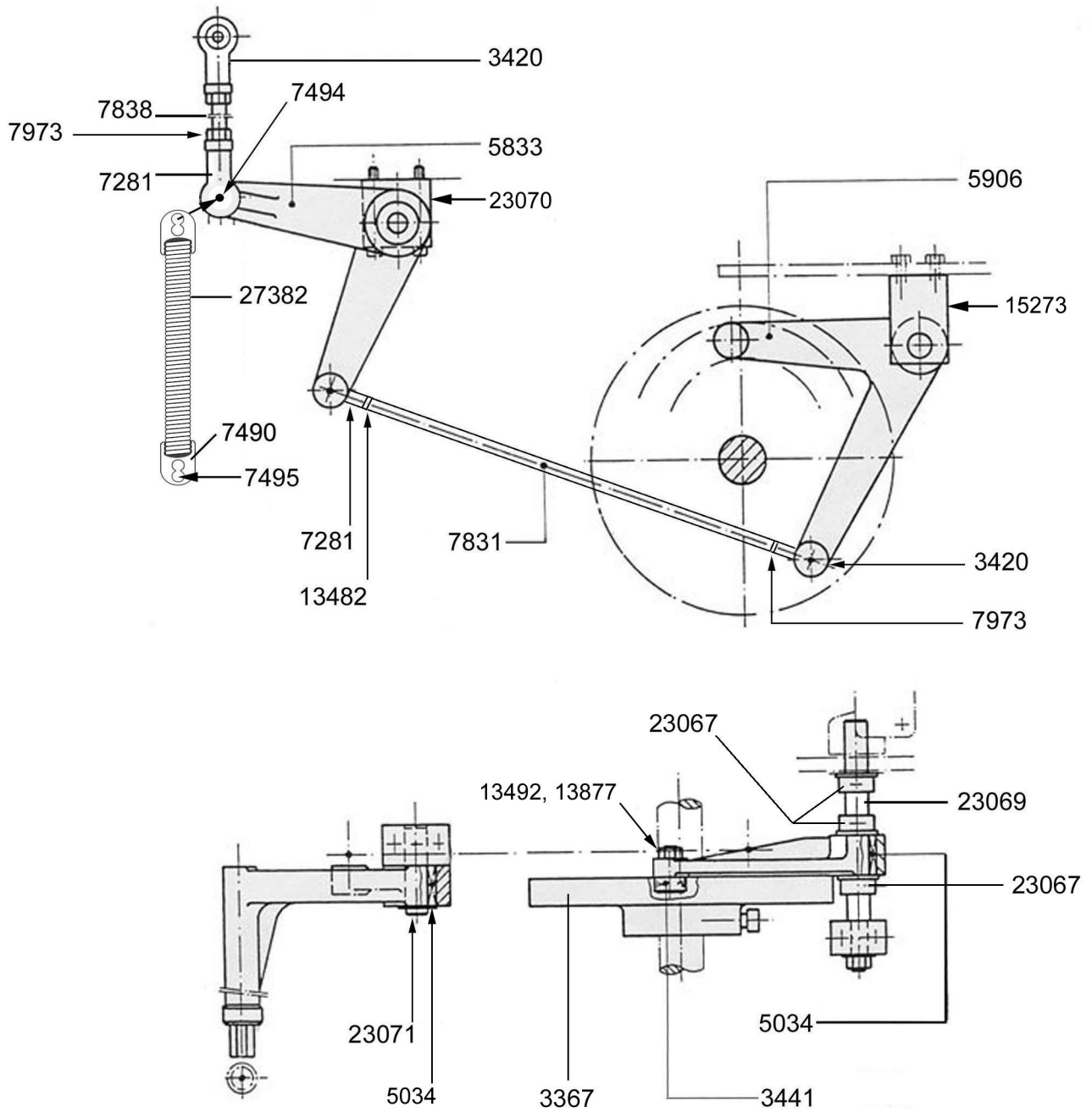


25406 Assembly includes Peanut Cam (5902), Hub (5901) & Geneva Drive Bolt w/ bearings (7586).
Parts come pre-assembled with 4 mount screws & alignment dowel.

Section 6: Drive cam, dosing geneva, double yoke

IIM No.	Description
934	ROLLER ONLY, NO BOLT, OLD STYLE (REQUIRES 2)
5033	ROLLER ONLY,NO BOLT,NEW STYLE (REQUIRES 1)
5843	SHAFT
5860	CAM ROLLER W/BOLT,NEW STYLE,SINGLE BEARING
5901	CAM,SMALL GENEVA DRIVE,DOSING (INTERCHANGEABLE WITH OLD STYLE)
5902	CAM,"PEANUT",SMALL GENEVA,DOSING
7582	BOLT,SHOULDER,DOSING DRIVE CAM,(OLD STYLE), USES DOUBLE BEARING
7585	BOLT,SHOULDER,NEW STYLE
7586	CAM ROLLER W/BOLT,OLD STYLE,DOUBLE BEARING
13444	KEY
25406	PEANUT CAM/RATCHET ASSEMBLY - comes assembled with 4 mount screws and alignment dowel.

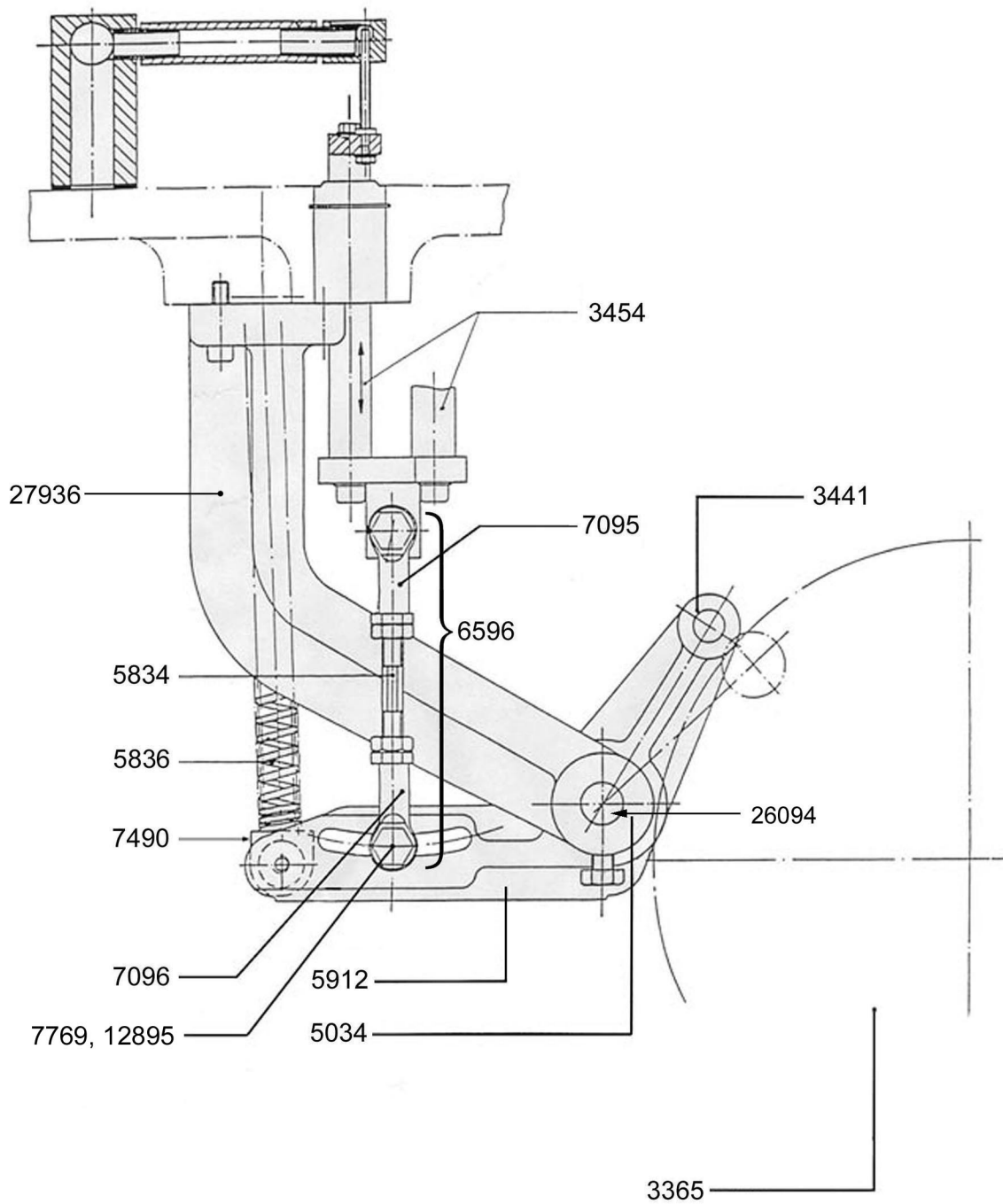
Section 7: sorting drive



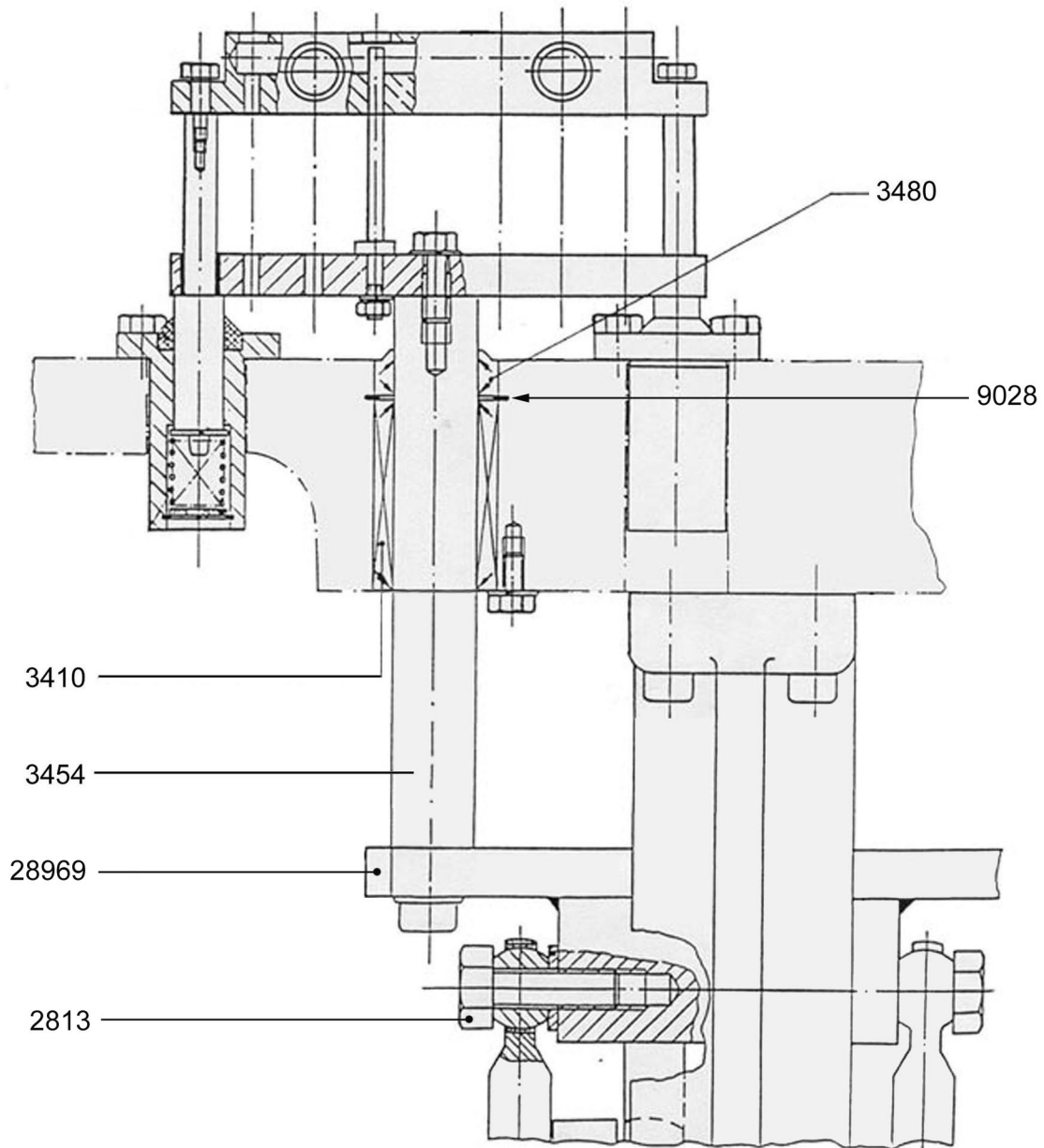
Section 7: sorting drive

IIM No.	Description
3367	CAM, SORTING
3420	ROD END, RIGHT, M12
3441	BEARING, CAM FOLLOWER
5034	BEARING
5833	LEVER, DRIVE, SORTING STATION
5906	LEVER, CAM, SORTING MECHANISM DRIVE
7281	ROD END, LEFT, M12
7492	PLATE, SPRING HOLDING
7494	ROD, SPRING FASTENER
7495	ROD, SPRING FASTENER, HEX, 90 DEGREE
7831	ROD, CONNECTING
7838	ROD, CONNECTING
7973	NUT, M12, RH
13482	NUT, M12, LH
13492	HEX JAM NUT
13877	WASHER, SERRATED, M12
23067	SHAFT COLLAR
23069	AXLE, SORTING LEVER
23071	SHAFT, PIVOT
27382	SPRING, EXTENSION, 3 X 25 X 460

Section 8.1: separation drive



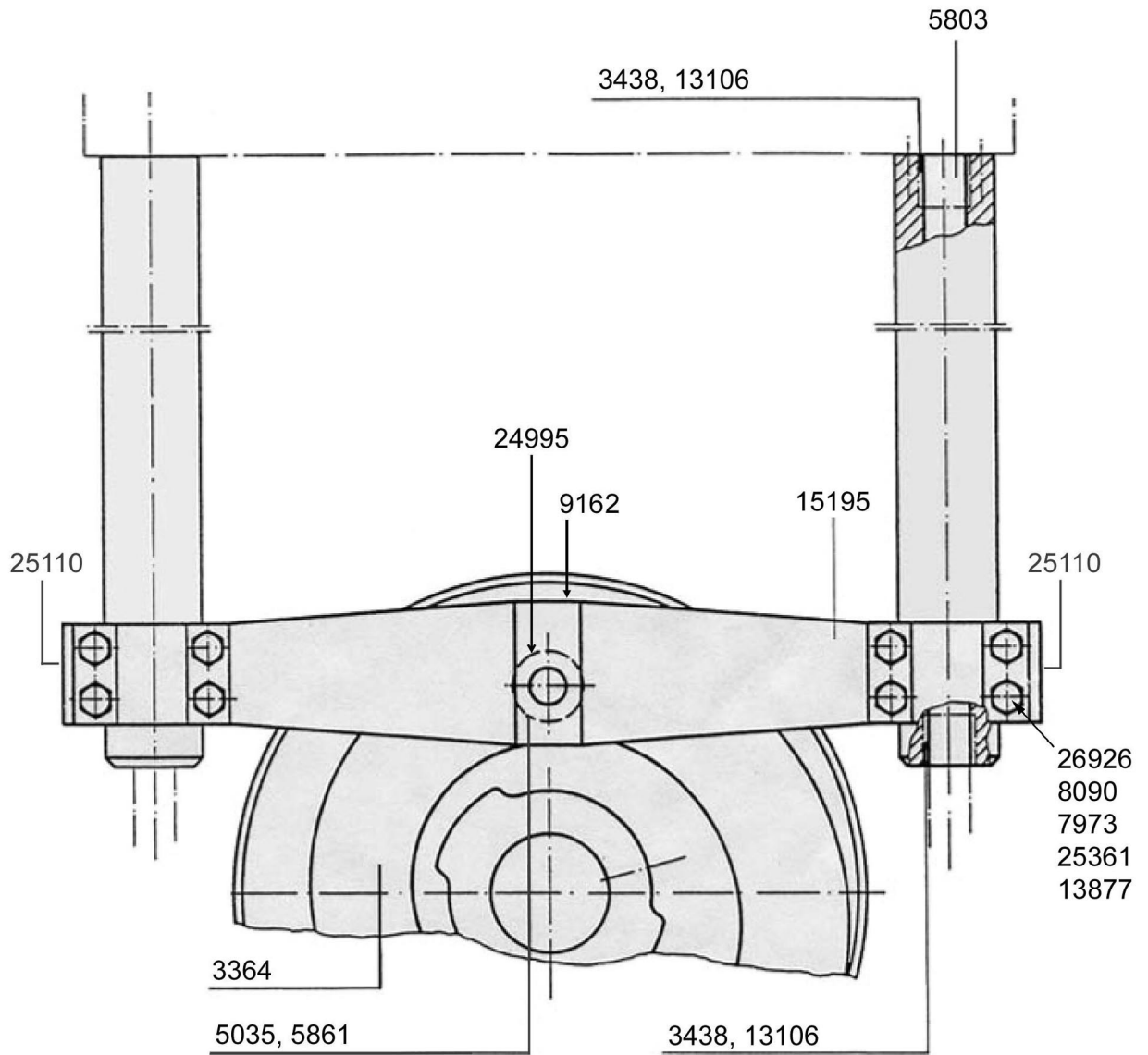
Section 8.2: separation drive



Section 8: separation drive

IIM No.	Description
3365	CAM,SEPARATION,W/ NEW ALIGNMENT HOLE
3410	BEARING,LINEAR,FOR 20 MM DRIVE SHAFT
3441	BEARING,CAM FOLLOWER
3454	SHAFT,CAPSULE SEPARATION
3480	SEAL RING,FOR 20MM DRIVE SHAFT
5034	BEARING
5834	TIE ROD, M10
5836	SPRING,EXTENSION,2.5 X 20.5 X 150
5912	LEVER,SEPARATION STATION
7095	ROD END,M10,RIGHT HAND
7096	ROD END,M10,LEFT HAND
7490	PLATE,SPRING FASTENER (BOTH ENDS OF SPRING)
7769	ROD,CONNECTING,SEPARATION DRIVE,H&K 1500 ONLY (M8 VERSION)
9028	RETAINING RING
12895	ROD,CROSS,SORTING STATION, H&K 1200 ONLY (M10 VERSION)
15004	POST,L-SHAPED,TOP OF SPRING 12888
23740	TURNBUCKLE, M12, COMPLETE
26094	SHAFT,PIVOT,SEPARATION/LOWER CLOSING
27936	SUPPORT
28969	SEPARATION CROSSBAR

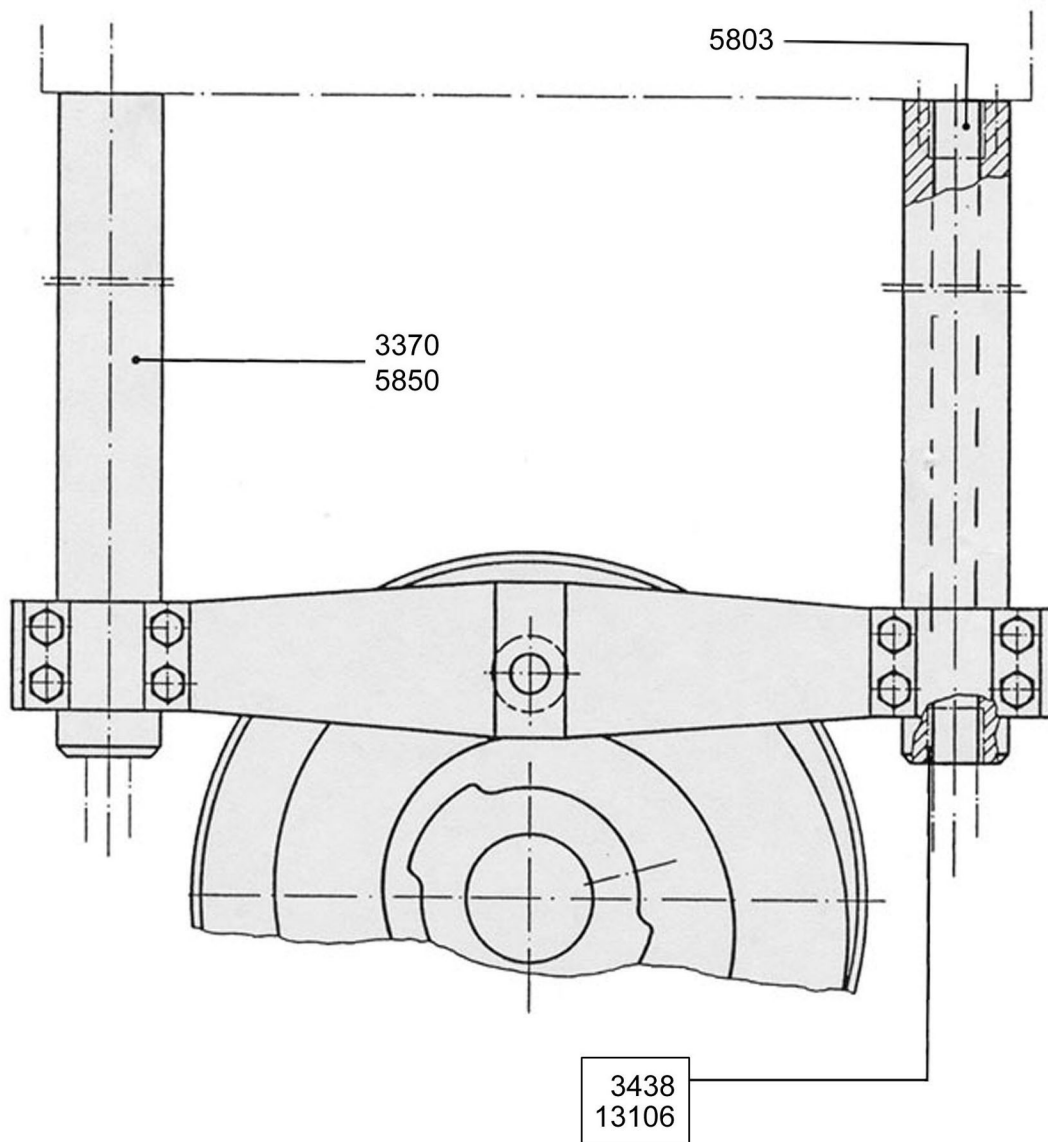
Section 9: tamping drive



Section 9: tamping drive

IIM No.	Description
3364	CAM,DOSING,W/ NEW ALIGNMENT HOLE
3438	BUSHING, BOSCH VERSION, H&K 1500
5035	ROLLER,CAM,DOSING DRIVE
5803	SHAFT,TAMPER HEAD,RAISING,NEW STYLE
5861	CAM FOLLOWER,NEW STYLE W/GREASE FITTING AND SHORTER 42 MM SHANK
7973	NUT, HEX, M12
8090	WASHER M12
13106	BEARING,CYLINDRICAL,BUSHING, IIM AND H&K 1200 STYLE
13877	WASHER, M12,SERRATED
15195	CROSS MEMBER,TAMPING HEAD LIFTING DRIVE
25110	MOUNT BLOCK,GREASE FITTING
25361	WASHER,LOCKING,W/TAB
26926	SCREW,M12 X 150,TAMPING CROSSMEMBER

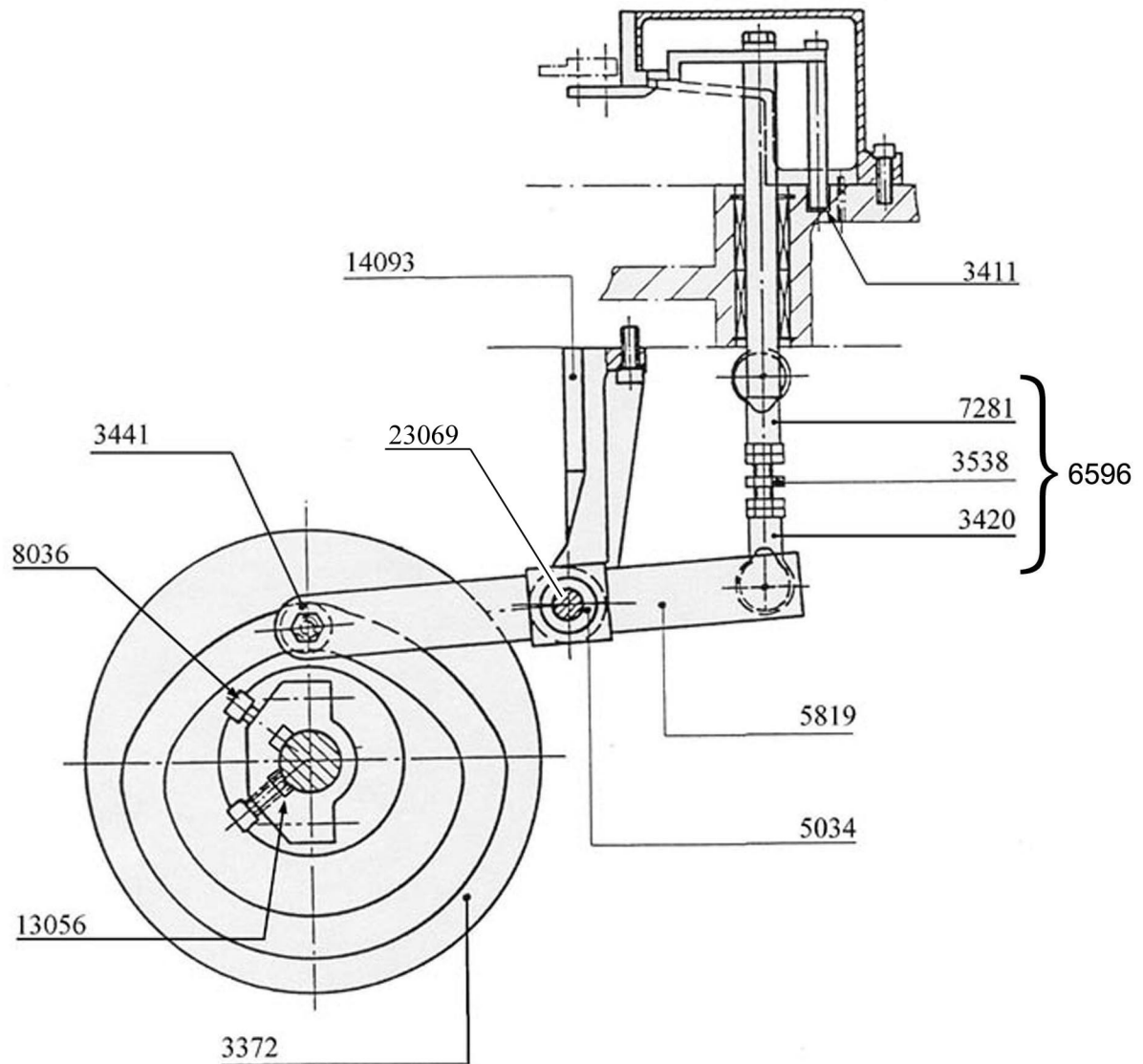
Section 10: tamping shafts



Section 10: tamping shafts

IIM No.	Description
3370	SHAFT,TAMPING SLIDE,NEW STYLE
3438	BUSHING
5803	SHAFT,TAMPING HEAD,RAISING,NEW STYLE AND OLD STYLE
5850	SHAFT,TAMPING SLIDE,OLD STYLE,BRONZE GUIDE RING
13106	BEARING,CYLINDRICAL,BUSHING, IIM AND H&K 1200 STYLE

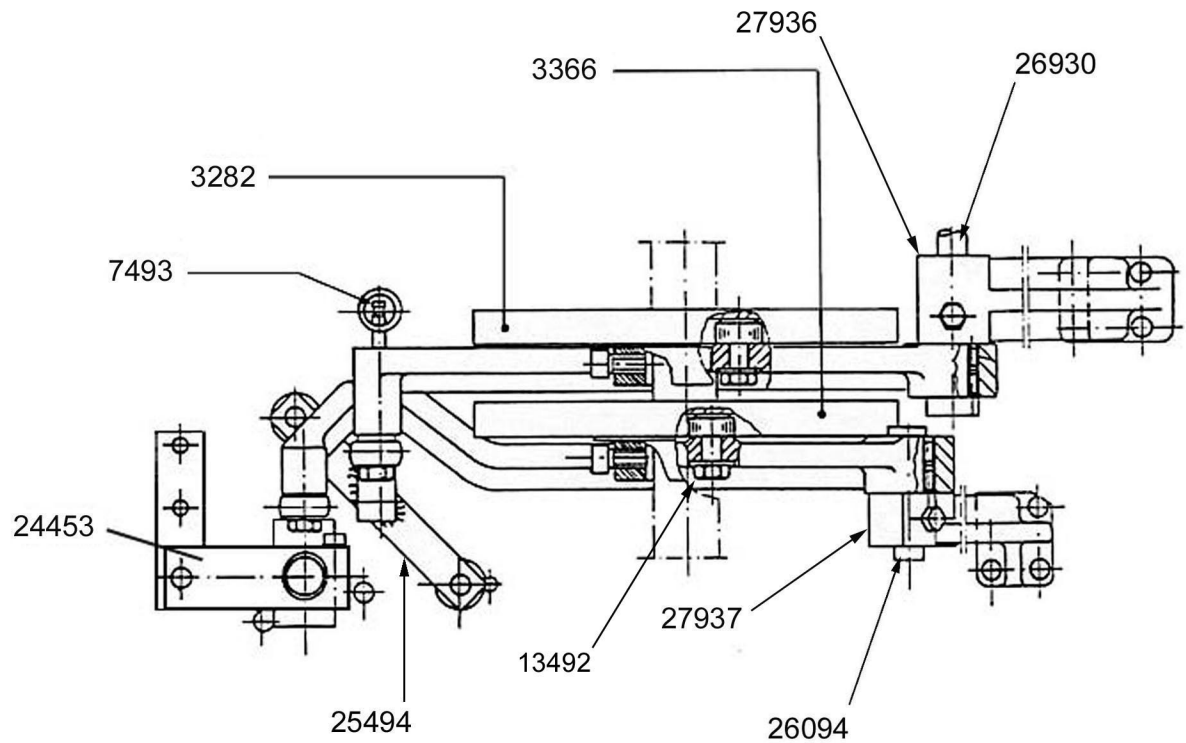
Section 11: faulty capsule drive, old style



Section 11: faulty capsule drive, old style

IIM No.	Description
3372	CAM, FAULTY CAPSULE, W/NEW ALIGNMENT HOLE
3411	BUSHING
3420	ROD END, RIGHT, M12
3441	BEARING, CAM FOLLOWER
3538	TIE ROD, M12
5034	BEARING
5819	LEVER, DRIVE, FAULTY CAPSULE EJECTION
6596	TURNBUCKLE, M12, COMPLETE
7281	ROD END, LEFT, M12
8036	SOCKET HEAD CAP SCREW
13056	KEY
14093	SUPPORT
23069	PIVOT SHAFT

