



**GKF 1500**  
Capsule filling machine  
Replacement spare parts

**INTERNATIONAL INVENTORY MANAGEMENT**

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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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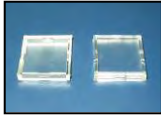
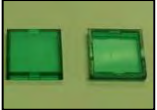

<b>Section</b>	<b>Description</b>
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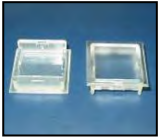

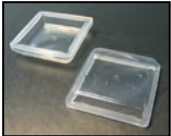
46	Change parts: segment blocks, alignment pins
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### **Pellet/Bead feed parts**

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50.5	Dosing chambers, station 6
50.6	Exit plates, 12 and 16 count
50.7	Hopper and base

## Section ELEC: operator panel parts

IIM p/n	Description	Image
2554	Contact, momentary "ATL 2"	
3091	Contact, maintained "AFL 2"	
3090	Socket, pilot	
3403	Pushbutton	
3408	Pilot light	
3089	Bulb	
3404	Plate, label, white/opaque	
3409	Lens, pushbutton, clear	
3406	Lens, pushbutton, green	
3407	Lens, pushbutton, red	

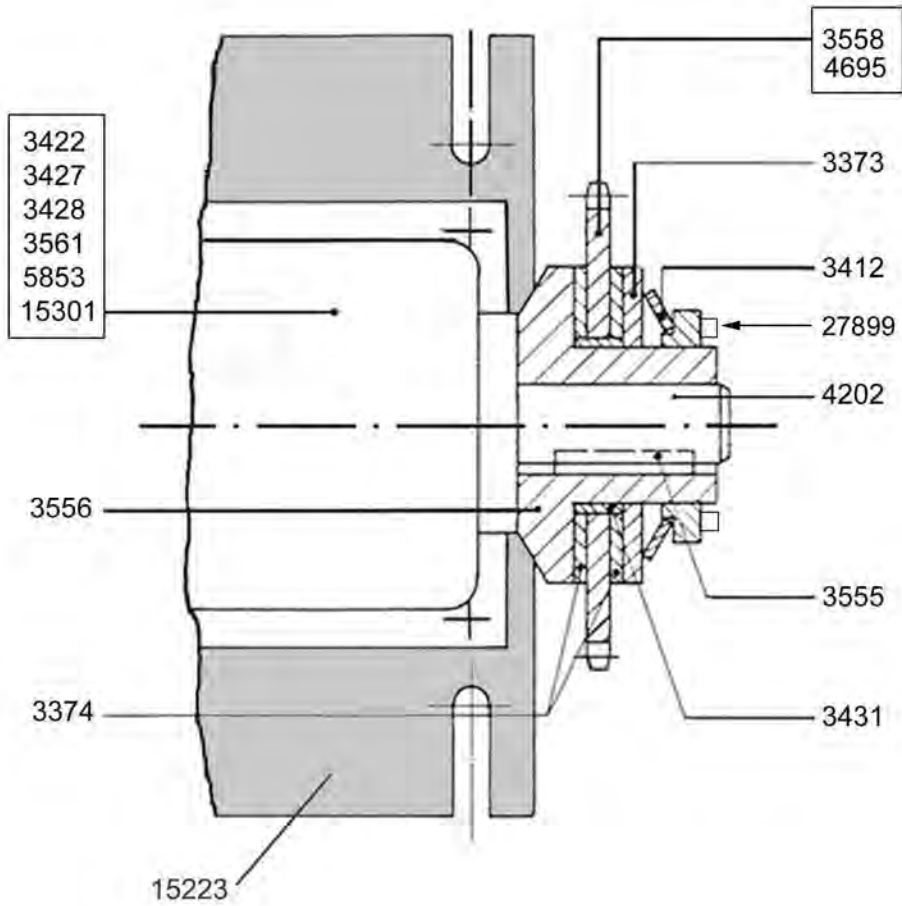
IIM p/n	Description	Image
3401	Lens, pilot, clear	
3405	Lens, pilot, red	
31743	Silicone cover	

### Pushbutton labels

Label	IIM p/n
Air pressure	5410
Auger feeding	5419
Brake open	5414
Capsule alarm	30625
Cleaning segment	5422
Control voltage	5409
Doors open	5423
Feed control	5420
Feeder jog	5421
Inching	5417
Level sensor alarm	5425
Lock-off capsules	5424
Normal run	5415
Reset	5413
Start	5412
Stop	5416
Vacuum alarm	5411
Vacuum on/off	5418
Water	5434



## Section 1.2: main drive



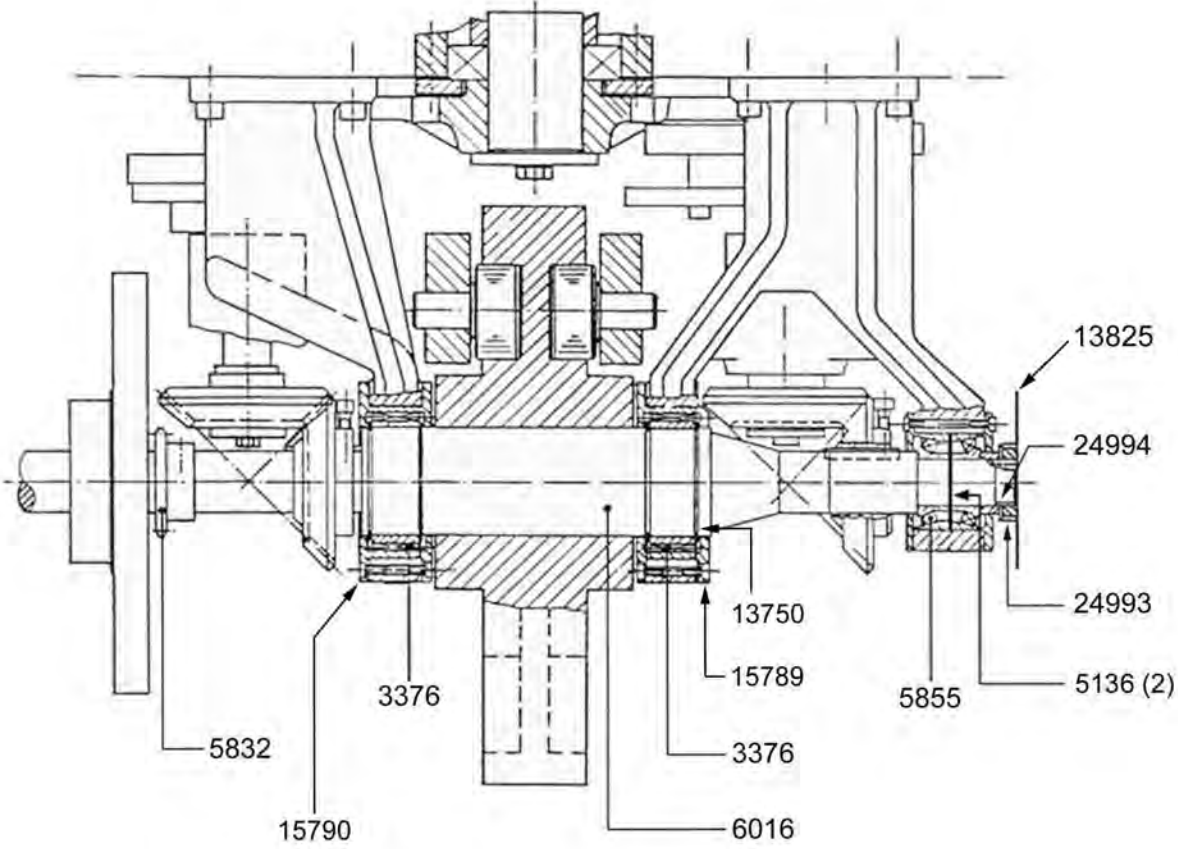
**Section 1: Main drive**

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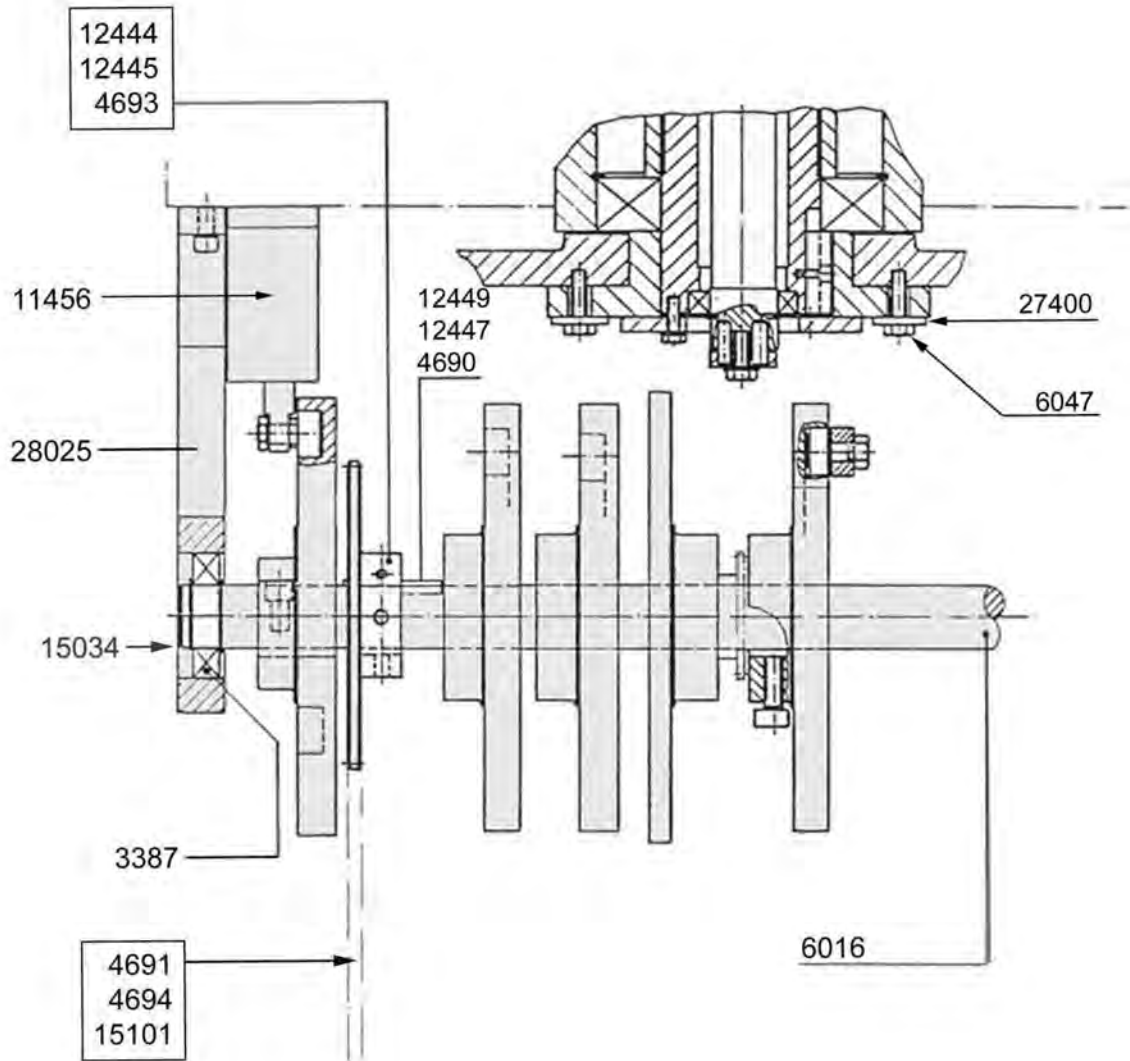
<b>IIM No.</b>	<b>Description</b>
3373	DISC, PRESSURE
3374	LINING, FRICTION
3412	SPRING, DISC
3417	BRAKE
3418	DISC, FOR BRAKE IIM 3417
3422	SEAL, SHAFT, LENZE
3424	MAIN DRIVE COMPLETE
3425	GEARBOX, MAIN DRIVE
3426	ADJUSTMENT MECHANISM
3427	BEARINGS, KIT OF 2, LENZE
3428	SPUR GEAR, LENZE
3429	PULLEY, MECHANICAL ADJUSTMENT
3430	PULLEY, SPRING LOADED, DRIVEN
3431	BUSHING
3432	V-BELT, MAIN DRIVE, 28 X 750, NEW STYLE
3443	MOTOR, MAIN DRIVE, W/BRAKE
3546	HOUSING ONLY, MAIN DRIVE TRANSMISSION
3555	KEY,OUTPUT SHAFT,MAIN DRIVE GEARBOX (OLD STYLE)
3556	SLIP CLUTCH, 500-1
3558	SPROCKET, MAIN DRIVE, 40 TEETH, DIA 30
3561	GEARBOX OVERHAUL KIT
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
11327	GEARBOX,COMPLETE,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, INPUT SHAFT, MAIN DRIVE GEARBOX
15807	MOTOR, MAIN DRIVE, H&K 2400
15808	PULLEY, VARIABLE SPEED, H&K 2400
15809	V-BELT, MAIN DRIVE, H&K 2400
16390	GEARBOX REPAIR (EXCHANGE)
16473	ALIGNMENT GUIDE,MAIN DRIVE GEARBOX
25839	MAIN DRIVE OVERHAUL
25924	GEARBOX, MAIN DRIVE, NEW STYLE (SQUARE)
27807	HANDWHEEL, SPEED ADJUSTMENT
28890	PLASTIC CAP
29166	HANDWHEEL, 18mm BORE



# Section 2.1: main shaft support



## Section 2.2: main shaft support

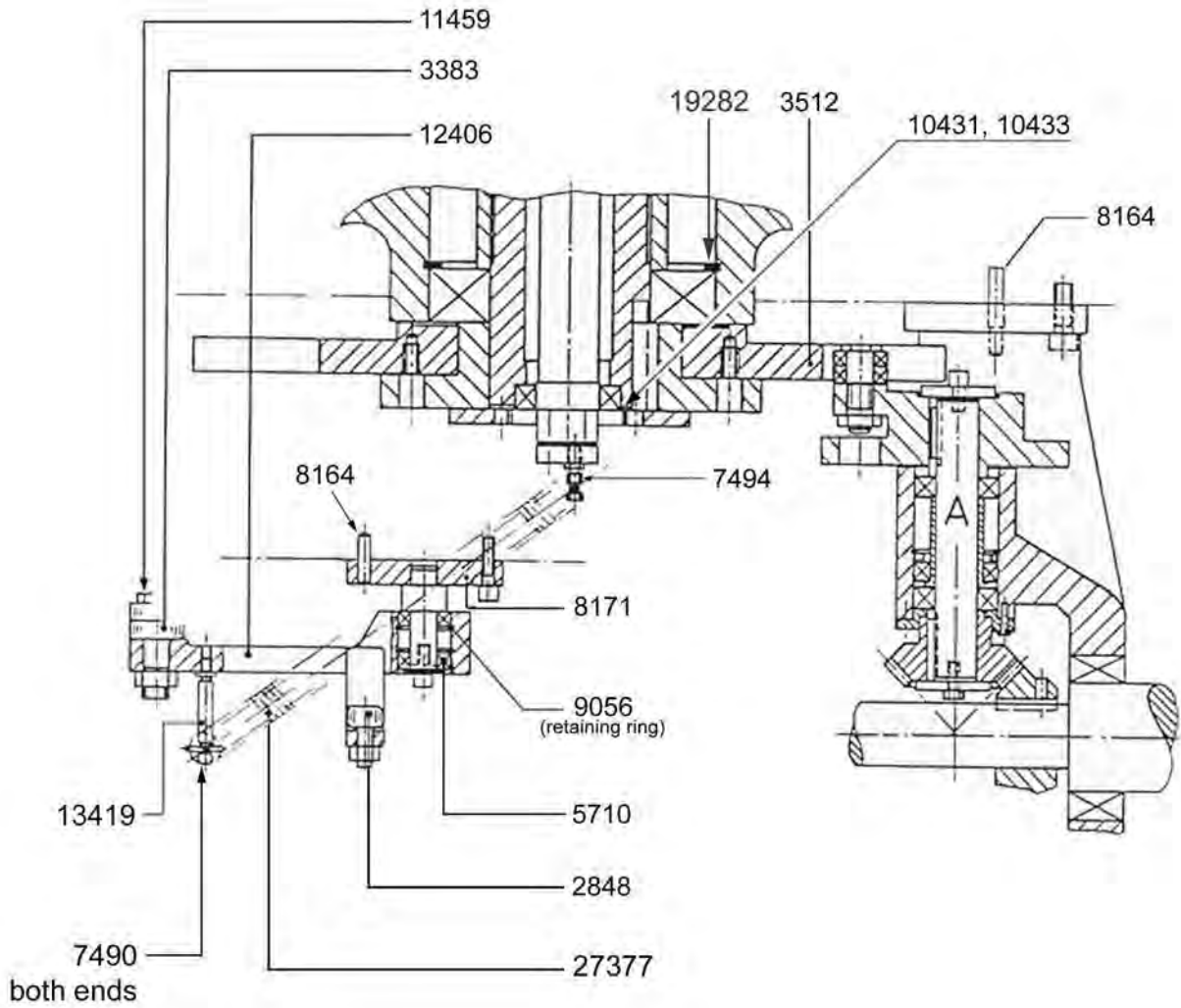


## Section 2: Support, main shaft

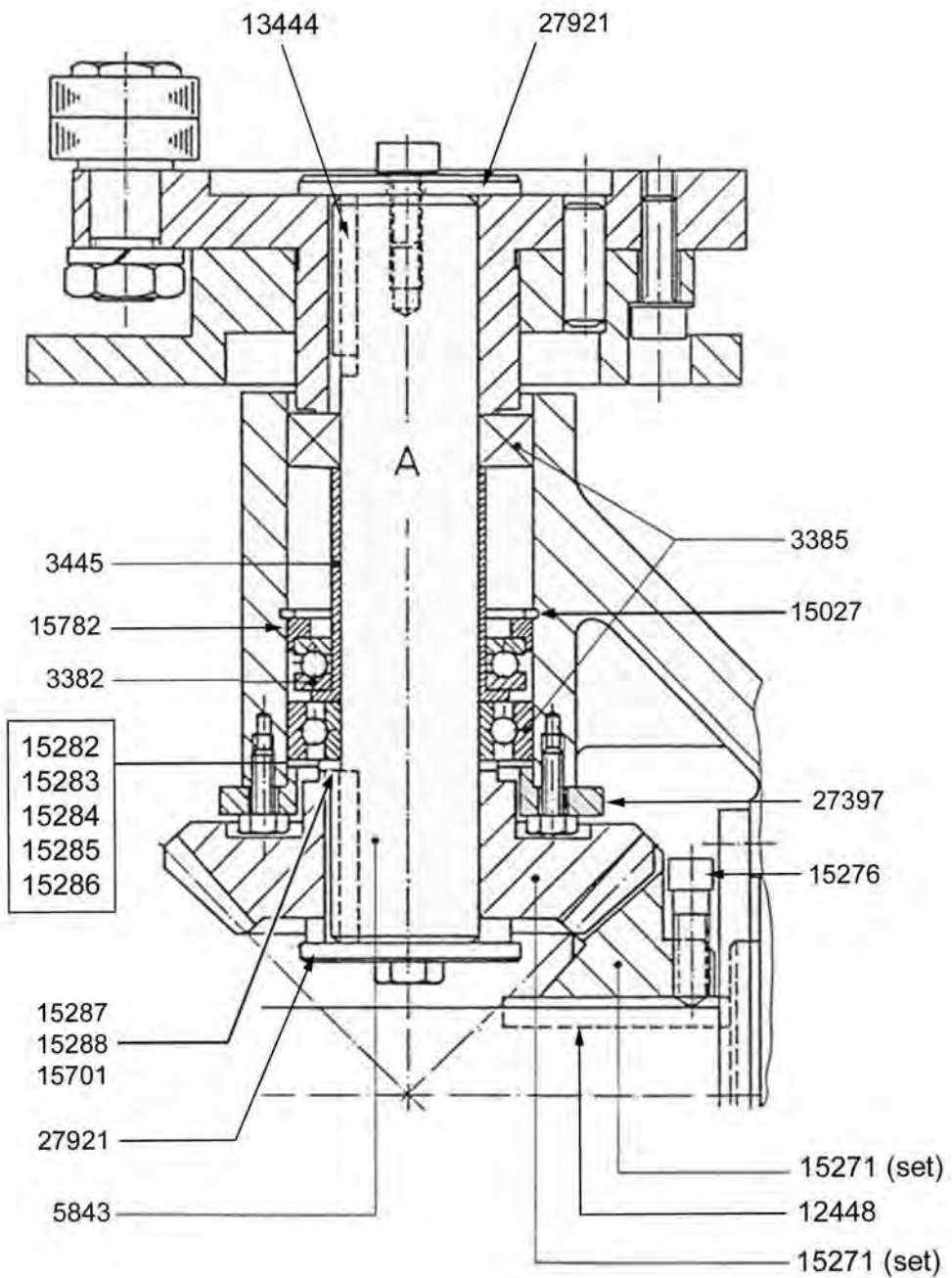
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IIM No.	Description
3376	BEARING, NEEDLE
3387	BEARING, BALL
4690	KEY
4691	CHAIN, 1500
4693	SPROCKET,DRIVEN,38 TEETH,8MM KEY
4694	MASTER LINK
5136	SHIM,50 X 62 X 1
5832	WHEEL, CHAIN
5855	BEARING W/ROLLER
6016	SHAFT, MAIN DRIVE
6047	HEX BOLT
11456	HOUSING, 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

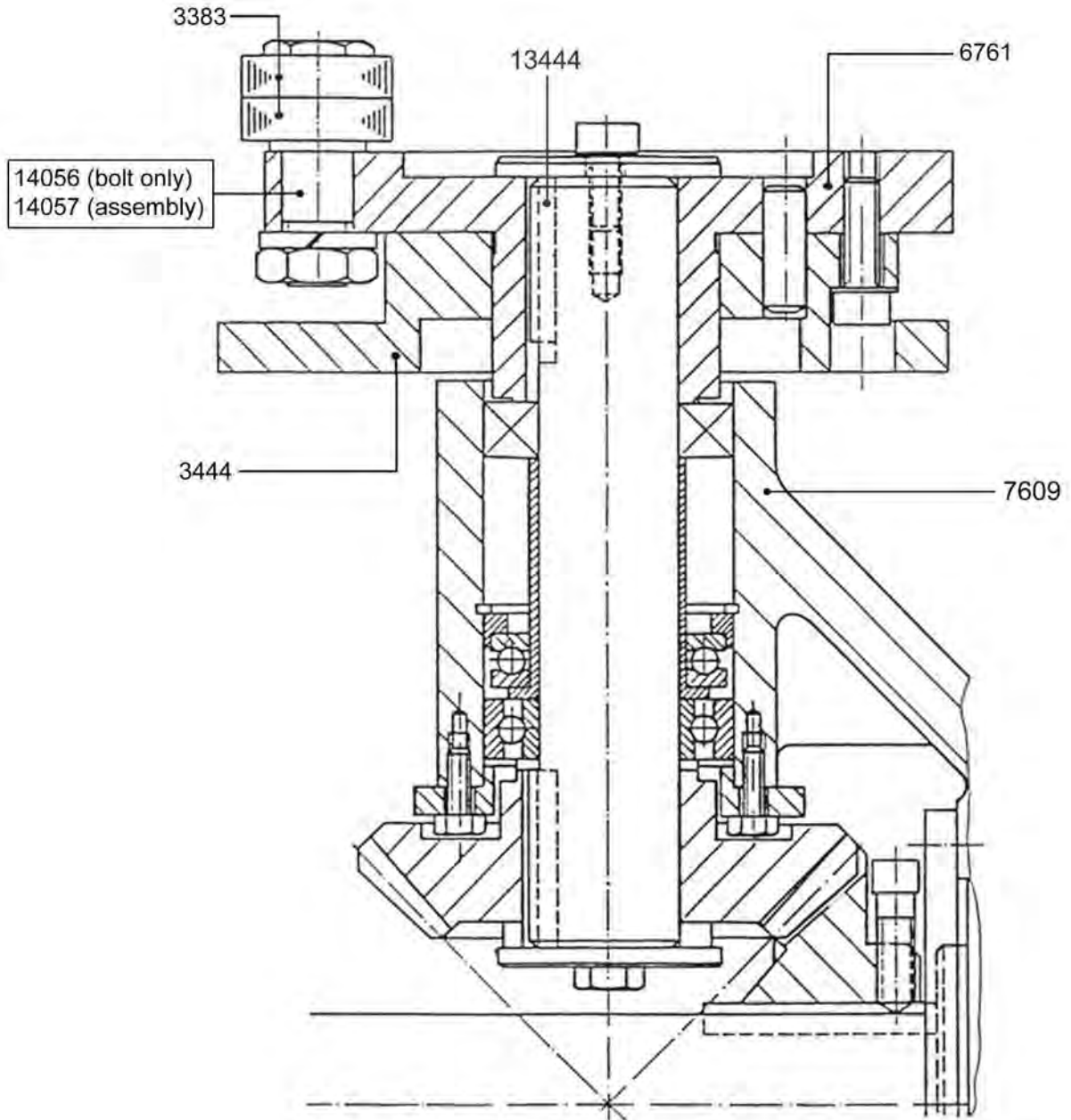


### Section 3: segment geneva

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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.

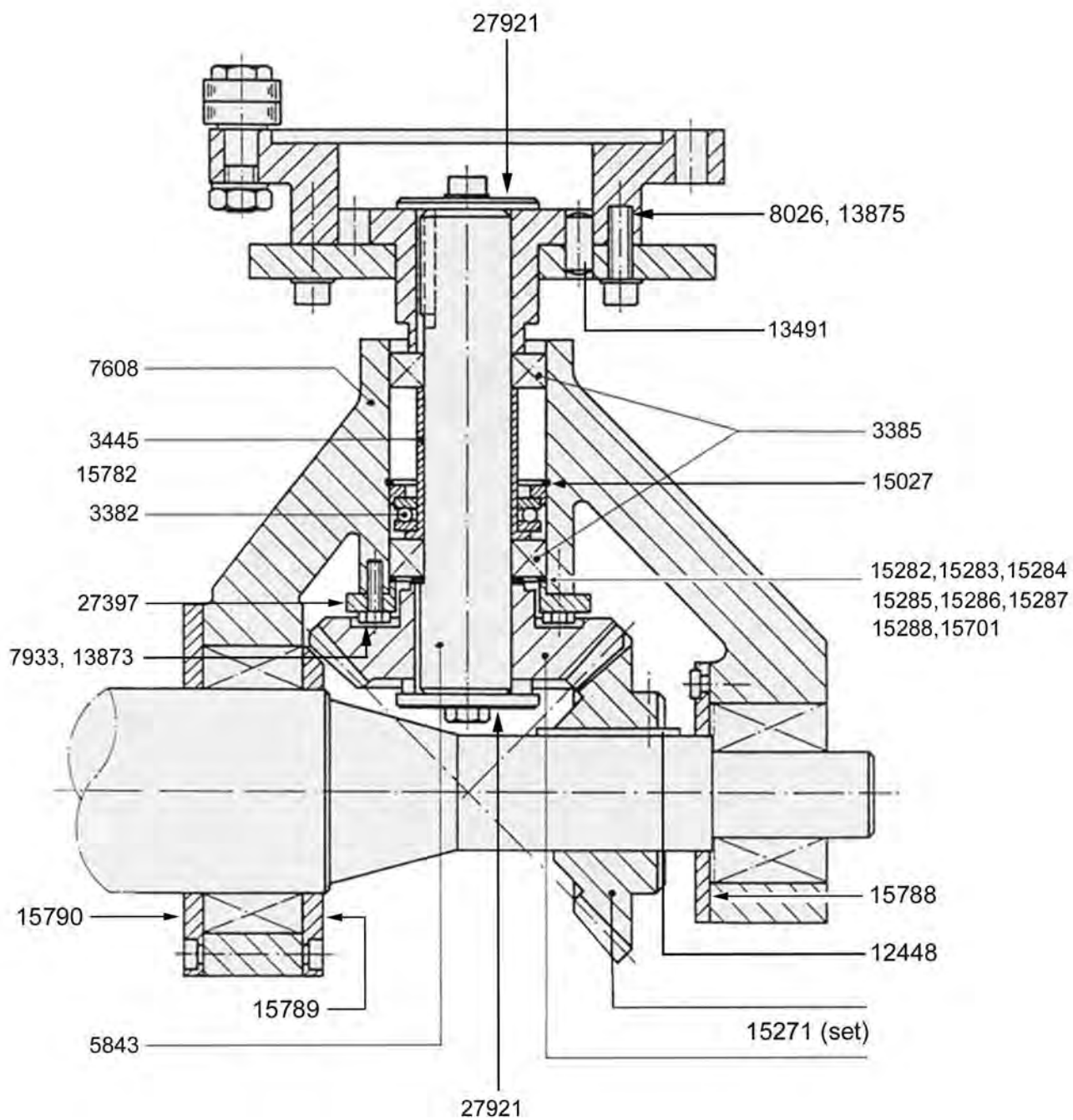
#### Section 4: Drive cam, segment drive, single yoke

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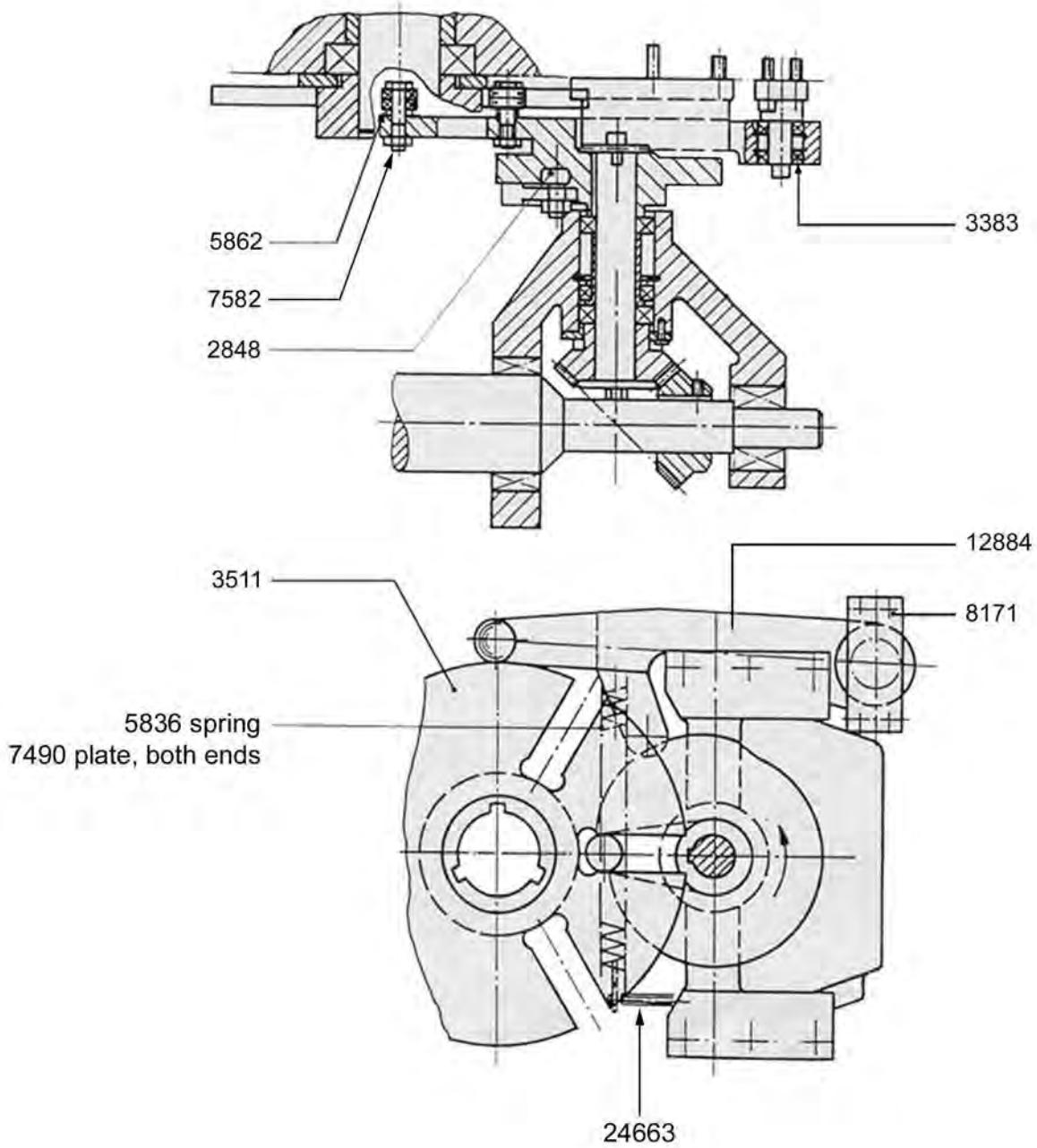
IIM No.	Description
3383	BEARING,BALL,DEEP GROOVE
3444	CAM,PEANUT,LARGE/SEGMENT GENEVA
6761	CAM,DRIVE RATCHET,LARGE/SEGMENT GENEVA
7609	SINGLE YOKE HOUSING
9277	DOWEL PIN M10 X 24
13444	KEY
14056	BOLT ONLY
14057	CAM ROLLER ASSY
25407	PEANUT CAM/RATCHET ASSEMBLY - comes assembled with 4 mount screws and alignment dowel.



# Section 5.1: dosing geneva, double yoke



## Section 5.2: dosing geneva, double yoke

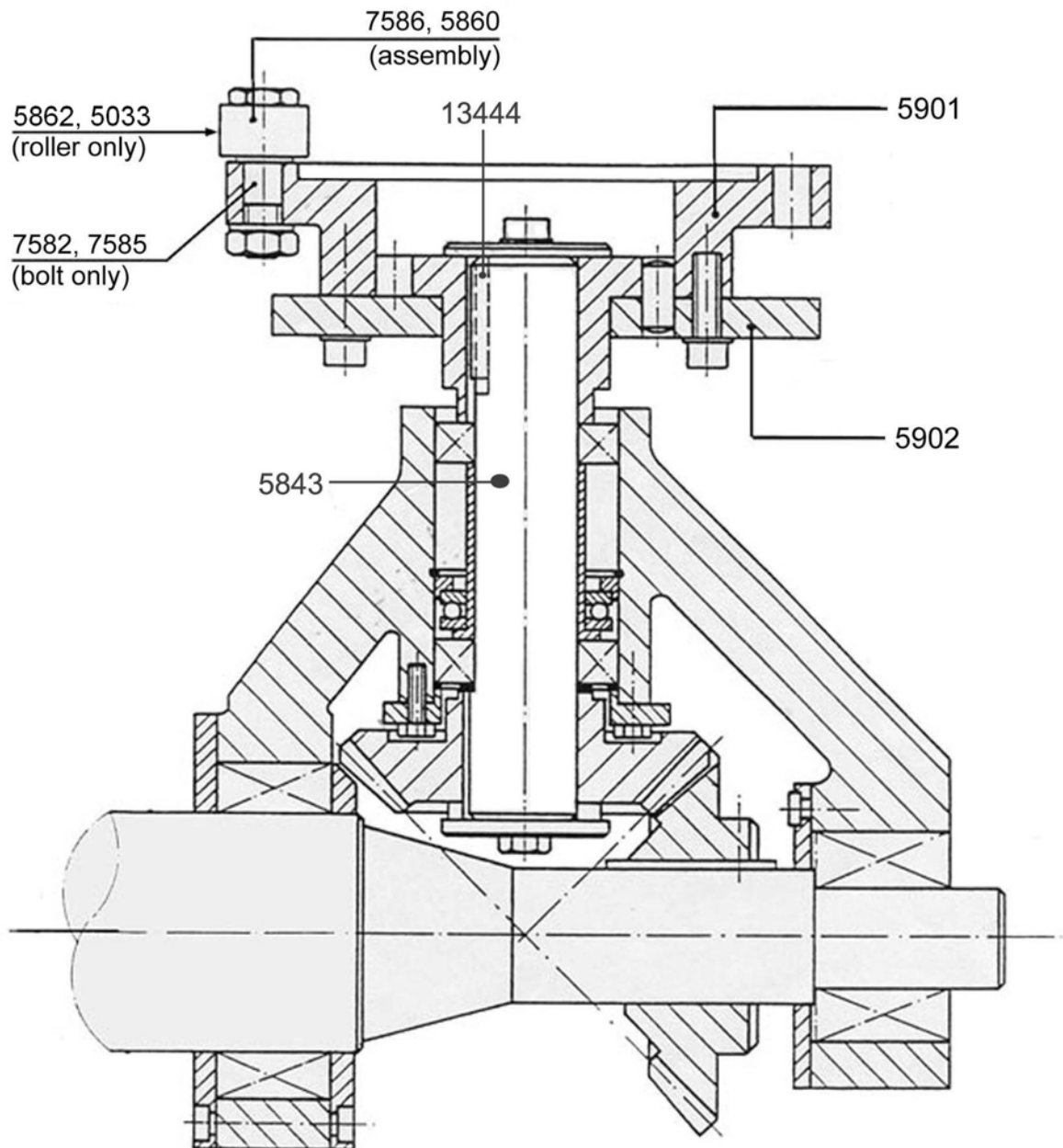


## Section 5: Dosing geneva, double yoke

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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