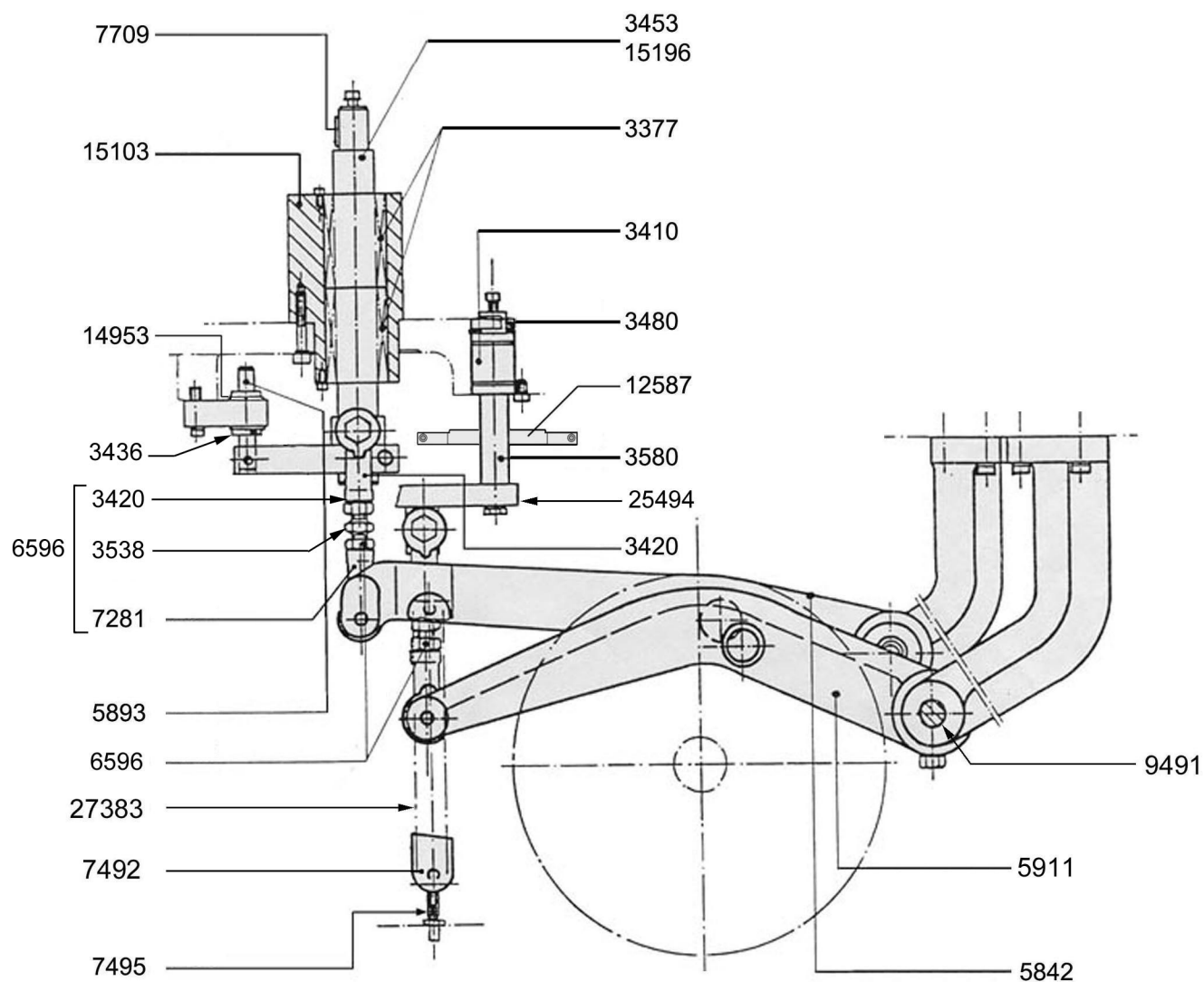
Section 12: upper closing drive



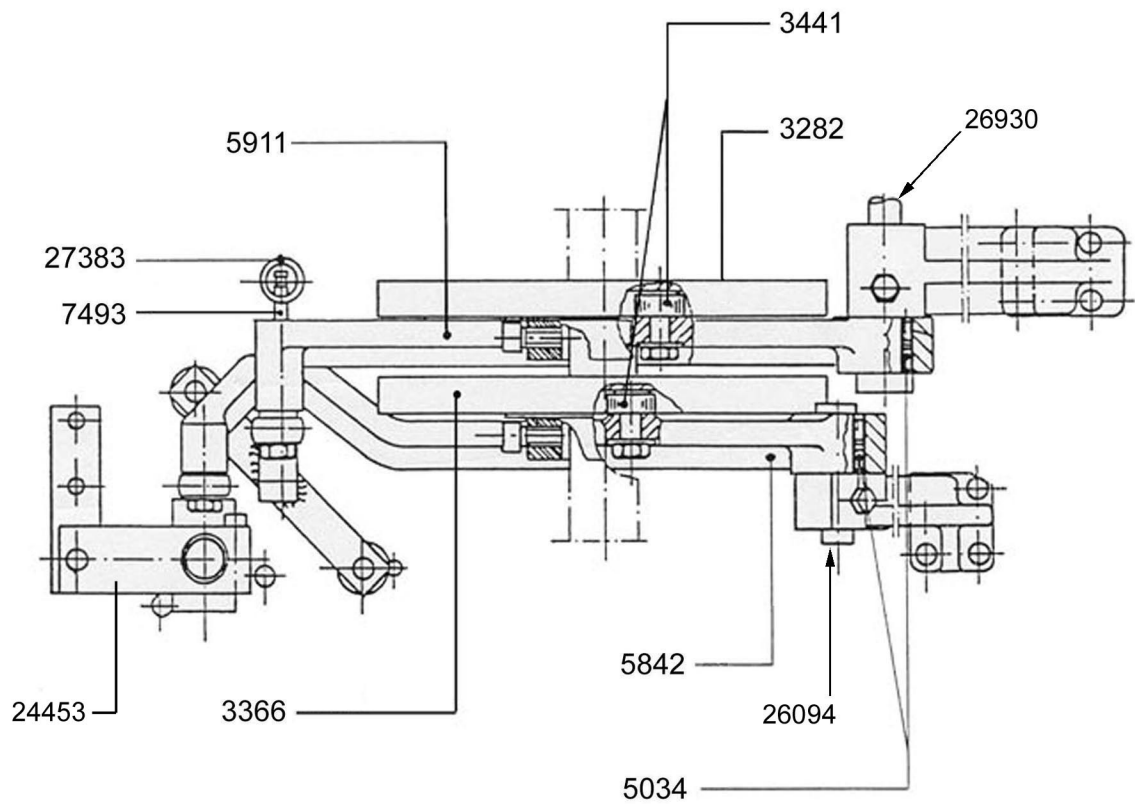
Section 12: upper closing drive

IIM No.	Description
3282	CAM, CLOSING, UPWARD MOVEMENT
3366	CAM, CLOSING, COUNTERBEARING
7493	ROD,SPRING FASTENER,HEX,SHORT,32MM
13492	HEX JAM NUT
24453	MOUNT BLOCK
25494	CLOSING CROSSBAR
26094	SHAFT,PIVOT,COUNTER CLOSING ACTUATOR ARM
26930	SHAFT,PIVOT,SEPARATION & LOWER CLOSING
27936	SUPPORT, UPPER CLOSING
27937	SUPPORT, UPPER CLOSING

Section 13.1: upper & lower closing drive



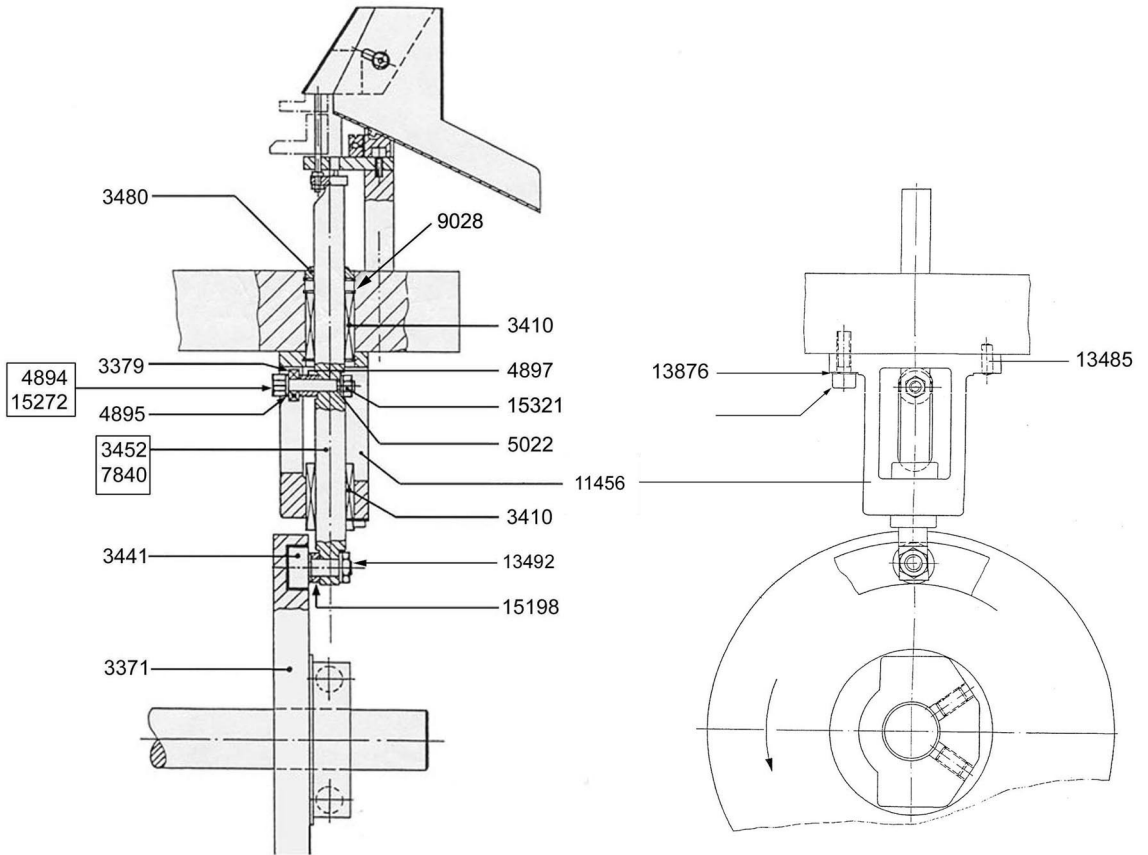
Section 13.2: upper & lower closing drive



Section 13: upper and lower closing drive

IIM No.	Description
3282	CAM, CLOSING,W/ NEW ALIGNMENT HOLE
3366	CAM, CLOSING, COUNTERBEARING
3377	BEARING,LINEAR
3410	BEARING,LINEAR,FOR 20 MM DRIVE SHAFT
3420	ROD END,RIGHT,M12
3436	BEARING,LINEAR
3441	BEARING,CAM FOLLOWER
3453	SHAFT,UPPER,CLOSING STATION, QUICK CHANGE, NEW STYLE
3480	SEAL RING,FOR 20MM DRIVE SHAFT
3580	SHAFT,LOWER,CLOSING STATION
5034	BEARING
5842	LEVER, UPPER CLOSING
5893	SHAFT,GUIDE,UPPER CLOSING
5911	LEVER,CLOSING STATION,LOWER
6596	TURNBUCKLE ASSEMBLY, M12
7281	ROD END,LEFT,M12
7492	PLATE,SPRING FASTENER,LARGE,30 MM WIDE,FOR 3 DIA X 25
7493	ROD,SPRING FASTENER,HEX,SHORT,32MM
7495	ROD,SPRING FASTENER,HEX,90
7709	KEY,SHAFT,UPPER CLOSING
9491	EXTERNAL RETAINING RING
12587	CROSS MEMBER,PREVENTS ROTATION OF SHEAR PIN CLOSING PLATE
14953	EXTERNAL RETAINING RING
15103	BEARING FLANGE
15196	SHAFT,UPPER,CLOSING STATION, OLD STYLE (W/ THREADED TOP NUT)
24453	MOUNT BLOCK,UPPER CLOSING
26094	SHAFT,PIVOT,COUNTER CLOSING ACTUATOR ARM
26930	SHAFT,PIVOT,SEPARATION & LOWER CLOSING
27383	SPRING,EXTENSION,3 X 25 X 355

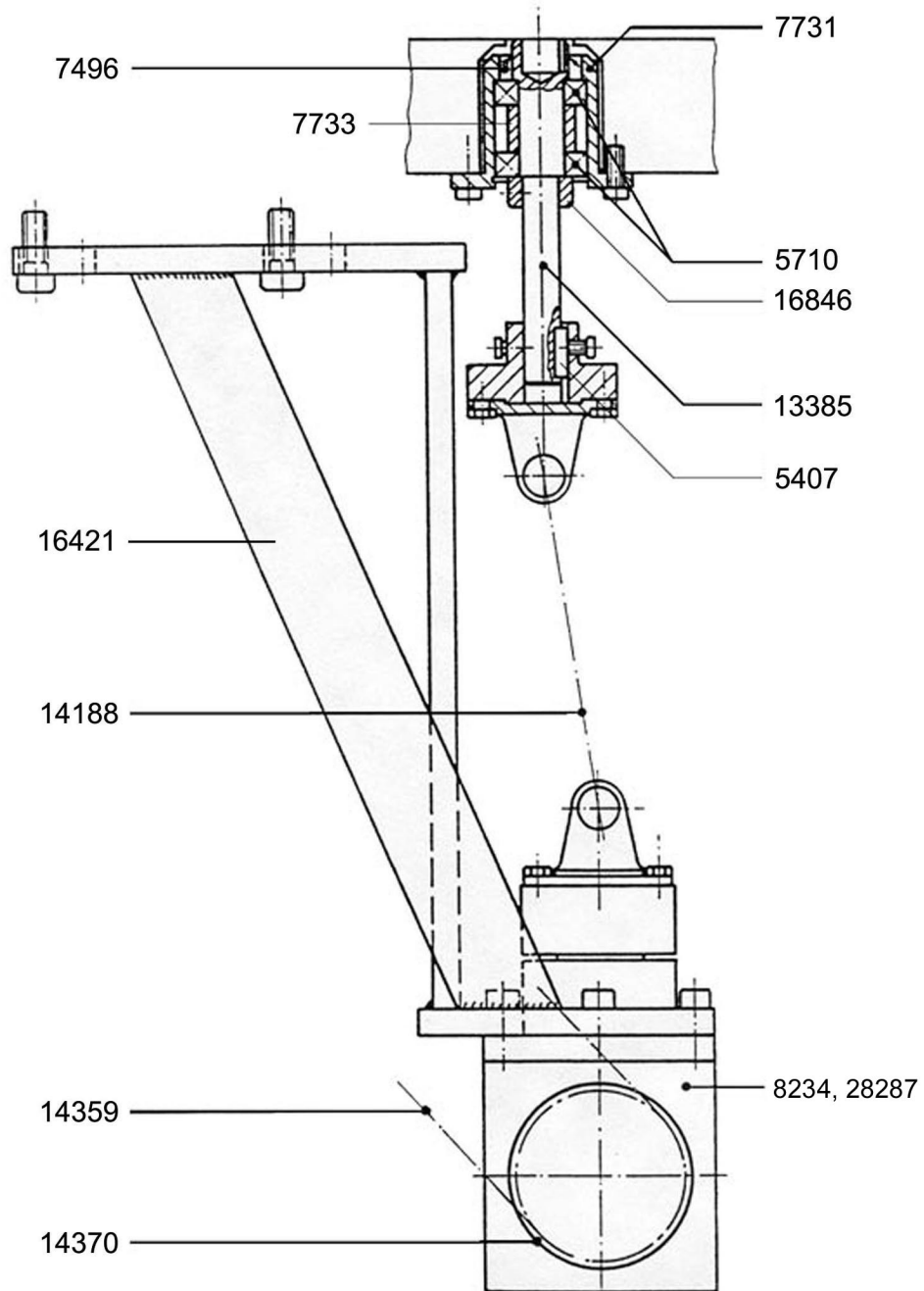
Section 14: ejection drive



Section 14: ejection drive

IIM No.	Description
3371	CAM,EJECTION,W/ NEW ALIGNMENT HOLE
3379	BEARING
3410	BEARING,LINEAR,FOR 20 MM DRIVE SHAFT
3441	BEARING,CAM FOLLOWER
3452	SHAFT,EJECTION,NEW STYLE,FOR H&K 1500
3480	RING,SCRAPER
4894	SHAFT,M8X58,W/BLOW-OUT ATTACHMENT
4895	SHIM,ON SPACER SIDE
4897	SPACER,8.15 ID X 14 OD X 11
5022	WASHER,SPIRAL,M8
7840	SHAFT,EJECTION,OLD STYLE,FOR 1200 AND 2400
9028	SNAP RING
11456	HOUSING,EJECTION SHAFT,1200-1500 CONV PART
13492	NUT,HEX,JAM,M12 X 1.5
15096	PIN,TAPER,6MM
15198	SPACER,EJECTION SHAFT TO CAM FOLLOWER
15272	SCREW,SHOULDER,M8X55,OLD STYLE WITHOUT BLOW OUT ARM
15321	NUT M8 WITH NYLON INSERT
26214	PIN,TAPER,8MM

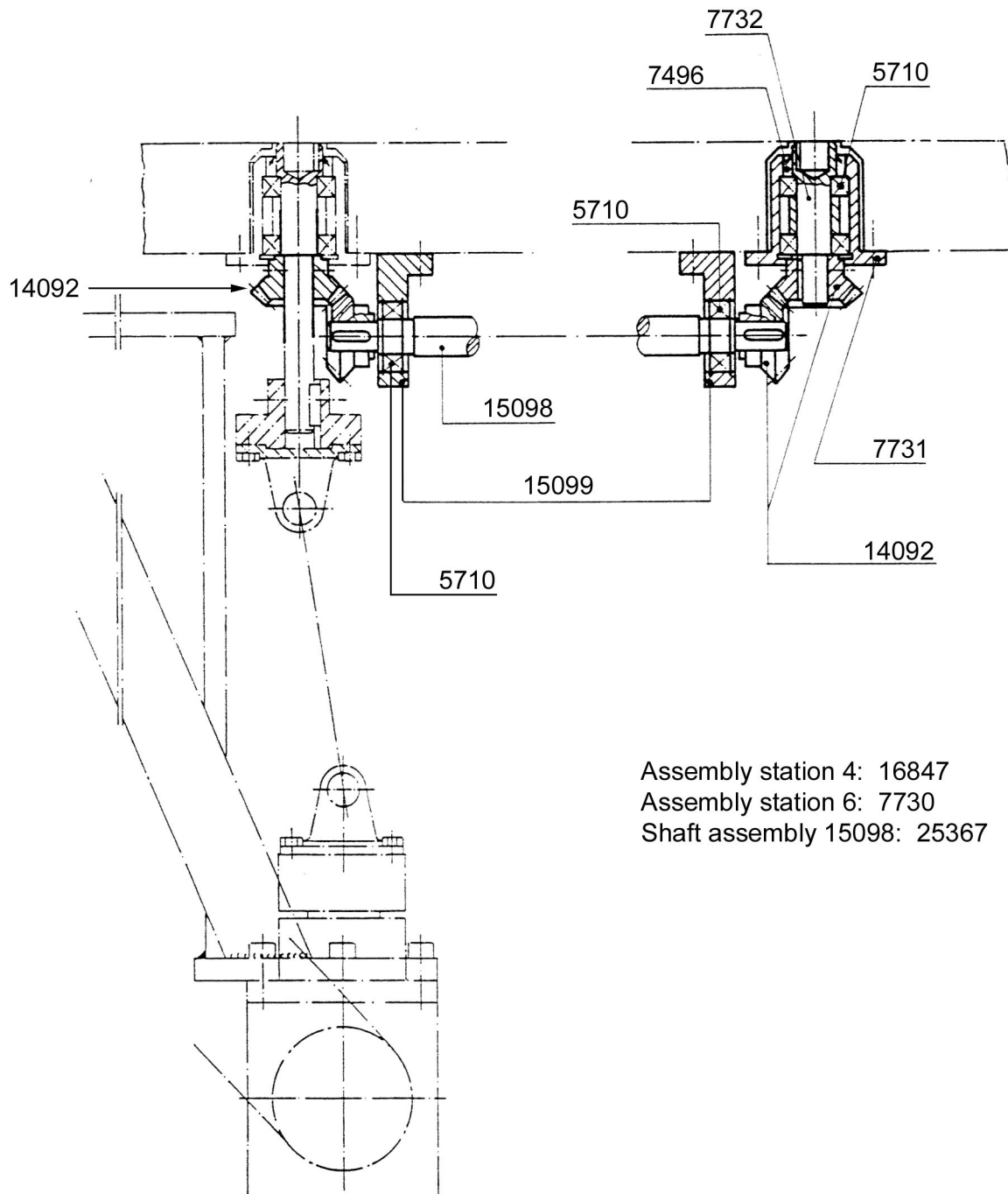
Section 15: station 4 pellet drive



Section 15: station 4 pellet drive

IIM No.	Description
5407	KEY, FOR MOTOR SHAFT
5710	BEARING
7496	SEAL
7731	HOUSING, BEADER/KNIFE DRIVE
7733	SPACER, BEADER/KNIFE DRIVE
8234	GEARBOX,FOR PELLETT ATTACHMENT
13385	SHAFT,NO SCREWED KEY
14188	UNIVERSAL JOINT
14359	CHAIN
14360	MASTER LINK
14370	SPROCKET
16421	BRACKET,MOUNTING,FOR BEAD FEED
16846	COLLAR,SHAFT,ST#4 BEAD FEED DRIVE SHAFT
28287	GEARBOX REPAIR/EXCHANGE

Section 16: station 6 pellet drive

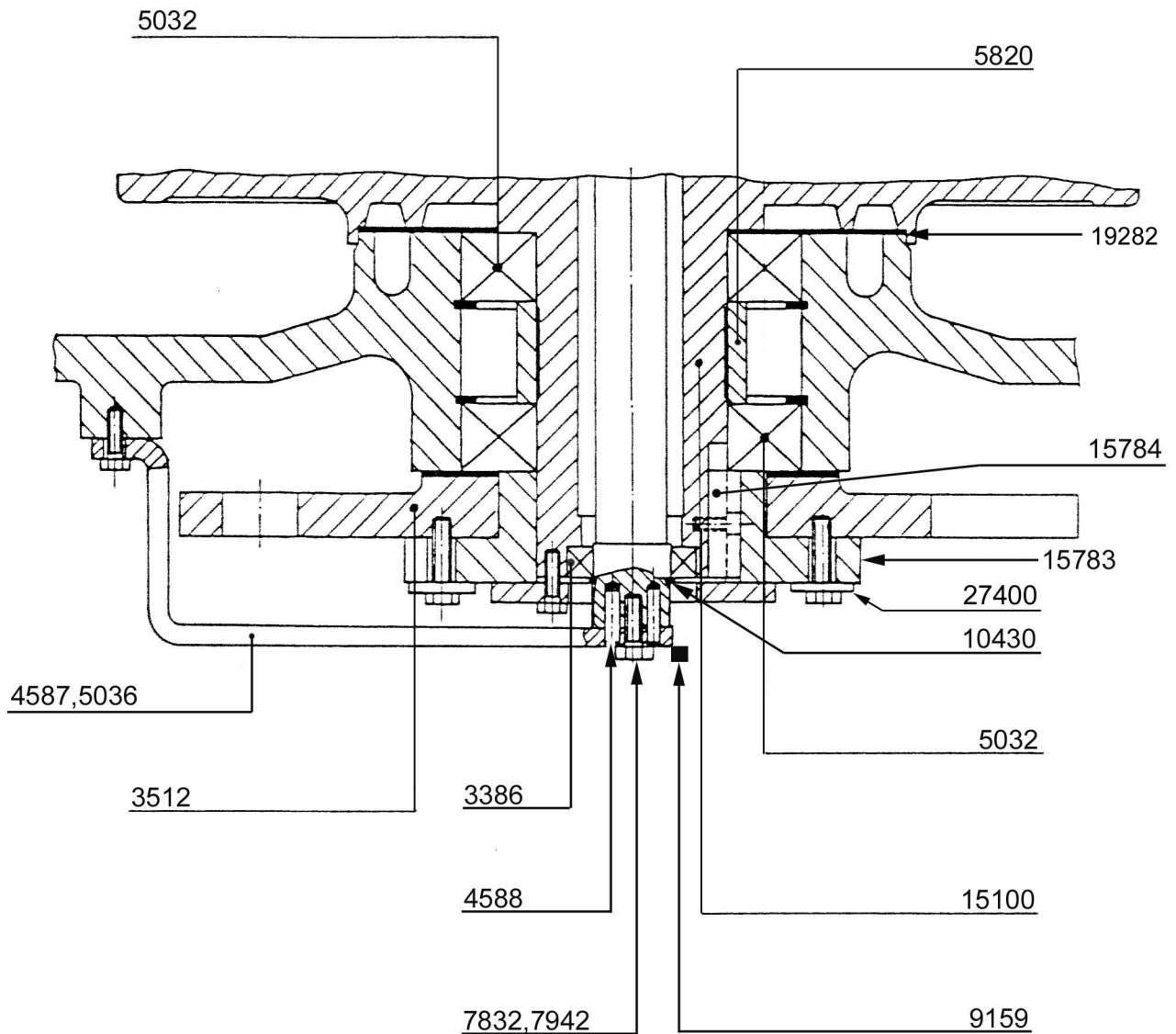


Assembly station 4: 16847
Assembly station 6: 7730
Shaft assembly 15098: 25367

Section 16: station 6 pellet drive

IIM No.	Description
5710	BEARING
7496	SEAL
7731	HOUSING, BEADER/KNIFE DRIVE
7732	SHAFT, DRIVE, BEADER/KNIFE DRIVE
14092	BEVEL GEAR
15098	SHAFT, BEAD FEED, ACROSS TABLE, DRIVE
15099	HOUSING, RIGHT ANGLE, FOR BEARING

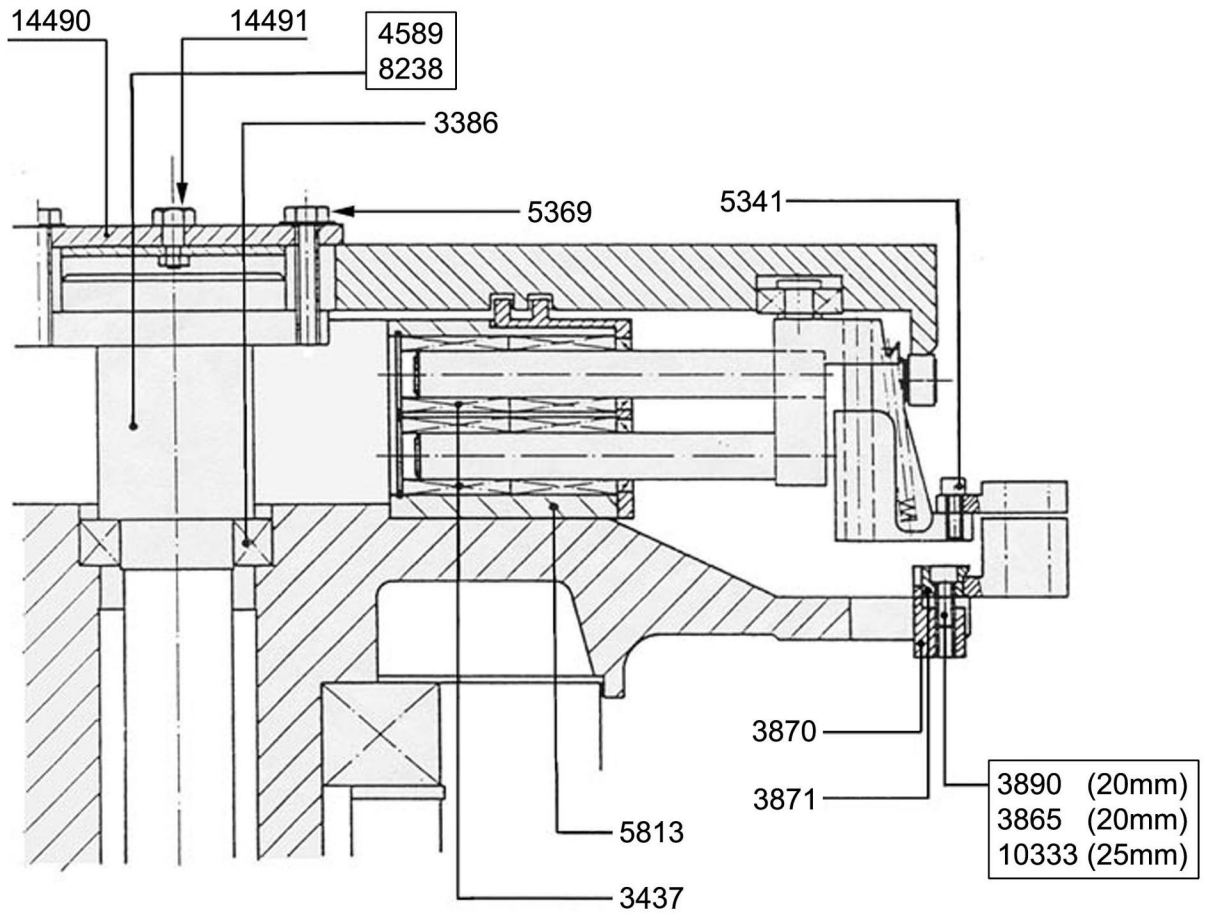
Section 17: segment geneva



Section 17: Segment geneva

IIM No.	Description
3386	BEARING
3512	GENEVA,LARGE,SEGMENT STATION
4587	BRACKET, TOP CAM SHAFT, W / AIR LINE (NEW STYLE, 2 BOLTS)
4588	DOWEL PIN
5032	BEARING, LARGE GENEVA
5036	BRACKET,STABILIZER, TOP CAM SHAFT, W/O AIR LINE (OLD STYLE, 1 BOLT)
5820	SPACER, INDEXING
7832	SCREW, NEW STYLE
7942	SCREW, OLD STYLE, W/O AIR LINE
9159	AIR LINE CONNECTOR
10430	RETAINING RING FOR BEARING 3386
15100	SEGMENT TURRET, NEW STYLE W/LOWER SEGMENT GROOVES
15783	FLANGE, SEGMENT TURRET
15784	KEY, SEGMENT TURRET TO SEGMENT GENEVA
19282	SNAP RING
27400	WASHER
10431	SHIM 40 X 50 X 0.1
10432	SHIM 40 X 50 X 0.2 (top of shaft)
10433	SHIM 40 X 50 X 0.3
10434	SHIM 40 X 50 X 0.5
10435	SHIM 40 X 50 X 1.0 (under snap ring)

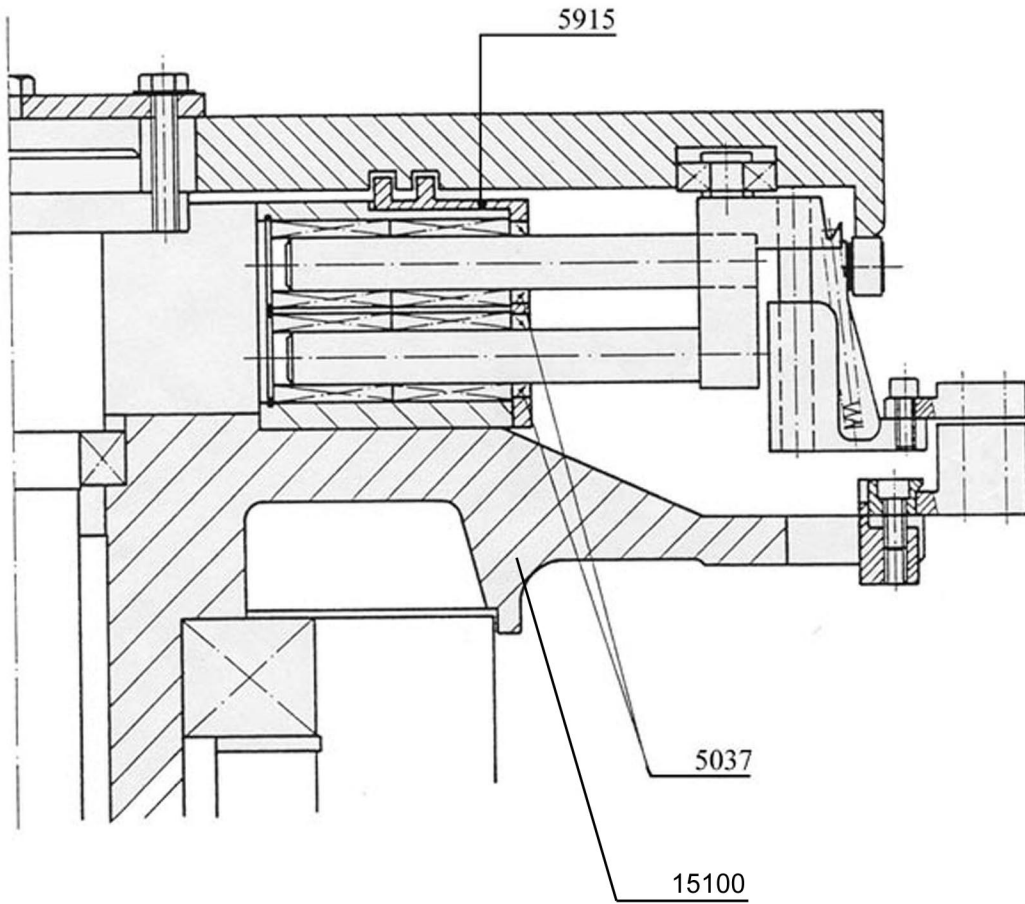
Section 18: segment carriers



Section 18: Segment carriers

IIM No.	Description
3386	BEARING,BALL
3437	BEARING,LINEAR
3865	SCREW,LOWER SEGMENT MOUNT,20MM LONG
3870	LOWER SECURING BLOCK
3871	UPPER SECURING BLOCK
3890	SCREW,LOWER SEGMENT MOUNT,FOR QUICK RELEASE TURRET
4589	SHAFT,TOP CAM,W/AIR HOLE,W/TOP ALIGNMENT PINS, NEW STYLE
5341	BOLT,UPPER SEGMENT MOUNT,WITH INTEGRAL WASHER
5369	SCREW,HEX HEAD W/INTEGRAL WASHER
5813	TURRET,SEGMENT
8328	SHAFT,TOP CAM,W/AIR HOLE,OLD STYLE,4 THREADED HOLES AT TOP
10333	SCREW,LOWER SEGMENT MOUNT,M6 X 25
14490	BRACKET,TOP CAM HOLD-DOWN, NEW STYLE
14491	SCREW,SHOULDER,PIVOT SCREW

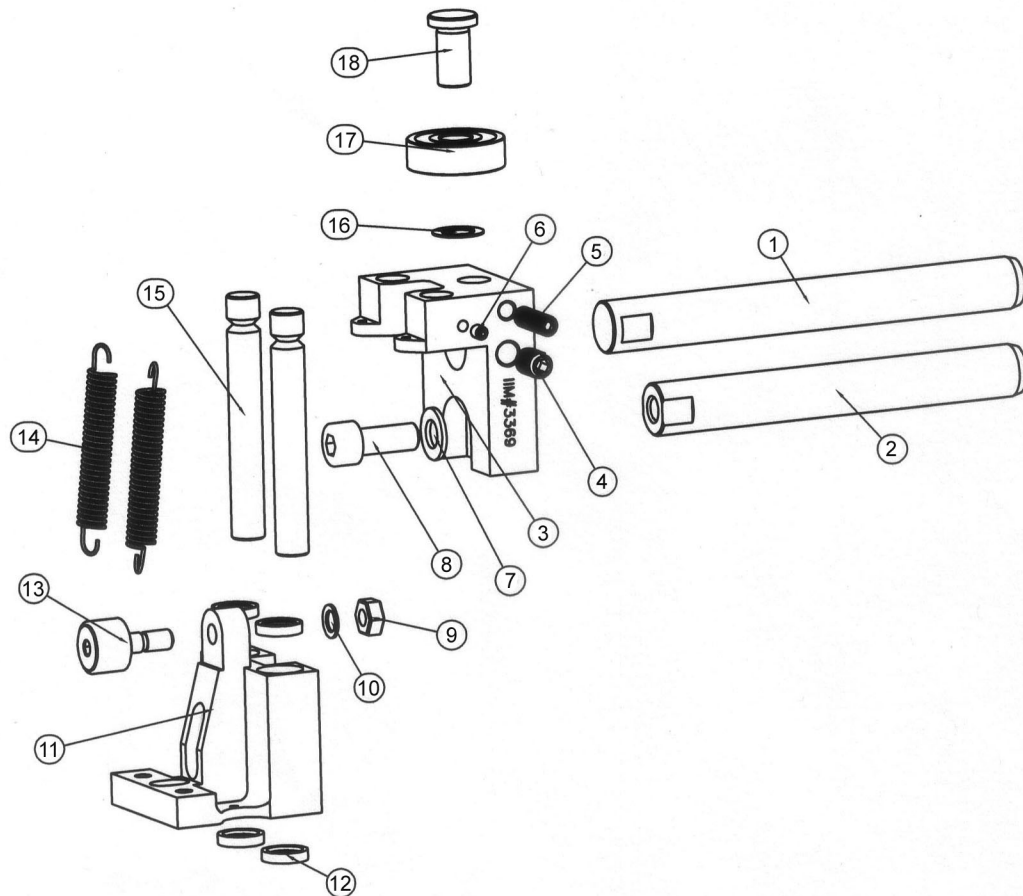
Section 19: segment doughnut



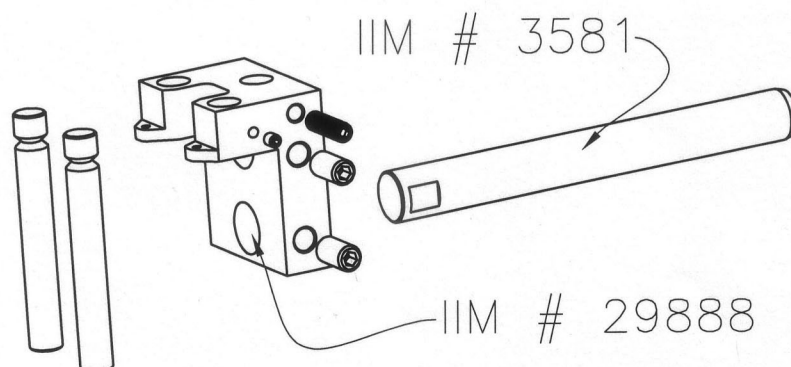
Section 19: Segment doughnut

IIM No.	Description
5037	STRIPPER SEAL
5915	COVER,RING
15100	TURRET,LOWER SEGMENT

Section 20: Complete segment carrier IIM # 7094



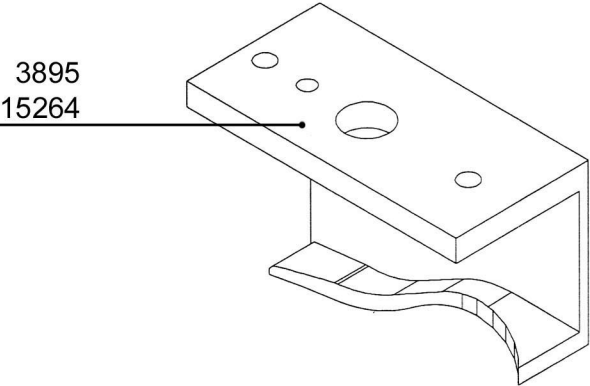
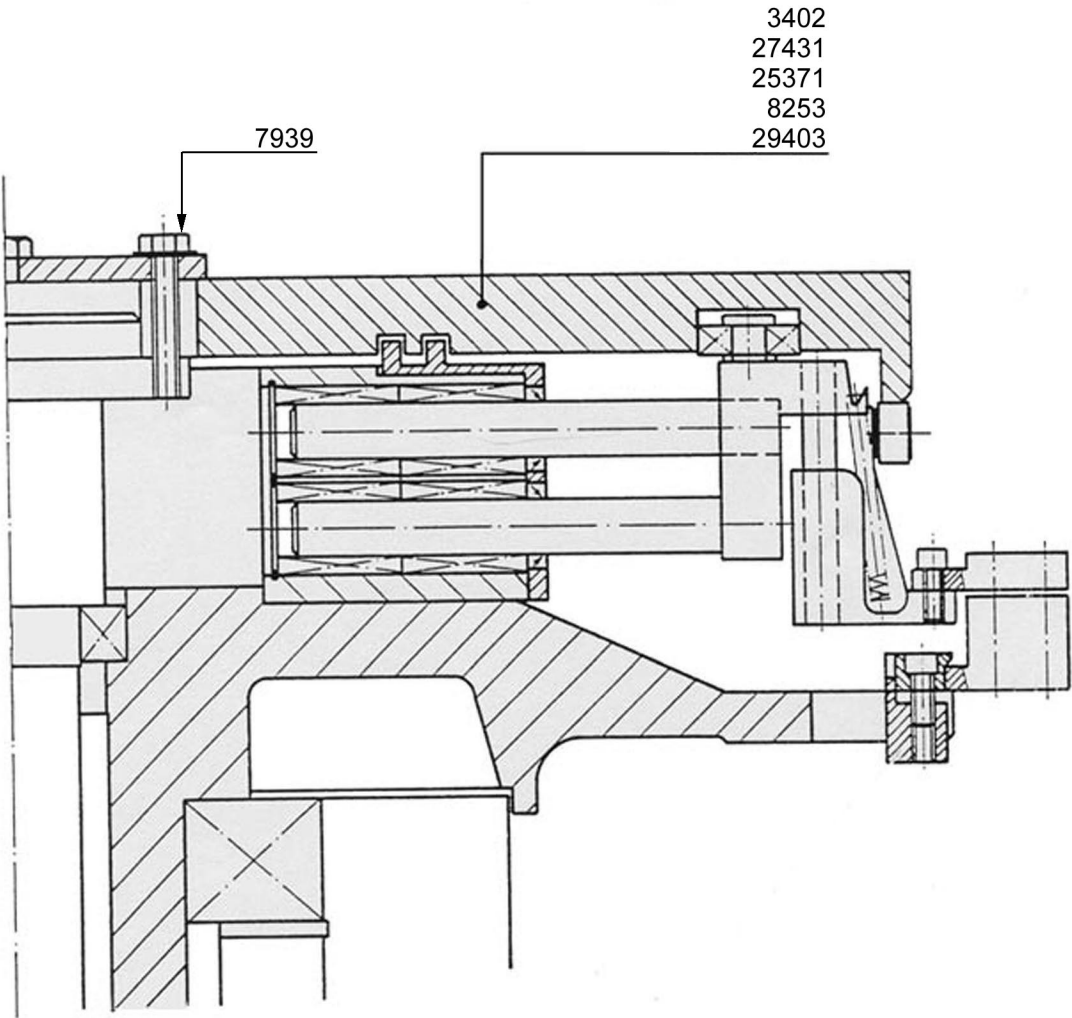
Option: upgraded with both rear shafts fixed



Section 20: complete segment carrier

Pos	IIM no.	Description	Qty/assy
1	3581	Shaft, 16mm upper	1
2	3485	Shaft, 16mm lower	1
3	3369	Rear segment carrier	1
4	8074	Set screw	1
5	8070	Set screw	1
6	15307	Set screw	2
7	6808	Washer, flat	1
8	1151	Screw, socket head cap	1
9	13769	Nut	1
10	13874	Washer, lock	1
11	23323	Front segment carrier with seals	1
11.1	8124	Front segment carrier with seals and bushings	1
12	3557	Seal ring	4
13	2863	Cam follower, 16mm	1
14	3497	Spring, ext	2
15	7463	Shaft, 10mm vertical	2
16	8168	Shim	1
17	3380	Bearing, 30mm	1
18	3400	Pin, bearing	1
-	29888	Rear segment carrier, accepts fixed shaft 3581	1
-	30001	Segment carrier complete with fixed horiz shafts	1

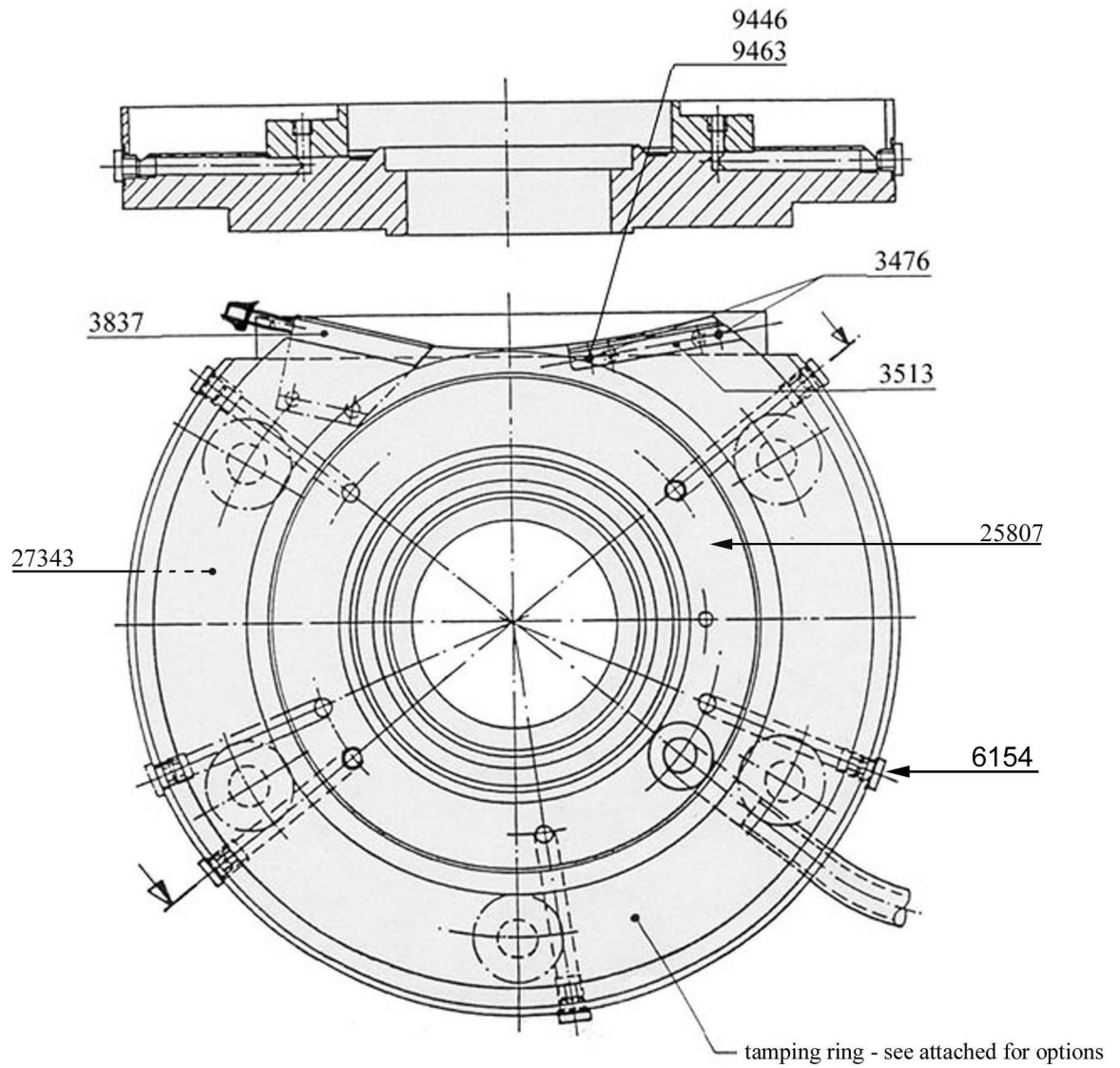
Section 21: segment top cam



Section 21: top cam

IIM No.	Description
3402	CAM, SEGMENT, NEW STYLE (QUICK CHANGE)
27431	CAM, SEGMENT, NEW STYLE (QUICK CHANGE) with removable mouthpiece
25371	CAM, SEGMENT, OLD STYLE (4 BOLTS)
8253	CAM, SEGMENT, OLD STYLE (4 BOLTS), DUAL CLOSING
29403	CAM, SEGMENT, OLD STYLE (4 BOLTS), with removable mouthpiece
14476	HANDLE,LIFTING, TOP CAM
3895	SAFETY CAM, NEW STYLE
15264	SAFETY CAM, OLD STYLE

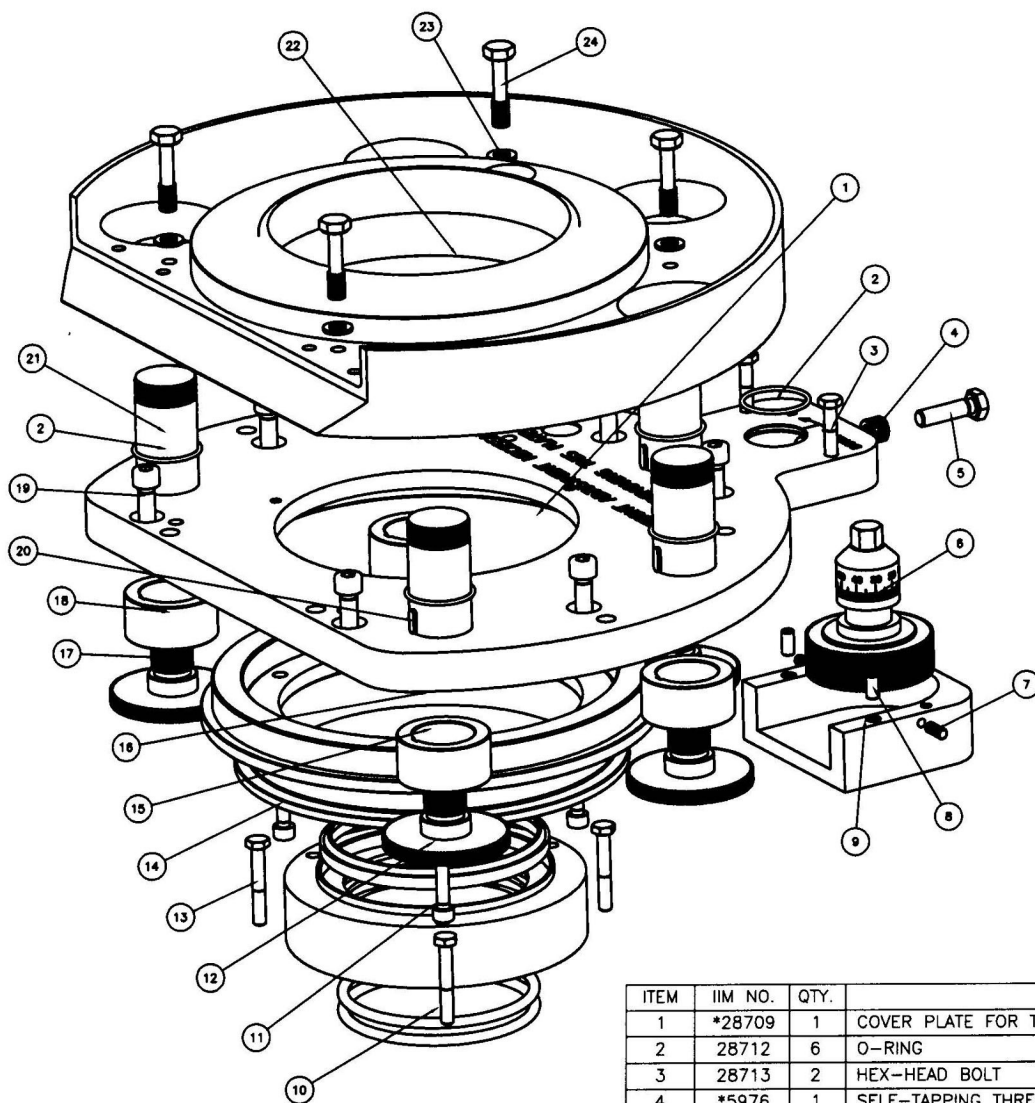
Section 22: tamping ring



Section 22: Tamping ring

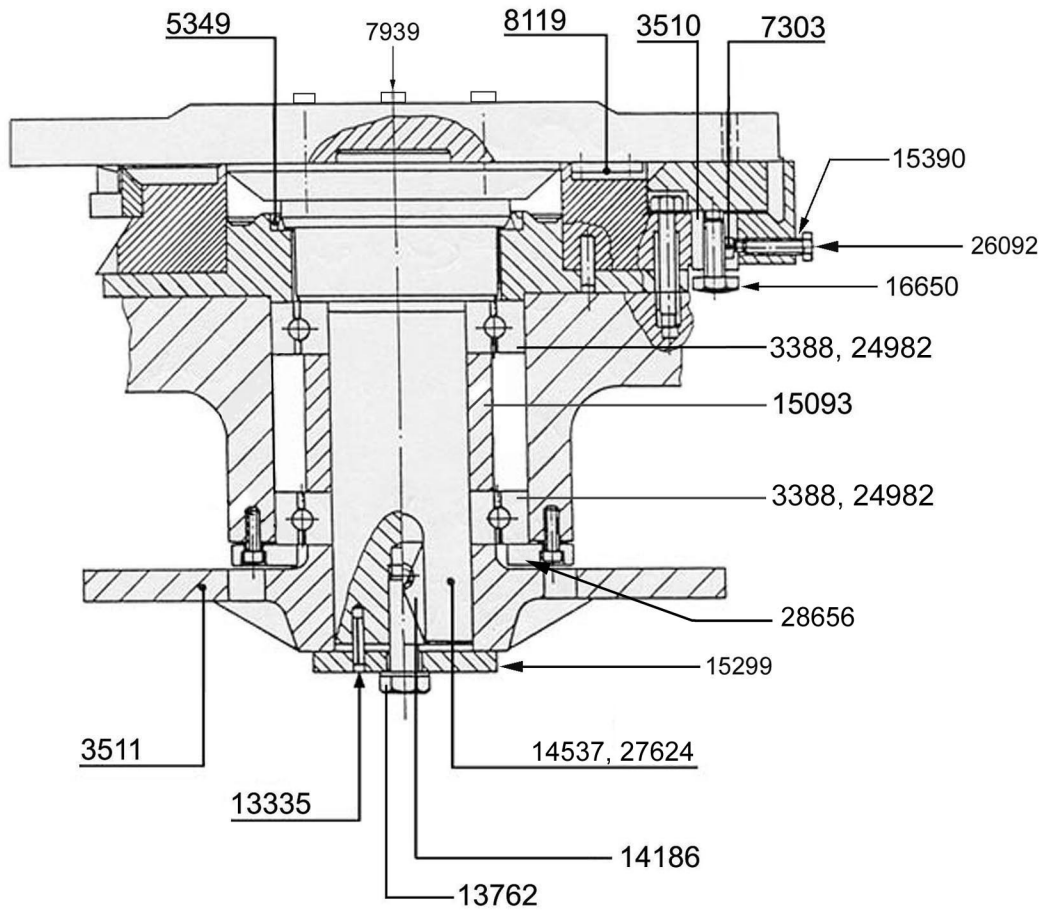
IIM No.	Description
3476	SPRING,COMPRESSION,FOR TAMPING RING
3513	SCRAPER (M3)
3837	DUST REMOVER, UNDER FILL RING
6154	PLUG,VACUUM
9446	SCREW, SOCKET HEAD CAP, M3
9463	SCREW, SOCKET HEAD CAP, M4
25807	COVER PLATE FOR VACUUM RING
27343	VACUUM RING
3281	TAMPING RING, BRONZE, PELLET
3514	TAMPING RING, BRONZE, POWDER
15826	TAMPING RING, BRONZE,ASSY
10170	TAMPING RING, FDA PLASTIC
24225	TAMPING RING, FDA PLASTIC,ASSY
26646	TAMPING RING, REWORK TO ACCEPT INSERT
26647	INSERT,PLASTIC,FOR MODIFIED TAMPING RING

Section 22.1: tamping ring support - IIM 2100

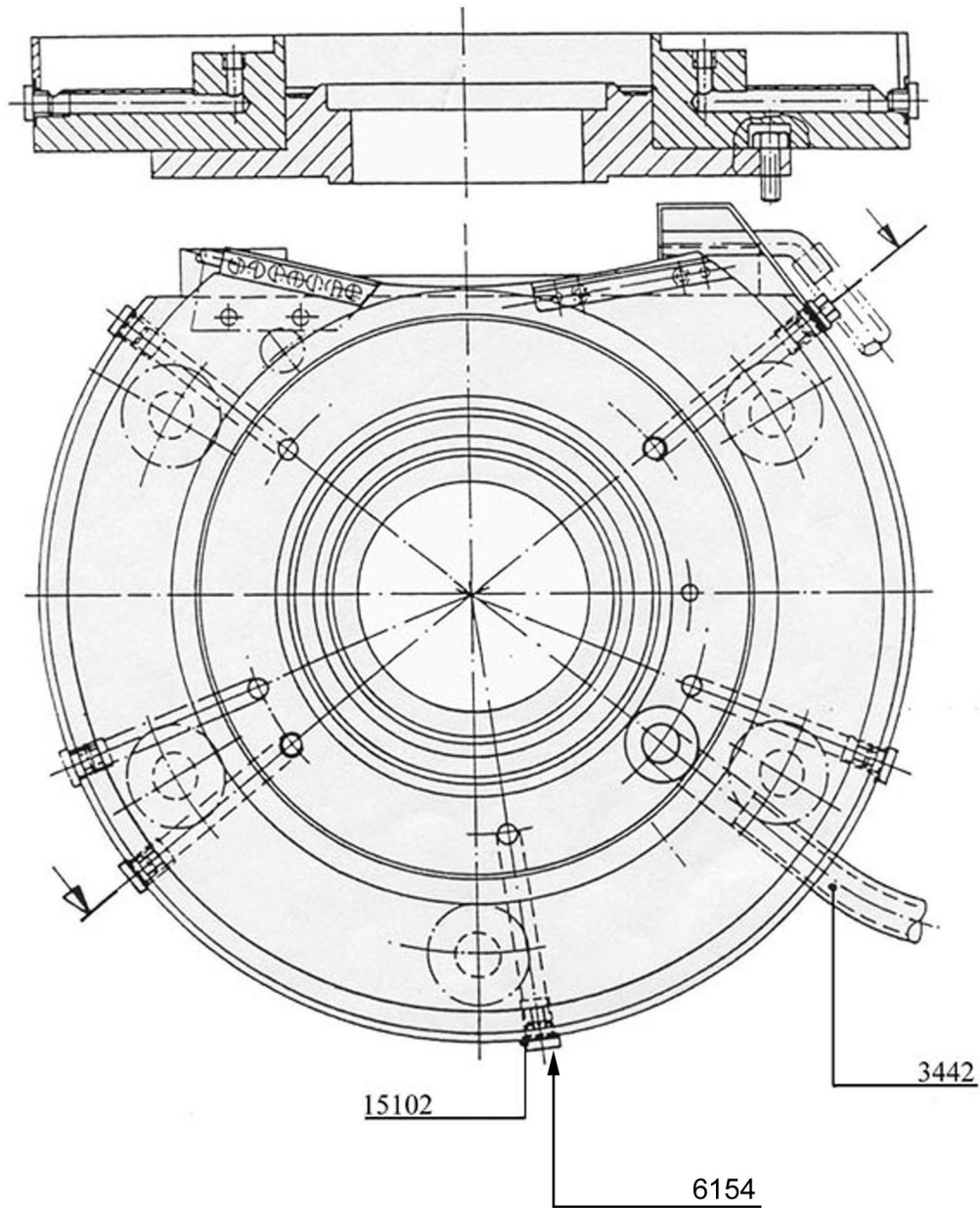


ITEM	IIM NO.	QTY.	DESCRIPTION
1	*28709	1	COVER PLATE FOR TAMPING HOUSING
2	28712	6	O-RING
3	28713	2	HEX-HEAD BOLT
4	*5976	1	SELF-TAPPING THREADED INSERT,M8,HS
5	4982	1	HEX-HEAD BOLT
6	28721	1	SPINDLE, GEAR, MASTER, ADJUSTMENT
7	26089	2	PLUNGER, M5, SST
8	*9270	2	PIN,DOWEL,6(M6)X12
9	28722	1	GEAR HOUSING FOR ADJUSTABLE TAMPING RING
10	28714	2	O-RING 87/97x5
11	28715	1	FLANGE
12	5349	1	SEAL, DOSING SHAFT
13	28716	3	HEX-HEAD BOLT
14	8025	3	CYLINDER HEAD CAP SCREW
15	28717	1	FLANGE
16	28723	1	SPUR GEAR
17	28724	5	SPINDLE, GEAR, THREADED, BRONZE
18	*28710	5	BUSHING
19	1151	6	CYLINDER HEAD CAP SCREW
20	28719	5	KEY 4X4
21	28725	5	BUSHING,THREADED,JACK SCREW
22	28718	1	HOUSING, TAMPING RING SUPPORT
23	28720	4	WASHER
24	28726	4	RETAINING SCREW, M8x35

Section 23.1: dosing disc drive

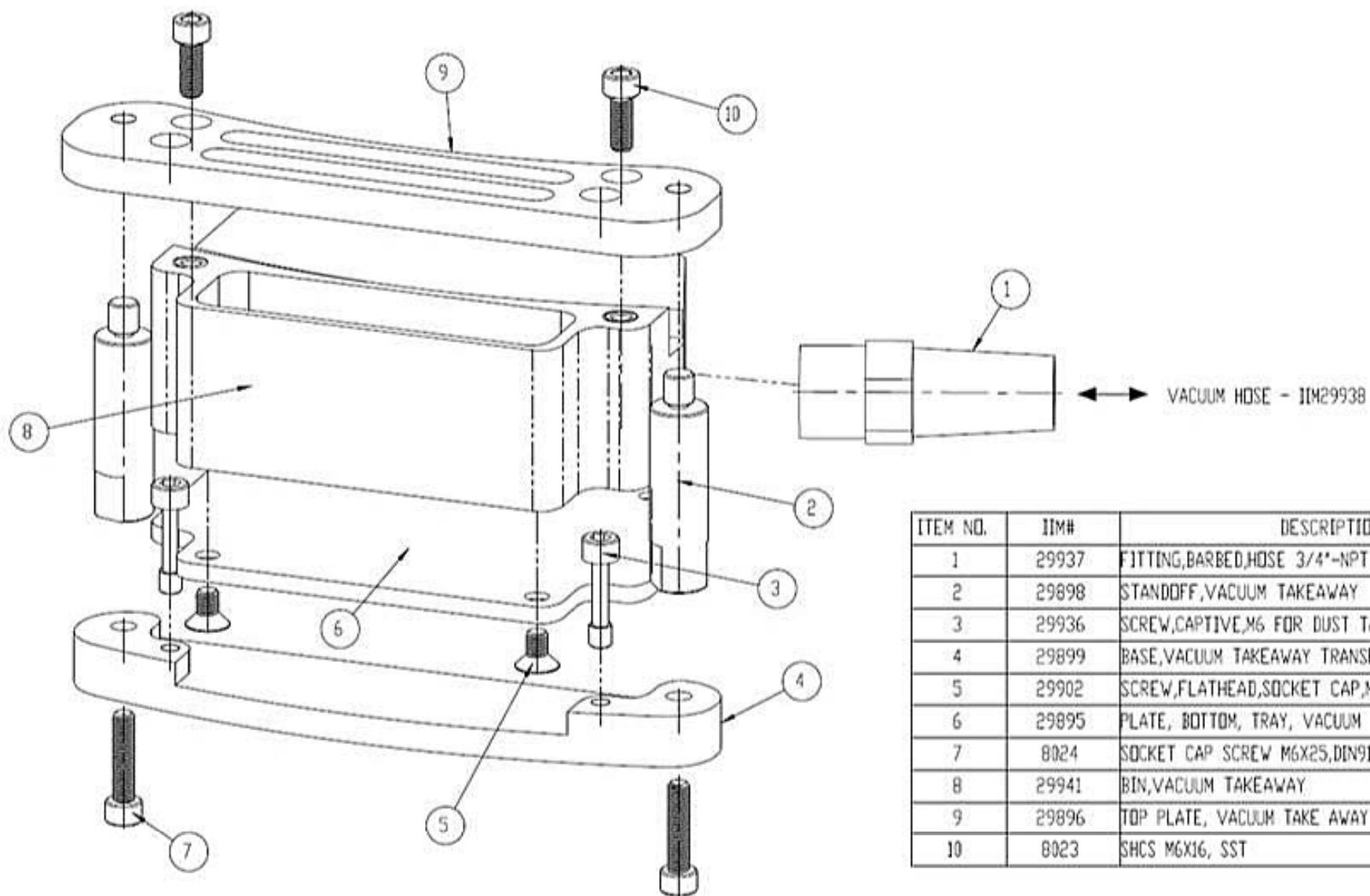


Section 23.2: dosing disc drive



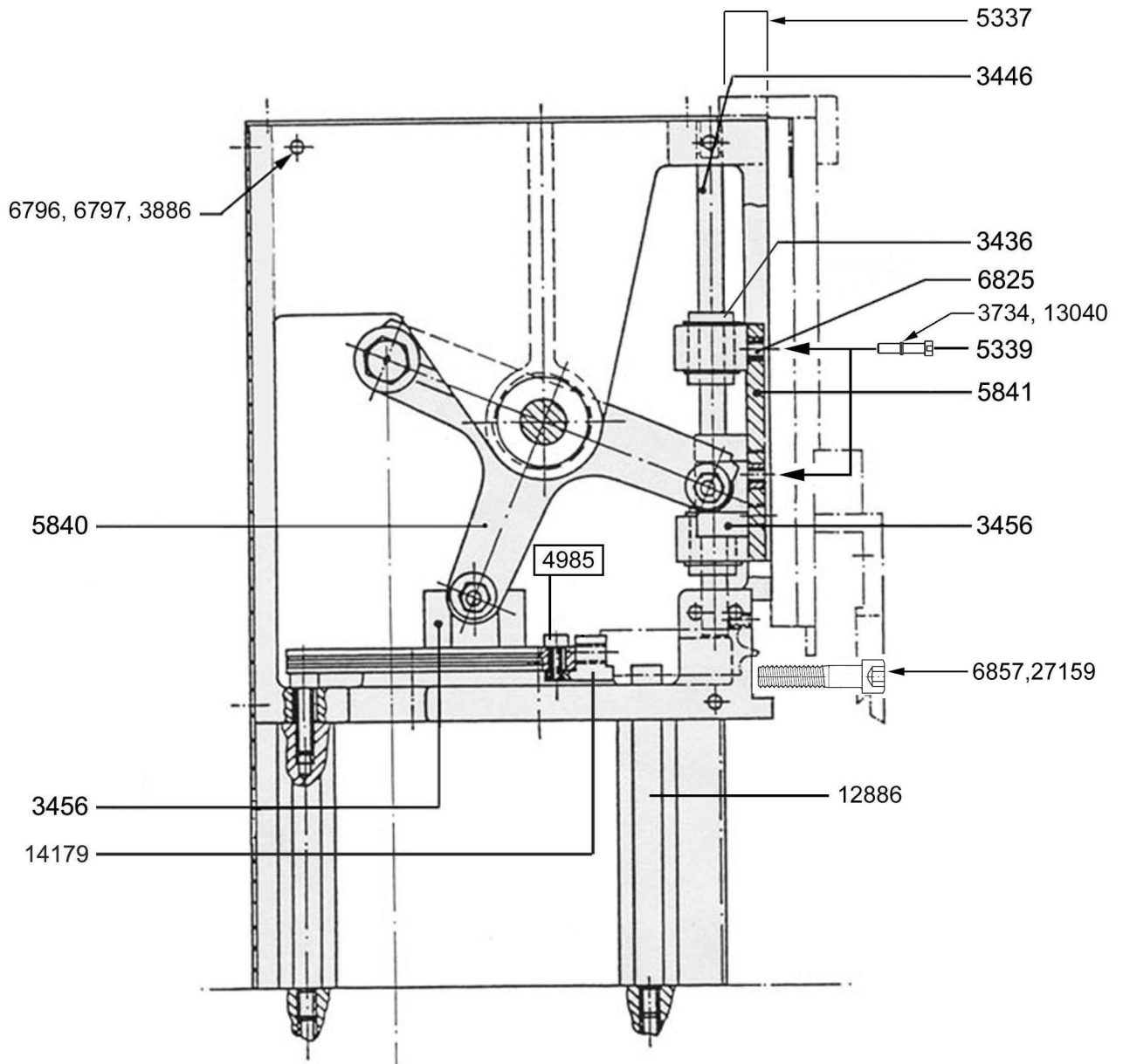
Section 23: Dosing disc drive

IIM No.	Description
3388	BEARING,BALL,DEEP GROOVE
3442	HOSE, DOSING RING
3508	SHAFT,MAIN,DOSING,BEVELED TOP,DIA 145
3510	BUSHING,THREADED - 5 PER MACHINE
3511	GENEVA,DOSING
5349	SEAL,DOSING SHAFT
6154	VACUUM PLUG
7303	THRUST MEMBER
7939	BOLT,DOSING DISC MOUNT
8119	KEY/SCRAPER,MOUNTED UNDER DOSING DISC
13335	PIN,SPRING,5 X 20
13762	BOLT
14186	KEY
14537	SHAFT,MAIN DOSING,(OLD STYLE)
15093	SPACER,INDEXING
15102	FLAT SEAL RING
15299	PLATE,CAPTURE,DOSING GENEVA
15390	THIN JAM NUT,HEX,M8
16650	SCREW,JACK/LEVELING,TAMPING RING - 5 PER MACHINE
24982	BEARING,BALL,DEEP GROOVE,UPGRADE
26092	CLAMPING SCREW
28656	BEARING CAPTURE PLATE