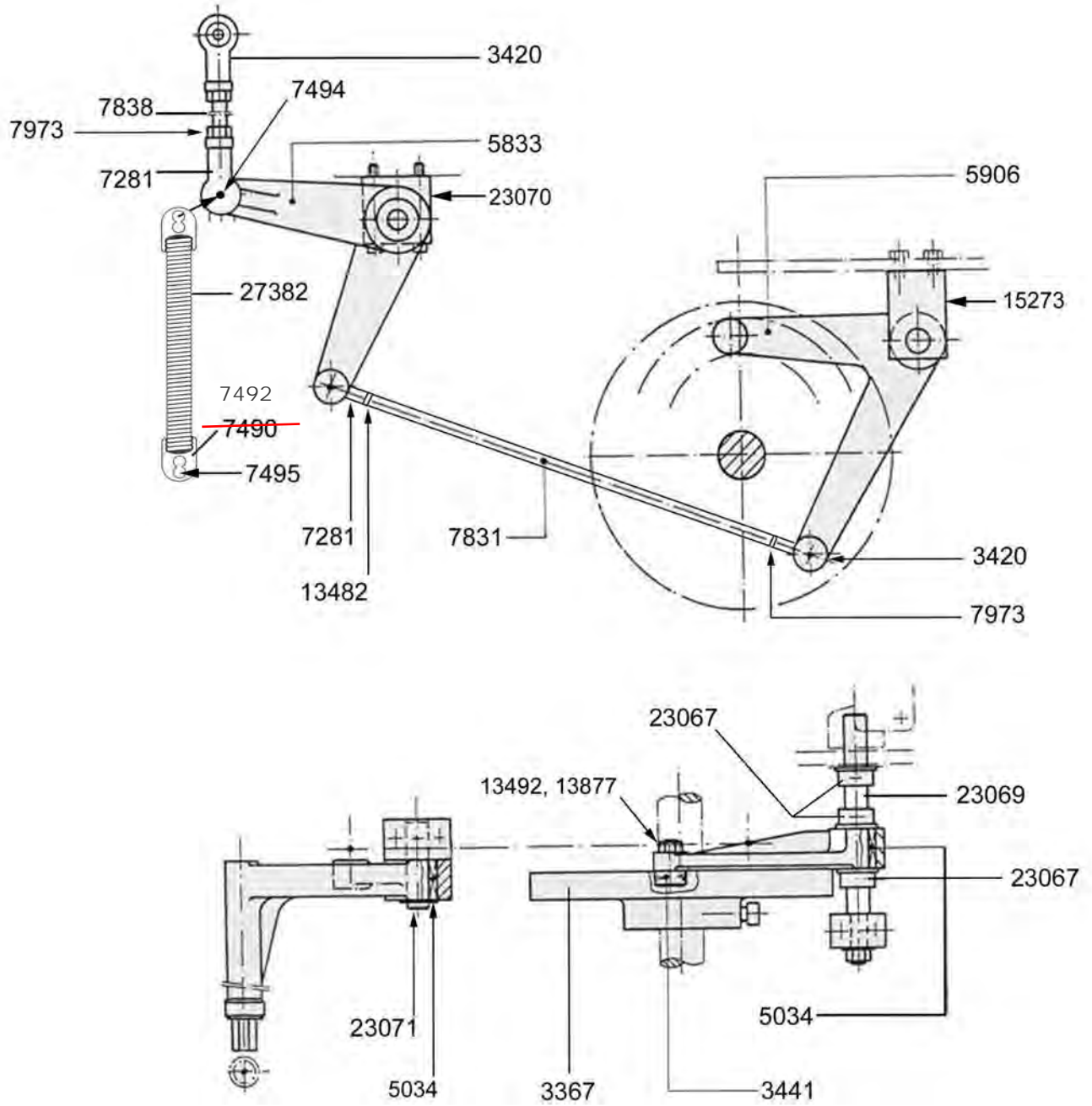
25406 Assembly includes Peanut Cam (5902), Hub (5901) & Geneva Drive Bolt w/ bearings (7586).  
Parts come pre-assembled with 4 mount screws & alignment dowel.

## Section 6: Drive cam, dosing geneva, double yoke

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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

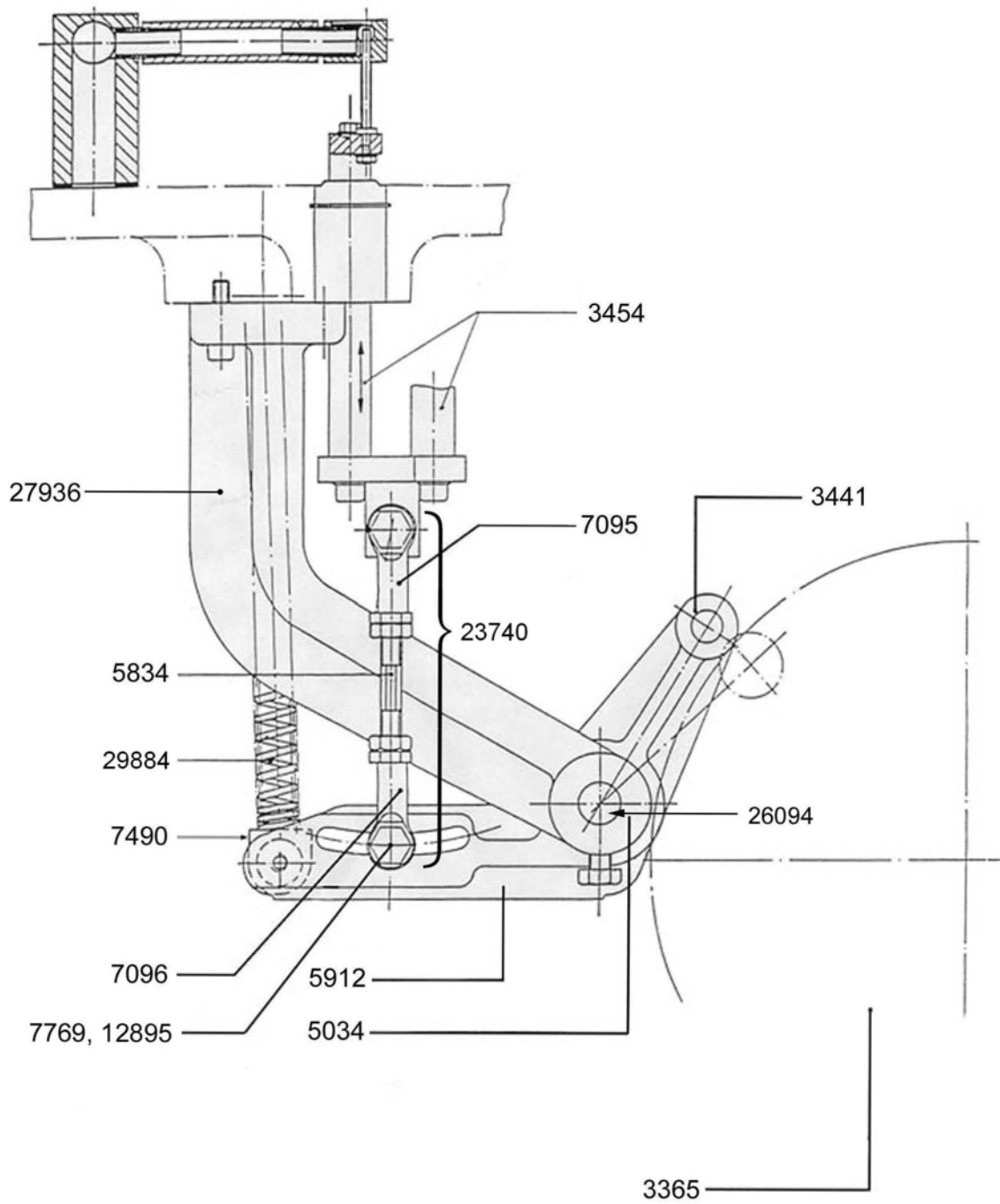


## Section 7: sorting drive

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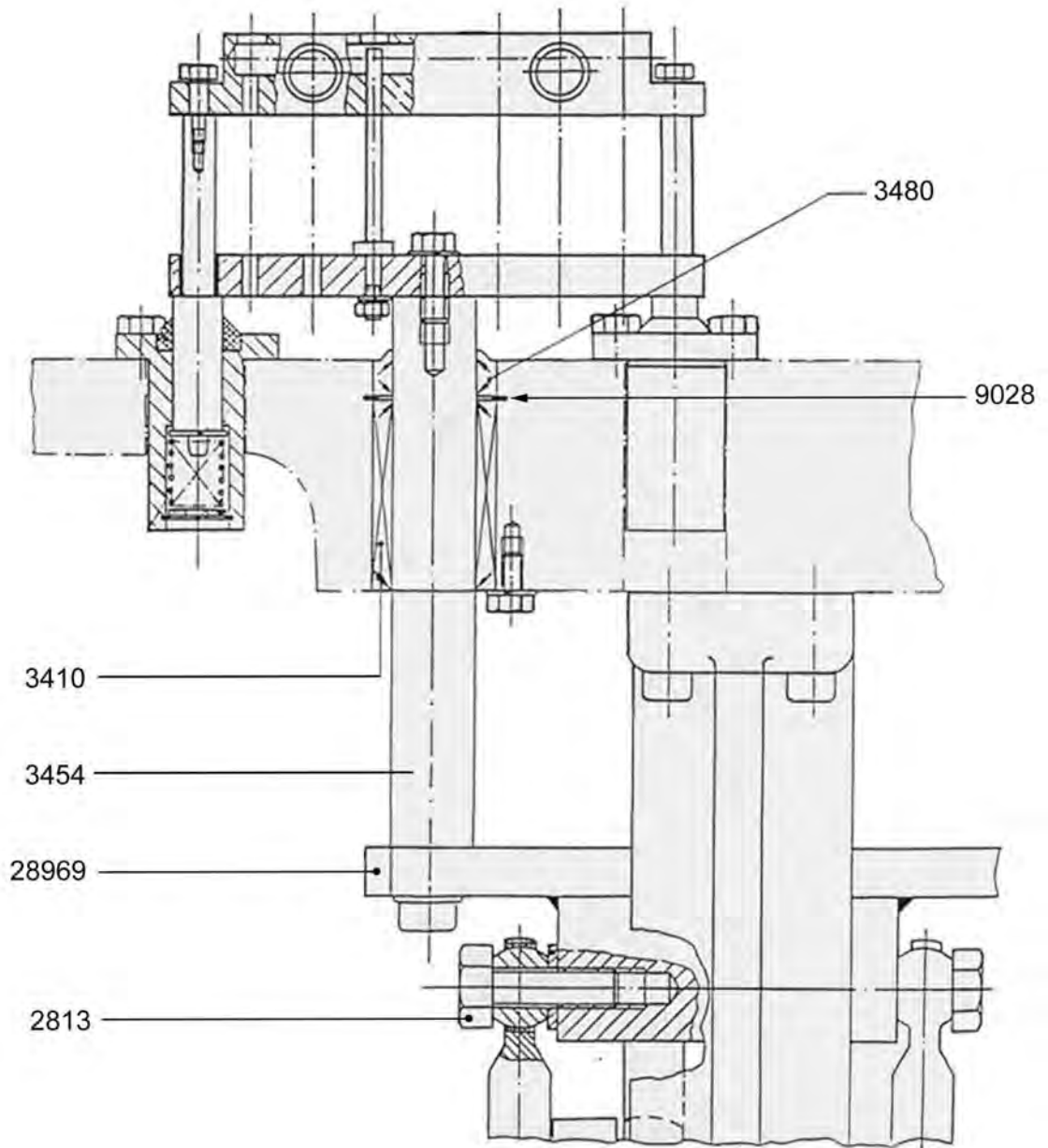
IIM No.	Description
3367	CAM,SORTING
3420	ROD END,RIGHT,M12
3441	BEARING,CAM FOLLOWER
5034	BEARING
5833	LEVER, DRIVE, SORTING STATION
5906	LEVER,CAM,SORTING MECHANISM DRIVE
7281	ROD END,LEFT,M12
7492	PLATE, SPRING HOLDING
7494	ROD,SPRING FASTENER
7495	ROD,SPRING FASTENER,HEX,90 DEGREE
7831	ROD,CONNECTING
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

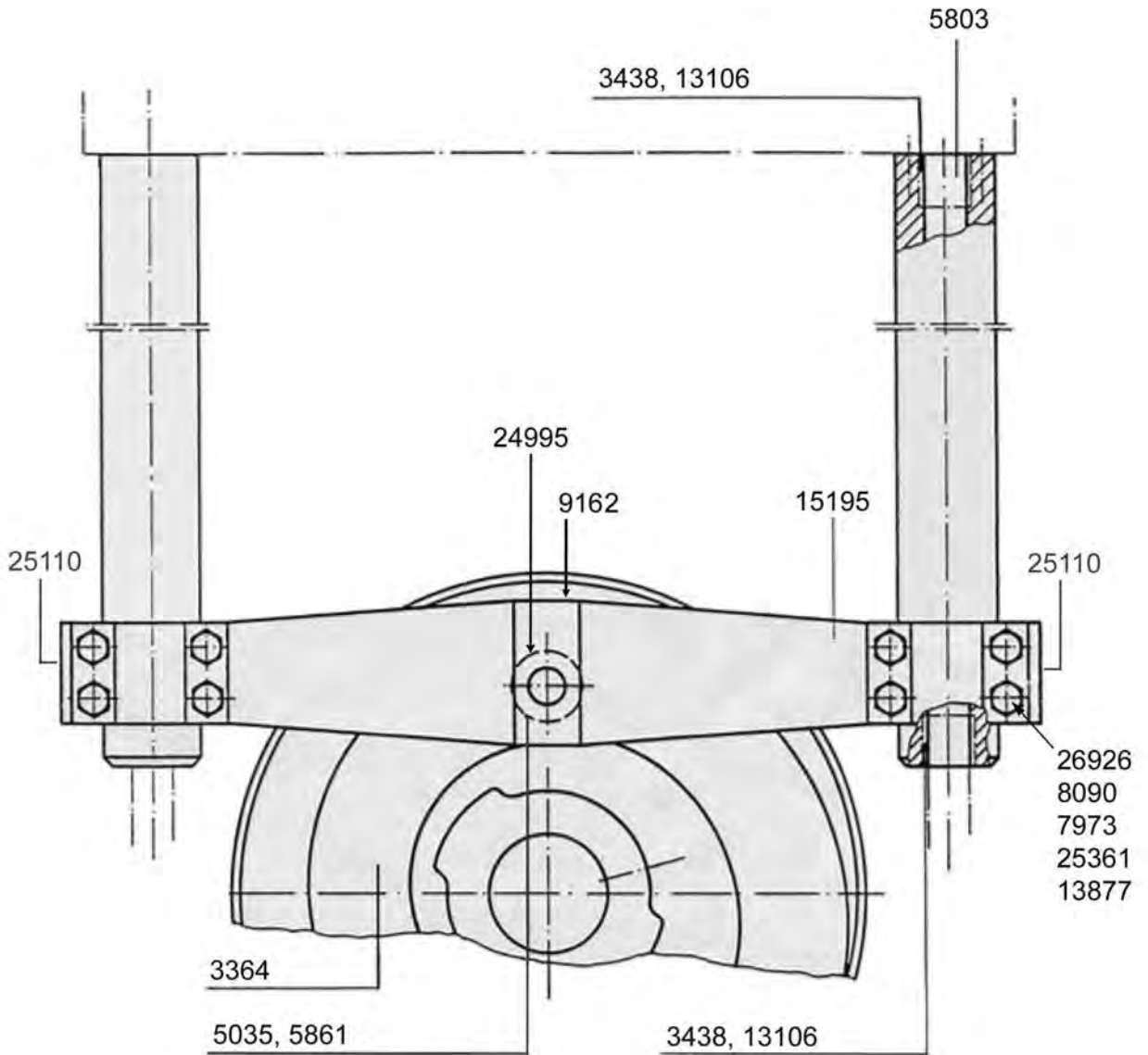


## Section 8: separation drive

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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
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, SPRING, 90 DEGREE, BEARING STYLE
23740	TURNBUCKLE, M12, COMPLETE
26094	SHAFT,PIVOT,SEPARATION/LOWER CLOSING
27936	SUPPORT
28969	SEPARATION CROSS BAR
29884	SPRING, EXT, SEPARATION DRIVE

# Section 9: tamping drive

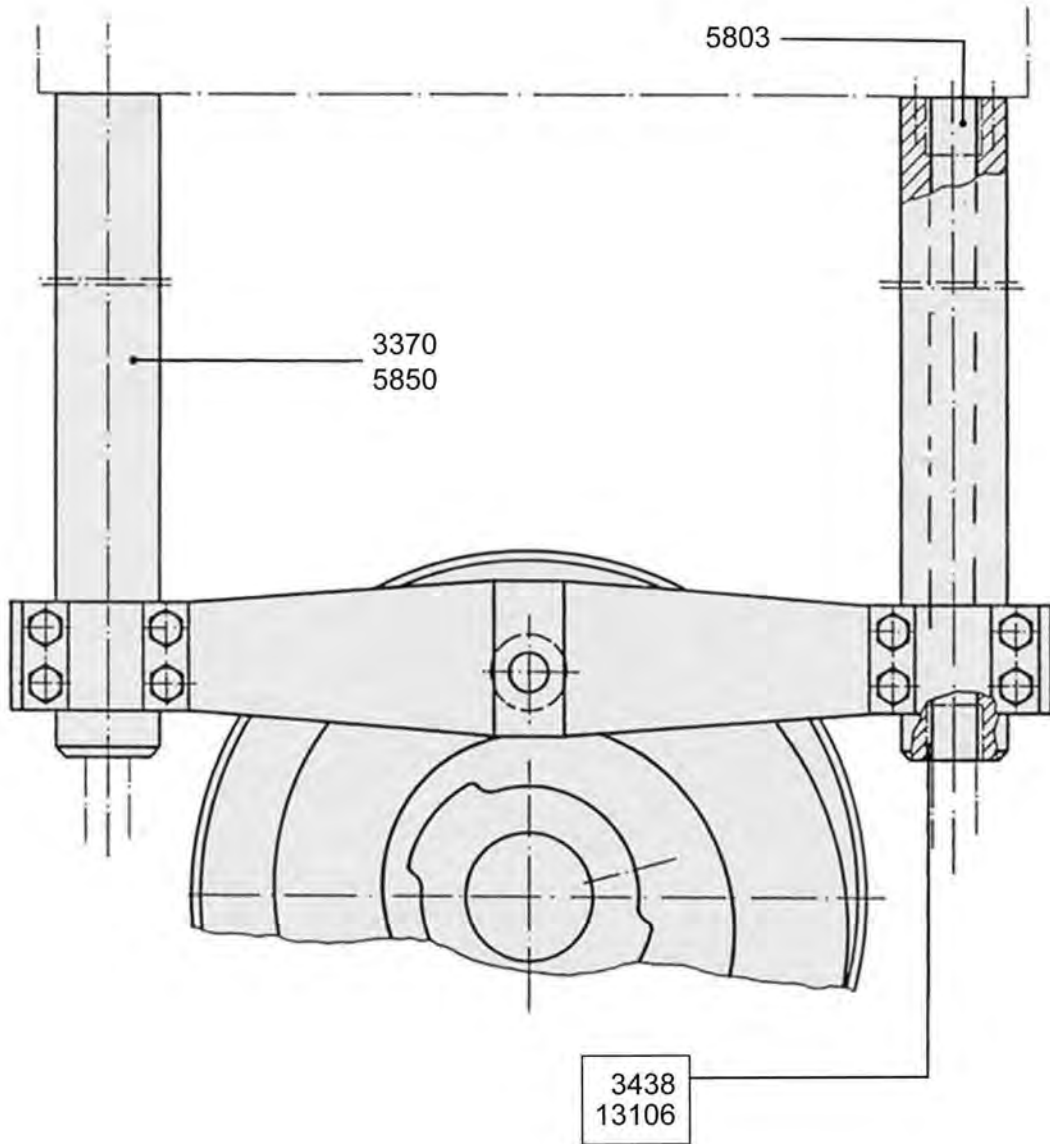


## Section 9: tamping drive

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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

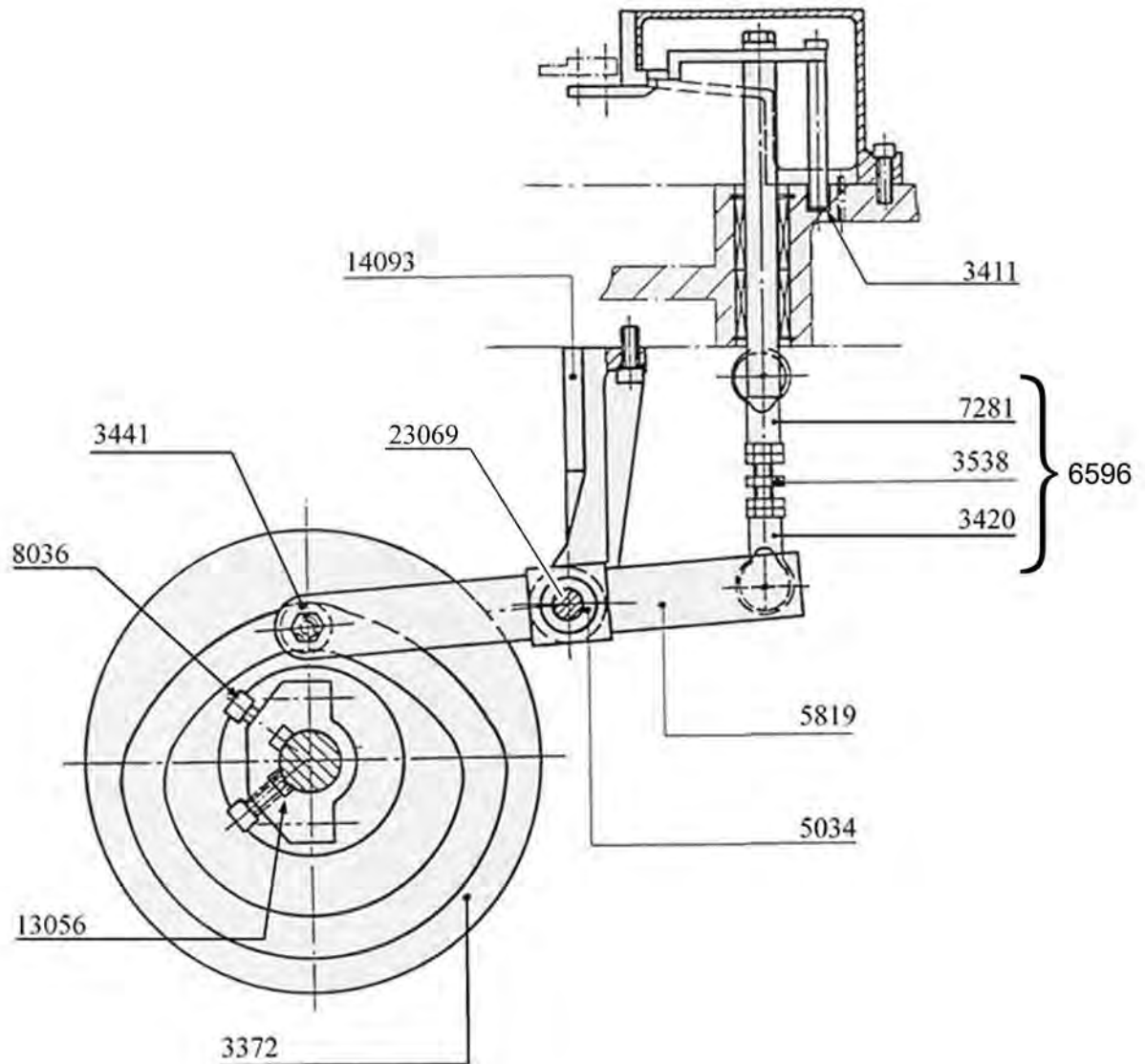


## Section 10: tamping shafts

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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



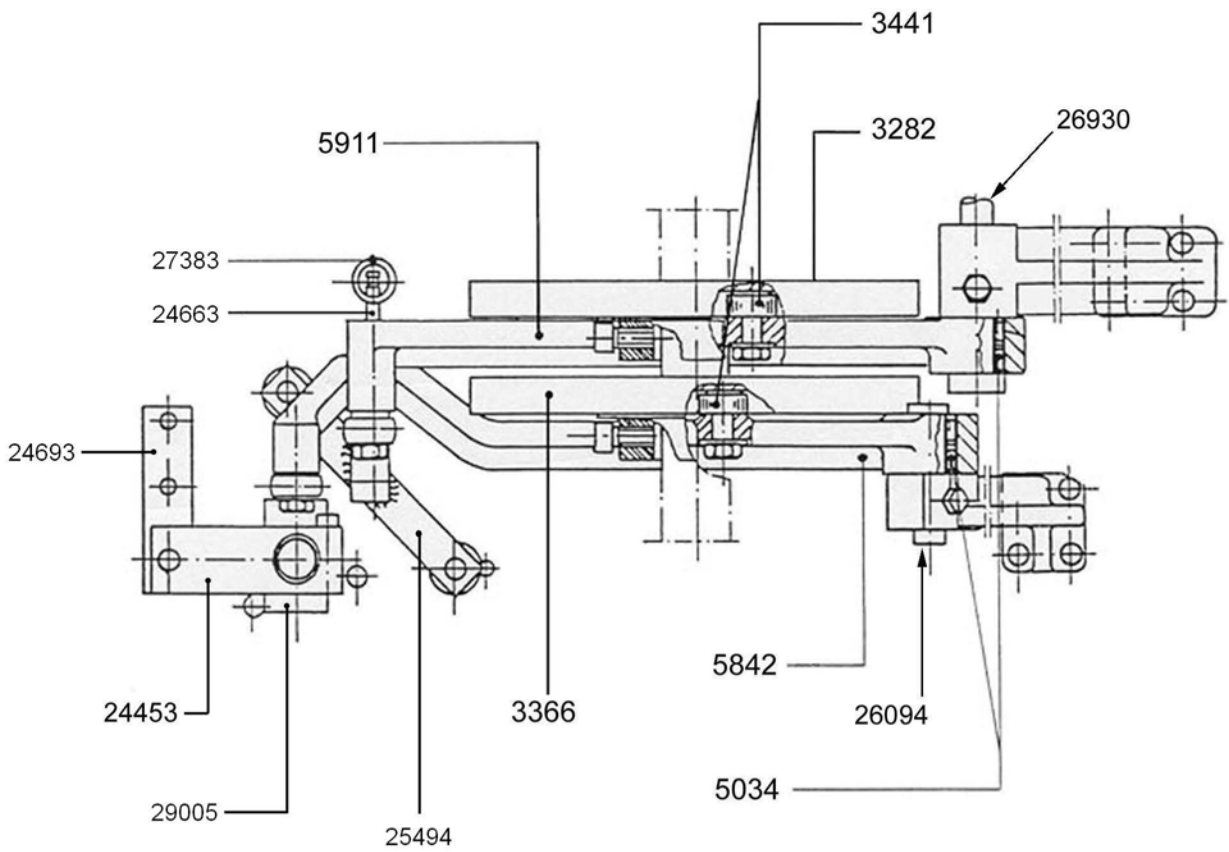
## Section 11: faulty capsule drive, old style

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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

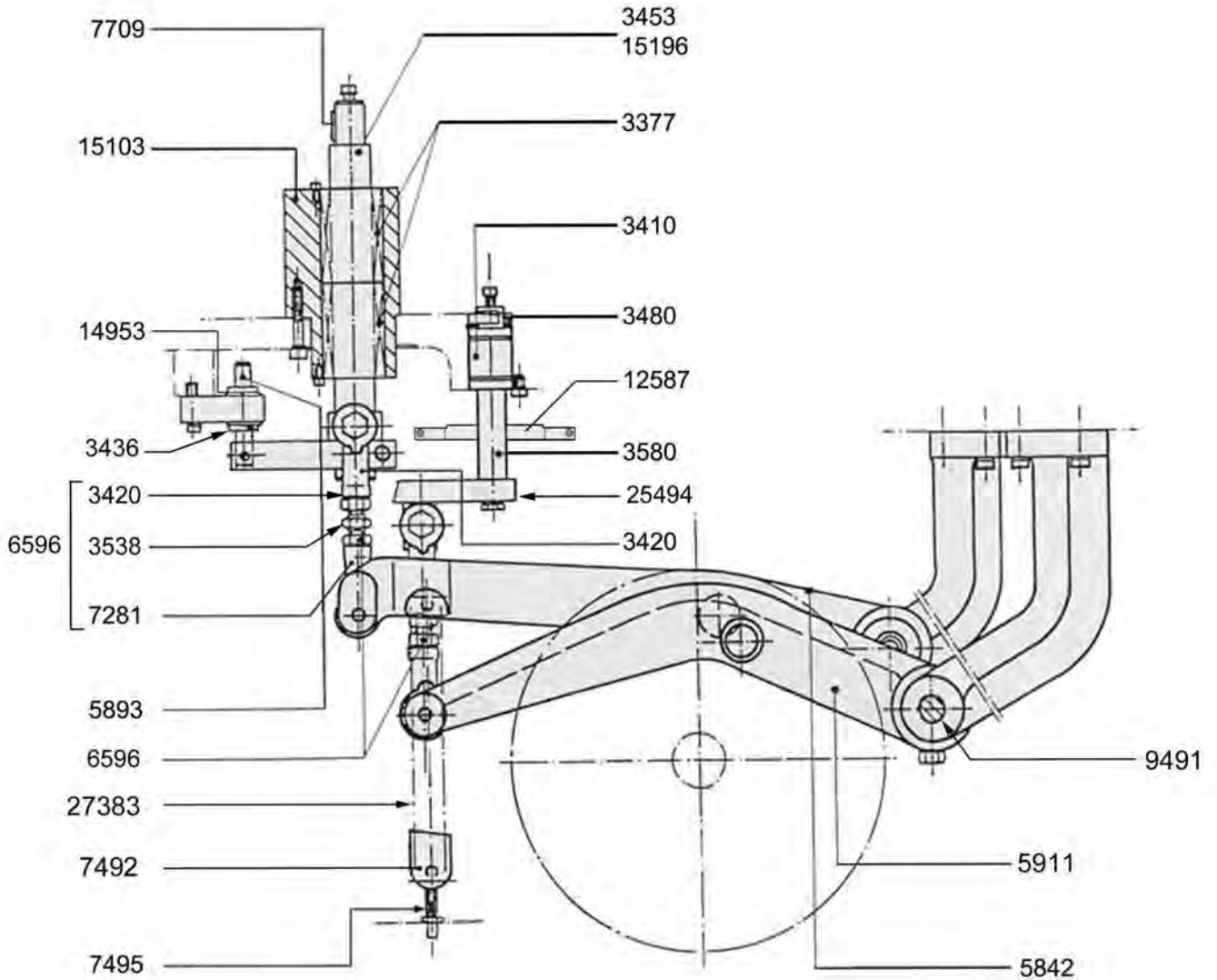


## Section 12: upper closing drive

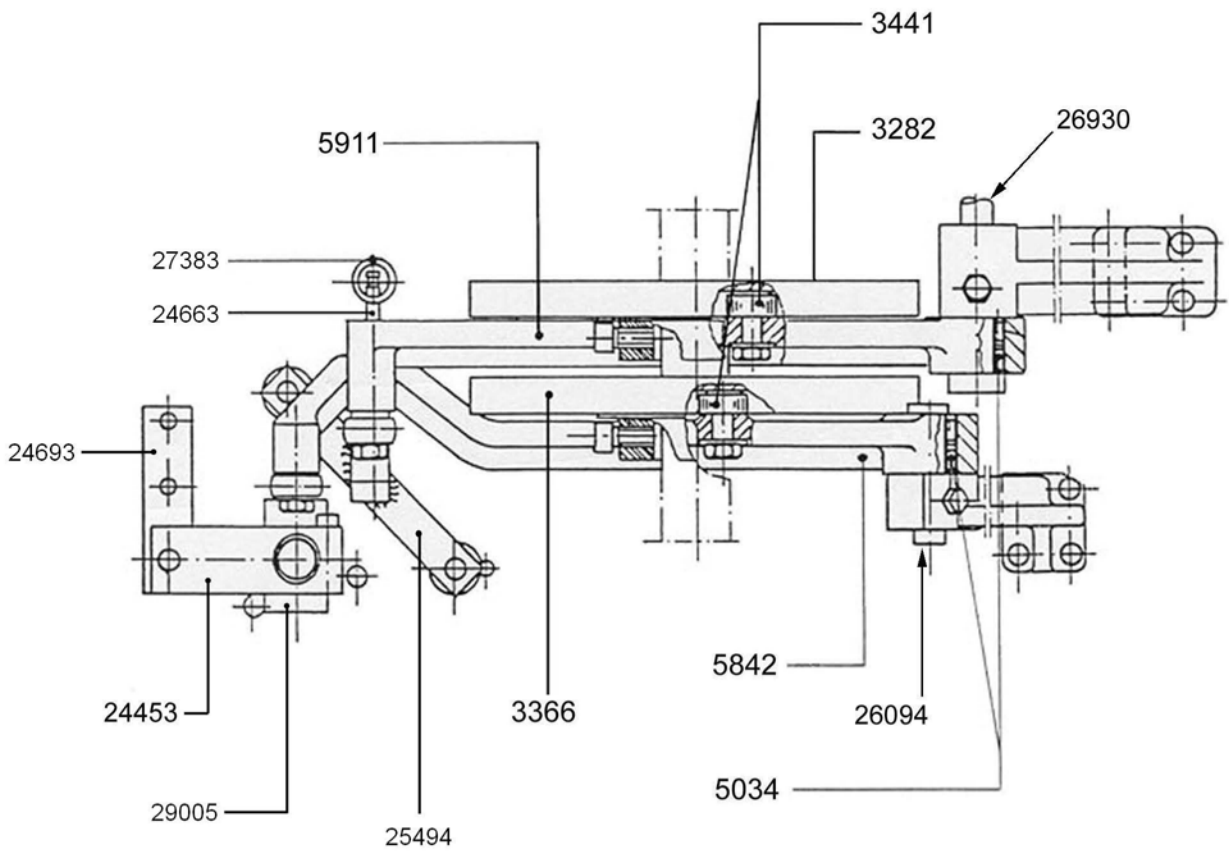
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IIM No.	Description
3282	CAM, CLOSING, UPWARD MOVEMENT
3366	CAM, CLOSING, COUNTERBEARING
13492	HEX JAM NUT
24453	MOUNT BLOCK
24663	ROD,SPRING FASTENER,HEX,SHORT,32MM
25494	CLOSING CROSSBAR
26094	SHAFT,PIVOT,COUNTER CLOSING ACTUATOR ARM
26930	SHAFT,PIVOT,SEPARATION & LOWER CLOSING
27383	SPRING,EXT,CLOSING DRIVE
27936	SUPPORT, UPPER CLOSING
27937	SUPPORT, UPPER CLOSING
29005	BLOCK,CLAMP

# Section 13.1: upper & lower closing drive



# Section 13.2: upper & lower closing drive

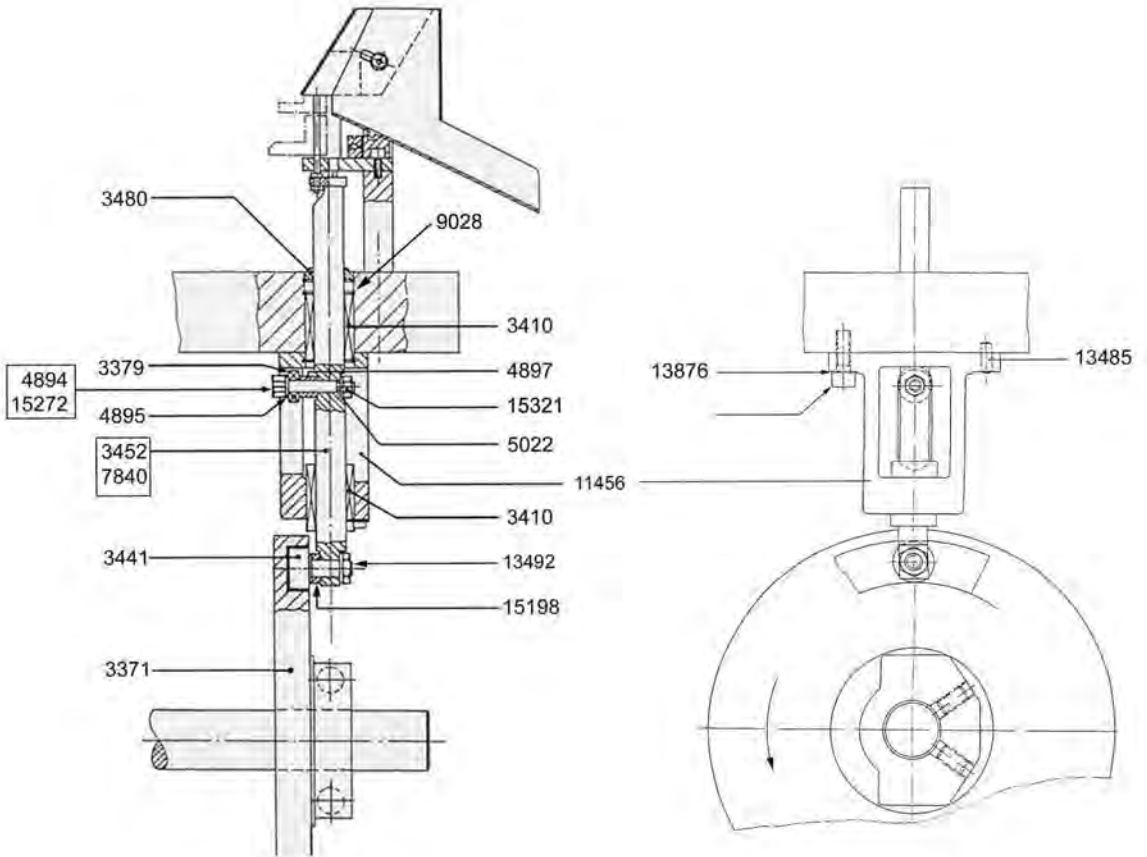


### Section 13: upper and lower closing drive

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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
24663	ROD,SPRING FASTENER
24693	BLOCK,MOUNT,BEARING
26094	SHAFT,PIVOT,COUNTER CLOSING ACTUATOR ARM
26930	SHAFT,PIVOT,SEPARATION & LOWER CLOSING
27383	SPRING,EXT
29005	BLOCK,CLAMP