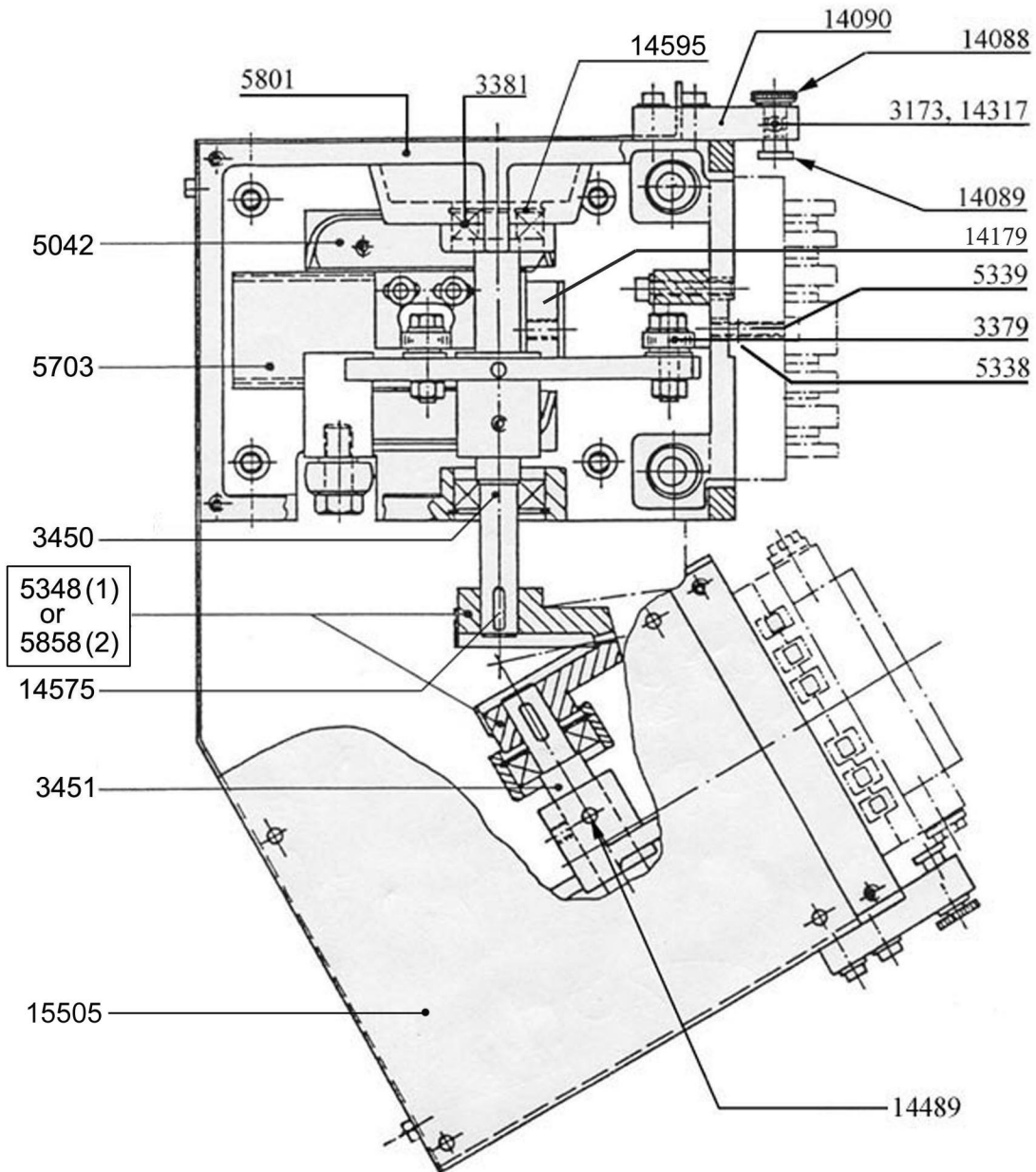


ITEM NO.	IIM#	DESCRIPTION	QTY.
1	29937	FITTING, BARBED, HOSE 3/4"-NPT S/S	1
2	29898	STANDOFF, VACUUM TAKEAWAY	2
3	29936	SCREW, CAPTIVE, M6 FOR DUST TAKEAWAY	2
4	29899	BASE, VACUUM TAKEAWAY TRANSFER STATION	1
5	29902	SCREW, FLATHEAD, SOCKET CAP, M6X10, SST	4
6	29895	PLATE, BOTTOM, TRAY, VACUUM	1
7	8024	SOCKET CAP SCREW M6X25, DIN912, SST	2
8	29941	BIN, VACUUM TAKEAWAY	1
9	29896	TOP PLATE, VACUUM TAKE AWAY	1
10	8023	SHCS M6X16, SST	2

Section 24.1: sorting device, magazine housings



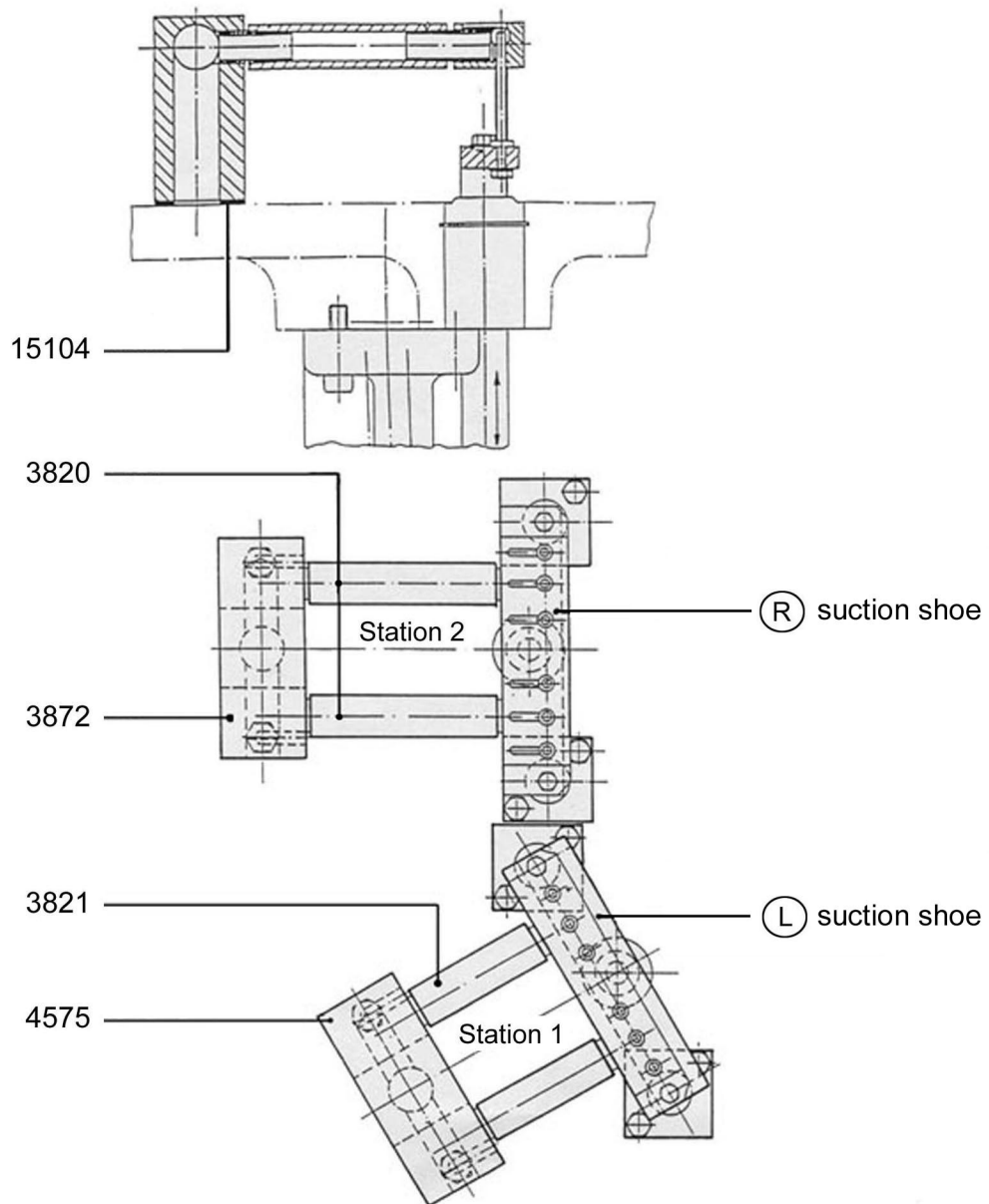
Section 24.2: sorting device, magazine housings



Section 24: Magazine housing components

IIM No.	Description
3173	ELASTIC PRESSURE PIECE,M6
3379	BEARING
3381	BEARING
3436	BEARING,LINEAR
3446	SHAFT,SORTING,SLIDING
3450	SHAFT,SORTING,RIGHT RECTIFIER DRIVE
3451	SHAFT,SORTING,LEFT RECTIFIER DRIVE
3456	GUIDE,BLOCK,MAGAZINE RECIPROCATOR
3886	NYLON WASHER,1/4 TURN FASTENER
4985	SCREW
5042	BALL GUIDE,5MM
5337	HEX BOLT FOR MOUNTING CAPSULE HOPPER
5338	RETAINING RING
5339	BOLT,MODIFIED,MAGAZINE HOLDER
5348	GEAR,BEVEL,CAPSULE SORTER - SEE 5858 FOR PAIR
5703	GUIDE RAIL
5801	FRAME/HOUSING,MAGAZINE,W/QUICK FASTENERS
5840	LEVER
5841	GUIDE,SLIDE,MAGAZINE MOUNTING BLOCK
5858	GEAR,BEVEL,CAPSULE SORTER,PAIR
6796	1/4 TURN SCREW
6797	1/4 TURN SOCKET
6825	INSERTS,THREADED, FOR MAGAZINES,S/S
6857	SCREW,SORTING BLOCK MOUNT
8249	HOUSING, MAGAZINE, COMPLETE, LEFT
8250	HOUSING, MAGAZINE, COMPLETE, RIGHT
9525	RING,RETAINING,INTERNAL
12886	SPACER BOLT
13040	E-CLIP FOR 5339
14088	NUT,KNURLED
14089	BOLT
14090	SUPPORT BLOCK
14179	MOUNT BLOCK,SORTING FINGER
14317	PIECE,ELASTIC PRESSURE,OLD STYLE,M8
14489	TAPERED PIN
14953	RETAINING RING
15505	GUARD SET, 5 PIECE
27159	SCREW,SORTING BLOCK MOUNT,W/INTEGRAL WASHER

Section 25.1: capsule separation

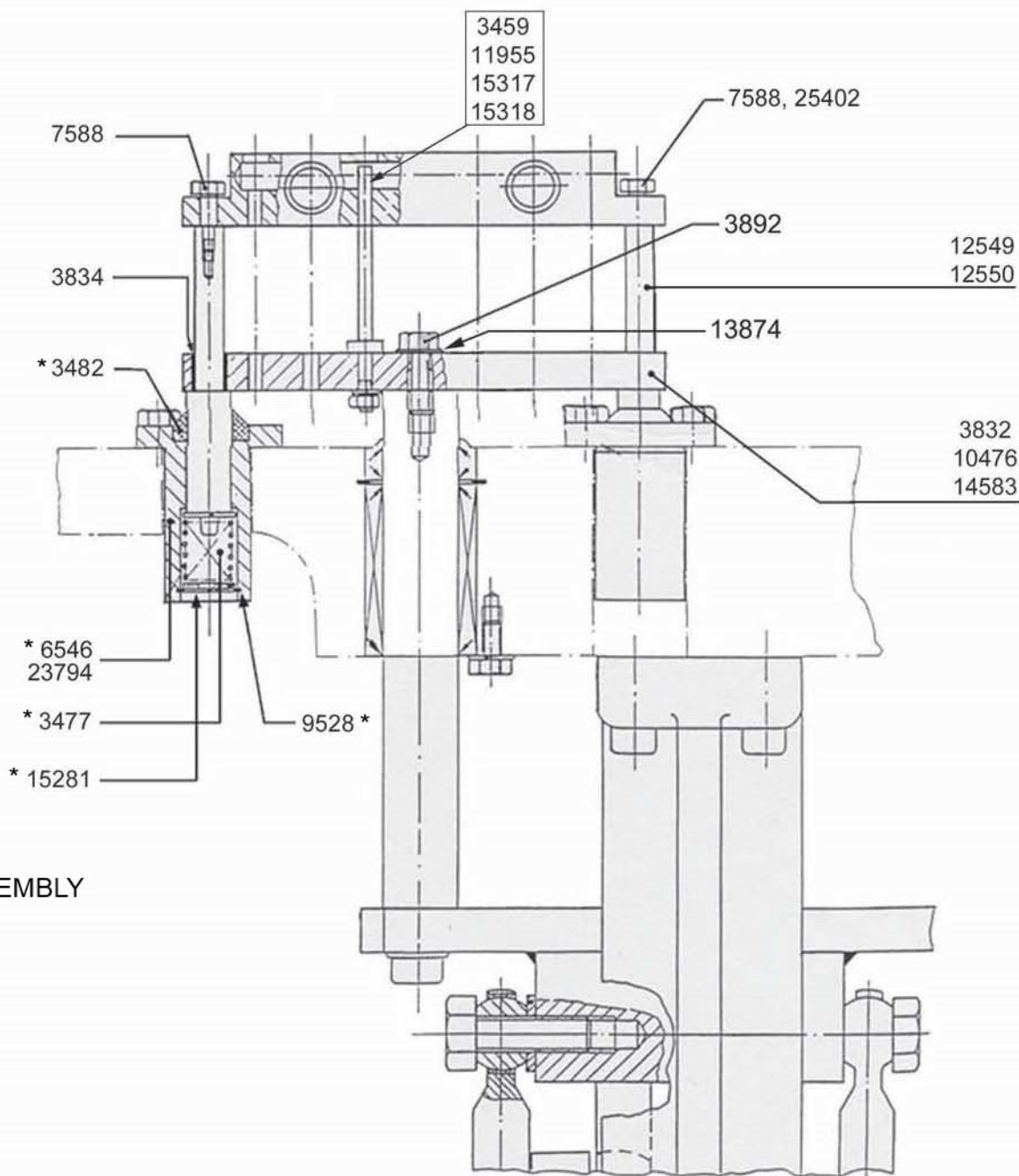


Section 25.1: capsule separation

Hose, vacuum tube, 91mm	3820
Hose, vacuum tube, 84mm	3821
Manifold, vacuum, right	3872
Manifold, vacuum, left	4575
Seal	15104
Seal, green	6987

	std	plastic	sealed	w/star	no holes
Suction shoe, left, 12ct	3457	26740	25772	11559	28652
Suction shoe, right, 12ct	3458	26741	25773	24567	28653
Suction shoe, left, 16ct	10489	25504	23724	27596	-
Suction shoe, right, 16ct	10488	25503	23723	27595	-

Section 25.2: capsule separation



*23793 ASSEMBLY

Section 25.2: Capsule separation

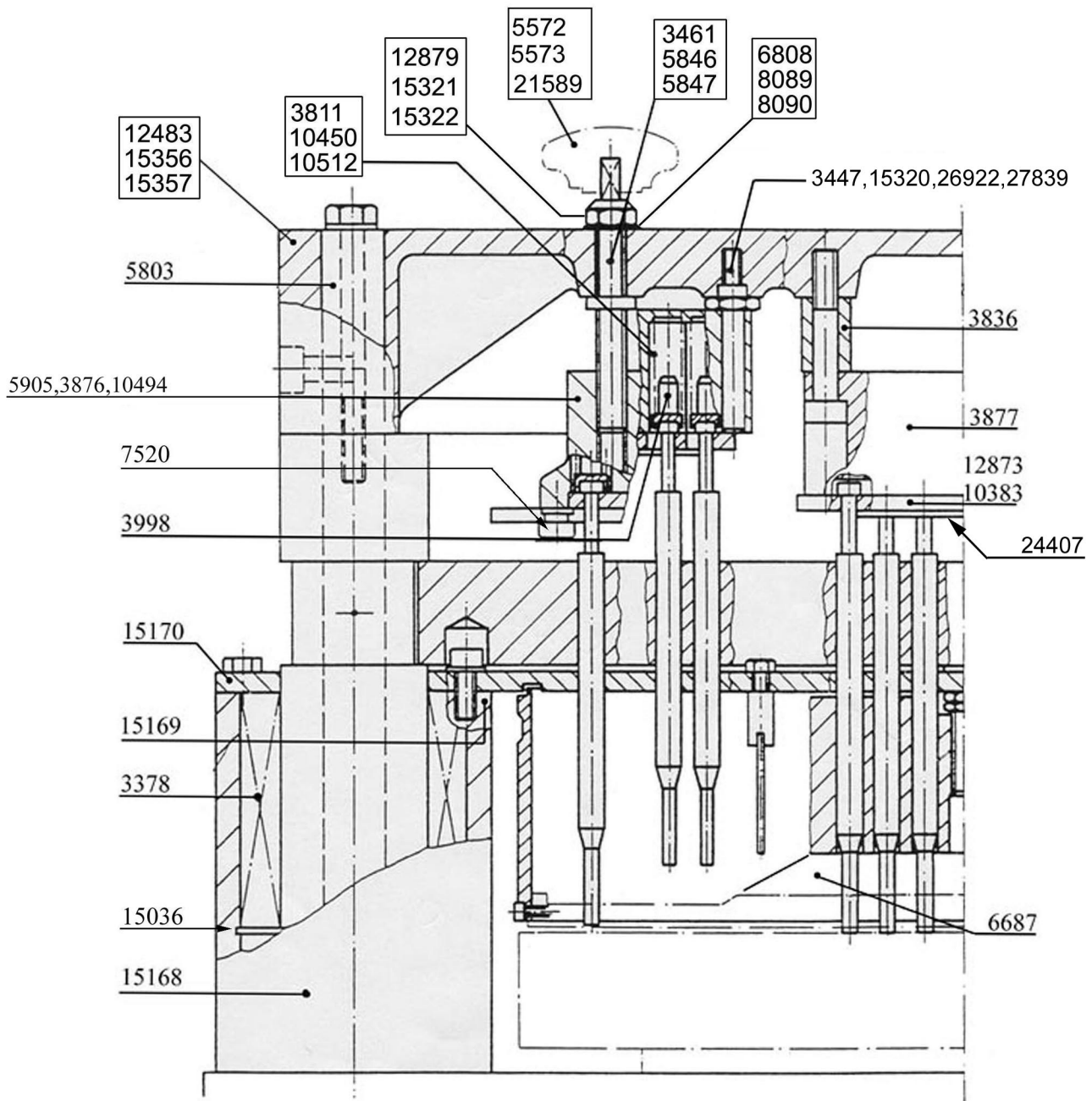
IIM No.	Description
3459	SEPARATION PIN, OLD STYLE, DOES NOT USE CAPTIVE NUT
3477	SPRING, COMPRESSION
3482	SCRAPER
3832	SEPARATION PLATE, NEW STYLE, 12 COUNT
3834	BUSHING, SPLIT
3892	BOLT M6X16
3892	SECURING BOLT, CAPTIVE
6546	BUSHING,BRONZE,SEPARATION COLUMN
7588	SHOULDER BOLT, GUIDE COLUMN, USE WITH 12549
9528	SNAP RING
10476	SEPARATION PLATE, NEW STYLE 16 COUNT
11955	SEPARATION PIN, NEW STYLE, USES CAPTIVE NUT
12549	GUIDE COLUMN, BOSCH VERSION
12550	GUIDE COLUMN, OLD STYLE, USES NUTS
13874	WASHER
14583	SEPARATION PLATE, OLD STYLE 12 COUNT
15281	WASHER
15317	PIN,SEPARATION,NEW STYLE,12 & 16 CT,57MM LONG,CONCAVE
15318	PIN,SEPARATION,OLD STYLE,12 CT,61MM LONG,CONCAVE
23794	BUSHING,PLASTIC,SEPARATION COLUMN
25402	SHOULDER BOLT,SLOTTED HEAD, GUIDE COLUMN, USE WITH 12549
* 23793 GUIDE COLUMN COMPLETE, BRONZE (ASSEMBLY OF 3477, 3482, 6546, 9528, 15281)	

Section 26: powder level sensor

IIM No.	Description
25100	Capacitive proximity sensor, powder level
28175	Cable, powder level sensor



Section 27: dosing device, tamping station

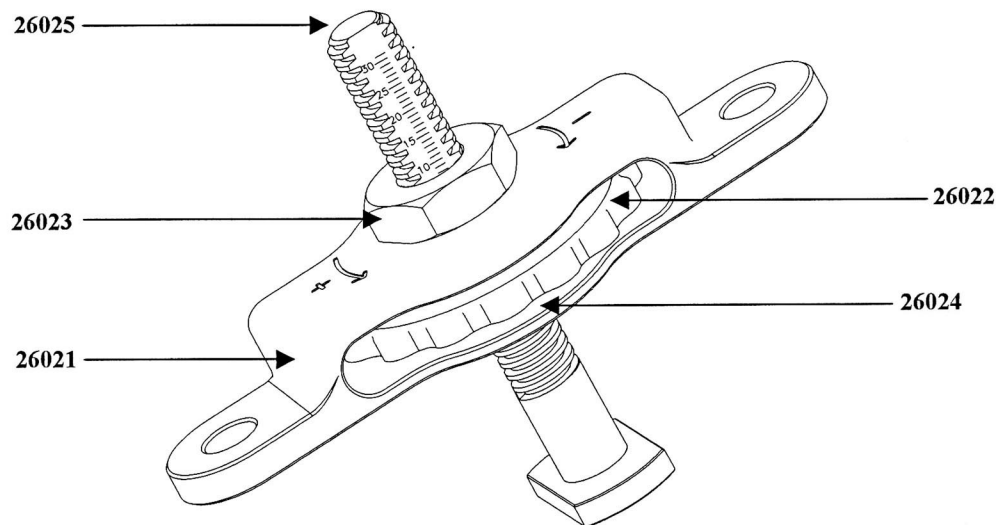


Section 27: Dosing device, tamping station

IIM No.	Description
3378	BEARING, LINEAR
3447	GUIDE, TAMPING PIN HOLDER, M8, Ø10MM, 71MM LONG
3461	SPINDLE, TAMPING PIN HOLDER, M8, NEW STYLE, comes with washer, nut, dowel, knob
3811	SPRING, COMPRESSION, TAMPING PIN, STIFF
3836	SPACER, FIXED TAMPING PIN HOLDER
3876	HOLDER, ADJUSTABLE, TAMPING, COMPLETE ASSY, 12CT, 48MM (5/machine)
3877	HOLDER, FIXED, TAMPING, COMPLETE, 12CT (1/machine)
3998	CAP, PLASTIC, TAMPING PIN
5572	STAR KNOB, M8, NEW VERSION
5573	STAR KNOB, M12, OLD VERSION
5803	SHAFT, TAMPER HEAD, RAISING, NEW STYLE
5846	SPINDLE, TAMPING PIN HOLDER, M12, OLD VERSION, square top
5847	SPINDLE, TAMPING PIN HOLDER, M10, OLD VERSION
5905	HOLDER, ADJUSTABLE, TAMPING, COMPLETE ASSY, 12CT, 60MM (5/machine)
6687	CONE, POWDER DISPERSEMENT
6808	WASHER, M8
8089	WASHER, M10
8090	WASHER, M12
10383	PLATE, COMPRESSION TAMPER PIN HOLDER, 16 COUNT
10450	SPRING, COMPRESSION, TAMPING PIN, MEDIUM STRENGTH
10494	HOLDER, ADJUSTABLE, TAMPING, COMPLETE ASSY, 16CT (5/machine)
10499	HOLDER, FIXED, TAMPING, COMPLETE, 16CT (1/machine)
10512	SPRING, COMPRESSION, TAMPING PIN, STIFF, S/S
12873	PLATE, COMPRESSION TAMPER PIN HOLDER, 12 COUNT
15036	SNAP RING
15168	BEARING BLOCK, TAMPING SHAFT
15169	SPACER BAR, W/ ALIGNMENT HOLE, FOR LEVEL SENSOR PLATE
15170	COVER PLATE, TAMPING COLUMN
15320	GUIDE, TAMPING PIN HOLDER, 115MM LONG, bronze guide ring
21589	KNOB, M10
26922	GUIDE, TAMPING PIN HOLDER, 84MM LONG, M10, OLD STYLE
27839	GUIDE, TAMPING PIN HOLDER, M10, Ø10MM, OLD STYLE
15321	NUT, M8, W/NYLON INSERT, NEW STYLE
15322	NUT, M10, W/NYLON INSERT, OLD STYLE
12879	NUT, M12, W/NYLON INSERT, OLD STYLE
12483	TAMPING HEAD, M8
15356	TAMPING HEAD, M10
15357	TAMPING HEAD, M12

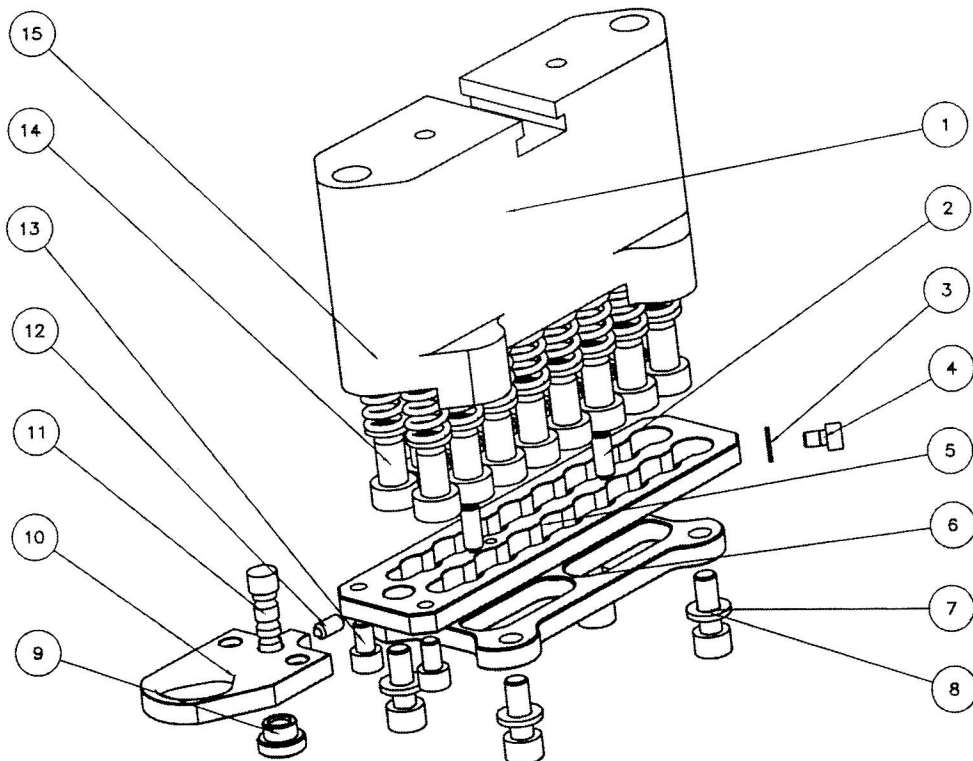
Section 27.1: new style 16 count tamping block adjustment mechanism

IIM No.	Description
10497	ASSEMBLY
26021	BRACKET
26022	ADJUSTMENT WHEEL
26023	NUT
26024	BRASS WASHER
26025	SPINDLE

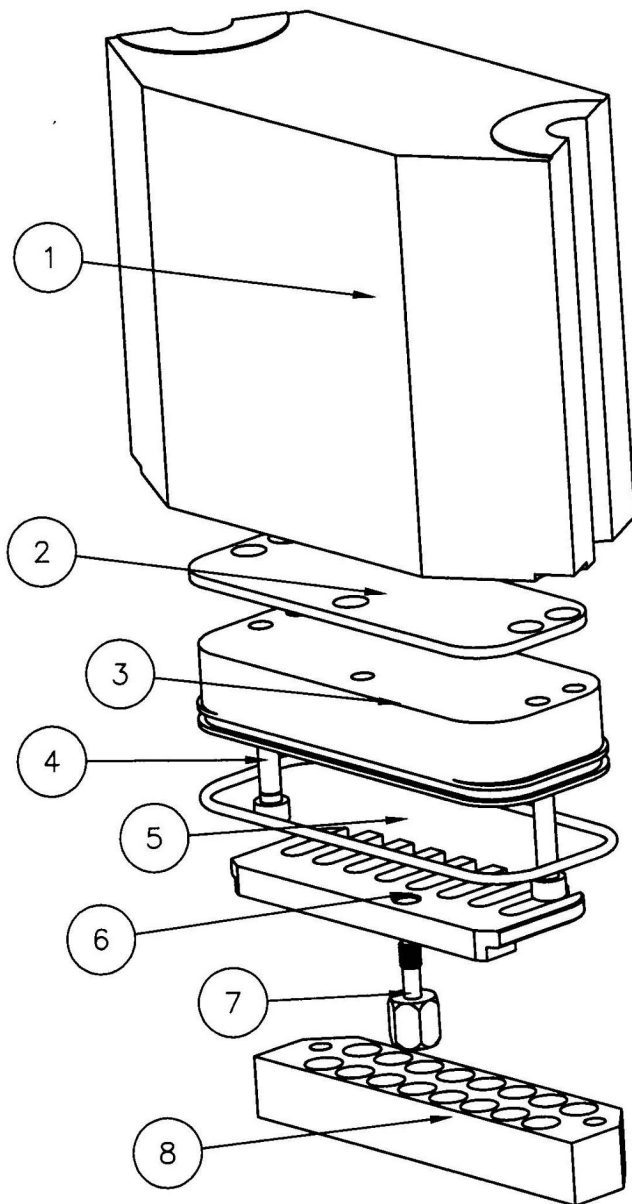


Section 27.2: new style 16 count tamping block

Pos.	Description	IIM no.	Qty
-	ASSEMBLY	10494	1
1	BLOCK	25849	1
2	PLUNGER, SPRING	26089	2
3	WASHER	8088	1
4	SCREW	12151	1
5	SLIDE PLATE, TAMPING PIN HOLDING	25850	1
6	PLATE, RETAINING, SLIDE PLATE	25854	1
7	WASHER	3734	4
8	BOLT	989	4
9	KNOB, PIN, LOCKING, SLIDE PLATE	25853	1
10	PLATE, PULL RING, SLIDE PLATE	25851	1
11	PIN, LOCK, SLIDE PLATE	25852	1
12	PLUNGER, SPRING	26087	1
13	SCREW, SOCKET HEAD CAP	9460	2
14	CAP, PLASTIC, TAMPING SPRING	3998	16
15	SPRING, TAMPING	3811	16