# Section 14: ejection drive

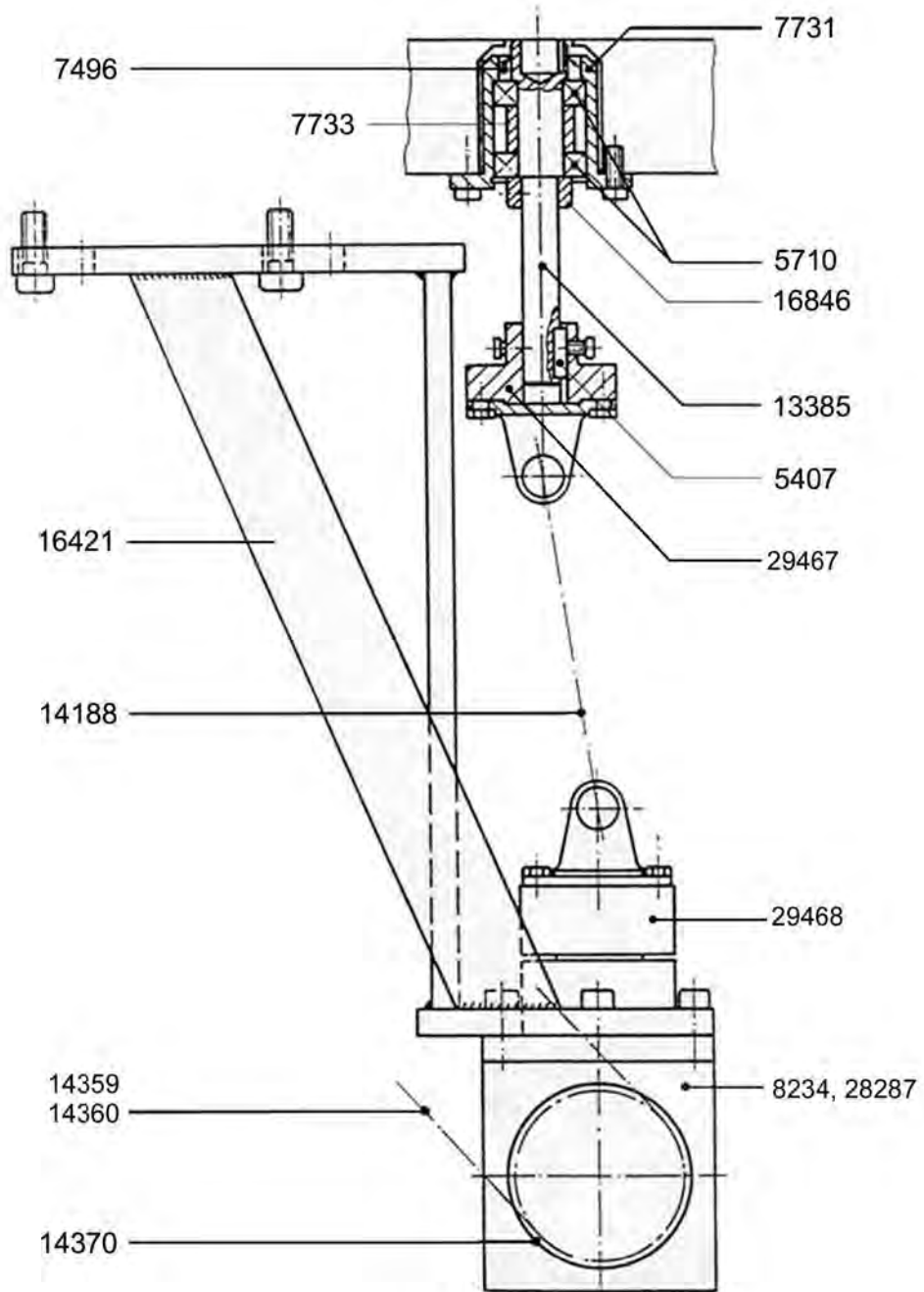


## Section 14: ejection drive

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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	SCREW,SHOULDER,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



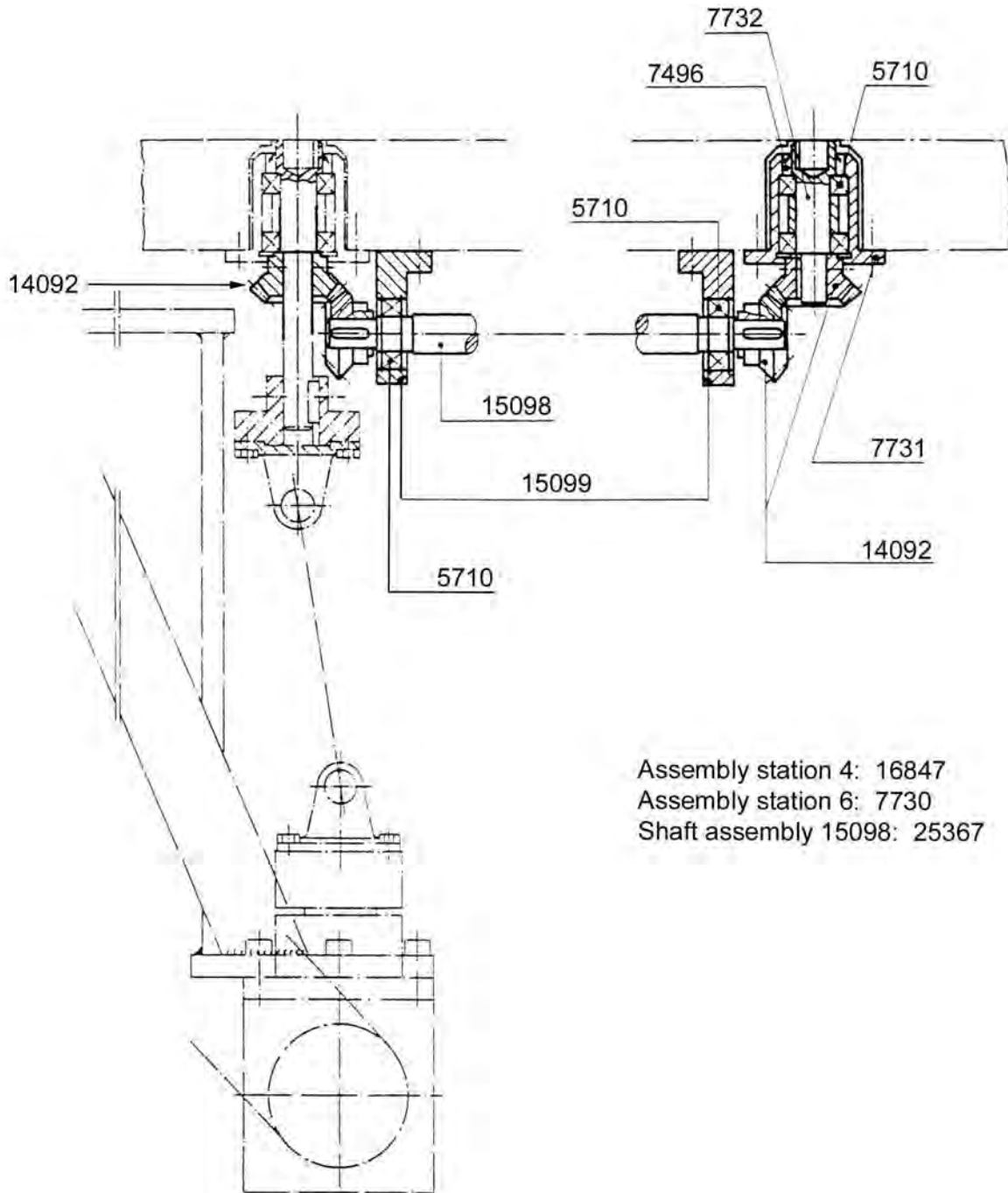


**Section 15: station 4 pellet drive**

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<b>IIM No.</b>	<b>Description</b>
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
29467	COUPLING, SHAFT TO U-JOINT, DRIVEN END
29468	COUPLING, SHAFT TO U-JOINT, DRIVER END

# Section 16: station 6 pellet drive



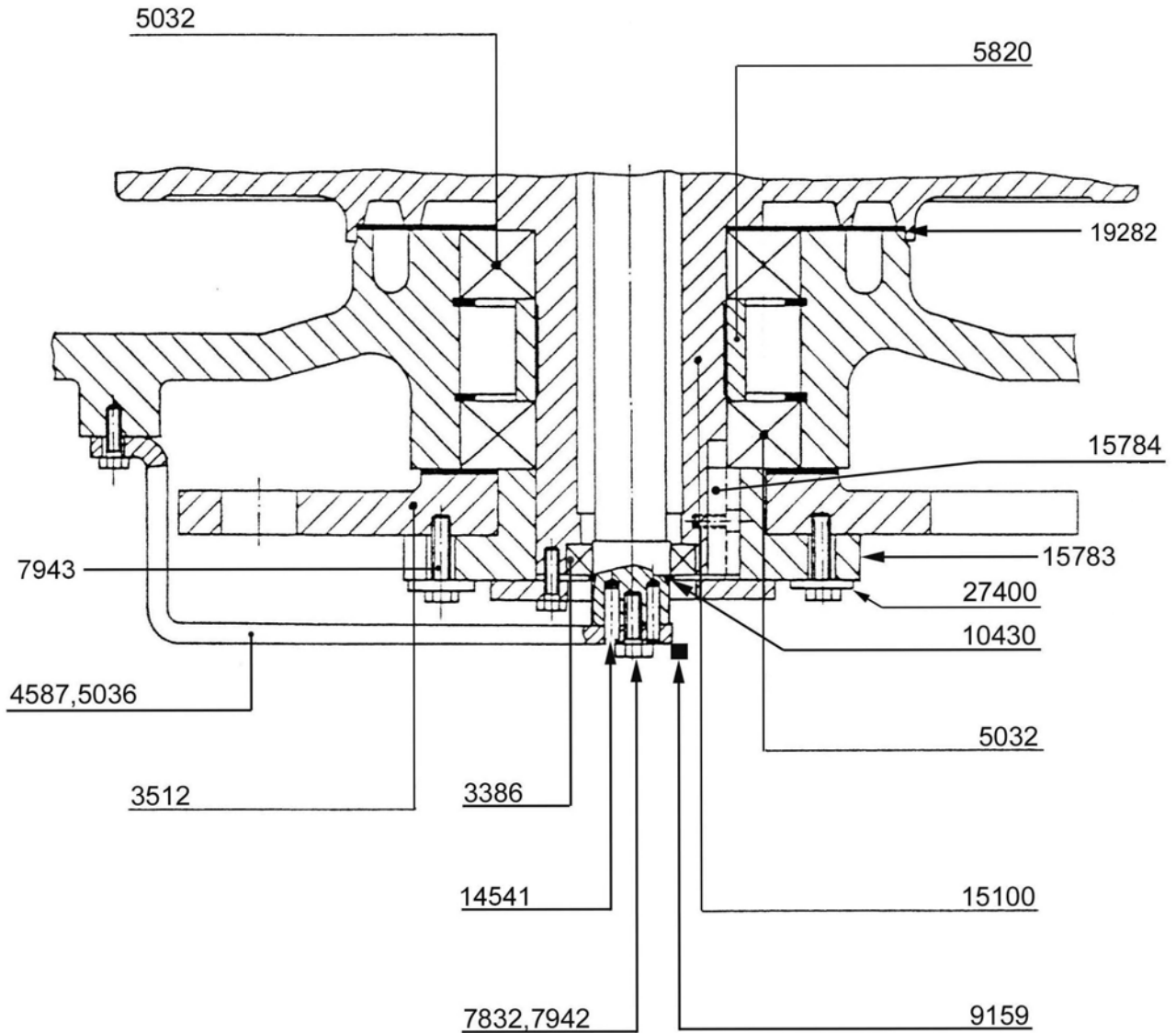
Assembly station 4: 16847  
Assembly station 6: 7730  
Shaft assembly 15098: 25367

## 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

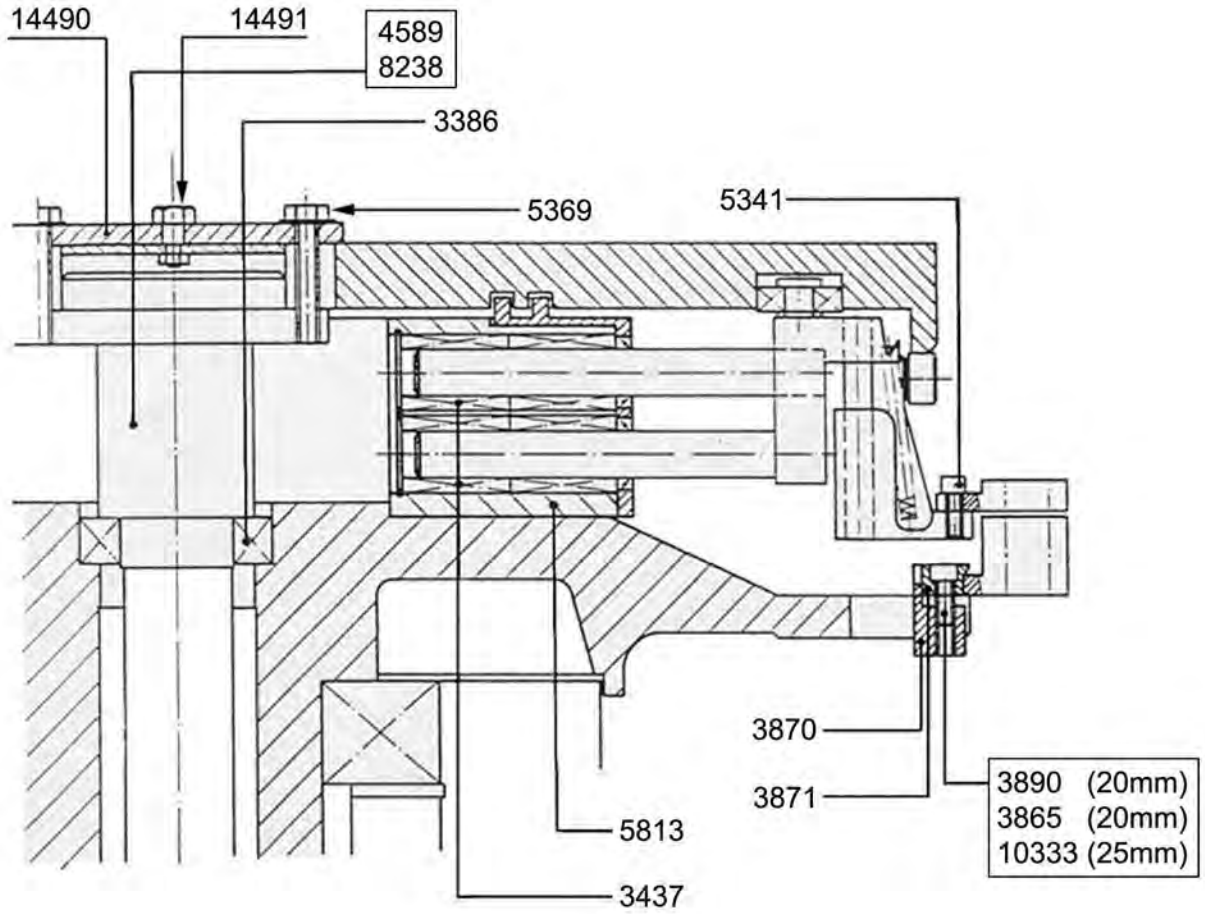


**Section 17: Segment geneva**

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<b>IIM No.</b>	<b>Description</b>
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
7943	SCREW, M10 X 40
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

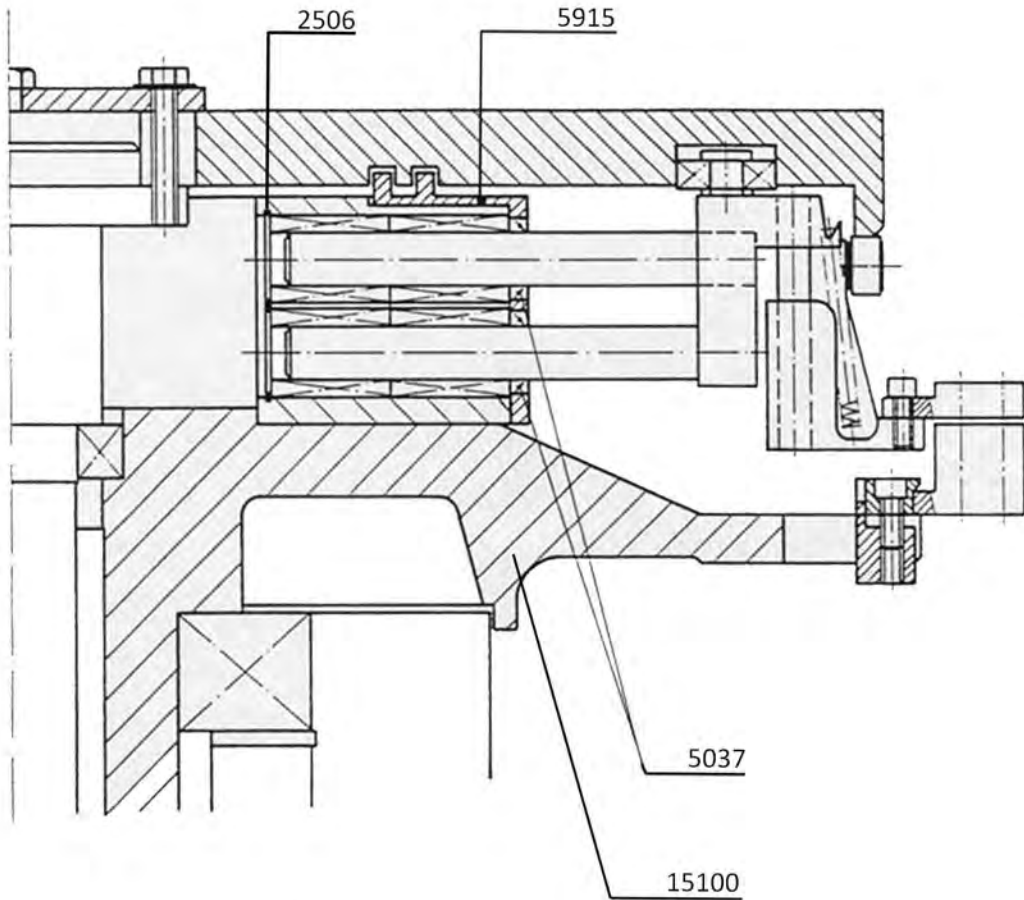


## Section 18: Segment carriers

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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



Red seal: 28861

Linear bearing: 3437

Segment doughnut: 29235



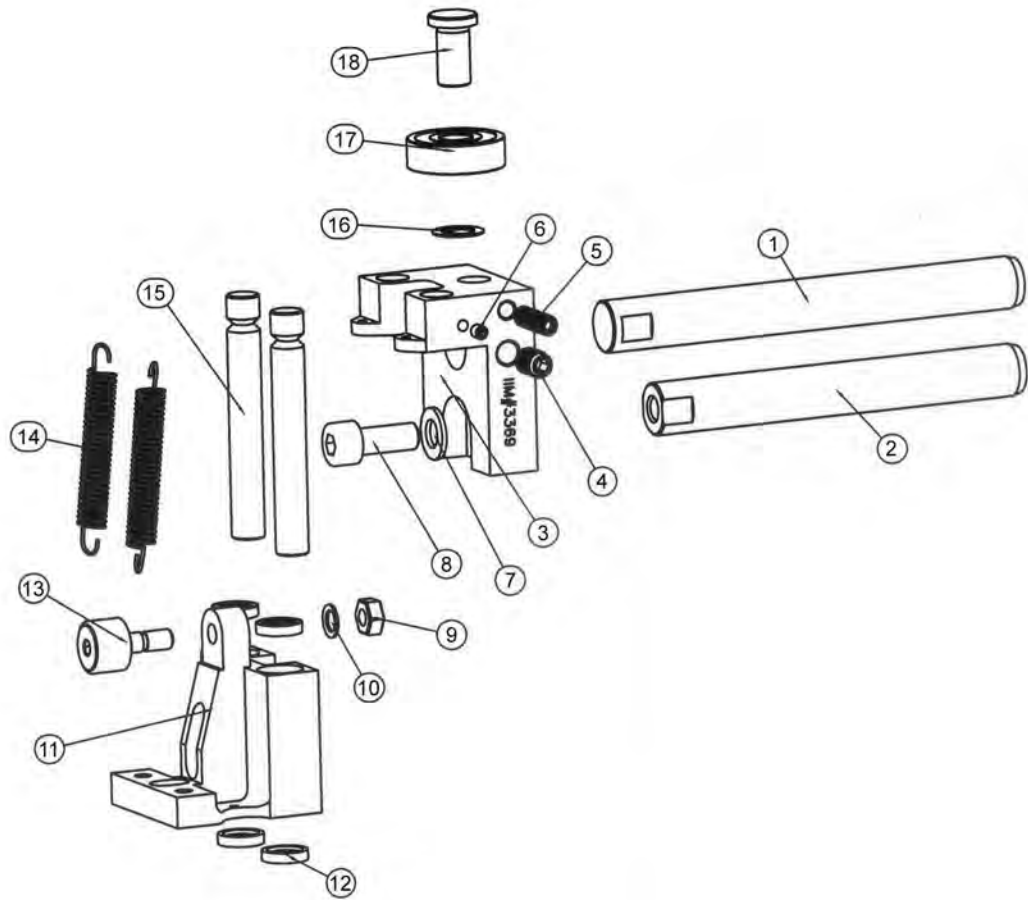


## Section 19: Segment doughnut

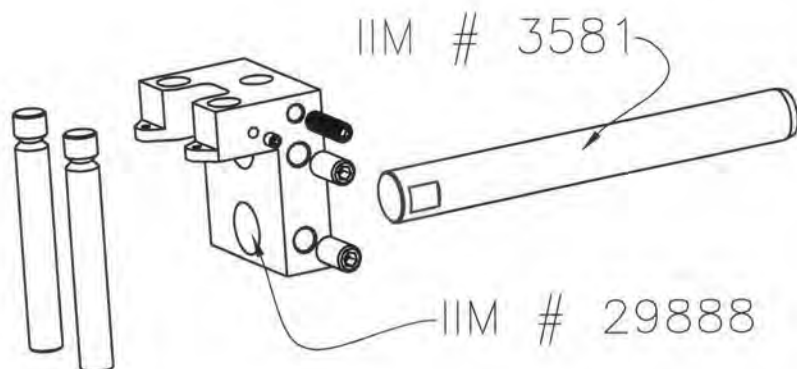
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IIM No.	Description
2506	RETAINING RING
3437	LINEAR BEARING
5037	SEAL
5915	COVER,RING
15100	TURRET,LOWER SEGMENT
28861	SEAL, RED, 16MM
29235	DOUGHNUT,SEGMENT,IIM DESIGN

# Section 20: Complete segment carrier IIM # 7094



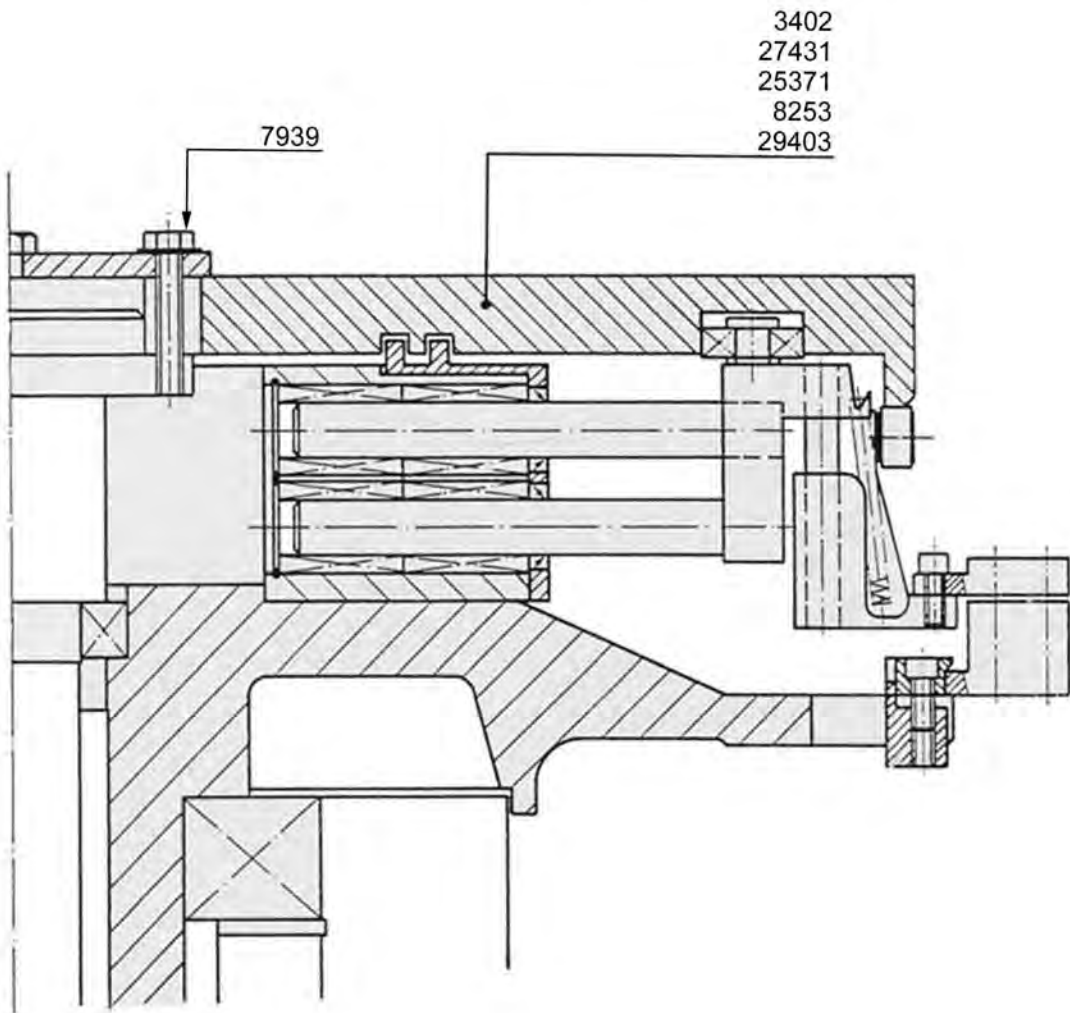
Option: upgraded with both rear shafts fixed



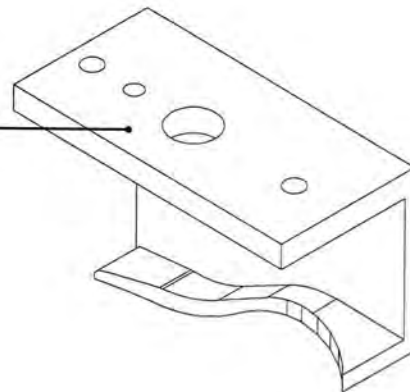
## Section 20: complete segment carrier

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



3895  
15264

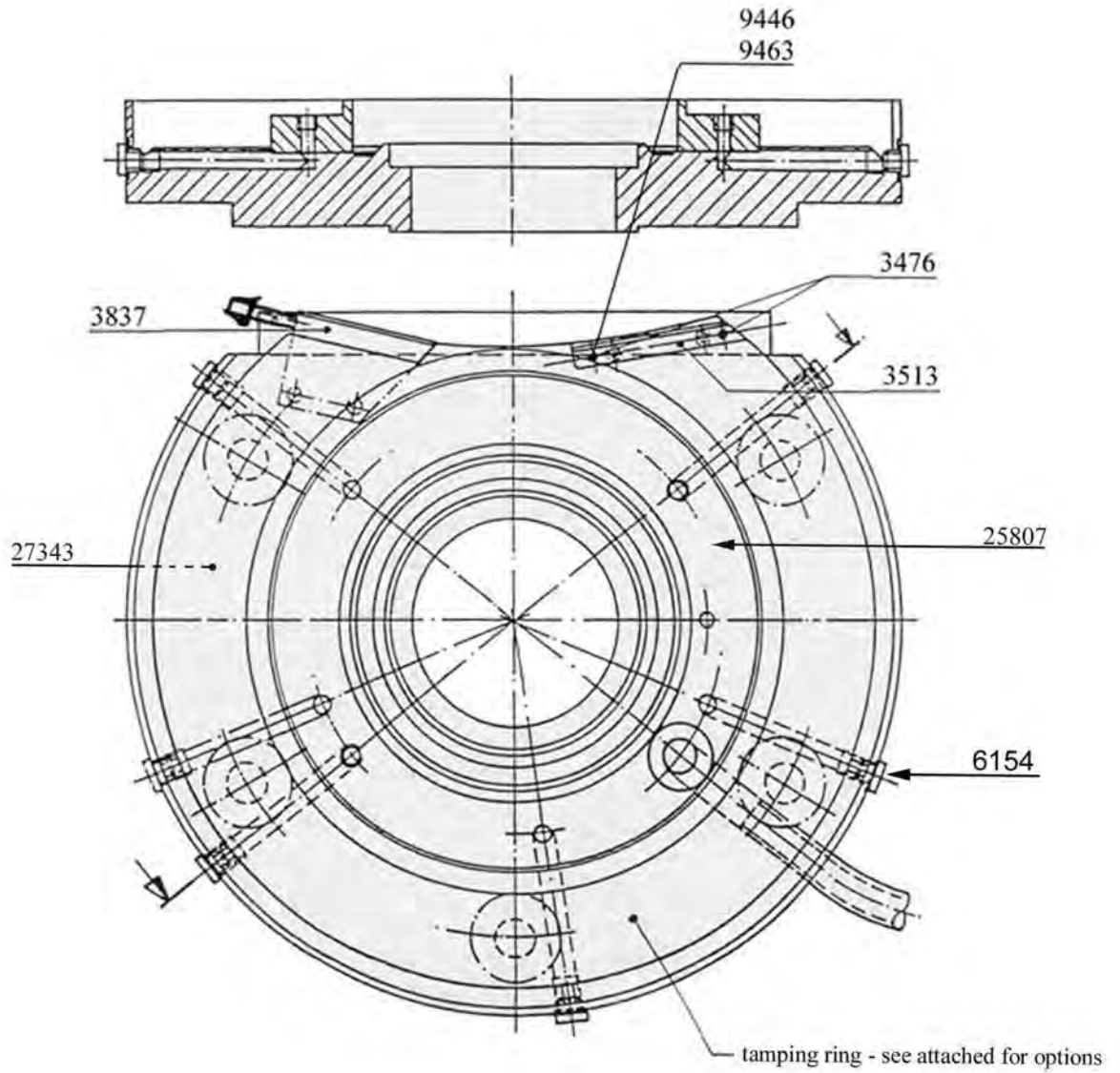


**Section 21: top cam**

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<b>IIM No.</b>	<b>Description</b>
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

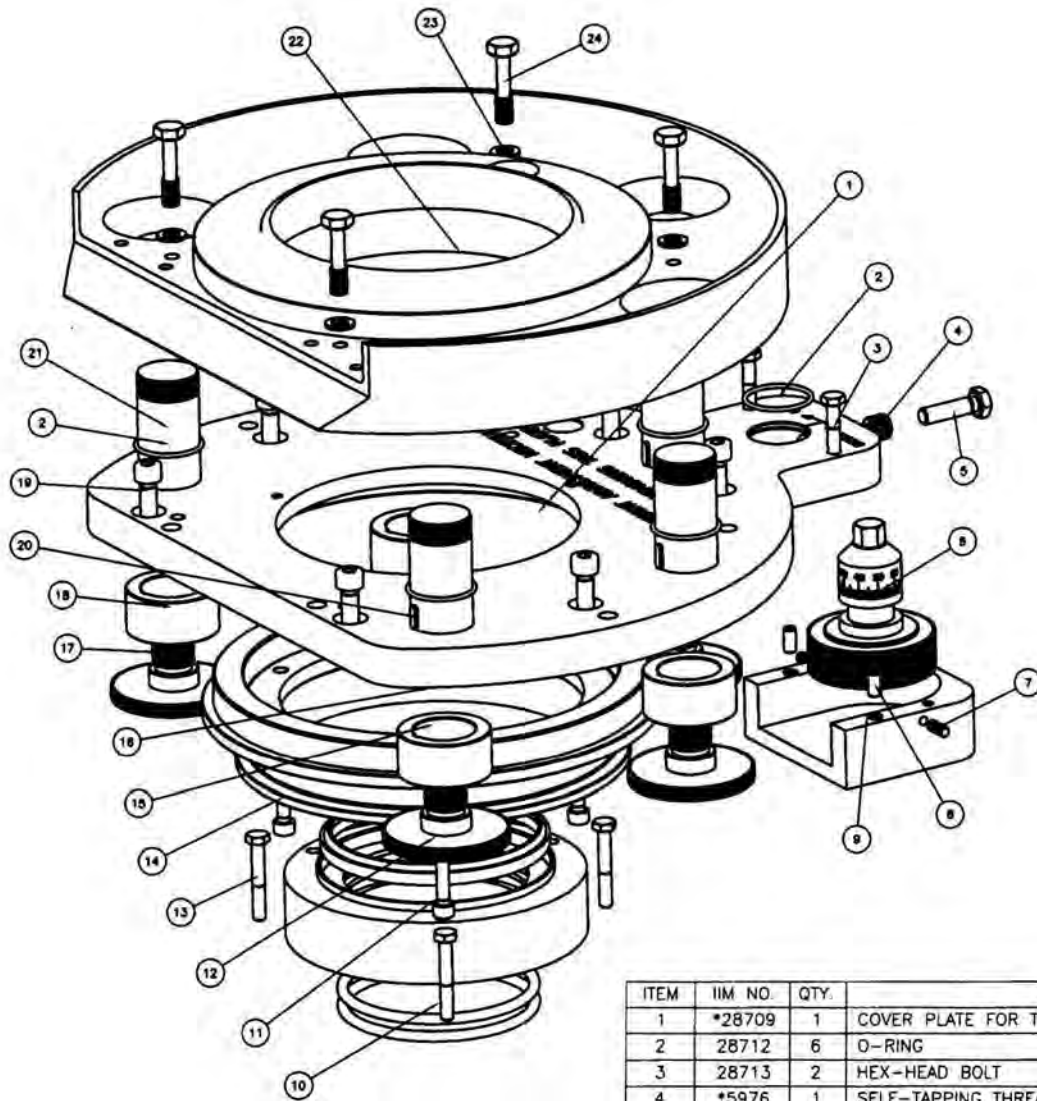


## Section 22: Tamping ring

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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