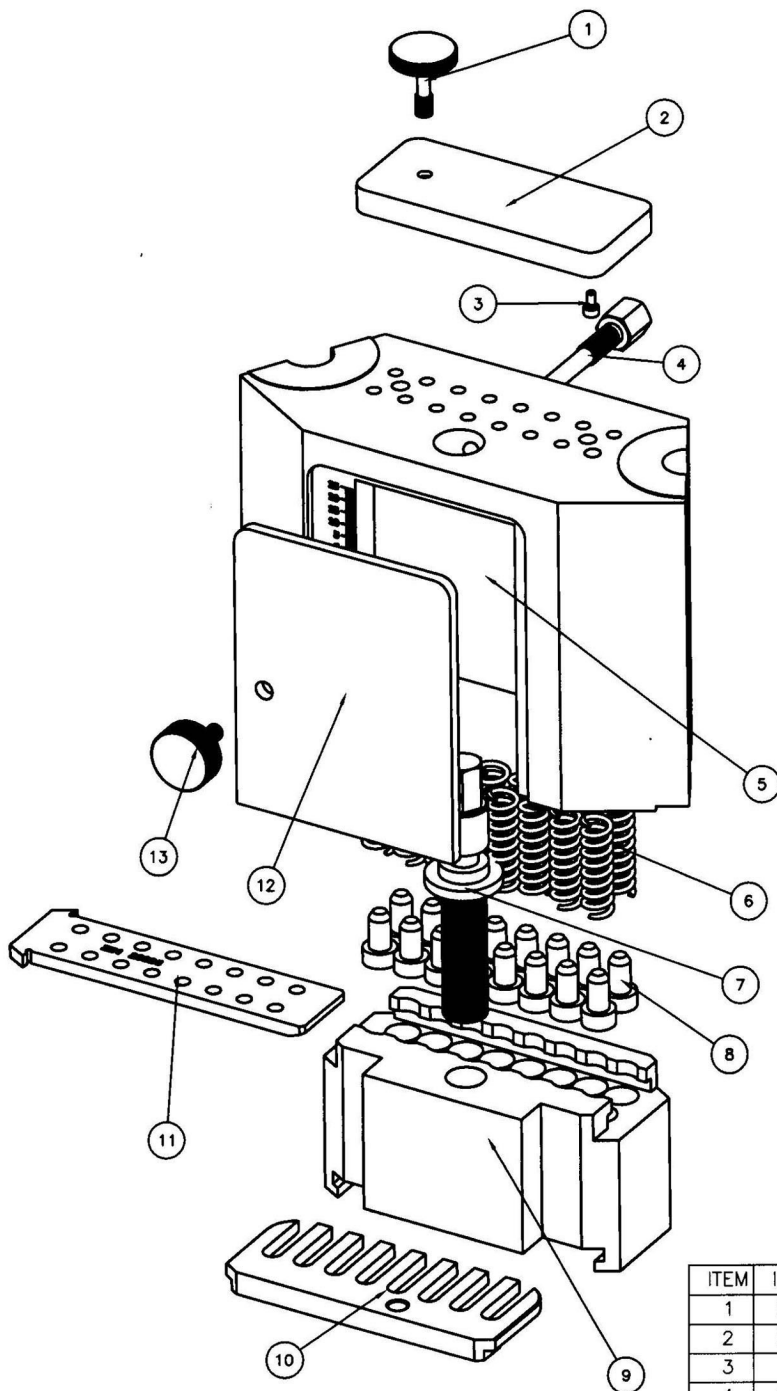


Section 27.3: fixed/transfer tamping block - IIM 2100



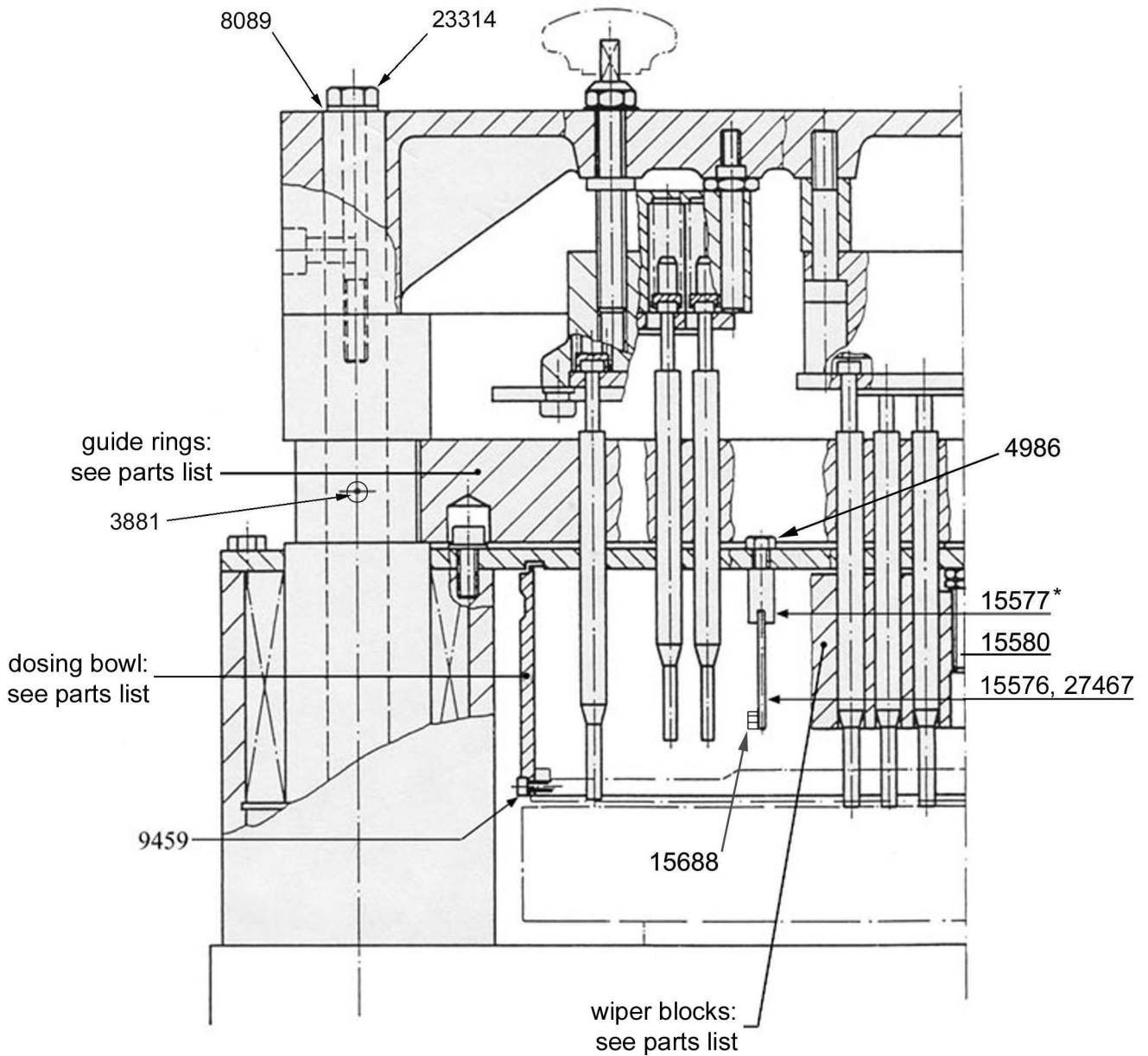
ITEM	IIM NO.	QTY.	DESCRIPTION
1	28796	1	BLOCK,TRANSFER,FIXED,1600/2100,ASSY
2	28795	1	SHIM
3	28793	1	BLOCK,TAMPING,TRANSFER,16CT
4	8025	2	CYLINDER HEAD CAP SCREW
5	28791	1	O-RING
6	28790	1	PLATE,RETAINING FINGER,16CT
7	13561	1	BOLT,RETAINING FINGER PLATE,18CT
8	28789	1	GUIDE,UPPER,TRANSFER BLOCK,16CT

Section 27.4: adjustable tamping block - IIM 2100



ITEM	IIM NO.	QTY.	DESCRIPTION
1	28838	1	CAPTIVE KNURLED KNOB
2	28837	1	COVER PLATE
3	9452	1	CYLINDER HEAD CAP SCREW
4	28863	1	SCREW, RETAINING, TAMPING BLOCK
5	28848	1	HOUSING, TAMPING BLOCK, IIM 1600/2100
6	10512	16	SPRING, COMP, TAMPING, HARD, STR
7	28840	1	GUIDE, BOLT, TAMPING HEAD, IIM1600
8	3998	16	CAP, PLASTIC, PIN, TAMPING
9	28842	1	BLOCK, TAMPING, 16CT
10	28790	1	PLATE, RETAINING, FINGER, 16CT
11	28836	1	PLATE, TOP, TAMPING, BLOCK
12	28845	1	PLATE, SIDE, TAMPING BLOCK
13	28830	1	KNURLED KNOB

Section 28: tamping guide ring

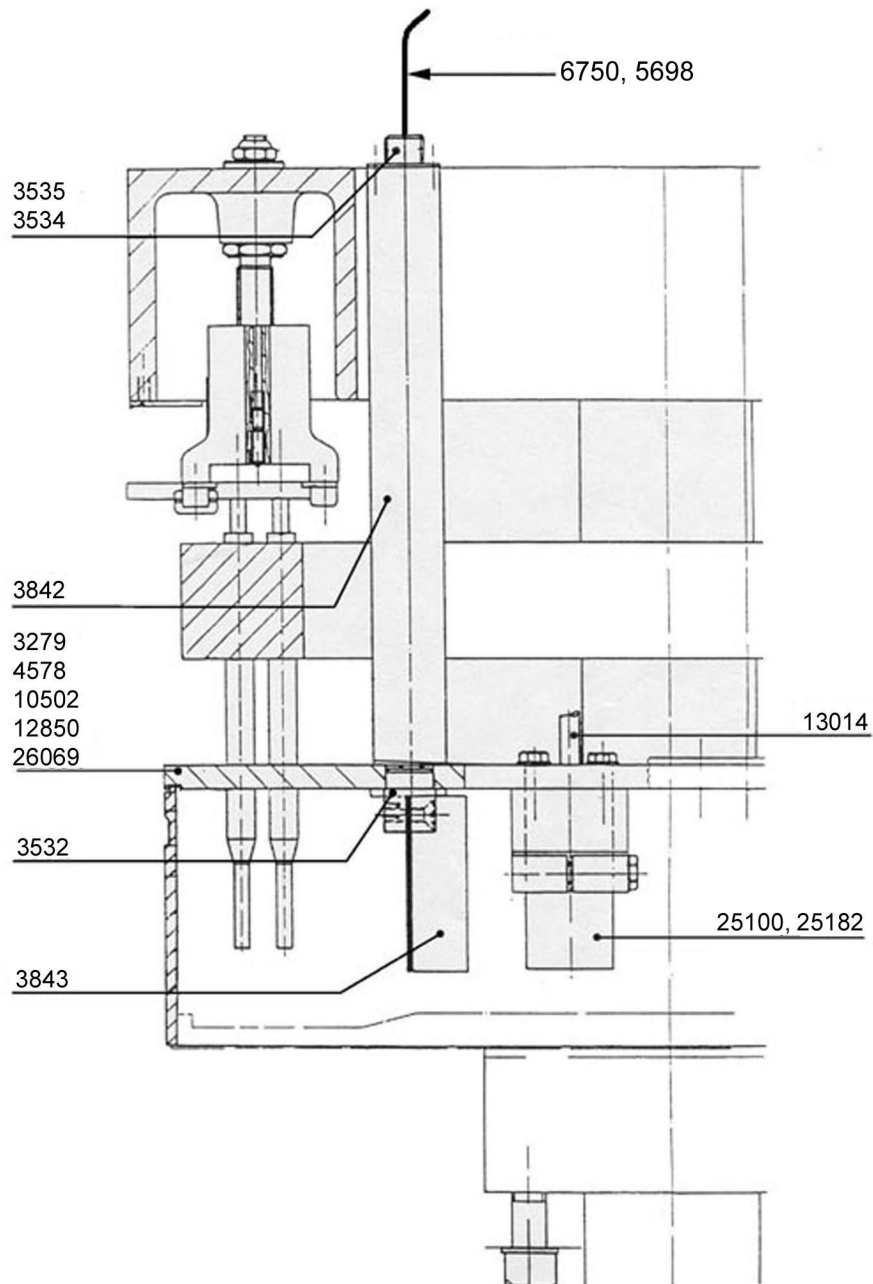


* IIM p/n 15577 includes 1 ea. 15688, 4986 and 15576.

Section 28: Tamping guide ring and surrounding parts

IIM No.	Description
3881	CAPTIVE BOLT FOR GUIDE RING MOUNT
4986	SCREW, TOP OF STUD 15577
8089	WASHER,M10,TAMPING HEAD MOUNT
9459	SCREW, SOCKET HEAD CAP
12880	GUIDE,15MM,OLD STYLE,BRONZE GUIDE RING
12881	GUIDE,10MM,NEW STYLE
15321	NUT,LOCK,WIPER BLOCK GUIDES,M8
15576	PLATE,POWDER MIXING
15577	STUD,MOUNT FOR POWDER LEVELER/MIXER PLATE,DOSING BOWL
15580	SCREW,ASSEMBLY,TRANSFER/WIPER BLOCK ADJUSTMENT
15688	SCREW,ATTACHES STUD 15577 TO PLATE 15576
23314	BOLT,TAMPING HEAD MOUNT
27467	POWDER MIXER/STIRRER
3280	GUIDE RING, 12 CT, ALUMINUM
16382	GUIDE RING, 12 CT, BRONZE
25189	GUIDE RING, 12 CT, BRONZE, WITH PLASTIC INSERTS
5347	GUIDE RING, 12 CT, BRONZE, REFURB
16411	GUIDE RING, 12 CT, REFURBISHED, BUSHINGS TO BUSHINGS
5570	GUIDE RING, 12 CT, STANDARD, REFURBISHED
8469	GUIDE RING, 12 CT, STANDARD, REWORKED W/SCRAPERS
3500	GUIDE RING, 12 CT, UPGRADED W/SCRAPERS & BUSHINGS
8125	GUIDE RING, 12 CT, W/BUSHINGS & SCRAPERS, REFURBISHED TO SAME
25381	GUIDE RING, 12 CT,W/BUSHINGS ONLY
24700	GUIDE RING, 16 CT, REFURB BUSHINGS
24968	GUIDE RING, 16 CT, REFURB, ADD BUSHINGS
10475	GUIDE RING, 16 CT, STANDARD
24918	GUIDE RING, 16 CT, WITH BUSHINGS
13091	GUIDE RING, 16 CT, WITH BUSHINGS & SEALS
27623	BOWL,DOSING,350MM OD X 104MM HIGH
5350	BOWL,DOSING,350MM OD X 105MM HIGH
7299	BOWL,DOSING,350MM OD X 104.5MM HIGH
15579	BOWL,DOSING,350MM OD X 89MM HIGH
12947	WIPER BLOCK,12 CT,ALUM,10MM GUIDES,61MM TALL,FOR ADJ DOS DISC
12878	WIPER BLOCK,12 CT,ALUM,15MM GUIDES,55MM TALL
15077	WIPER BLOCK,12 CT,ALUM,BUSHED/SEALED,10MM GUIDES,60MM TALL
3841	WIPER BLOCK,12 CT,ALUM,NEW STYLE,61MM TALL,10MM GUIDES
16083	WIPER BLOCK,12 CT,ALUM,WINGED BOTTOM,10MM GUIDES
16082	WIPER BLOCK,12 CT,ALUM,WINGED BOTTOM,12MM GUIDES
16081	WIPER BLOCK,12 CT,ALUM,WINGED BOTTOM,W/SPR. HOLES,10MM GUIDES
6950	WIPER BLOCK,12 CT,PLASTIC,10MM GUIDES,FOR ALUM GUIDE RING
6946	WIPER BLOCK,12 CT,PLASTIC,FOR BRONZE GUIDE RING
11956	WIPER BLOCK,16 CT,COATED AL,10MM GUIDES,61MM TALL
12053	WIPER BLOCK,16 CT,AL UPPER/PET SHOE AND FEET
16705	WIPER BLOCK,16 CT,INDEX
10503	WIPER BLOCK,16 CT,PLASTIC,ADJUSTABLE DISC

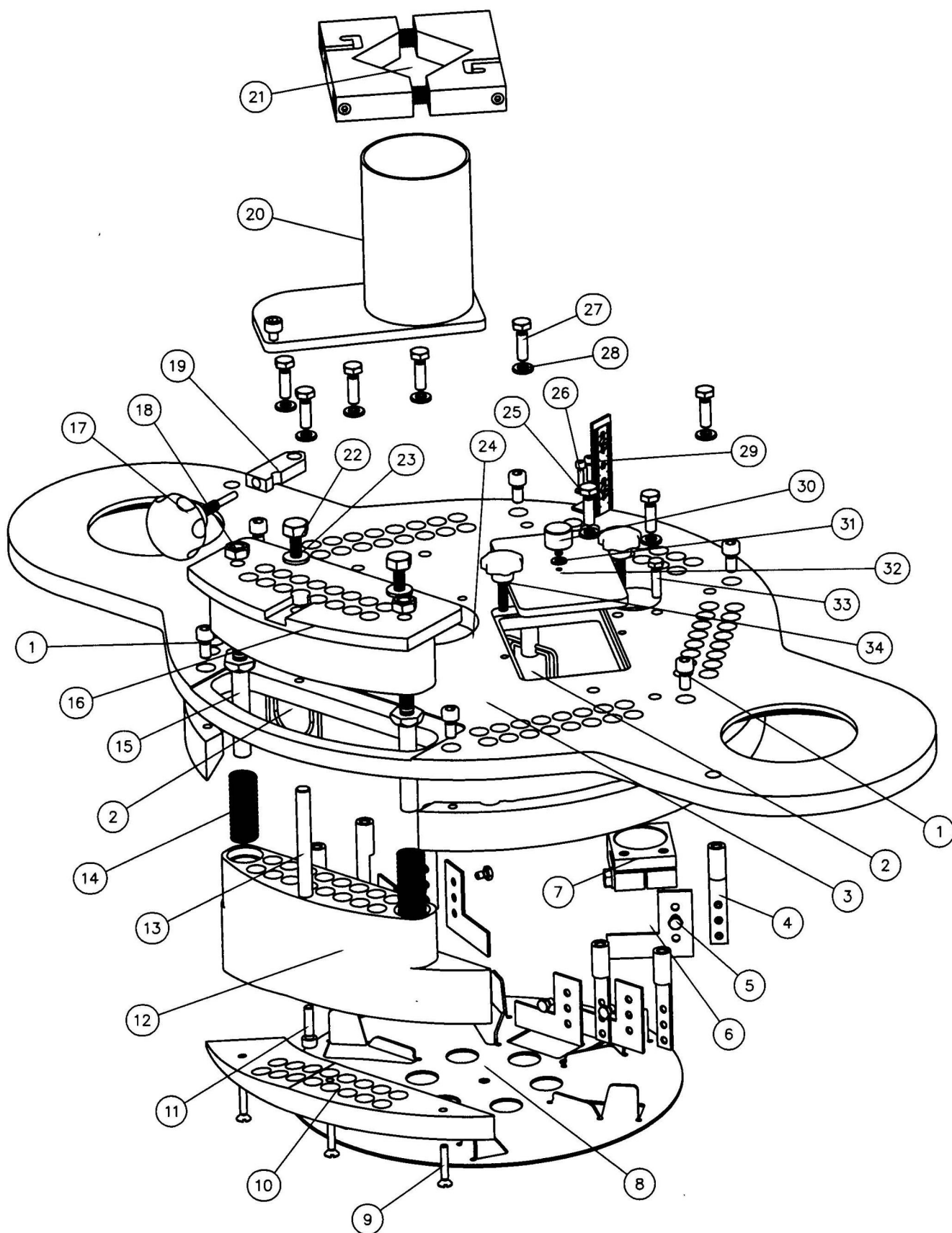
Section 29: powder level sensing



Section 29: Powder level sensing

IIM No.	Description
3532	PLASTIC SLEEVE
3534	CONNECTOR,FEMALE
3535	PLUG,VHF,MALE
3683	ENT6 UNIT, 230 VOLT VERSION
3842	TUBE,SENSOR
3843	PLATE,LEVEL SENSOR,CURVED
3882	COVER,ACRYLIC,LEVEL SENSOR PLATE
5698	CABLE,COAXIAL,OLD STYLE,SINGLE WIRE
6750	CABLE,COAXIAL,NEW STYLE
13014	CABLE, FOR POWDER LEVEL BARREL SENSOR IIM 3088
25100	PROXIMITY SWITCH
25182	ENT ELIMINATOR KIT
3279	LEVEL SENSOR PLATE,12 COUNT
4578	LEVEL SENSOR PLATE,12 COUNT,COMPLETE ASSY, for ENT6 system
26069	LEVEL SENSOR PLATE,12 COUNT,COMPLETE ASSY, new style for prox powder sensing system
10502	LEVEL SENSOR PLATE,16 COUNT
12850	LEVEL SENSOR PLATE,16 COUNT,INDEX

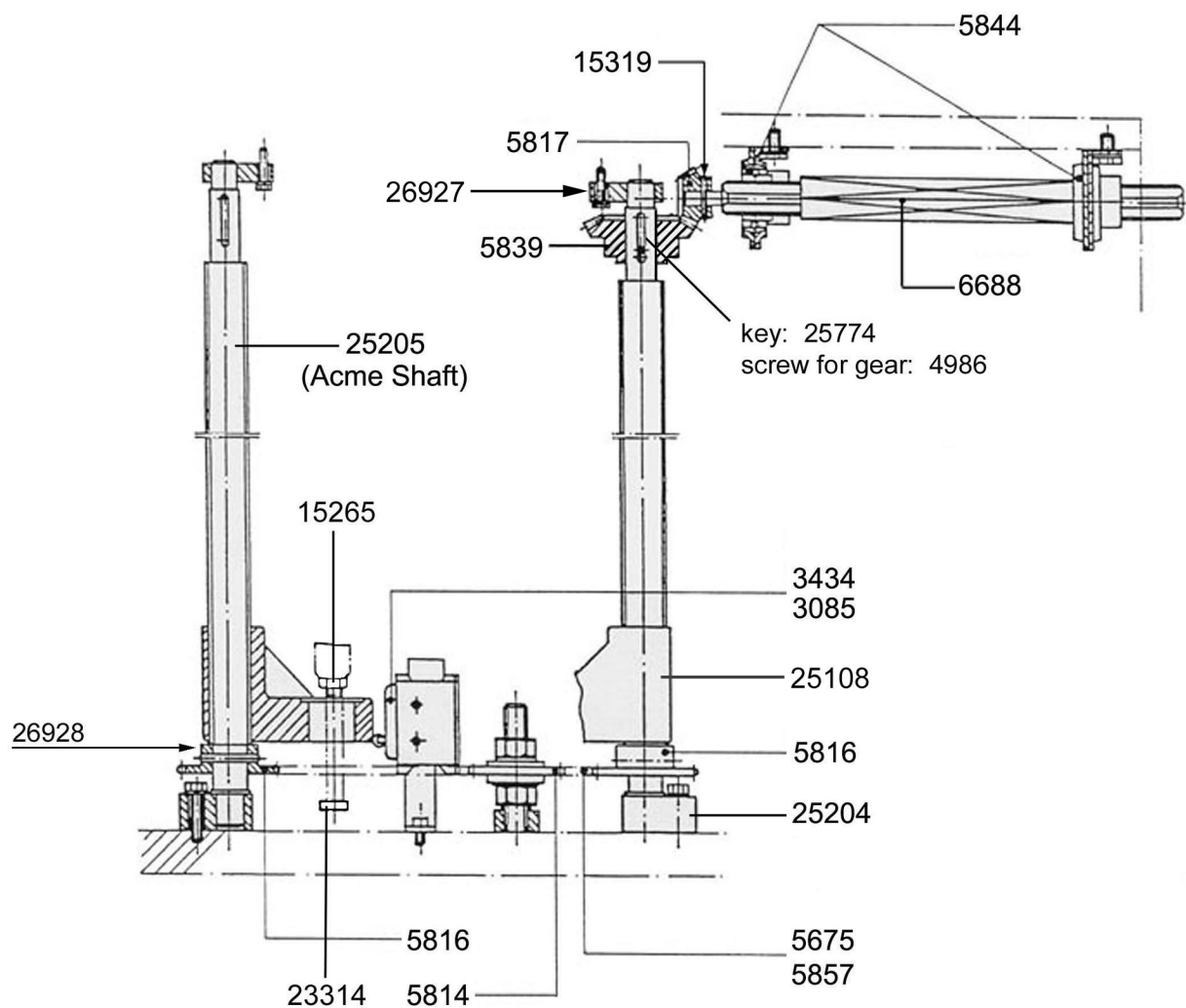
Section 29.1: powder level sensing - IIM 2100



Section 29.1: powder level sensing – IIM 2100

Pos	IIM No.	Qty	Description
1	28907	1	MOUNT, PROX SENSOR
2	15577	6	STUD, MOUNT
3	13852	6	SCREW, HEX HEAD
4	15576	6	PLATE, POWDER LEVEL
5	28263	1	WATERWHEEL
6	28908	1	BASE, DEFLECTOR
7	24523	3	SCREW, FLAT HEAD SLOTTED, NYLON
8	5273	1	SCREW, CYLINDER HEAD CAP
9	28909	1	WIPER BLOCK
10	28295	1	SHAFT
11	28298	2	SPRING
12	14500	2	WASHER
13	12881	2	GUIDE, 10MM
14	28910	1	PLATE, TOP
15	13563	1	KNOB, WIPER BLOCK
16	15569	2	LOCKNUT
17	13562	1	BRACKET
18	28885	1	TUBE
19	28913	1	HOLDER, PROX-POWDER
20	28911	2	BOLT
21	28912	1	COVER PLATE ASSY
22	28769	1	LEVEL SENSOR PLATE
23	8177	2	WASHER
24	9446	2	SCREW, SOCKET HEAD CAP
25	25161	1	SCALE
26	28914	1	KNOB, KNURLED
27	8088	1	WASHER
28	28915	1	COVER PLATE
29	14349	8	SCREW, HEX HEAD
30	6039	8	WASHER
31	7934	2	SCREW, HEX HEAD
32	27467	2	STIRRER, POWDER
34	29168	1	SKIRT, LEVEL SENSOR PLATE
35	4984	6	SCREW, SOCKET HEAD CAP

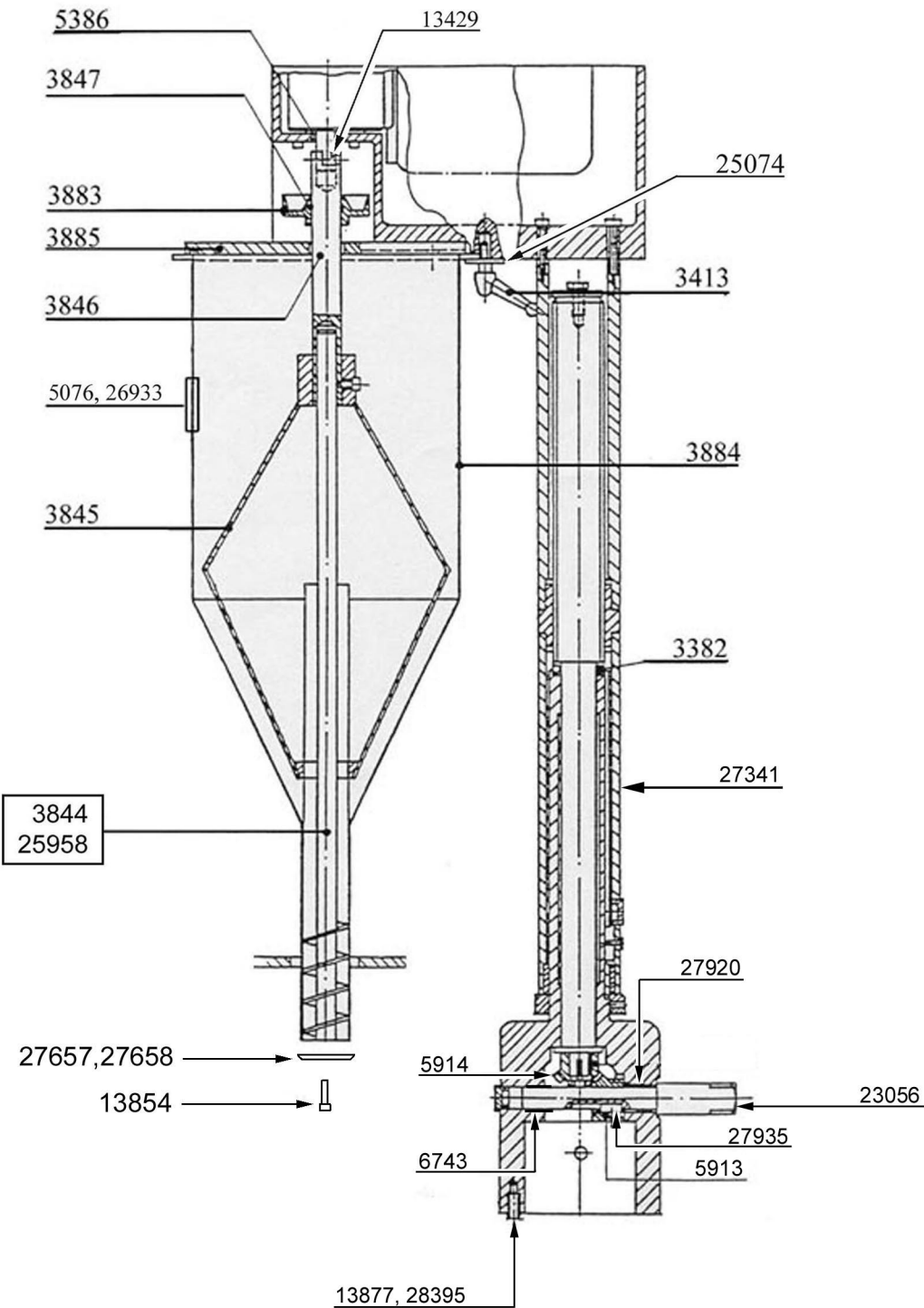
Section 30: lifting for dosing device



Section 30: Lifting for dosing device

IIM No.	Description
3085	SWITCH,MOTOR PROTECTIVE
3434	ROLLER,STARTING
4986	SCREW M6X16 FOR BEVEL GEAR 5839
5675	MASTER LINK, CHAIN
5814	WHEEL,CHAIN TENSIONING
5816	WHEEL,CHAIN
5817	GEAR,BEVEL
5839	GEAR,BEVEL
5844	PILLOW BLOCK BEARING
5857	CHAIN,ROLLER,SINGLE
6688	CRANK SHAFT
12331	HANDLE, CRANK SHAFT
15319	PIN,ROLL,3 X 30
25108	FOOT,TAMPING HEAD LIFTING
25204	BLOCK,VERTICAL TAMPING HEAD LIFT SHAFT,BOTTOM
25205	SHAFT,ACME THREADED
25724	KEY,ACME THREADED SHAFT
26927	BLOCK,VERTICAL TAMPING HEAD LIFT SHAFT,TOP
26928	SHIM,SPACER

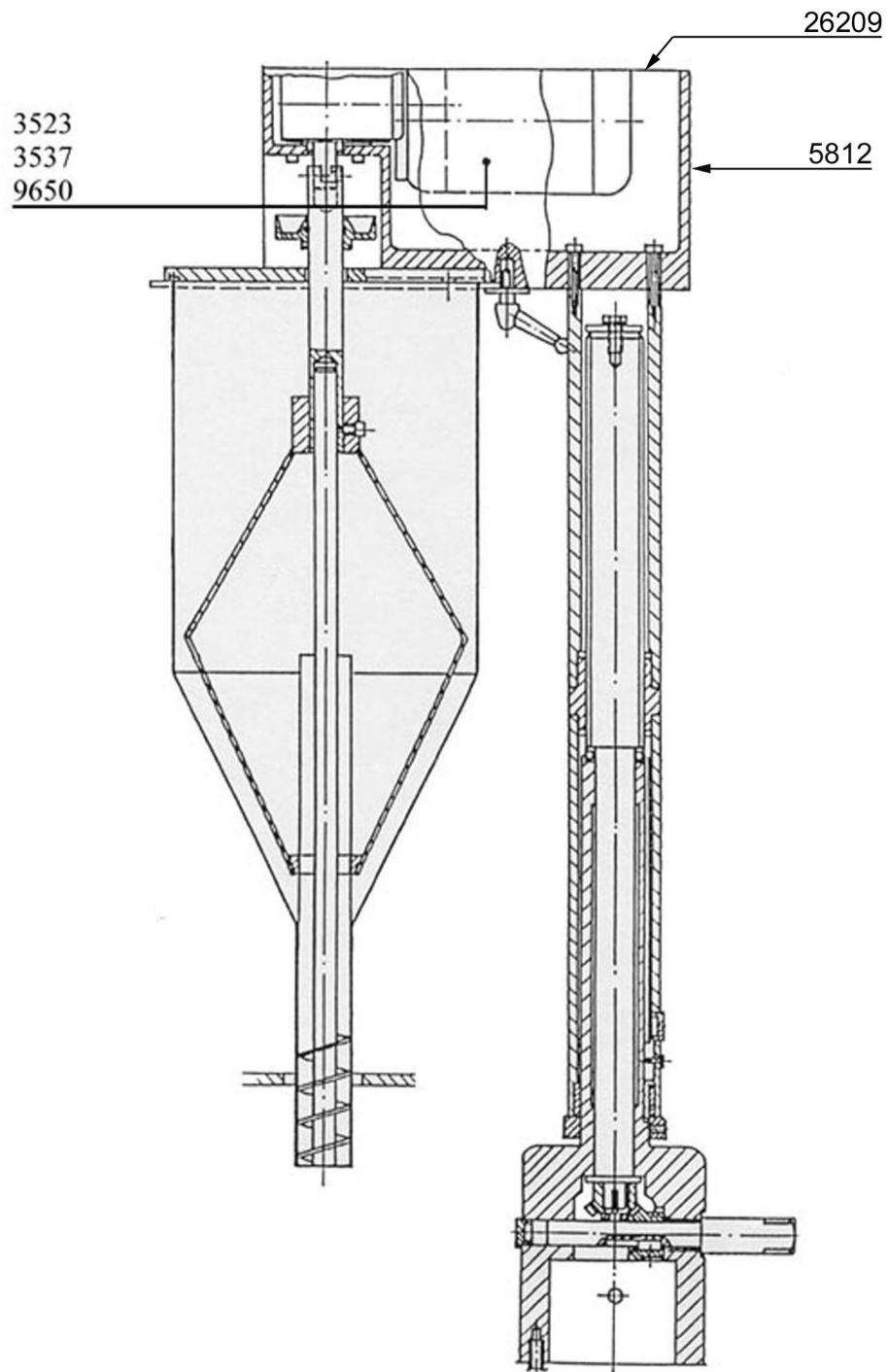
Section 31: powder infeed



Section 31: Powder infeed, vertical

IIM No.	Description
3382	BALL BEARING
3413	HANDLE,RATCHET
3844	AUGER, 13 TWIST,STANDARD
3845	STIRRER
3846	COUPLING
3847	O-RING
3883	CUP
3884	HOPPER,POWDER,W/SIGHT GLASS PORT
3885	COVER,HOPPER
5076	SIGHT GLASS,NO BOLT VERSION
5386	SEAL RING
5913	GEAR,BEVEL,HOPPER LIFT
5914	GEAR,BEVEL,HOPPER LIFT
13429	PIN,DOWEL,AUGER SHAFT LOCKING
23056	SHAFT
25074	WASHER,OVERSIZED,POWDER HOPPER
25958	AUGER, 8 TWIST, FASTER FEED
28395	SCREW,POWDER HOPPER LIFT HOUSING
13877	WASHER M12 SERRATED
26209	COVER, AUGER MOTOR HOUSING
26933	SIGHT GLASS,OLD STYLE
27341	COLUMN, POWDER HOPPER LIFT
27935	KEY