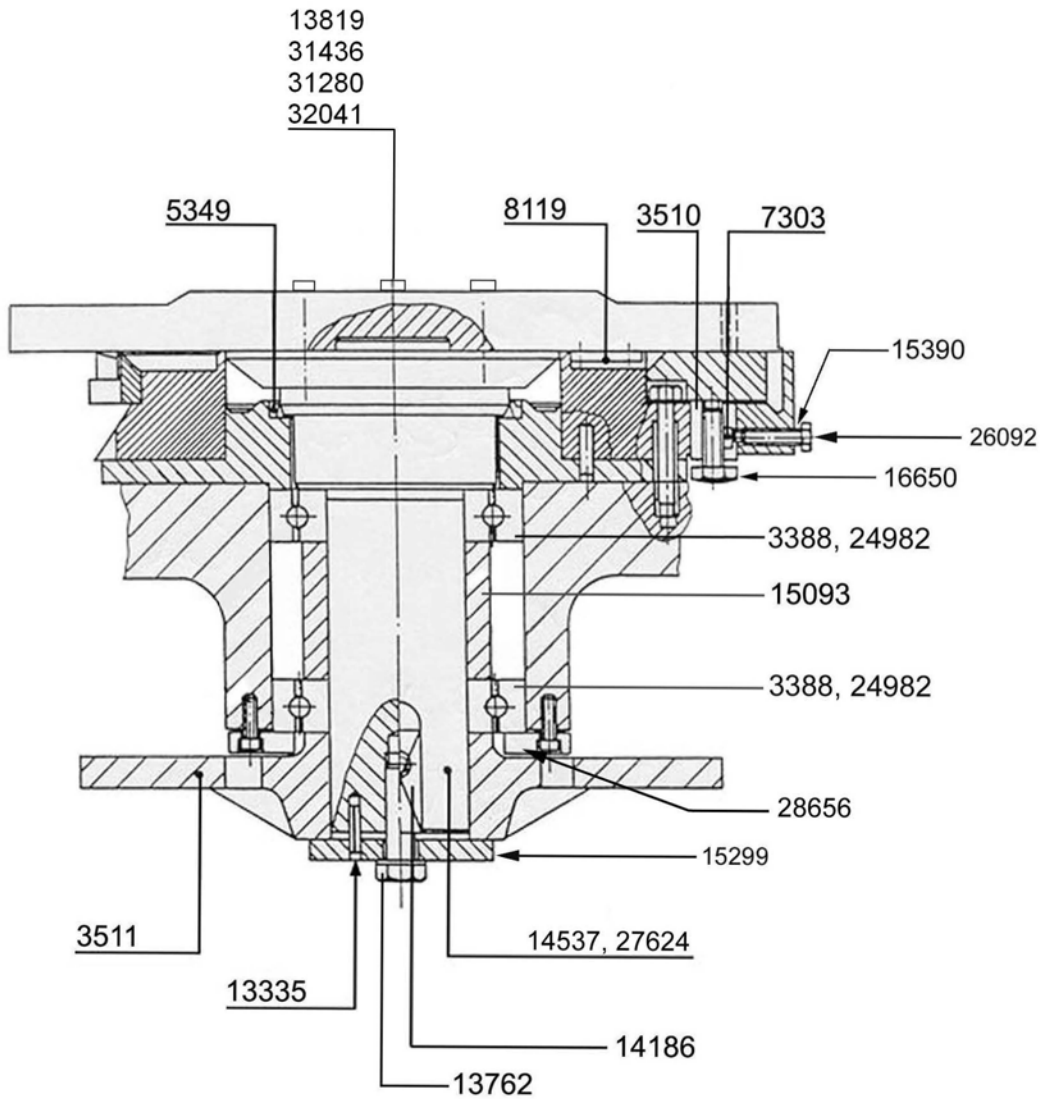
# Section 22.1: tamping ring support - IIM 2100



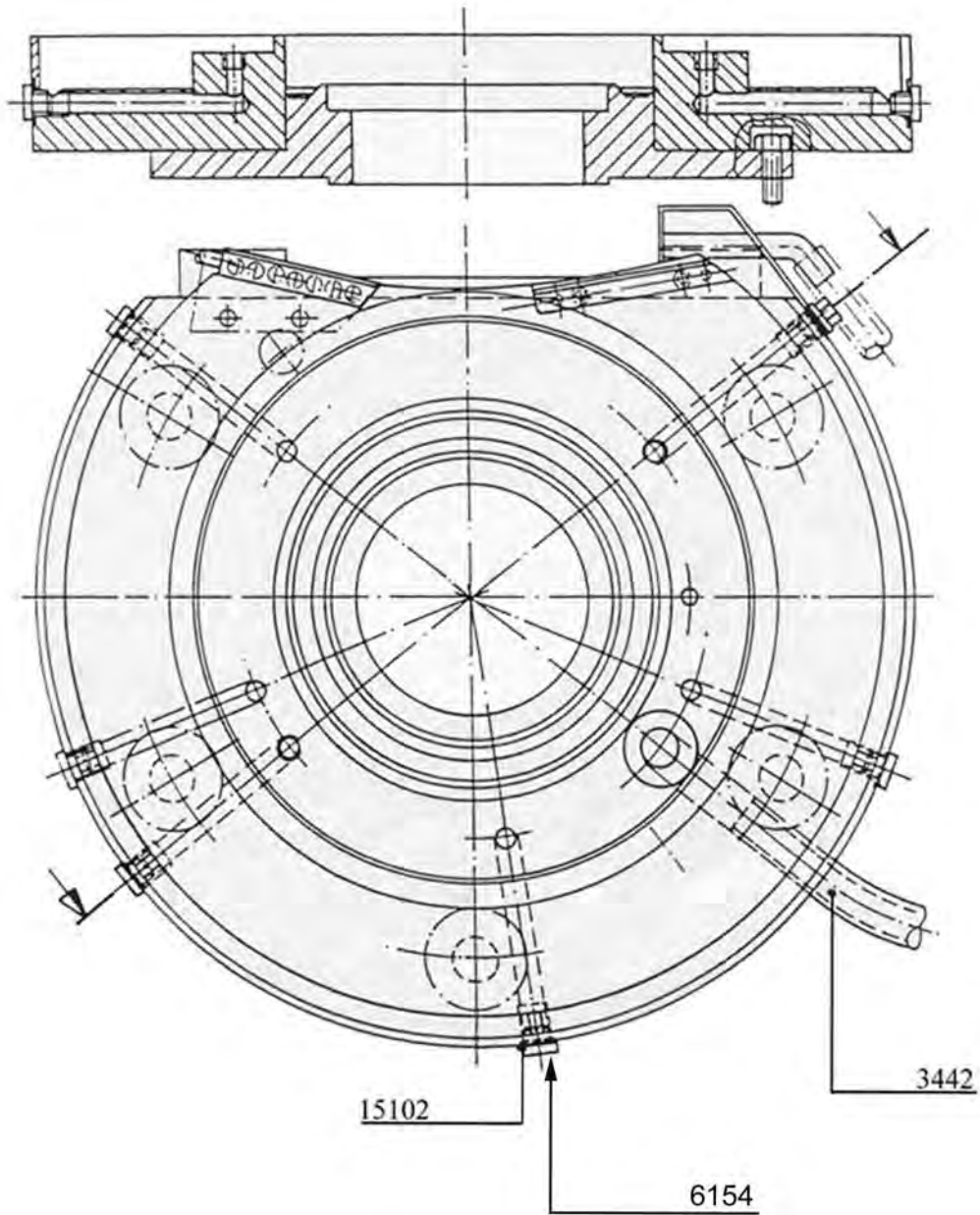
ITEM	IIM NO.	QTY.	DESCRIPTION
1	*28709	1	COVER PLATE FOR TAMPING HOUSING
2	28712	6	O-RING
3	28713	2	HEX-HEAD BOLT
4	*5976	1	SELF-TAPPING THREADED INSERT,M8,HS
5	4982	1	HEX-HEAD BOLT
6	28721	1	SPINDLE, GEAR, MASTER, ADJUSTMENT
7	26089	2	PLUNGER, M5, SST
8	*9270	2	PIN,DOWEL,6(M6)X12
9	28722	1	GEAR HOUSING 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

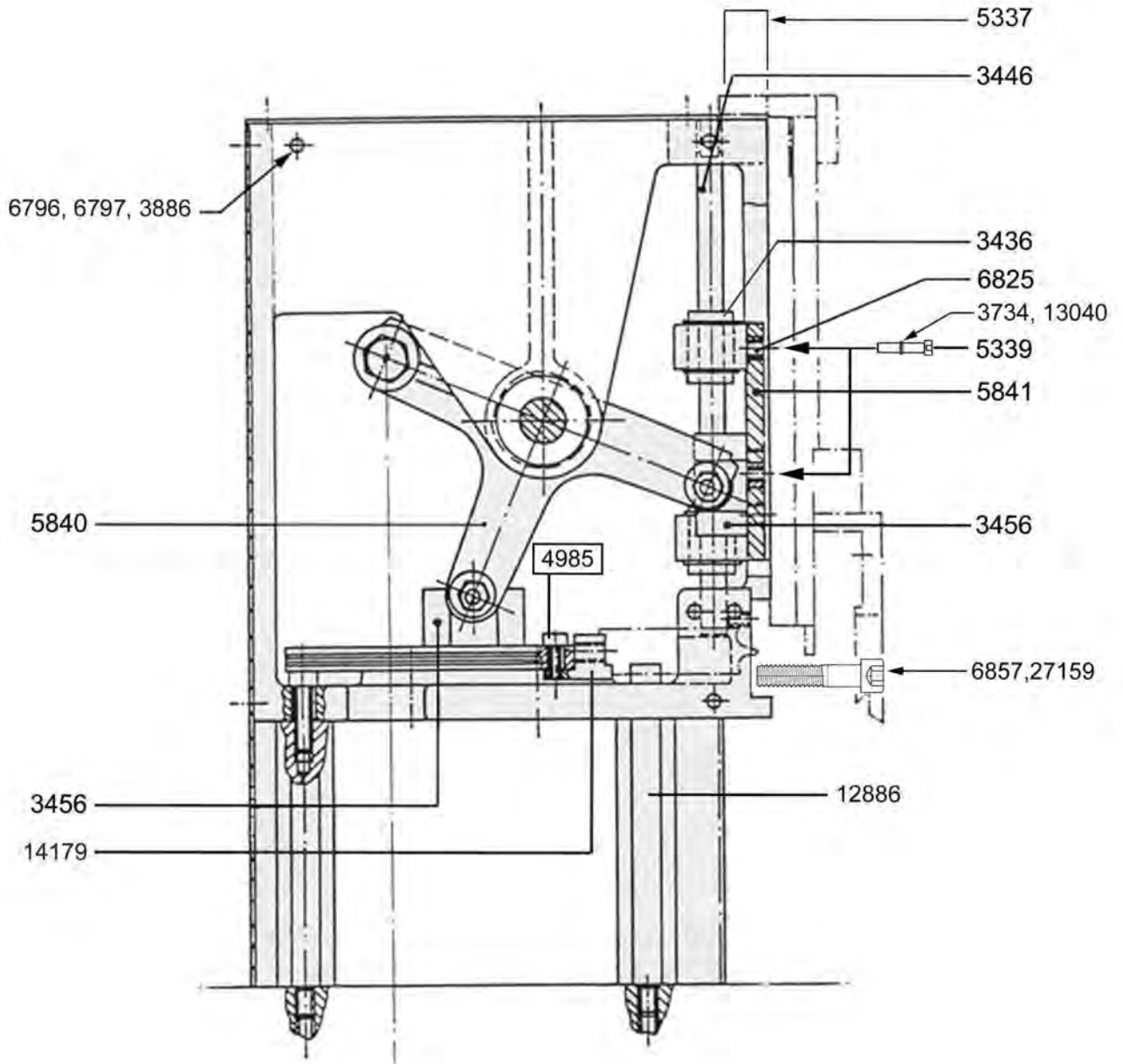


## Section 23: Dosing disc drive

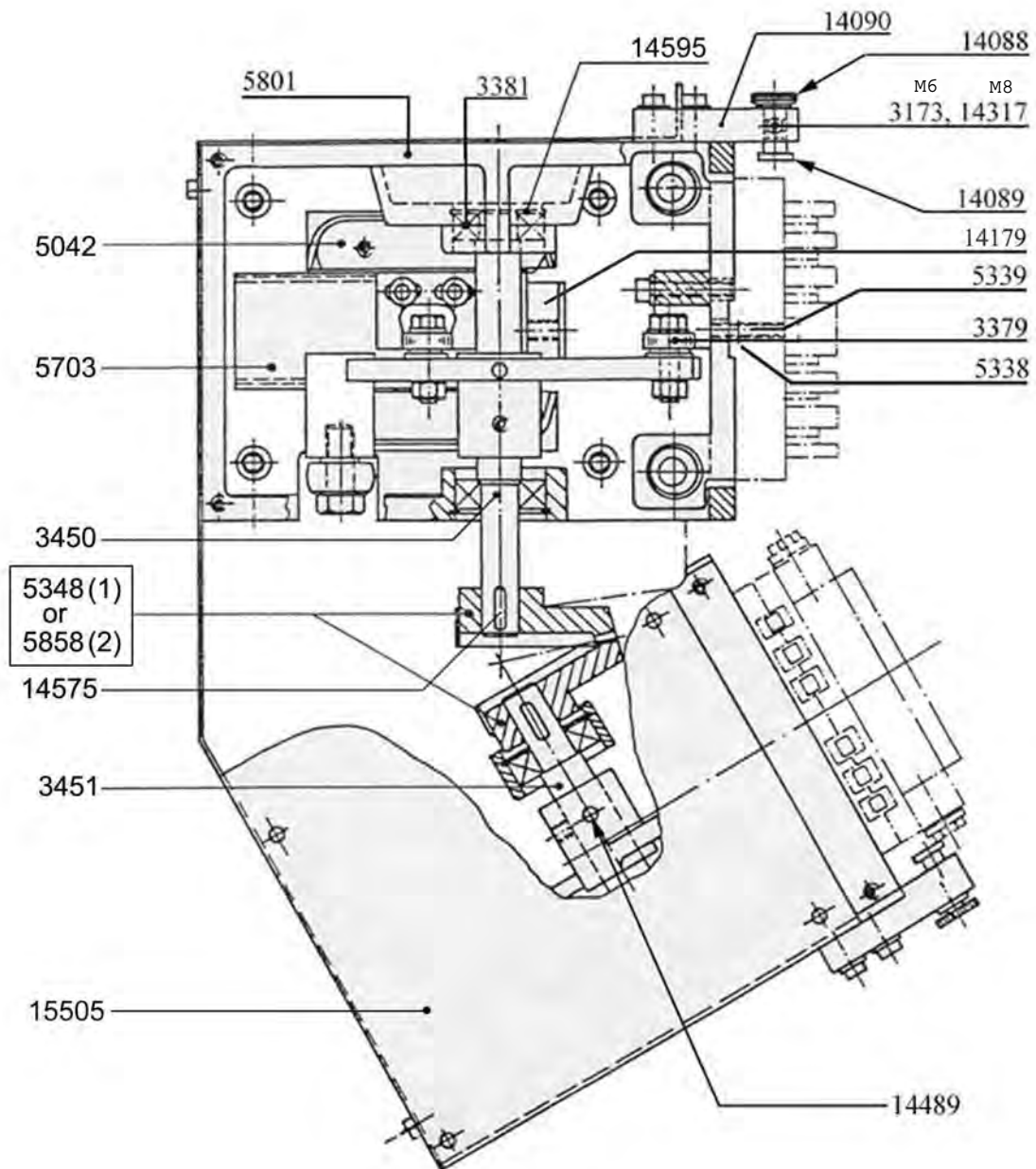
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IIM No.	Description
3388	BEARING,BALL,DEEP GROOVE
3442	HOSE, DOSING RING
3510	BUSHING,THREADED - 5 PER MACHINE
3511	GENEVA,DOSING
5349	SEAL,DOSING SHAFT
6154	VACUUM PLUG
7303	THRUST MEMBER
8119	KEY/SCRAPER,MOUNTED UNDER DOSING DISC
13335	PIN,SPRING,5 X 20
13762	BOLT
13819	BOLT,DOSING DISC MOUNT,M8 X 35
14186	KEY
14537	SHAFT,MAIN DOSING,(OLD STYLE)
15093	SPACER,INDEXING
15102	SEAL RING,FLAT
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
27624	SHAFT,MAIN,DOSING,BEVELED TOP,DIA 145
28656	BEARING CAPTURE PLATE
31280	BOLT,DOSING DISC MOUNT,M8 X 26
31436	BOLT,DOSING DISC MOUNT,M8 X 45
32041	BOLT,DOSING DISC MOUNT,M8 X 31

# Section 24.1: sorting device, magazine housings



# Section 24.2: sorting device, magazine housings

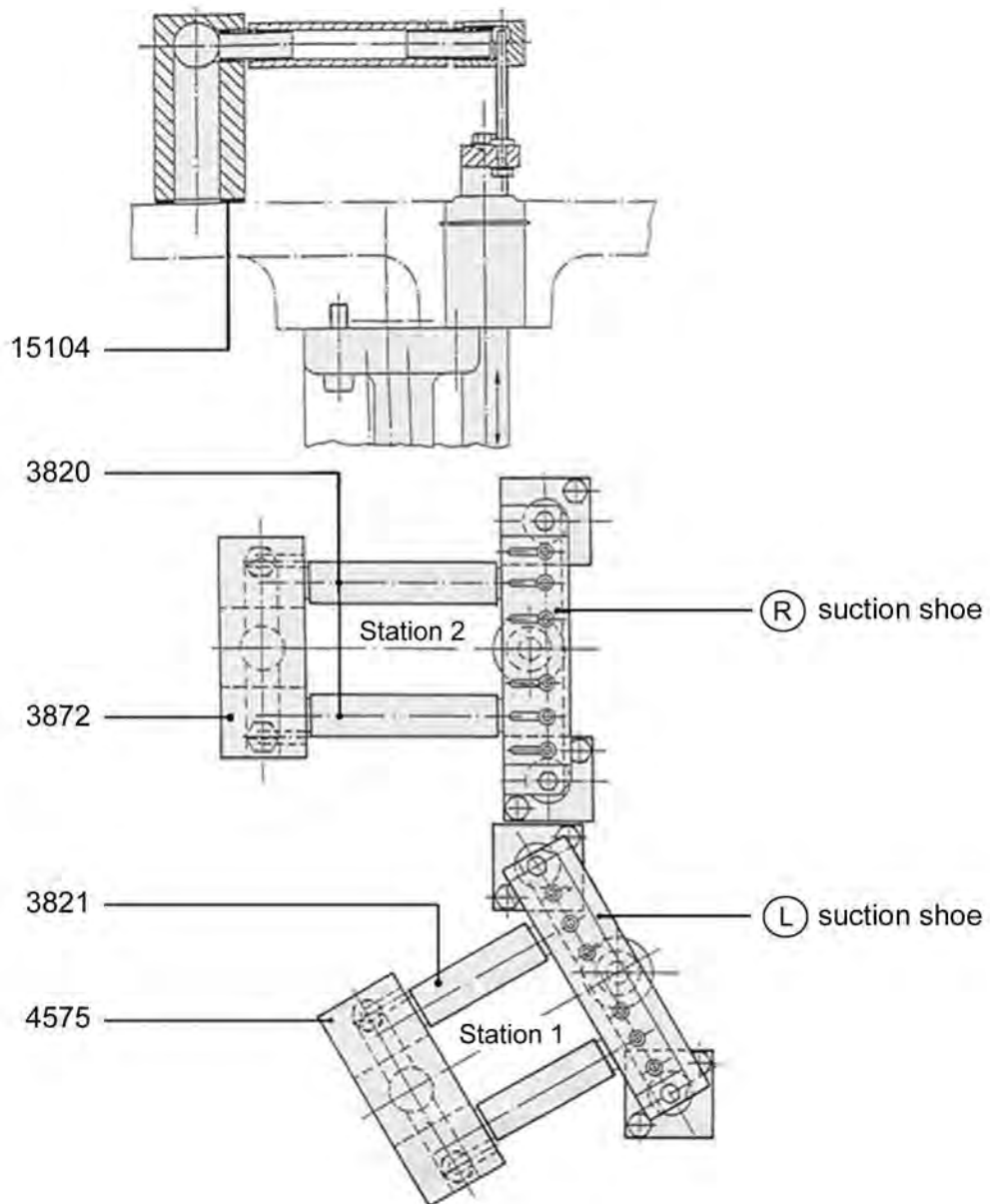


## Section 24: Magazine housing components

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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