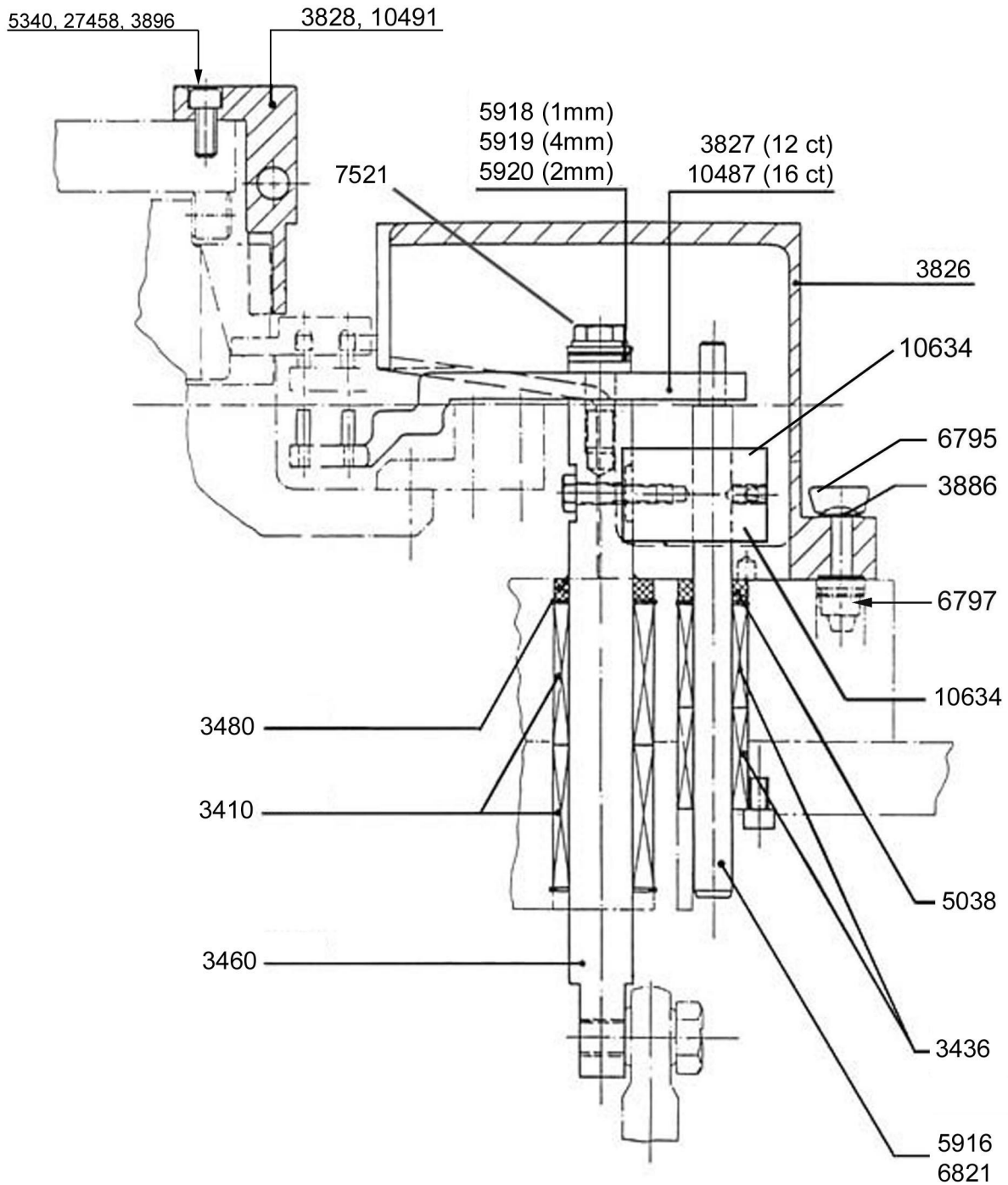
Section 32: powder infeed gearmotor



Section 32: Powder infeed gearmotors

IIM No.	Description
3523	MOTOR + GEARBOX, COMPLETE
3537	MOTOR ONLY,AGITATOR
5812	HOUSING
9650	MOTOR ONLY, 10% MORE HORSEPOWER
26209	GUARD, HOUSING

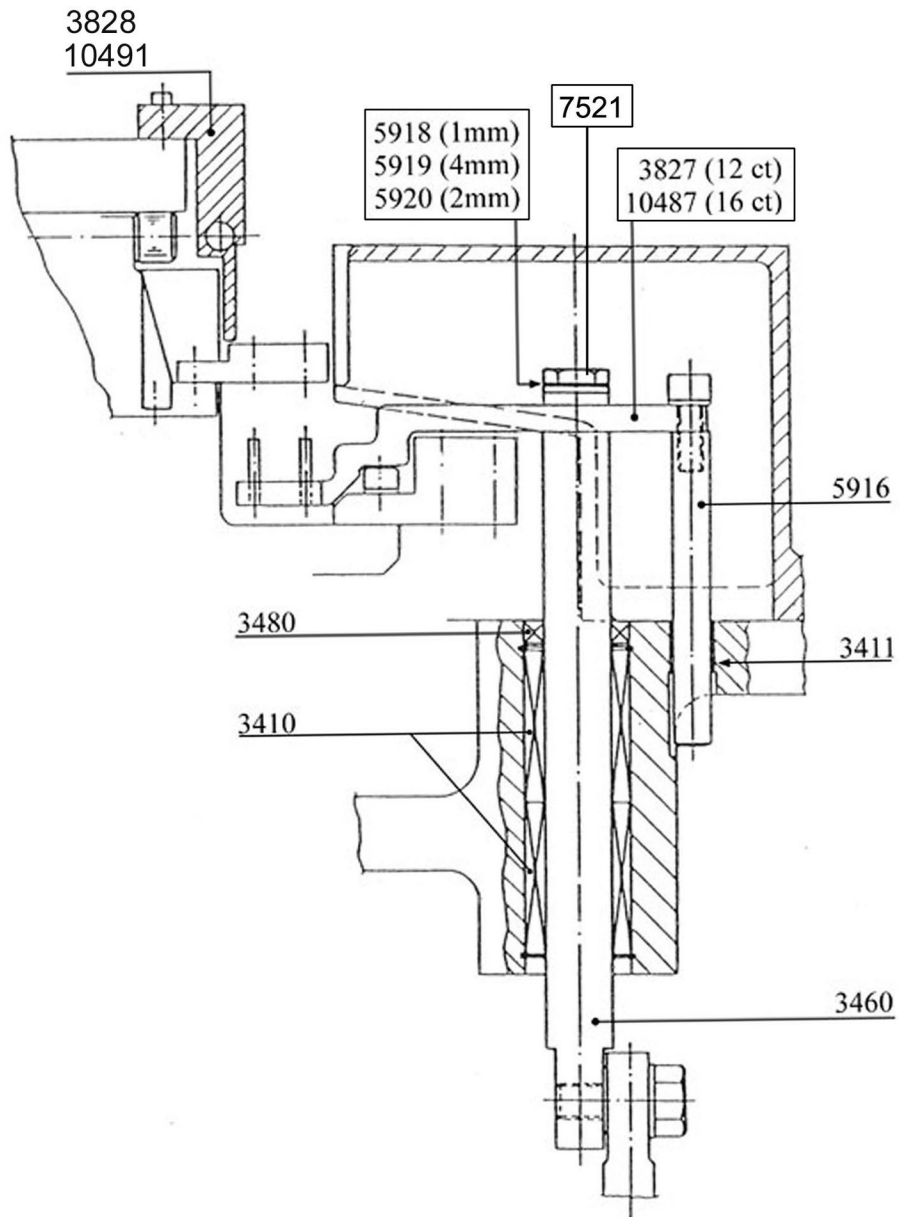
Section 33: faulty capsule ejection, new style



Section 33: Faulty capsule ejection, new style

IIM No.	Description
3410	BEARING,LINEAR,FOR 20 MM DRIVE SHAFT
3436	BEARING,LINEAR
3460	SHAFT,DRIVE,FAULTY CAPSULE EJECTION
3480	RING,SCRAPER
3818	HOSE,FAULTY CAPSULE BLOWING HEAD
3821	HOSE,VACUUM TUBE,84MM LONG
3826	BOX,REJECT,CAPSULES
3827	FAULTY CAPSULE EJECTION ARM, 12 COUNT
3828	HEAD/MANIFOLD,BLOWING,FAULTY CAPSULE,12 CT
3886	WASHER,NYLON
5038	SEAL RING
5340	BOLT W/INTEGRAL WASHER
5916	GUIDE SHAFT, FAULTY CAPSULE, OLD STLE,USED W/BUSHING
5918	SPACER,FAULTY CAPSULE EJECTOR,1MM,4/2/0
5919	SPACER,FAULTY CAPSULE,4MM,1/0/00
5920	SPACER,FAULTY CAPSULE EJECTION,2MM,3/2/00
6795	1/4 TURN FASTENER, FAULTY CAPSULE HOPPER
6821	GUIDE SHAFT, FAULTY CAPSULE, NEW STYLE,USED W/BEARINGS
7521	BOLT,SPECIAL,NEW STYLE
10487	FAULTY CAPSULE EJECTION ARM, 16 COUNT
10491	HEAD/MANIFOLD,BLOWING,FAULTY CAPSULE,12 or 16 COUNT
10634	BLOCK,MOUNT,F/C GUIDE SHAFT
27448	PLATE,HOLD DOWN
27458	PIVOT SCREW,HOLD DOWN PLATE

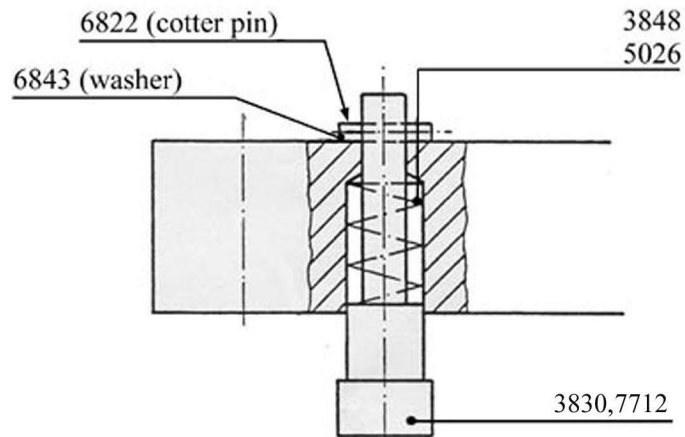
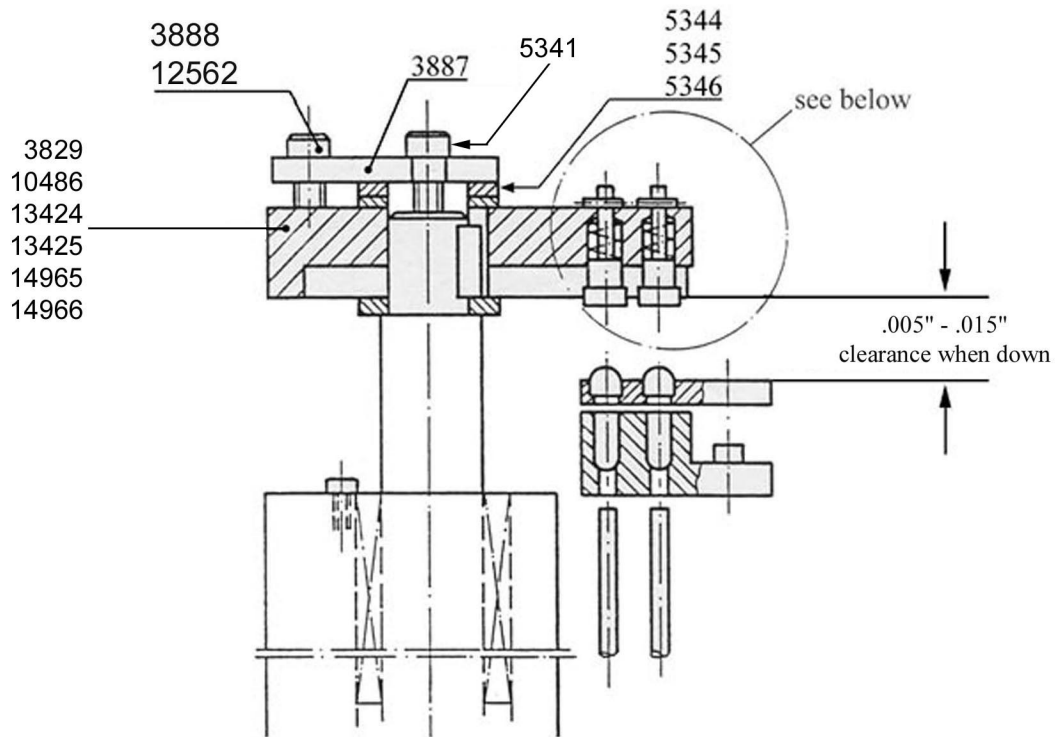
Section 34: faulty capsule ejection, old style



Section 34: Faulty capsule ejection, old style

IIM No.	Description
3410	BEARING,LINEAR,FOR 20 MM DRIVE SHAFT
3411	BUSHING
3460	SHAFT,DRIVE,FAULTY CAPSULE EJECTION
3480	RING,SCRAPER
3827	FAULTY CAPSULE EJECTION ARM, 12 COUNT
10487	FAULTY CAPSULE EJECTION ARM, 16 COUNT
3828	HEAD,BLOWING,FAULTY,CAPSULE,12 CT
10491	HEAD,BLOWING,FAULTY,CAPSULE,16 CT
5916	GUIDE SHAFT, FAULTY CAPSULE, OLD STLE,USED W/BUSHING
5918	SPACER,FAULTY CAPSULE EJECTOR,1MM,4/2/0
5919	SPACER,FAULTY CAPSULE,4MM,1/0/00
5920	SPACER,FAULTY CAPSULE EJECTION,2MM,3/2/00
10491	HEAD/MANIFOLD,BLOWING,FAULTY CAPSULE,12 or 16 COUNT
10487	FAULTY CAPSULE EJECTION ARM, 16 COUNT

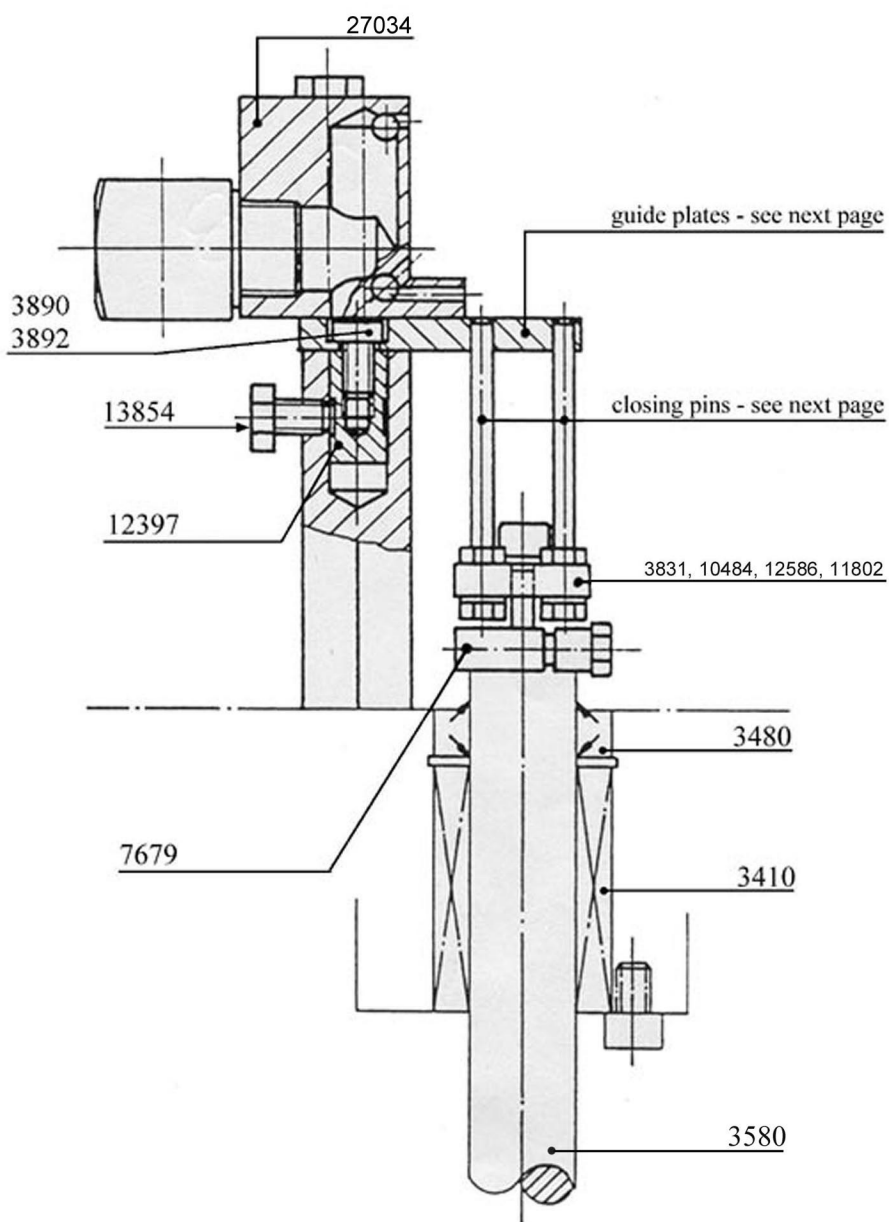
Section 35: upper closing



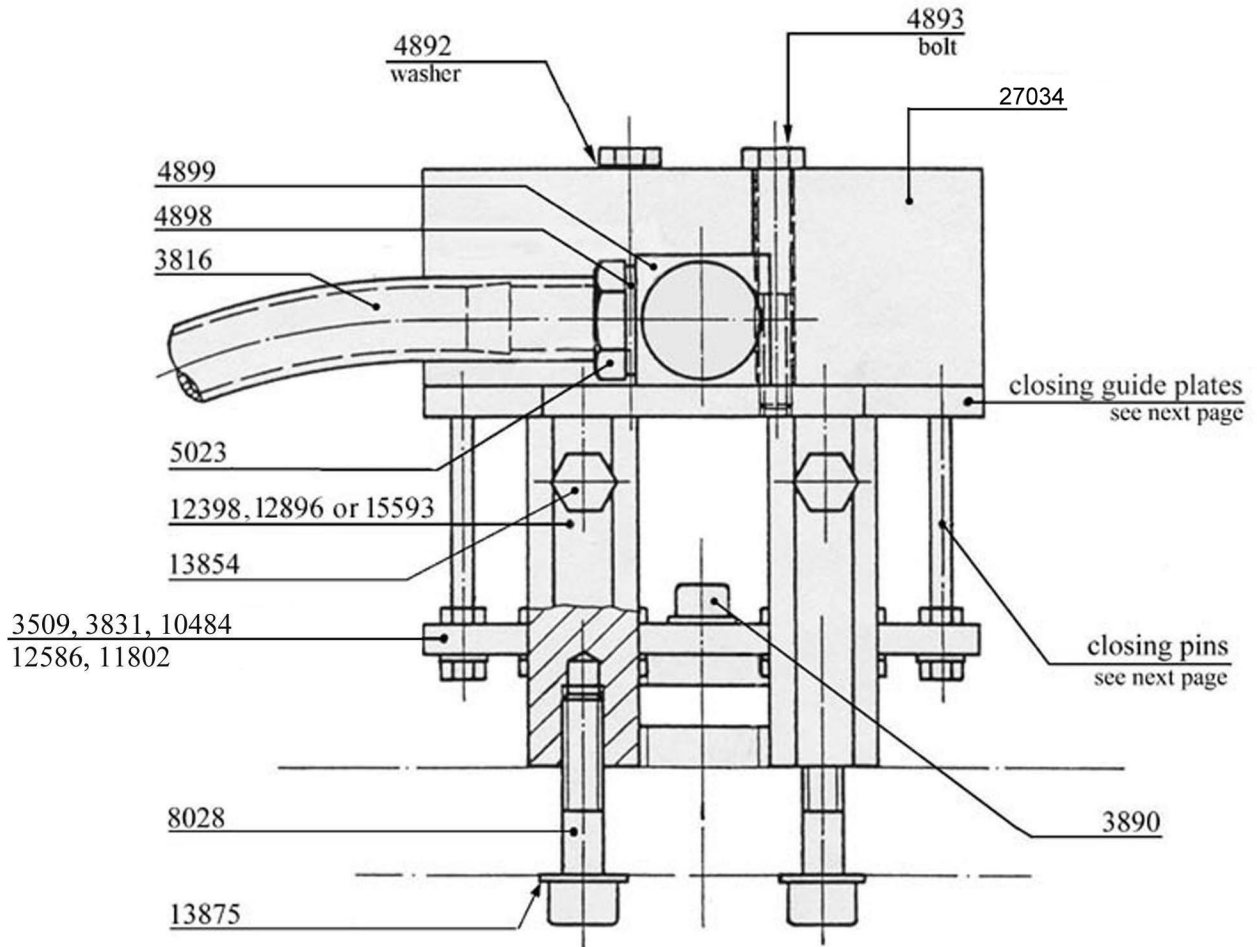
Section 35: Upper closing

IIM No.	Description
3830	SEALING PLUNGER
3848	COMPRESSION SPRING
3887	HOLD-DOWN,CLOSING,ARM
3888	SCREW,SHOULDER,SOCKET HEAD,HOLD-DOWN
5026	COMPRESSION SPRING, STAINLESS STEEL
5341	BOLT,INTEGRAL WASHER
6822	PIN,COTTER,S/S,CLOSING PLUNGER
6843	WASHER, M5
7709	KEY
7712	BLOCK,CLOSING,DELRIN (substitute for plungers 3830)
12562	BOLT,SHOULDER,HOLD-DOWN
5344	SPACER,UPPER CLOSING STATION,1MM,SIZE 4/2/0/000
5345	SPACER,UPPER CLOSING STATION,2MM,SIZE 3/2/00
5346	SPACER,UPPER CLOSING STATION,4MM,SIZE 1/0/00
3829	ARM,COUNTERBEARING,12 CT,COMPLETE ASSY
10486	ARM,COUNTERBEARING,16 CT,COMPLETE ASSY
13424	ARM ONLY,COUNTERBEARING,12 CT
13425	ARM ONLY,COUNTERBEARING,16 CT
14965	ARM ONLY,DOUBLE CLOSING
14966	ARM,DOUBLE CLOSING,ASSY

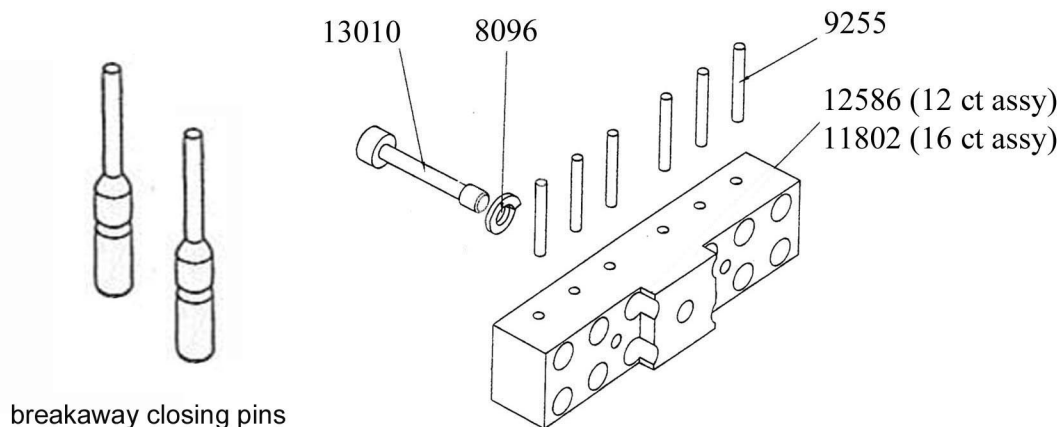
Section 36.1: lower closing



Section 36.2: lower closing



Breakaway closing block - accepts pins 16228, 16230, 16232



Section 36: Lower closing

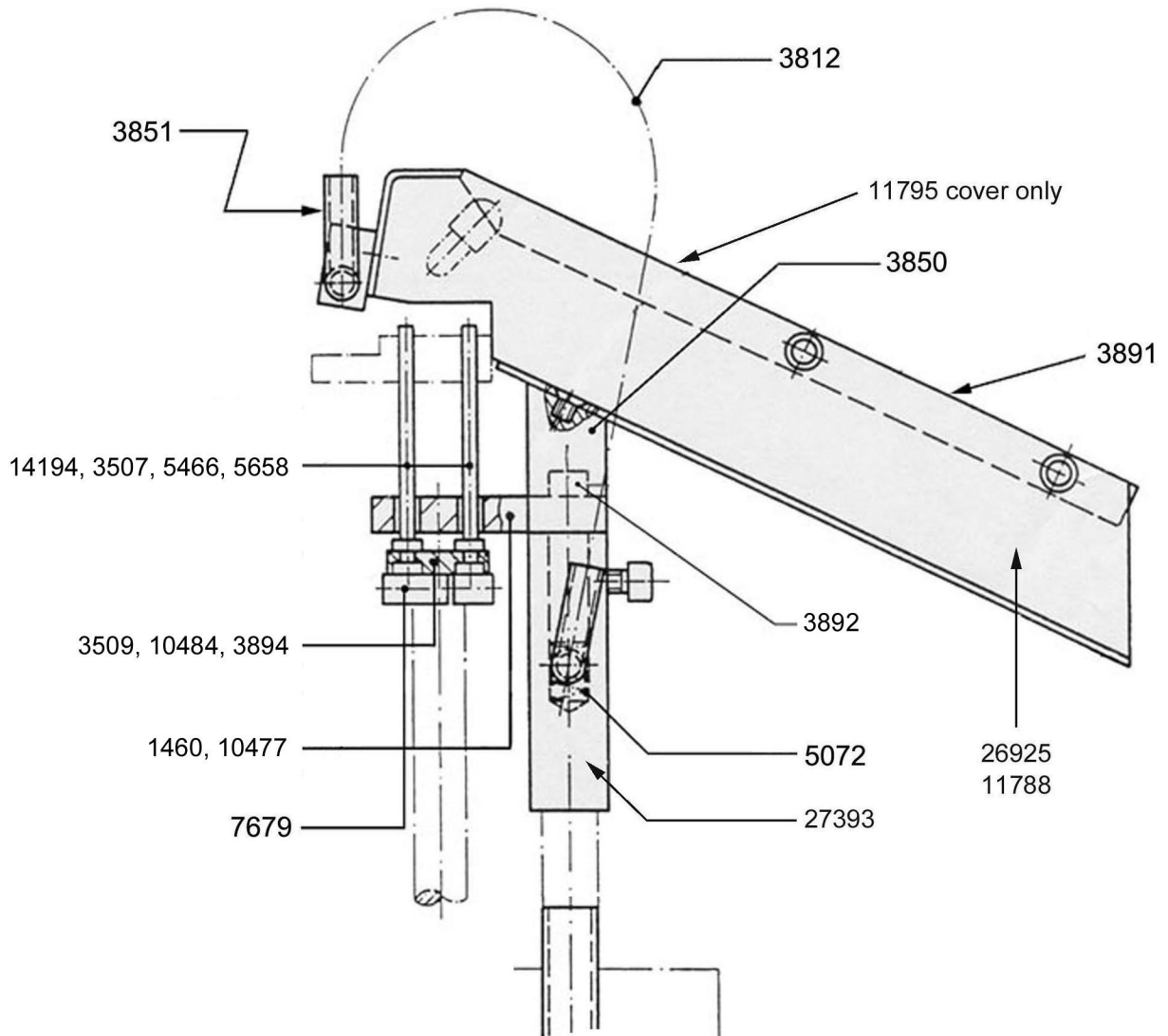
IIM No.	Description
3410	BEARING,LINEAR,FOR 20 MM DRIVE SHAFT
3480	RING, SCRAPER
3509	PLATE, EJECTION W/M6 HOLE, 4 DIA ALIGN.HOLES, W/BOLTS,NEW STYLE,12 CT
3816	HOSE, SUCKER BLOCK
3831	PLATE,CLOSING/LIFTING,THREADED,12 CT
27034	BLOCK,VACUUM,FINAL CLOSING STATION,W/FITTING
3890	BOLT,SECURING,SPECIAL M6X20
3892	BOLT,MODIFIED SPECIAL,M6X16
4892	WASHER,RIB
4893	BOLT,SPECIAL
4898	GASKET,VACUUM ADAPTER,FINAL CLOSING STATION
4899	ADAPTER,VACUUM,FINAL CLOSING STATION
5023	NOZZLE,FINAL CLOSING STATION
7679	PLATE,ALIGNMENT,CLOSING&EJECTION,QUICK CHANGE
8028	SCREW
8096	LOCK WASHER
9255	DOWEL PIN
10484	PLATE,CL/EJ,16 CT,W/ALIGN PINS+CAPT BOLT
12397	PIN,HEIGHT ADJUSTMENT
12398	STANDOFF,NEW STYLE,ADJUSTABLE
12896	STANDOFF,OLD STYLE
13010	CAPTIVE SCREW
13854	SCREW,M6 X 12
13875	WASHER,SERRATED
15593	STANDOFF ASSY,ADJUSTABLE,NEW STYLE
6820	GUIDE PLATE,CLOSING,SIZE 0 & 00,12 COUNT,M6 CAPTIVE SCREWS
14556	GUIDE PLATE,CLOSING,SIZE 0 & 00,16 COUNT,M6 CAPTIVE SCREWS
3120	GUIDE PLATE,CLOSING,SIZE 1 & 2,12 COUNT,M6 CAPTIVE SCREWS
10496	GUIDE PLATE,CLOSING,SIZE 1 & 2,16 COUNT,M6 CAPTIVE SCREWS
14517	GUIDE PLATE,CLOSING,SIZE 3 & 4,16 COUNT,M6 CAPTIVE SCREWS
3849	GUIDE PLATE,CLOSING,SIZE 3 & 4,12 COUNT,M6 CAPTIVE SCREWS
12586	BLOCK,CLOSING PIN,UPGRADE,12 COUNT (requires closing pins)
11802	BLOCK,CLOSING PIN,UPGRADE,16 COUNT (requires closing pins)

SEE NEXT PAGE FOR CLOSING PINS

Section 36: lower closing

IIM No.	Description
7320	PIN,CLOSING,SZ 0/00,49MM LONG,NEW STYLE
13414	PIN,CLOSING,SZ 0/00,53MM LONG,OLD STYLE
7323	PIN,CLOSING,SZ 0/00,55MM LONG,OLD STYLE,POWDER SHEDDING
16228	PIN,CLOSING,SZ 0/00,NEW STYLE,NO GUIDE,POWDER SHEDDING,BREAKAWAY
28121	PIN,CLOSING,SZ 0/00,NEW STYLE,NO GUIDE,POWDER SHEDDING,BREAKAWAY,ALUMINUM
7319	PIN,CLOSING,SZ 1/2,53MM LONG,OLD STYLE
7322	PIN,CLOSING,SZ 1/2,53MM LONG,OLD STYLE,POWDER SHEDDING
10493	PIN,CLOSING,SZ 1/2,NEW STYLE
16230	PIN,CLOSING,SZ 1/2,NEW STYLE,NO GUIDE,POWDER SHEDDING,BREAKAWAY
28122	PIN,CLOSING,SZ 1/2,NEW STYLE,NO GUIDE,POWDER SHEDDING,BREAKAWAY,ALUMINUM
3448	PIN,CLOSING,SZ 3/4,55MM LONG,OLD STYLE
7321	PIN,CLOSING,SZ 3/4,55MM LONG,OLD STYLE,POWDER SHEDDING
12041	PIN,CLOSING,SZ 3/4,NEW STYLE
16232	PIN,CLOSING,SZ 3/4,NEW STYLE,NO GUIDE,POWDER SHEDDING,BREAKAWAY
28123	PIN,CLOSING,SZ 3/4,NEW STYLE,NO GUIDE,POWDER SHEDDING,BREAKAWAY,ALUMINUM
27835	BREAKAWAY CLOSING PIN ASSY,SZ 0/00,12CT
27836	BREAKAWAY CLOSING PIN ASSY,SZ 1/2,12CT
27837	BREAKAWAY CLOSING PIN ASSY,SZ 3/4,12CT
27834	BREAKAWAY CLOSING PIN ASSY,SZ 0/00,16CT
27833	BREAKAWAY CLOSING PIN ASSY,SZ 1/2,16CT
27832	BREAKAWAY CLOSING PIN ASSY,SZ 3/4,16CT

Section 37: ejection

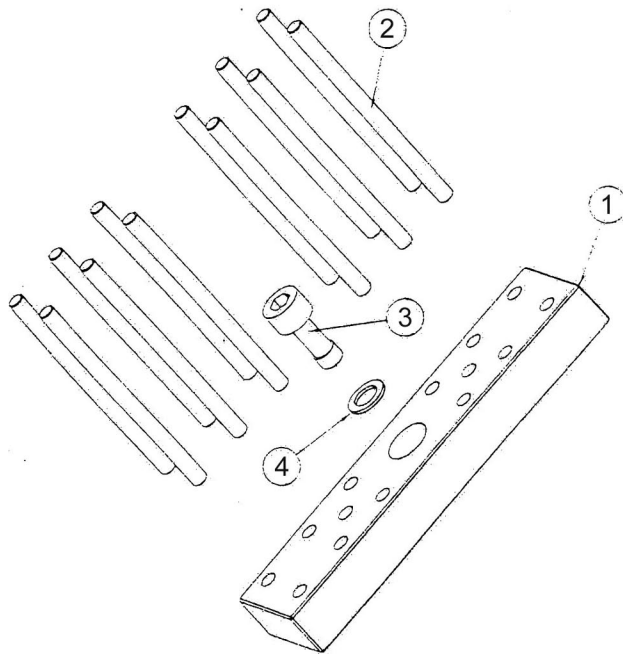


Section 37: ejection

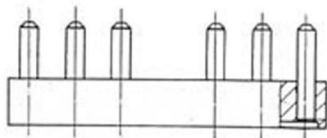
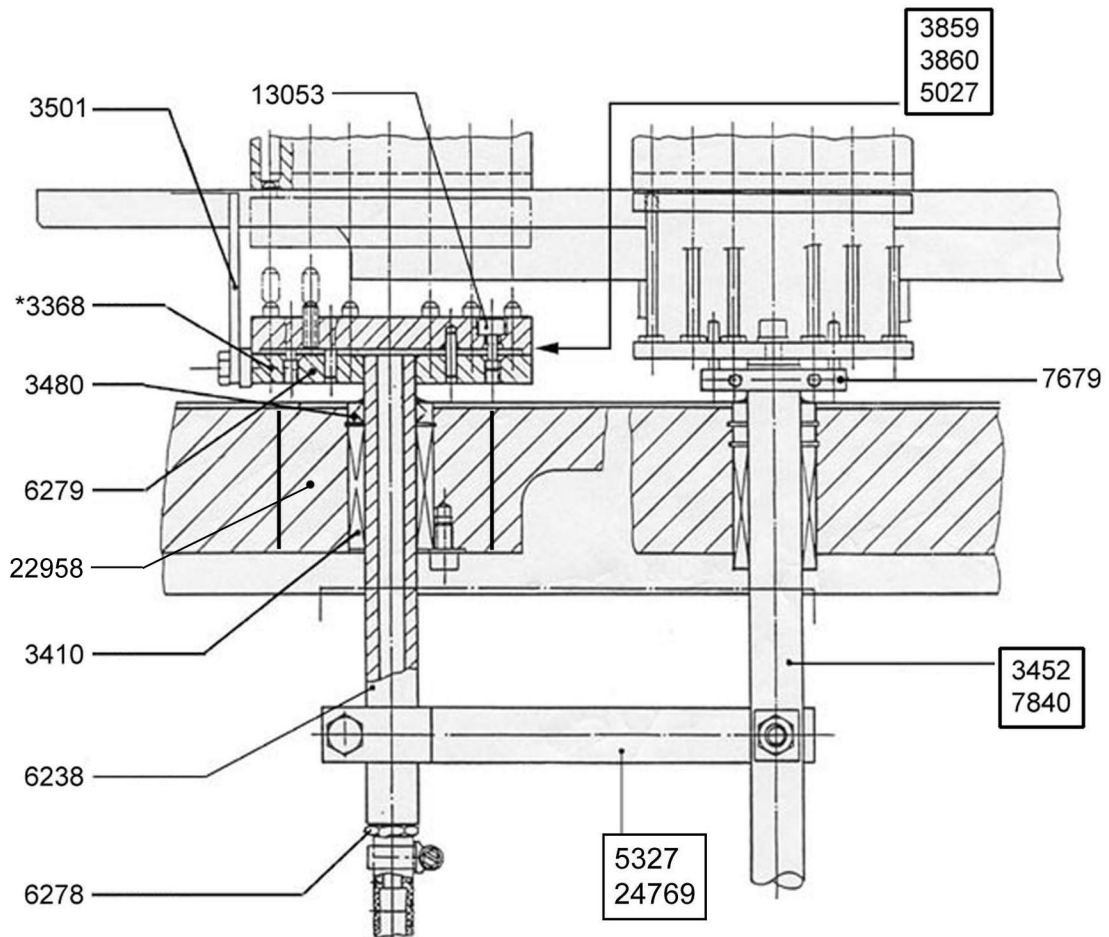
IIM No.	Description
1460	PLATE, EJECTION GUIDE, W/ALIGNMENT HOLES
3507	PIN, EJECTION, 62MM TALL, NEW STYLE, FLAT TIP
3509	PLATE, EJECTION W/M6 HOLE, 4 DIA ALIGN.HOLES, W/BOLTS,NEW STYLE,12 CT
3812	HOSE, VACUUM, DISCHARGE
3850	BRACKET, HOLDING CHUTE
3851	BLOWOFF BAR, CAPSULE EJECTOR, DUST REMOVER
3891	CHUTE, EJECTION W/ACRYLIC COVER
3892	BOLT,SECURING,SPECIAL,M6X16
3894	BOLT,SECURING,SPECIAL,M6X12
5072	SPRING, COMPRESSION
5466	PIN,EJECTION,OLD STYLE,66MM, CONCAVE TIP
5658	PIN, EJECTION, 67MM TALL, OLD STYLE, FLAT TIP
7679	PLATE, ALIGNMENT
10477	PLATE,EJECTION GUIDE,16 COUNT
10484	PLATE,CL/EJ,16 CT,W/ALIGN PINS+CAPT BOLT
11788	EJECTION CHUTE ONLY
11795	COVER,LEXAN,EJECTION CHUTE,5/16" THICK
13053	CAPTIVE SCREW
13874	LOCK WASHER
14192	EJECTION PLATE FOR BREAKAWAY PINS,16 COUNT
14194	PIN, EJECTION, BREAKAWAY
14196	BREAKAWAY EJECTION PIN ASSEMBLY, 16 COUNT
14265	BREAKAWAY EJECTION PIN ASSEMBLY, 12 COUNT
14266	EJECTION PLATE FOR BREAKAWAY PINS,12 COUNT
26925	CHUTE,EJECTION,COMPLETE
27393	MOUNT BLOCK,HOLDING BRACKET

Section 37.2: Breakaway ejection

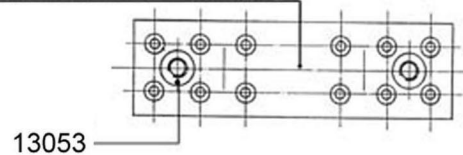
Pos	Description	P/n
0	Assembly (12 count)	14265
0.1	Assembly (16 count)	14196
1	Base, breakaway ejection pin (12 count)	14266
1.1	Base, breakaway ejection pin (16 count)	14192
2	Pin, ejection, breakaway	14194
3	Captive screw	13053
4	Lock washer	13874



Section 38: blowout and cleaning



Blowout blocks - see next page



* 3368 Assembly includes 6238, 6278, 6279

Section 38: blowout and cleaning

Description	IIM No.
BLOWOUT SUPPORT COMPLETE (INCLUDES 6238,6279,6278)	3368
BEARING,LINER,FOR 20 MM DRIVE SHAFT	3410
EJECTION SHAFT	3452
RING, SCRAPER	3480
GUARD, BLOWOUT PLATE	3501
ARM, LIFTING, CLEANOUT STATION	5327
SHAFT, BLOW-OUT, 20 MM, 2 THREADED ENDS	6238
FITTING,AIR LINE,BLOWOUT STATION	6278
PLATE, LOWER MOUNTING, BLOWOUT STATION	6279
PLATE, ALIGNMENT, QUICK CHANGE,W/4MM PINS	7679
EJECTION SHAFT,OLD STYLE FOR 1200 & 2400	7840
CAPTIVE SCREW	13053
BLOCK,MOUNT,LINER BEARING	22958
ARM, LIFTING, CLEANOUT STATION,ADJUSTABLE VERSION	24769

	12ct	16ct	16ct 8 hole
BLOWOUT BLOCK, SIZE 0, 00	3859	13408	25374
BLOWOUT BLOCK, SIZE 1, 2	3860	10478	25703
BLOWOUT BLOCK, SIZE 3, 4	5027	12855	25701

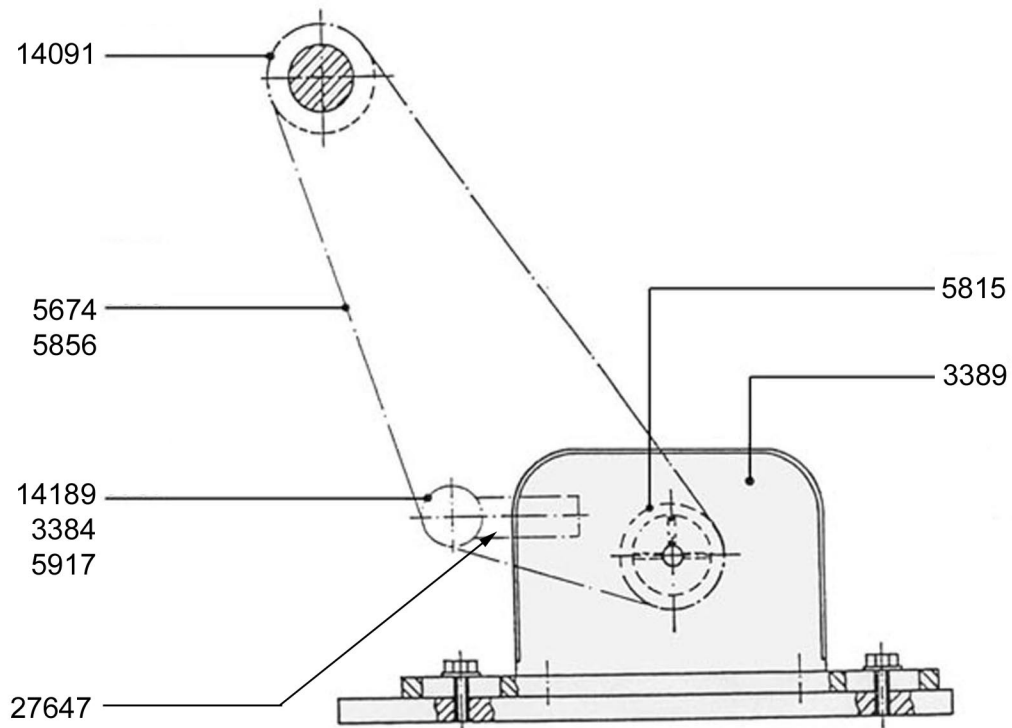
	12ct	16ct
BLOWOUT BLOCK WITH BRUSHES SIZE 0/00	5057	23972
BLOWOUT BLOCK WITH BRUSHES SIZE 1/2	5058	25461
BLOWOUT BLOCK WITH BRUSHES SIZE 3/4	24562	25126

	std ver	8 hole
NOZZLE,BLOWOUT,SIZE 0/00	4990	25254
NOZZLE,BLOWOUT,SIZE 1/2	4988	25255
NOZZLE,BLOWOUT,SIZE 3/4	4989	25256

REPLACEMENT BRUSH SIZE 0/00 (12 AND 16 COUNT)	5660
REPLACEMENT BRUSH SIZE 1/2 (12 AND 16 COUNT)	24266
REPLACEMENT BRUSH SIZE 3/4 (12 AND 16 COUNT)	24403

REPLACEMENT NOZZLE FOR BRUSH SIZE 0/00 (12 AND 16 COUNT)	5659
REPLACEMENT NOZZLE FOR BRUSH SIZE 1/2 (12 AND 16 COUNT)	25048
REPLACEMENT NOZZLE FOR BRUSH SIZE 3/4 (12 AND 16 COUNT)	24641

Section 39: cam box

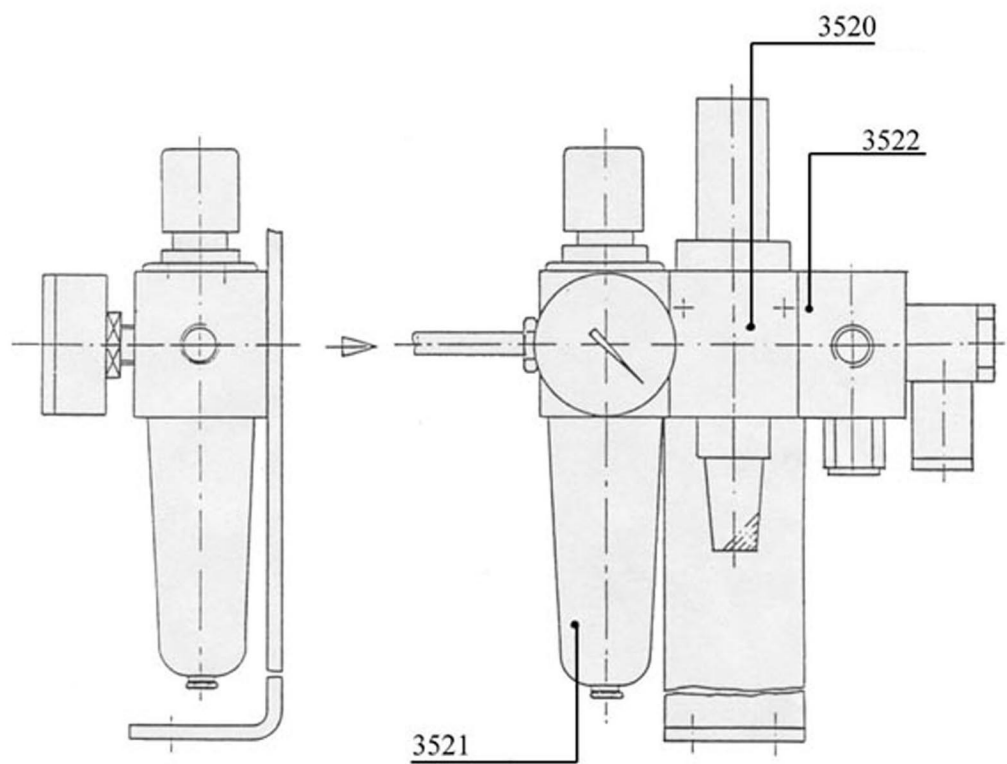


26019: adjusting tool for cam box

Section 39: Cam box

IIM No.	Description
3384	BEARING,BALL
3389	CAM BOX, PROX SWITCH VERSION
5674	MASTER LINK
5815	SPROCKET
5856	CHAIN
5917	SPROCKET, IDLER, CAM BOX
14091	CHAIN WHEEL
14189	THREADED STUD
25376	MICROSWITCH
26012	PLASTIC ROLLER
26019	WRENCH,ADJUSTING,CAM BOX
27580	CAM BOX, MICROSWITCH VERSION
27647	PLATE,CHAIN TENSIONER

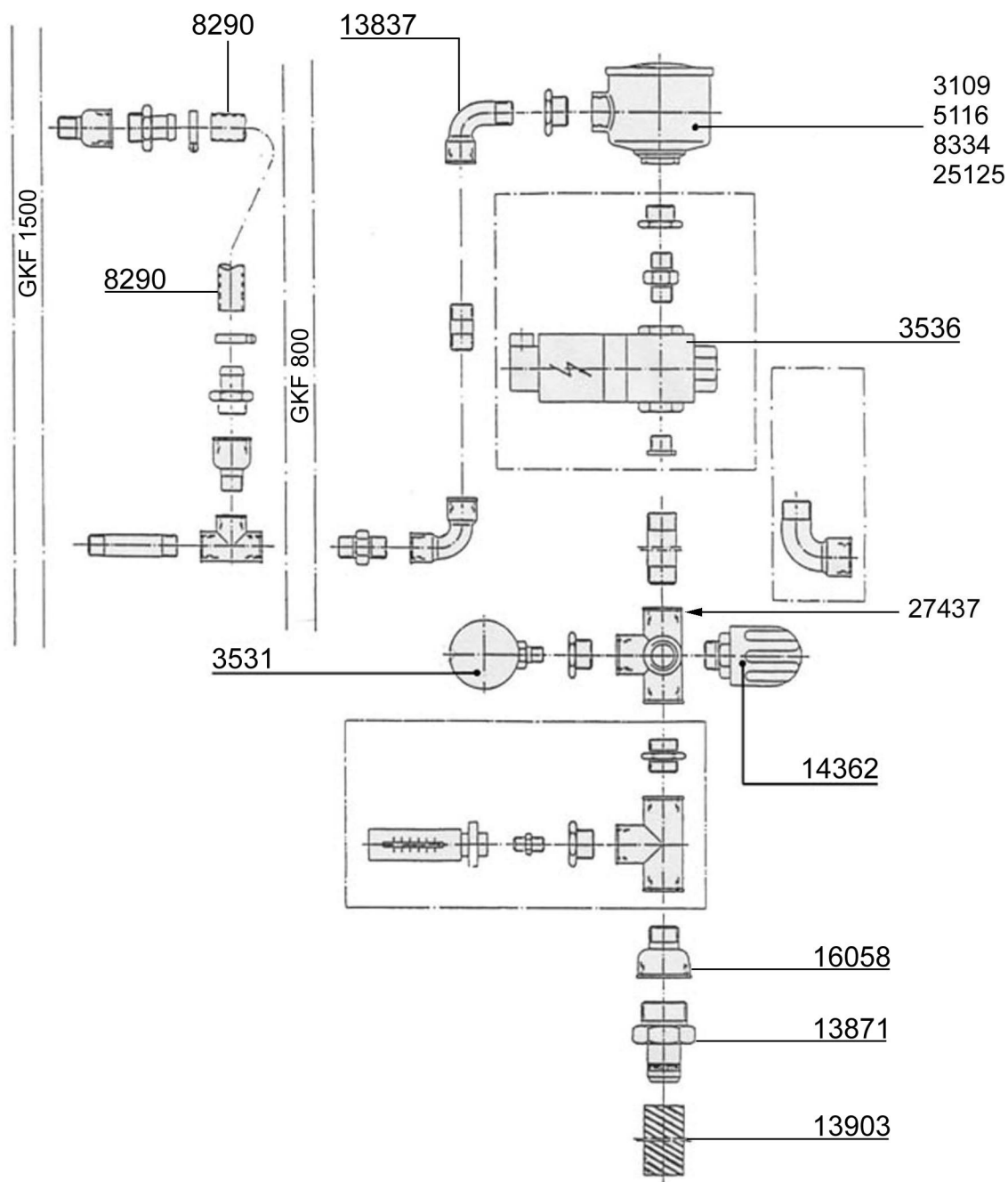
Section 40: compressed air components



Section 40: Compressed air components

IIM No.	Description
3520	VALVE, 3/2 WAY
3521	FILTER, PRESSURE REGULATOR
3522	DISTRIBUTOR, PRESSURE

Section 41: vacuum system with filter

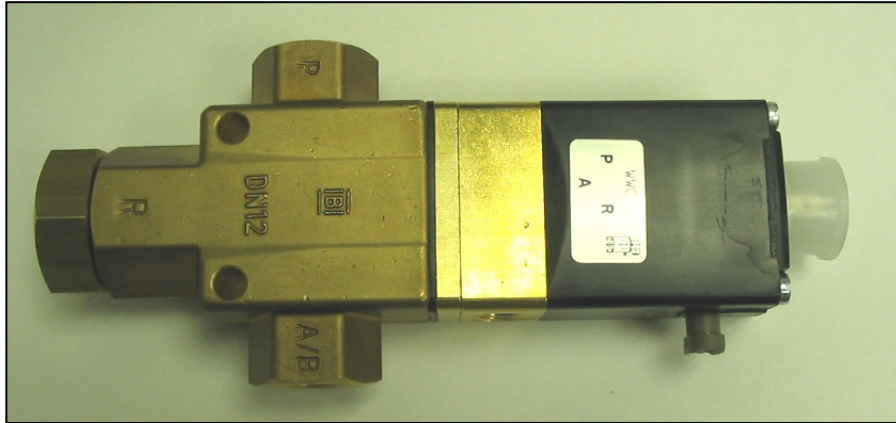


Section 41: Vacuum system with filter

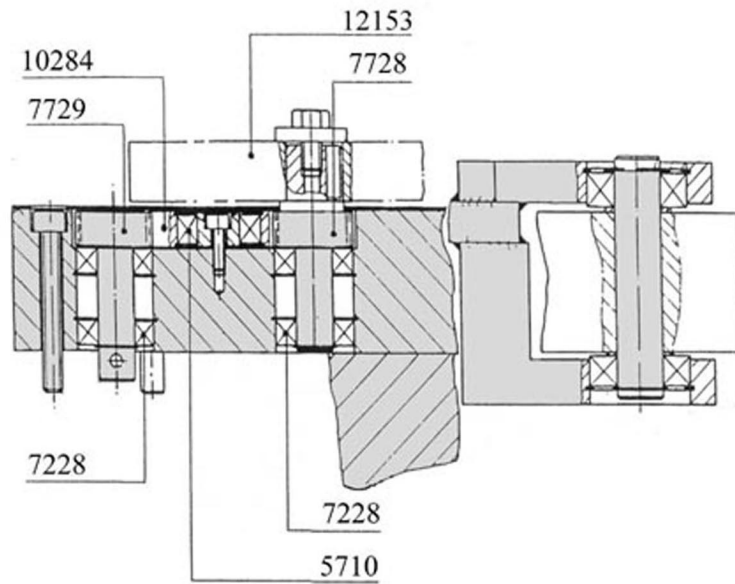
IIM No.	Description
3109	FILTER FOR CANISTER 8334
3531	GAUGE,VACUUM
5116	REPLACEMENT FILTER FOR CANISTER 25125
8334	FILTER CANISTER
13903	VACUUM HOSE
14362	VACUUM VALVE, black with red face
25125	CANISTER,LARGE,WITH FILTER
27437	TEE JOINT

Section 42: vacuum valve

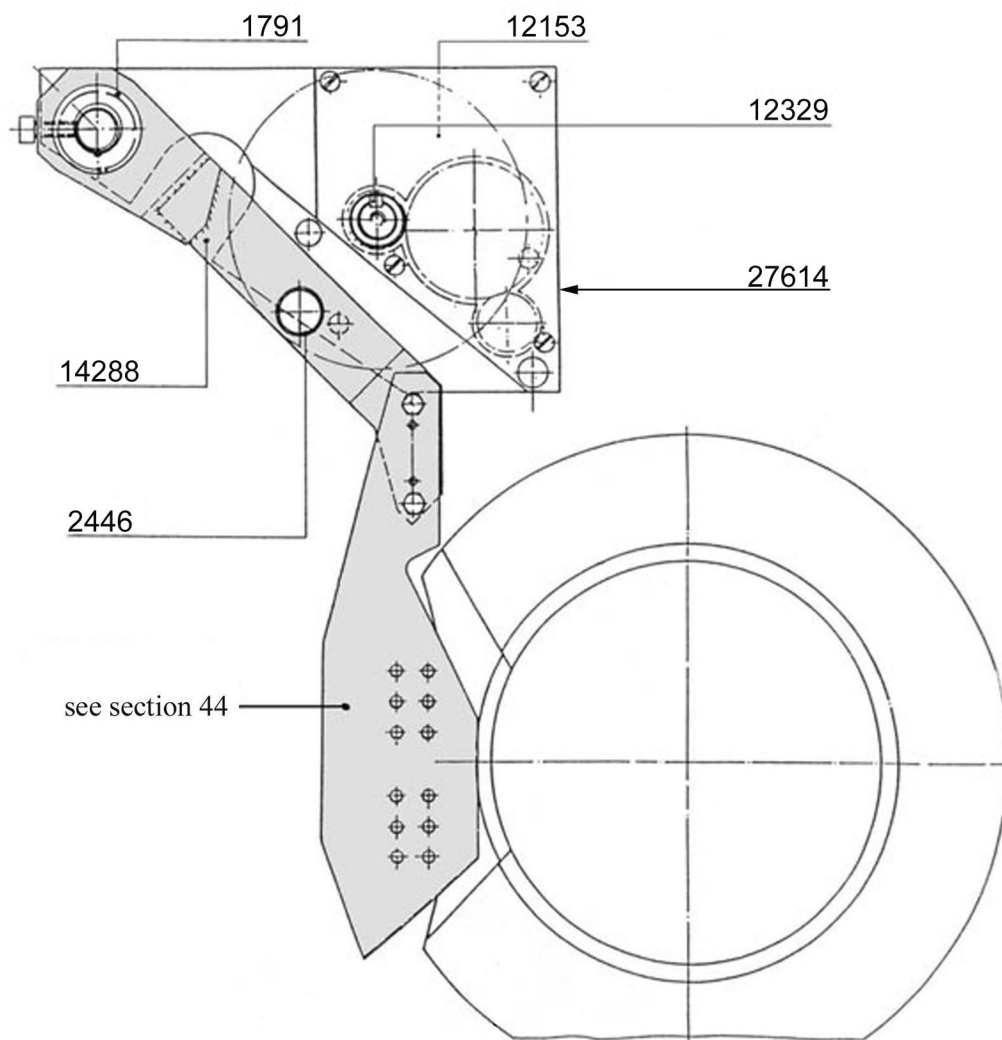
IIM No.	Description
3536	Vacuum valve 24V
24438	Vacuum valve 220V



Section 43.1: pellet filling with dosing disc



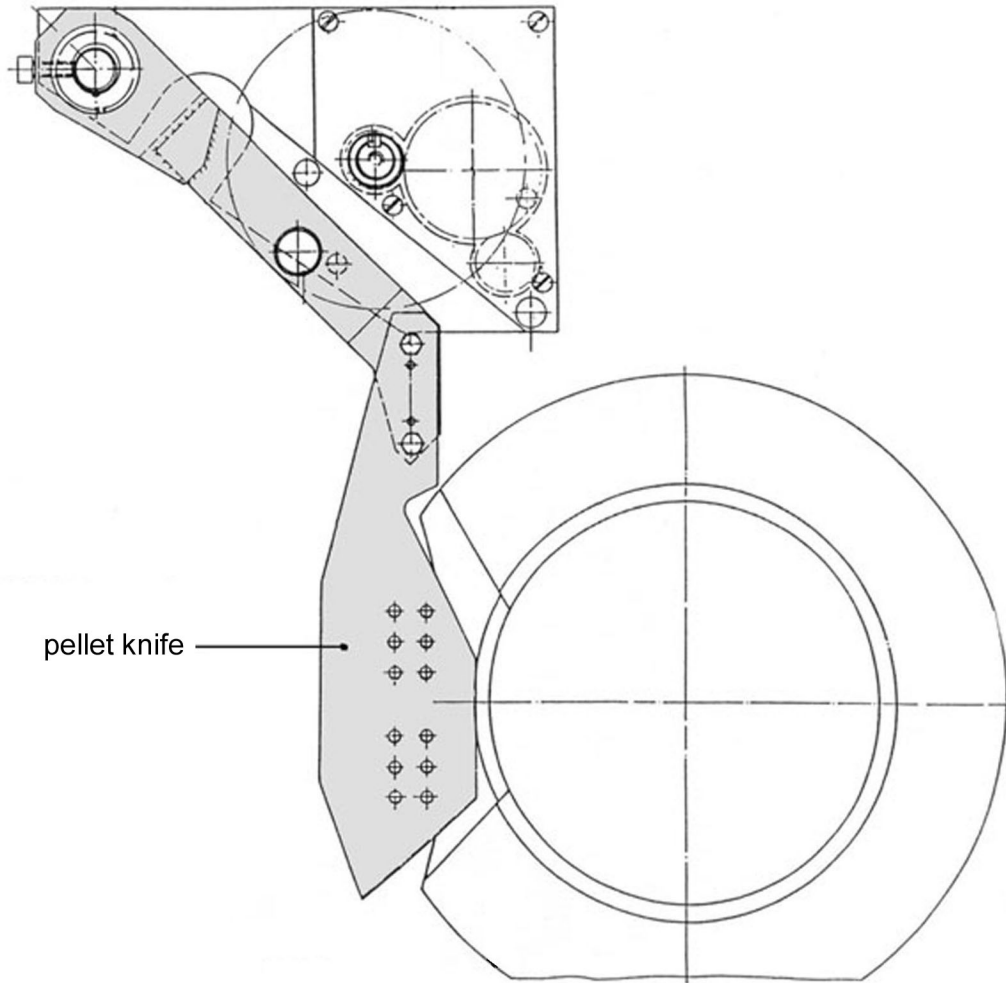
Section 43.2: pellet filling with dosing disc



Section 43: Pellet filling with dosing disc

IIM No.	Description
1791	BEARING,BALL
2446	CAM FOLLOWER
5710	BEARING,DEEP GROOVED
7228	BEARING, BALL, DEEP GROOVE
7729	PINION,BEADER/KNIFE DRIVE,UPGRADED
10284	GEAR,BRASS,55T
12153	DRIVE CAM, GROOVED
12329	KEY, CAM, PELLET KNIFE
14288	LEVER
21615	BEAD FEED MECHANISM COMPLETE,INCLUDES TAMPING RING
27614	DRIVE ASSY, TABLETOP, PELLET KNIFE

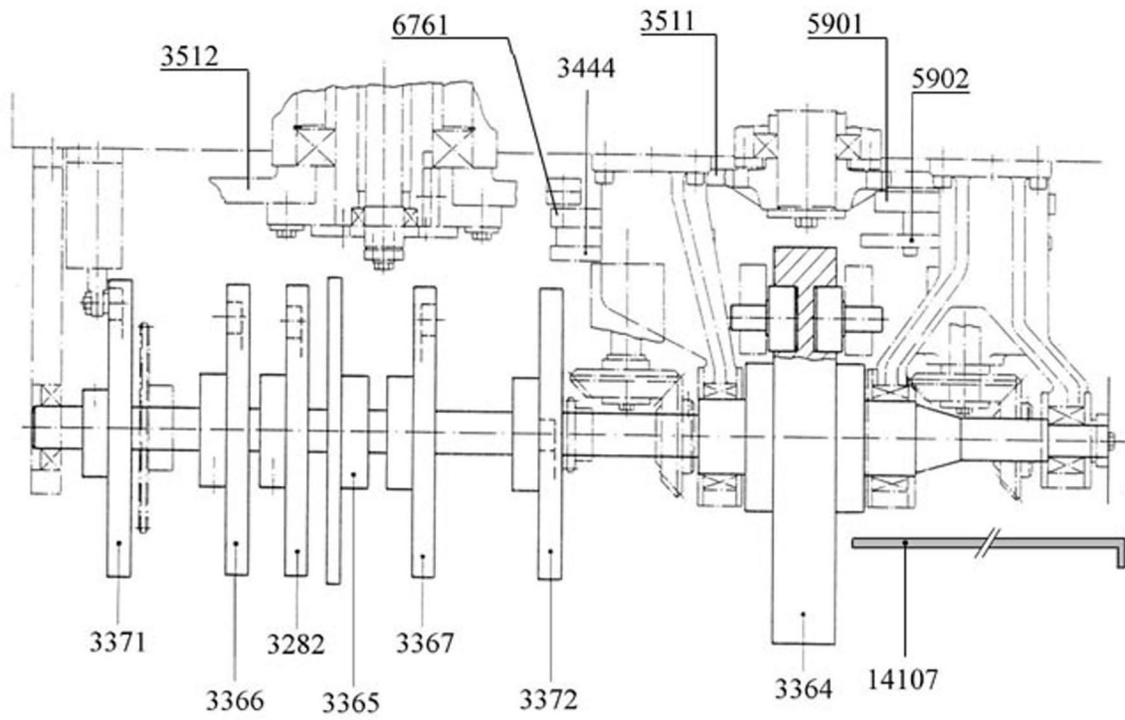
Section 44: pellet knife



Section 44: pellet knife

IIM No.	Description
15667	KNIFE,PELLET,12 COUNT,LARGER HOLES
6104	KNIFE,PELLET,12 COUNT,STAINLESS
15220	KNIFE,PELLET,16 COUNT,LARGER HOLES
13383	KNIFE,PELLET,16 COUNT,STAINLESS

Section 45: drive cams



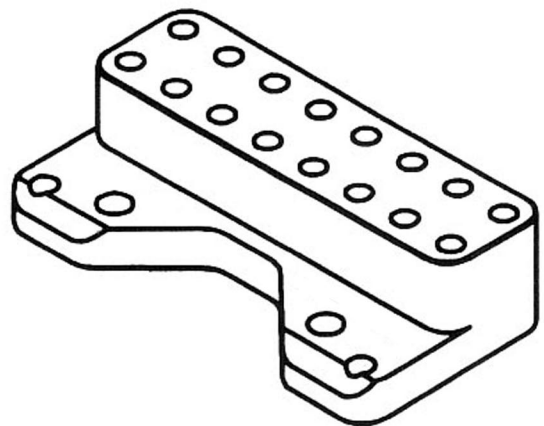
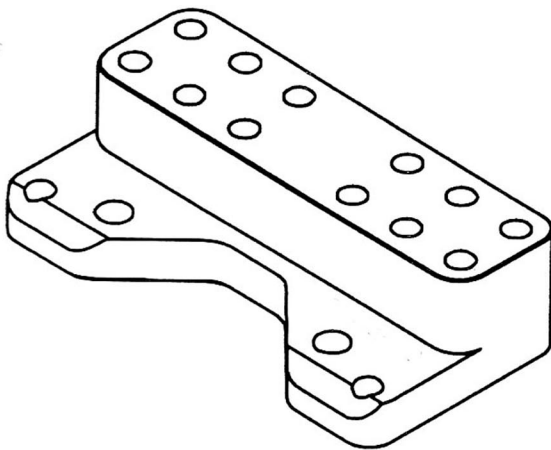
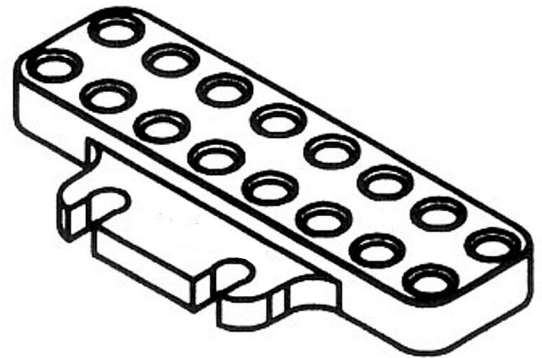
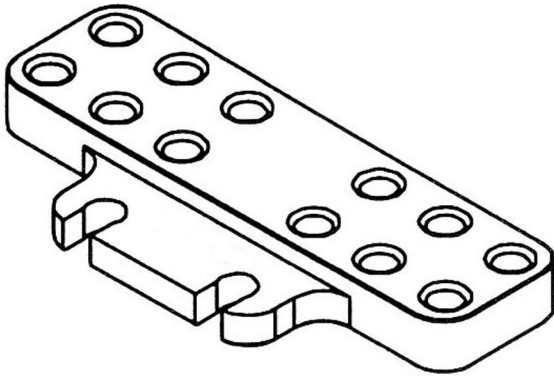
Section 45: drive cams

IIM No.	Description
3512	GENEVA,LARGE,SEGMENT STATION
6761	CAM,DRIVE RATCHET,LARGE GENEVA,SEGMENT
3444	CAM, PEANUT, LARGE GENEVA, SEGMENT STATION
3511	GENEVA,DOSING
5901	CAM,SMALL GENEVA DRIVE,DOSING (INTERCHANGEABLE WITH OLD STYLE)
5902	CAM, PEANUT, SMALL GENEVA, DOSING
3371	CAM, EJECTION,W/ALIGNMENT HOLE
3366	CAM,UPPER CLOSING,W/ALIGNMENT HOLE
3282	CAM, LOWER CLOSING (UPWARD MOVEMENT),W/ALIGNMENT HOLE
3365	CAM, SEPARATION,W/ALIGNMENT HOLE
3367	CAM, SORTING,W/ALIGNMENT HOLE
3372	CAM, FAULTY CAPSULE,W/ALIGNMENT HOLE
3364	CAM, DOSING,W/ALIGNMENT HOLE
14107	CAM ALIGNMENT ROD

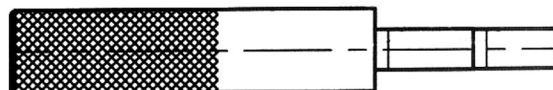
Section 46: change parts - segment blocks, alignment pins

12 count

16 count



segment alignment pin



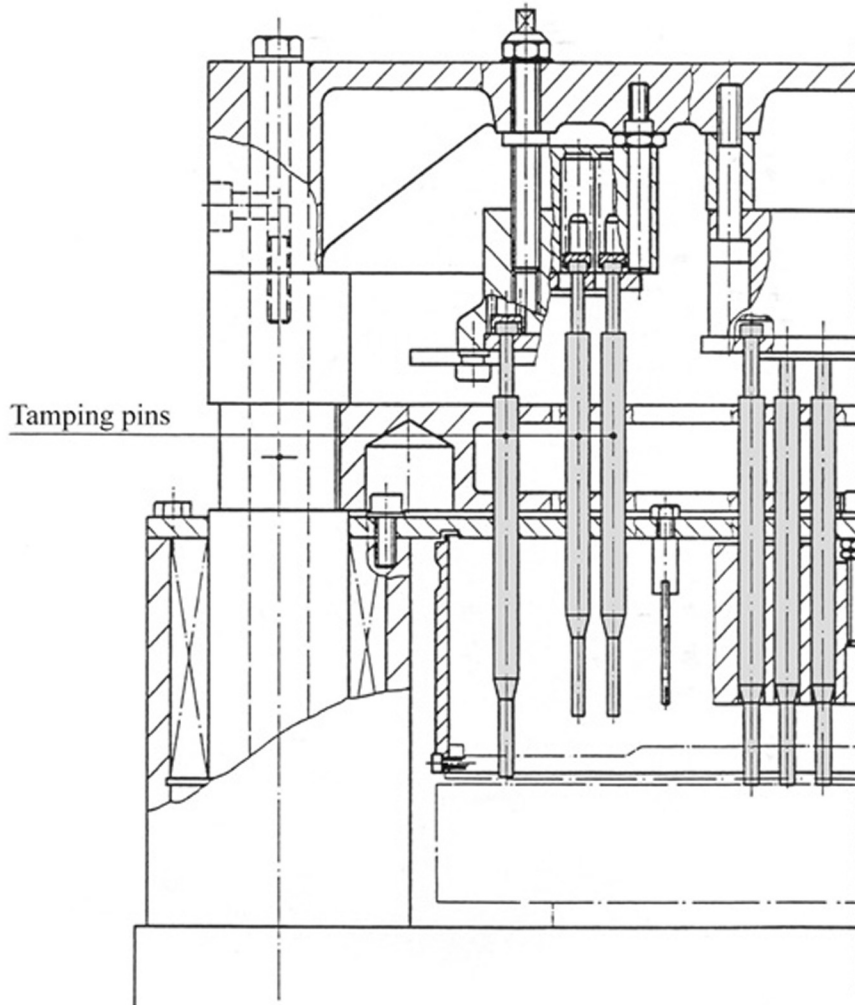
Section 46: Change parts: segment blocks, alignment pins

Description	12ct	16ct	tuck reducing 12ct	tuck reducing 16ct
BLOCK,SEGMENT,LOWER,SIZE 00 ELONGATED	26013	-	-	-
BLOCK,SEGMENT,LOWER,SIZE 0 ELONGATED	8318	25065	-	-
BLOCK,SEGMENT,LOWER,SIZE 0	3866	12228	29366	29522
BLOCK,SEGMENT,LOWER,SIZE 00	3579	13250	27641	29521
BLOCK,SEGMENT,LOWER,SIZE 000	13248	13249	-	-
BLOCK,SEGMENT,LOWER,SIZE 1	3868	12091	29367	29115
BLOCK,SEGMENT,LOWER,SIZE 2	3869	10482	29368	29520
BLOCK,SEGMENT,LOWER,SIZE 3	3283	12226	29516	29523
BLOCK,SEGMENT,LOWER,SIZE 4	7269	13245	29363	29524
BLOCK,SEGMENT,LOWER,SIZE 5	13246	13247		

	12ct	16ct	veggie 12ct	veggie 16ct
BLOCK,SEGMENT,UPPER,SIZE 00-ELONGATED	25960	-	-	-
BLOCK,SEGMENT,UPPER,SIZE 0-ELONGATED	8317	26448	-	-
BLOCK,SEGMENT,UPPER,SIZE 0	3861	12229	26986	26700
BLOCK,SEGMENT,UPPER,SIZE 00	3578	13244	28675	26699
BLOCK,SEGMENT,UPPER,SIZE 000	13242	13243	28674	26698
BLOCK,SEGMENT,UPPER,SIZE 1	3863	12090	28676	26701
BLOCK,SEGMENT,UPPER,SIZE 2	3864	10504	28677	26702
BLOCK,SEGMENT,UPPER,SIZE 3	5331	12227	28678	26703
BLOCK,SEGMENT,UPPER,SIZE 4	7270	13239	28679	26704
BLOCK,SEGMENT,UPPER,SIZE 5	13240	13241	-	26705

	standard	veggie
ALIGNMENT PIN,FOR SEGMENT BLOCK,SIZE 000	13360	26706
ALIGNMENT PIN,FOR SEGMENT BLOCK,SIZE 00	4923	26707
ALIGNMENT PIN,FOR SEGMENT BLOCK,SIZE 0	8185	26708
ALIGNMENT PIN,FOR SEGMENT BLOCK,SIZE 1	4924	26709
ALIGNMENT PIN,FOR SEGMENT BLOCK,SIZE 2	5190	26710
ALIGNMENT PIN,FOR SEGMENT BLOCK,SIZE 3	5191	26711
ALIGNMENT PIN,FOR SEGMENT BLOCK,SIZE 4	13361	26712
ALIGNMENT PIN,FOR SEGMENT BLOCK,SIZE 5	13362	26713

Section 47: change parts - tamping pins



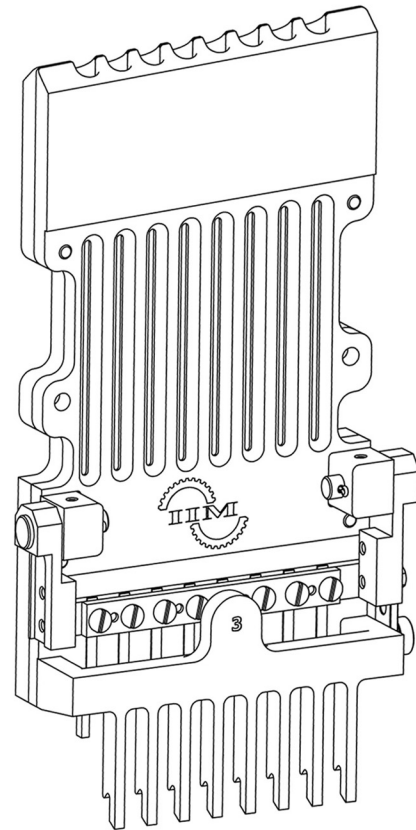
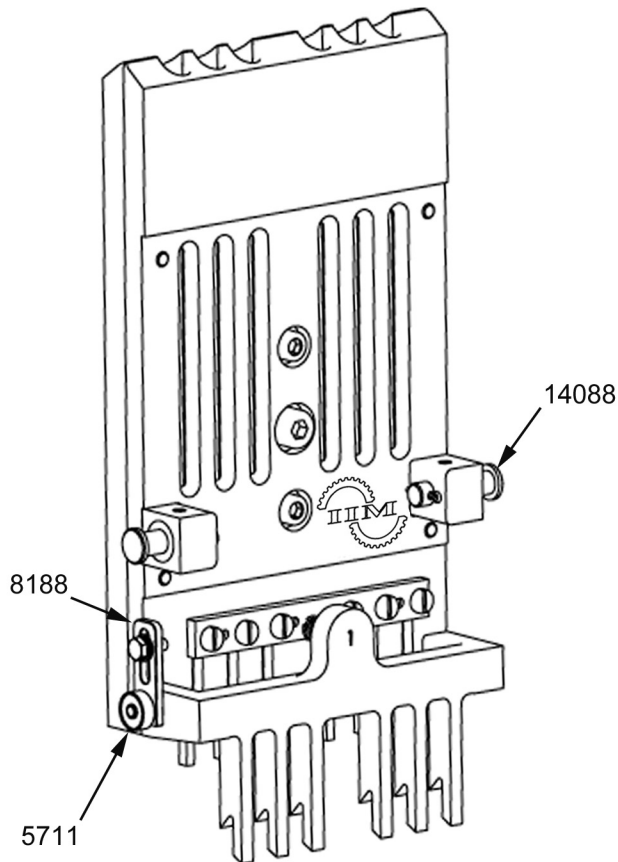
Section 47: tamping pins, dosing alignment pins

Description	Standard	Plated	Mirrored tip	Adj dosing disc
Tamping pin size 000	13165	-	29850	13358
Tamping pin size 00	3879	25198	29849	7533
Tamping pin size 0	3839	14371	29723	7534
Tamping pin size 1	3840	14283	29845	7535
Tamping pin size 2	3878	25199	29694	7536
Tamping pin size 3	5150	14108	29846	7537
Tamping pin size 4	5126	25200	29847	7538
Tamping pin size 5	11312	25201	29848	13359
Dosing alignment pin,size 000	7289			
Dosing alignment pin,size 00	3539			
Dosing alignment pin,size 0	7291			
Dosing alignment pin,size 1	4925			
Dosing alignment pin,size 2	5188			
Dosing alignment pin,size 3	5189			
Dosing alignment pin,size 4	7293			
Dosing alignment pin,size 5	7294			

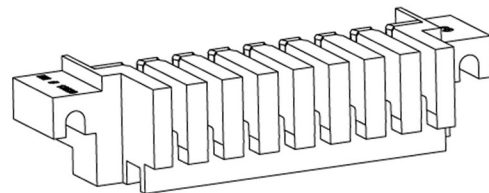
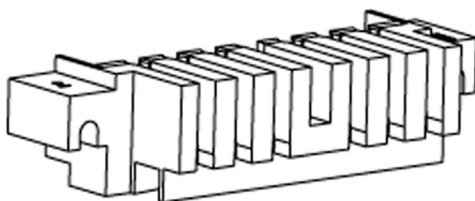
Section 48: change parts - sorting station

12 count

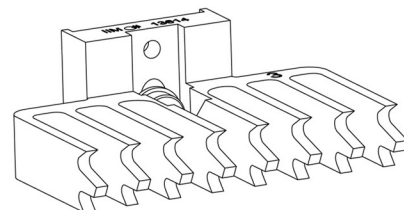
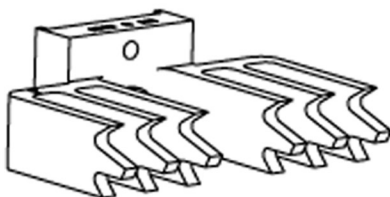
16 count



magazine



sorting block



orientation fingers

Section 48: change parts - sorting blocks, orientation fingers, magazines

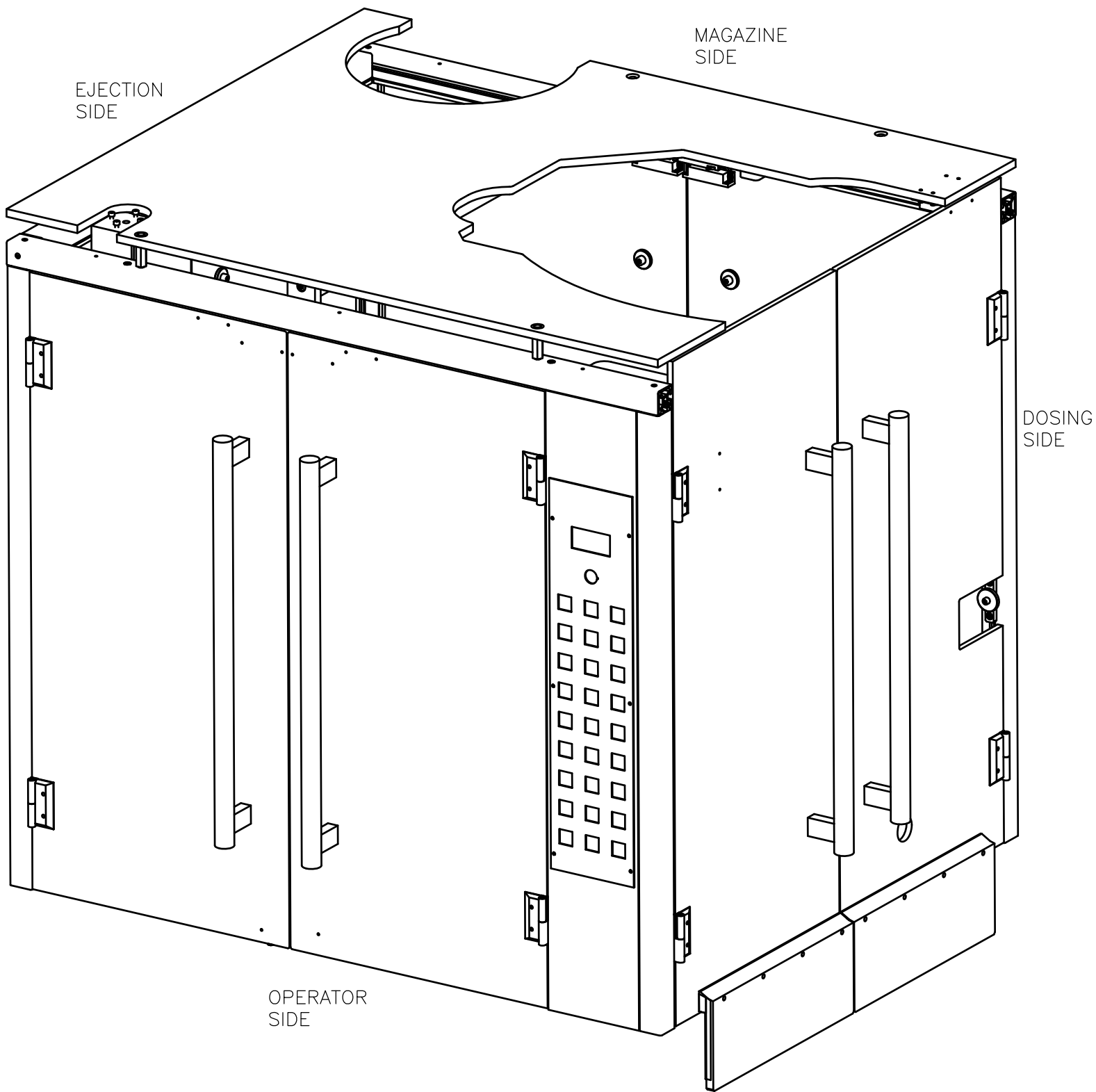
Screw, mount block holding, M6	4985
Screw, magazine holding	5339
Finger, magazine	5359
Bearing, magazine arm	5711
Spring, comp, magazine finger	5899
Arm, magazine adjusting	8188
Retaining ring, e-style	13040
Screw, 16ct orientation finger mount	23055
Screw, 12ct orientation finger mount	23163
Dowel pin	27138

	12ct	12ct plastic	16ct	16ct plastic
Sorting block, size 000	-	-	-	-
Sorting block, size 00e	25960	-	-	-
Sorting block, size 00	7347	27219	13500	-
Sorting block, size 0e	10308	-	-	-
Sorting block, size 0	7345	27220	13519	-
Sorting block, size 1	5356	8353	11865	-
Sorting block, size 2	5357	27221	10480	-
Sorting block, size 3	5358	25727	13520	27772
Sorting block, size 4	7346	24898	13521	-
Sorting block, size 5	-	-	-	-

	12ct	12ct plastic	16ct	16ct plastic
Orientation fingers, size 000	-	26614	13542	-
Orientation fingers, size 00e	25961	-	-	-
Orientation fingers, size 00	8219	26615	13610	-
Orientation fingers, size 0e	10309	-	-	-
Orientation fingers, size 0	14710	26616	13612	-
Orientation fingers, size 1	5353	26617	12087	-
Orientation fingers, size 2	5354	26526	10479	26755
Orientation fingers, size 3	5355	26618	13614	-
Orientation fingers, size 4	14711	26619	13615	-
Orientation fingers, size 5	-	-	-	-

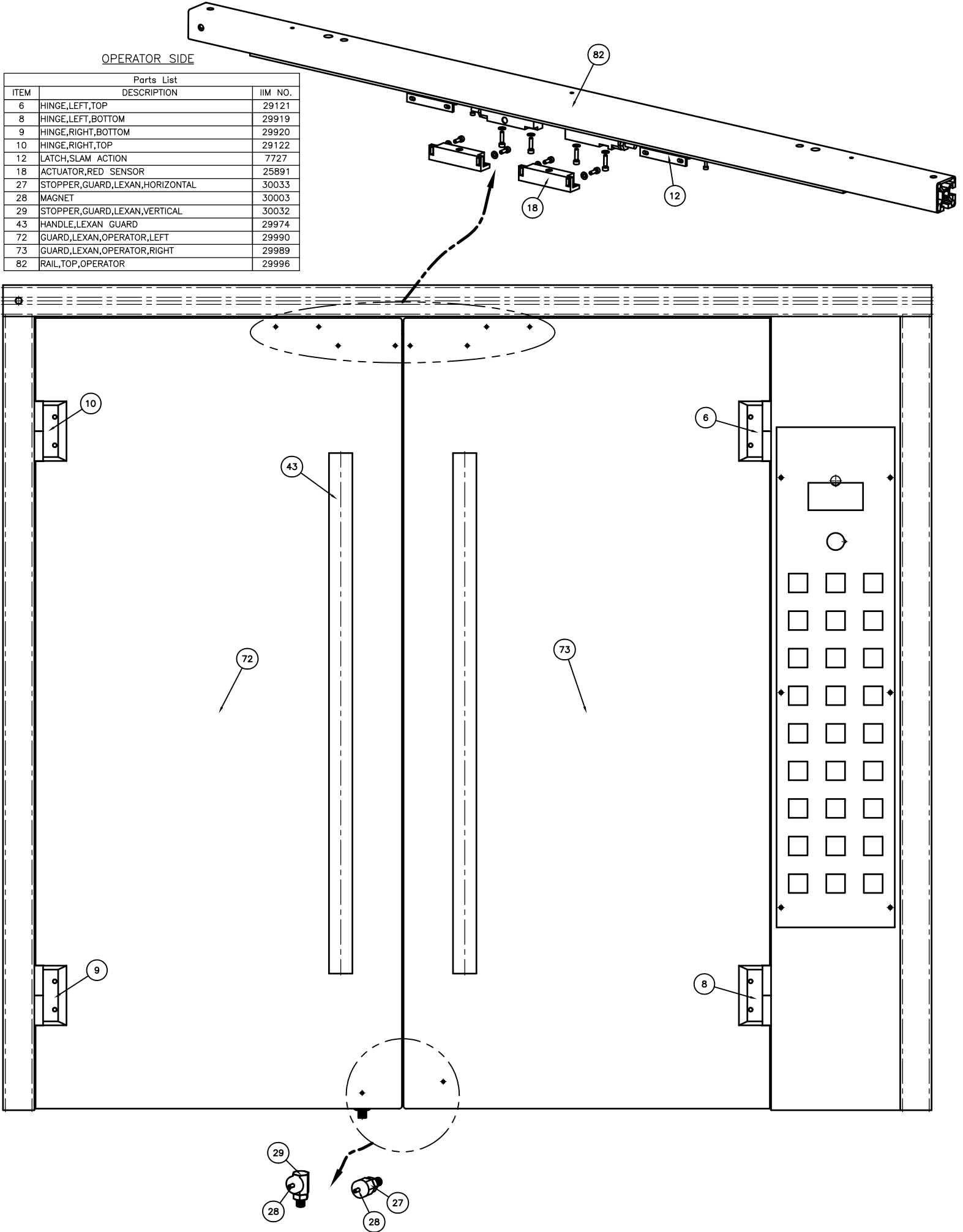
	12ct	16ct
Magazine, size 000	-	13661
Magazine, size 00e	26015	-
Magazine, size 00	26053	13663
Magazine, size 0e	24234	-
Magazine, size 0	15438	13829
Magazine, size 1	5351	12110
Magazine, size 2	7203	10481
Magazine, size 3	3515	13830
Magazine, size 4	15437	13881
Magazine, size 5	-	13900

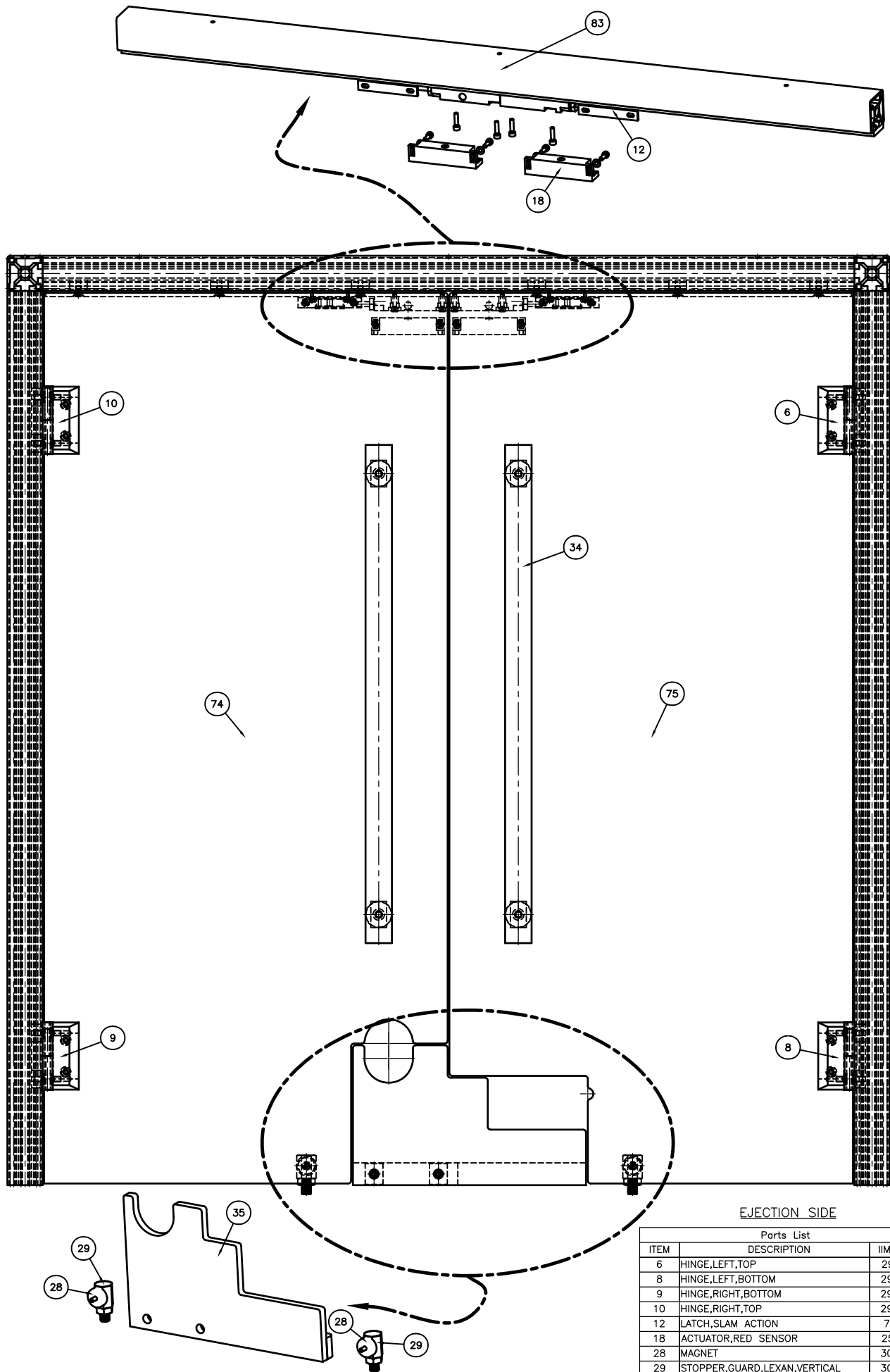
	12ct	16ct
Size change kit, size 000	25805	-
Size change kit, size 00e	15812	-
Size change kit, size 00	6244	7246
Size change kit, size 0e	24158	5371
Size change kit, size 0	24763	7247
Size change kit, size 1	6246	7248
Size change kit, size 2	6247	7249
Size change kit, size 3	6248	7250
Size change kit, size 4	6249	7251
Size change kit, size 5	-	7252



OPERATOR SIDE

Parts List		
ITEM	DESCRIPTION	IIM NO.
6	HINGE,LEFT,TOP	29121
8	HINGE,LEFT,BOTTOM	29919
9	HINGE,RIGHT,BOTTOM	29920
10	HINGE,RIGHT,TOP	29122
12	LATCH,SLAM ACTION	7727
18	ACTUATOR,RED SENSOR	25891
27	STOPPER,GUARD,LEXAN,HORIZONTAL	30033
28	MAGNET	30003
29	STOPPER,GUARD,LEXAN,VERTICAL	30032
43	HANDLE,LEXAN GUARD	29974
72	GUARD,LEXAN,OPERATOR,LEFT	29990
73	GUARD,LEXAN,OPERATOR,RIGHT	29989
82	RAIL,TOP,OPERATOR	29996



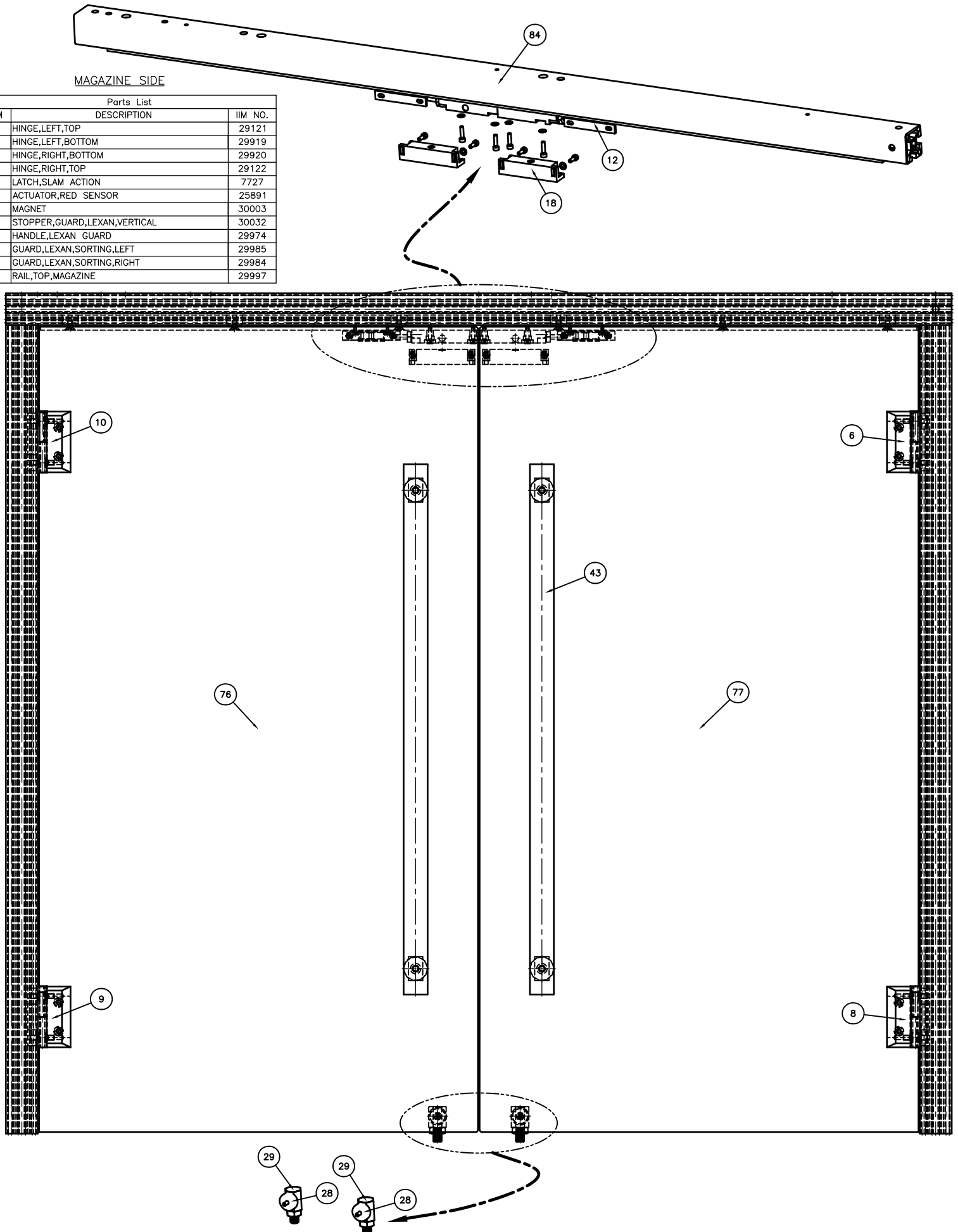


EJECTION SIDE

Parts List		
ITEM	DESCRIPTION	IIM NO.
6	HINGE,LEFT,TOP	29121
8	HINGE,LEFT,BOTTOM	29919
9	HINGE,RIGHT,BOTTOM	29920
10	HINGE,RIGHT,TOP	29122
12	LATCH,SLAM ACTION	7727
18	ACTUATOR,RED SENSOR	25891
28	MAGNET	30003
29	STOPPER,GUARD,LEXAN,VERTICAL	30032
34	HANDLE,LEXAN GUARD,SHORT	29975
35	GUARD,BELOW EJECT CHUTE	29139
74	GUARD,LEXAN,EJECTION,LEFT	29987
75	GUARD,LEXAN,EJECTION,RIGHT	29986
83	RAIL,TOP,EJECTION	29998

MAGAZINE SIDE

Parts List		
ITEM	DESCRIPTION	IIM NO.
6	HINGE,LEFT, TOP	29121
8	HINGE,LEFT, BOTTOM	29919
9	HINGE,RIGHT,BOTTOM	29920
10	HINGE,RIGHT, TOP	29122
12	LATCH,SLAM ACTION	7727
18	ACTUATOR,RED SENSOR	25891
28	MAGNET	30003
29	STOPPER, GUARD, LEXAN, VERTICAL	30032
43	HANDLE, LEXAN GUARD	29974
76	GUARD, LEXAN, SORTING, LEFT	29985
77	GUARD, LEXAN, SORTING, RIGHT	29984
84	RAIL, TOP, MAGAZINE	29997



DOSING SIDE

Parts List		
ITEM	DESCRIPTION	IIM NO.
6	HINGE,LEFT, TOP	29121
8	HINGE,LEFT, BOTTOM	29919
9	HINGE,RIGHT,BOTTOM	29920
10	HINGE,RIGHT, TOP	29122
18	ACTUATOR,RED SENSOR	25891
27	STOPPER, GUARD, LEXAN, HORIZONTAL	30033
28	MAGNET	30003
43	HANDLE, LEXAN GUARD	29974
48	MAGNET	29192
52	BAR, HOLDER, SUPPORT, OCTOPUS	29952
55	SKIRT, RIGHT, GUARD, LEXAN, DOSING	30031
56	SKIRT, LEFT, GUARD, LEXAN, DOSING	30031
78	GUARD, LEXAN, DOSING, LEFT	29988
79	GUARD, LEXAN, DOSING, RIGHT	29991