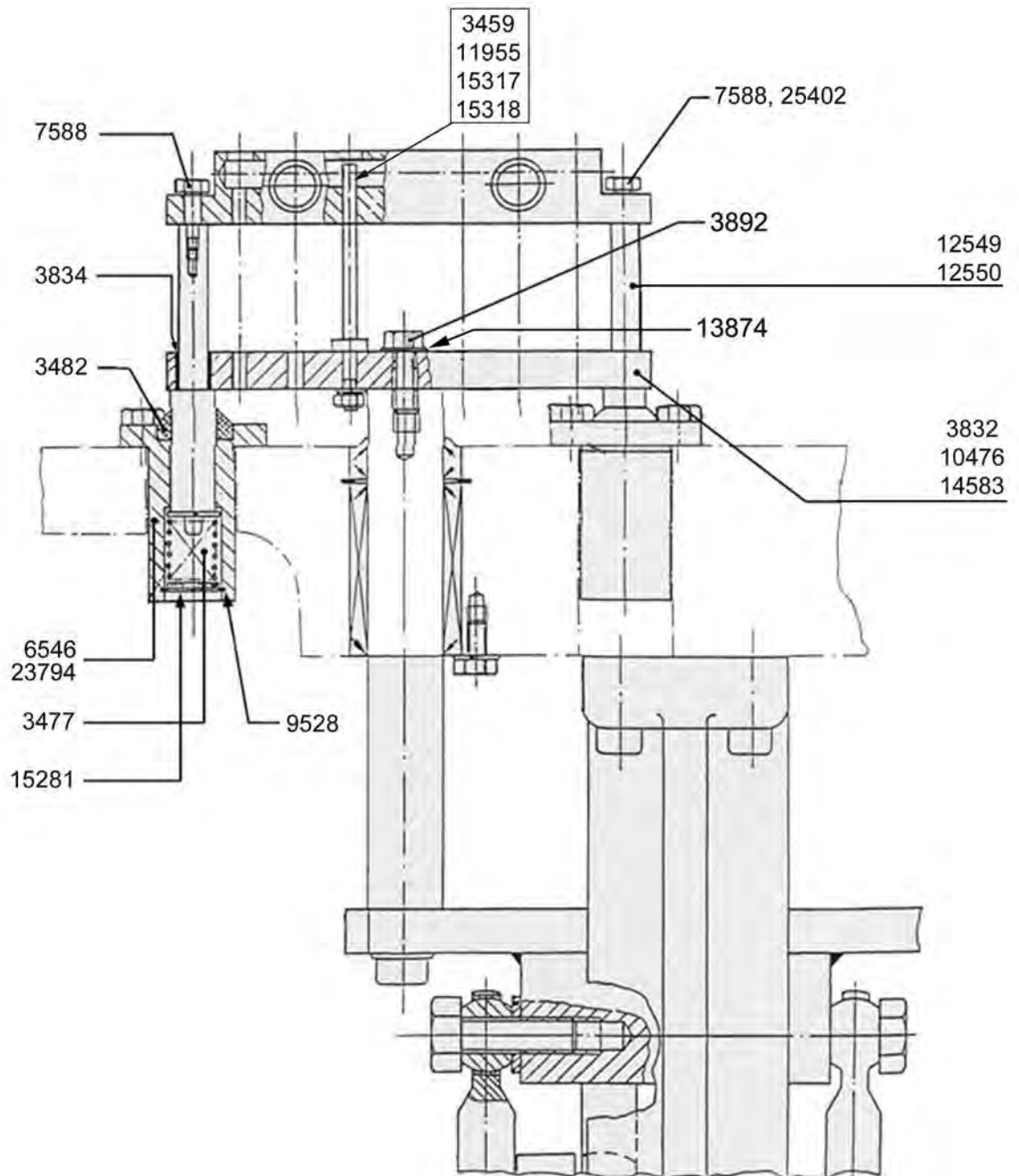
## Section 25.1: capsule separation

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

	<b>std</b>	<b>plastic</b>	<b>sealed</b>	<b>w/star</b>	<b>no holes</b>
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



## Section 25.2: Capsule separation

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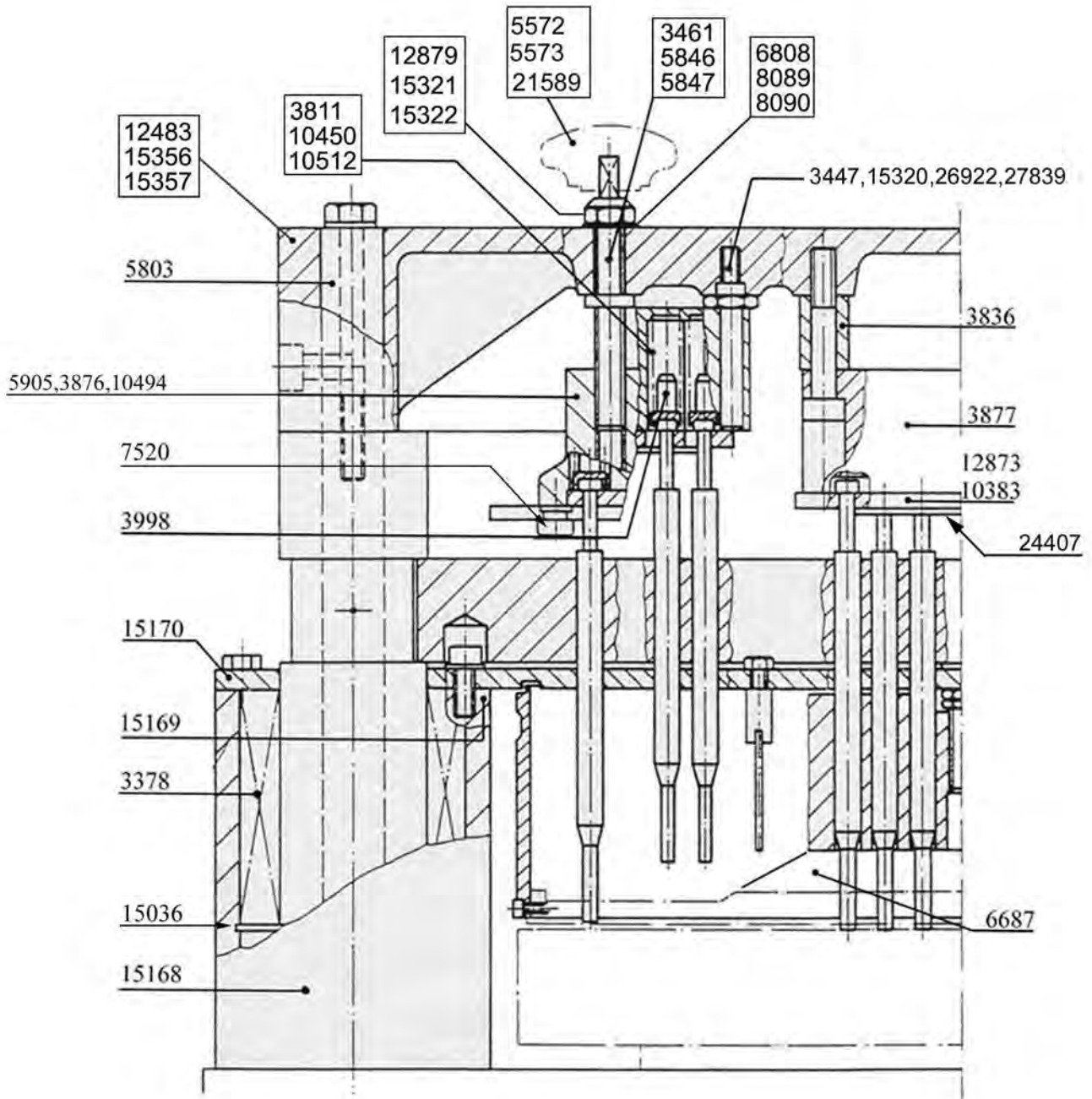
IIM No.	Description
3459	SEPARATION PIN, OLD STYLE, DOES NOT USE CAPTIVE NUT
3477	SPRING, COMPRESSION
3482	SCRAPER
3832	SEPARATION PLATE, NEW STYLE, 12 COUNT
3834	BUSHING, SPLIT
3892	BOLT M6X16
3892	SECURING BOLT, CAPTIVE
6546	BUSHING,BRONZE,SEPARATION COLUMN
7588	SHOULDER BOLT, GUIDE COLUMN, USE WITH 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

## Section 26: capsule level sensor

IIM No.	Description
3087	Capacitive proximity sensor, capsule level
25113	Cable, 5m



# Section 27: dosing device, tamping station



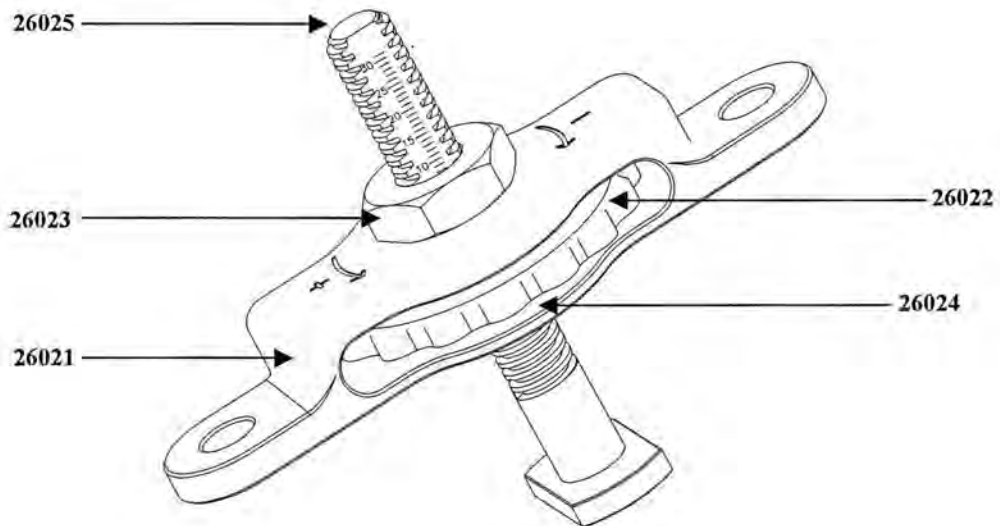
## Section 27: Dosing device, tamping station

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IIM No.	Description
15168	BEARING BLOCK,TAMPING SHAFT
3378	BEARING,LINER
3998	CAP,PLASTIC,TAMPING PIN
15170	COVER PLATE,TAMPING COLUMN
26320	GUIDE,TAMPING PIN HOLDER, 10MM X M10 X 104MM LONG
26922	GUIDE,TAMPING PIN HOLDER, 10MM X M10 X 84MM LONG, OLD STYLE
27839	GUIDE,TAMPING PIN HOLDER, 10MM X M12 X 84MM LONG, Ø10MM, OLD STYLE
3447	GUIDE,TAMPING PIN HOLDER, M8, Ø10MM, 71MM LONG
15320	GUIDE,TAMPING PIN HOLDER,12MM X M10 X 115MM LONG, bronze guide ring
12880	GUIDE,WIPER BLOCK,15MM,OLD STYLE
3876	HOLDER,ADJUSTABLE,TAMPING,12CT,48MM (5/machine)
5905	HOLDER,ADJUSTABLE,TAMPING,12CT,60MM (5/machine)
10494	HOLDER,ADJUSTABLE,TAMPING,COMPLETE ASSY,16CT (5/machine)
3877	HOLDER,FIXED,TAMPING,12CT,48MM (1/machine)
10499	HOLDER,FIXED,TAMPING,COMPLETE,16CT (1/machine)
26991	HOLDER,TAMPING,ADJ,12CT,ASSY,48MM
26990	HOLDER,TAMPING,ADJ,12CT,ASSY,60MM
28279	HOLDER,TRANSFER,FIXED,12CT,60MM
27931	HOLDER,TRANSFER,FIXED,12CT,60MM,ASSY
27932	HOLDER,TRANSFER,FIXED,16CT,60MM,S'STL,ASSY
12873	PLATE,COMPRESSION TAMPING PIN HOLDER,12 COUNT
10383	PLATE,COMPRESSION TAMPING PIN HOLDER,16 COUNT
5803	SHAFT,TAMPING HEAD,RAISING,NEW STYLE
15036	SNAP RING
15169	SPACER BAR,W/ ALIGNMENT HOLE,FOR LEVEL SENSOR PLATE
3836	SPACER,FIXED TAMPING PIN HOLDER
5847	SPINDLE,TAMPING PIN HOLDER,M10,OLD VERSION
5846	SPINDLE,TAMPING PIN HOLDER,M12,OLD VERSION, square top
3461	SPINDLE,TAMPING PIN HOLDER,M8,NEW STYLE, comes with washer, nut, dowel, knob
10450	SPRING,COMPRESSION,TAMPING PIN,MEDIUM STRENGTH
3811	SPRING,COMPRESSION,TAMPING PIN,STIFF
10512	SPRING,COMPRESSION,TAMPING PIN,STIFF,S/S
21589	STAR KNOB,M10
5573	STAR KNOB,M12,OLD VERSION
5572	STAR KNOB,M8,NEW VERSION
8089	WASHER, M10
8090	WASHER, M12
6808	WASHER, M8
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

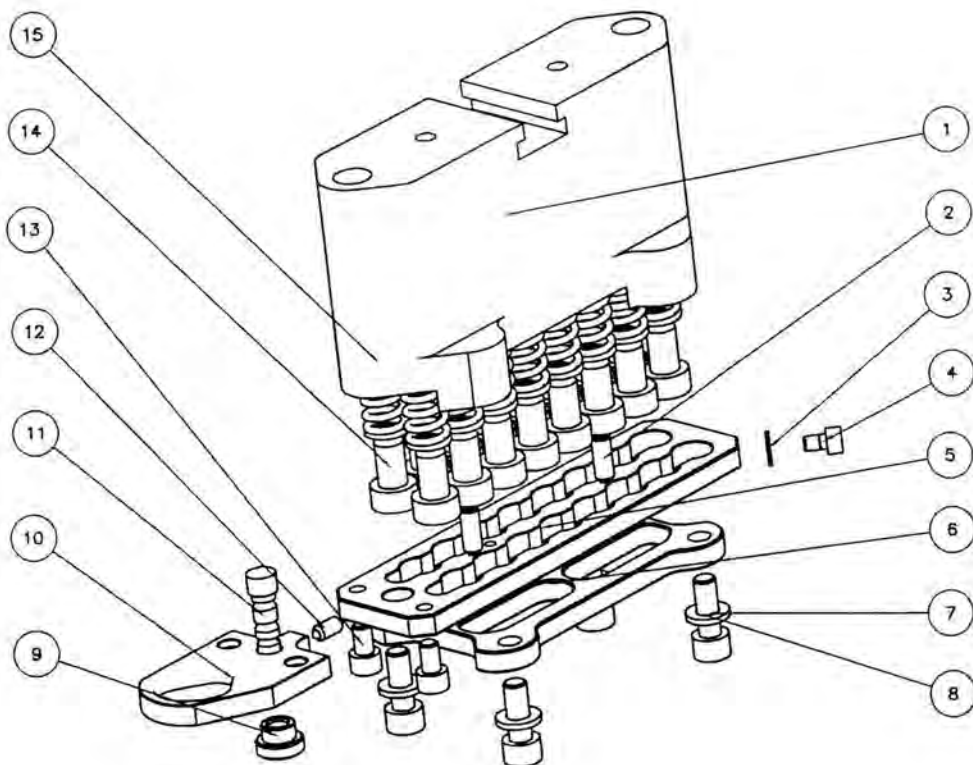
## Section 27.1: new style 16 count tamping block adjustment mechanism

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

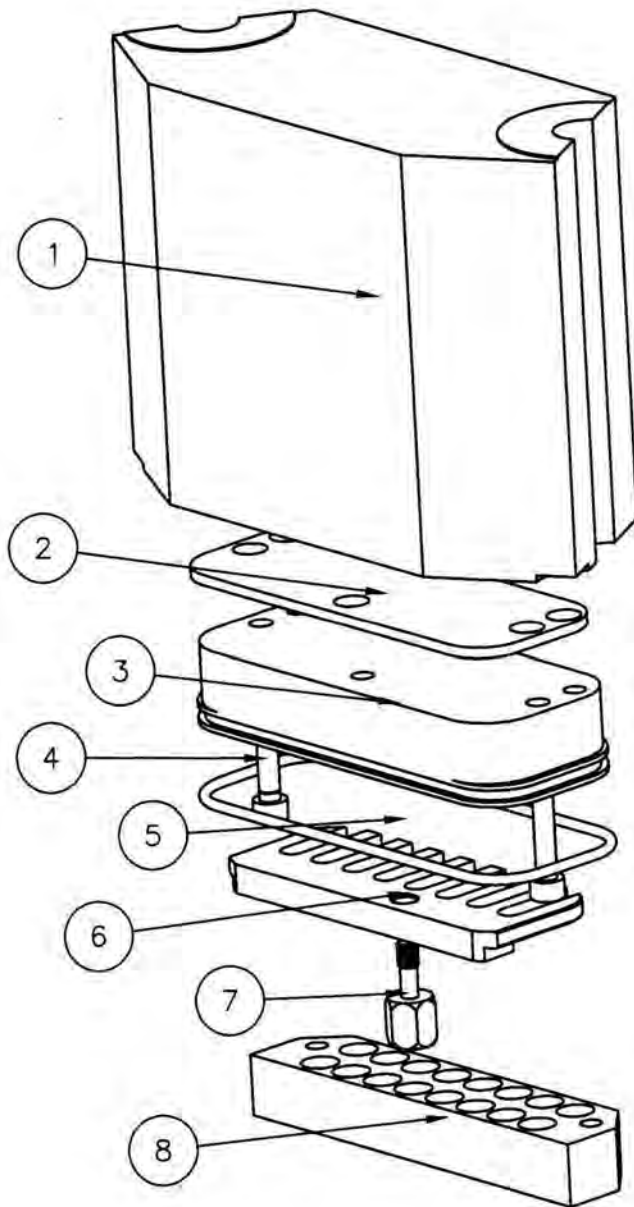


## Section 27.2: new style 16 count tamping block

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



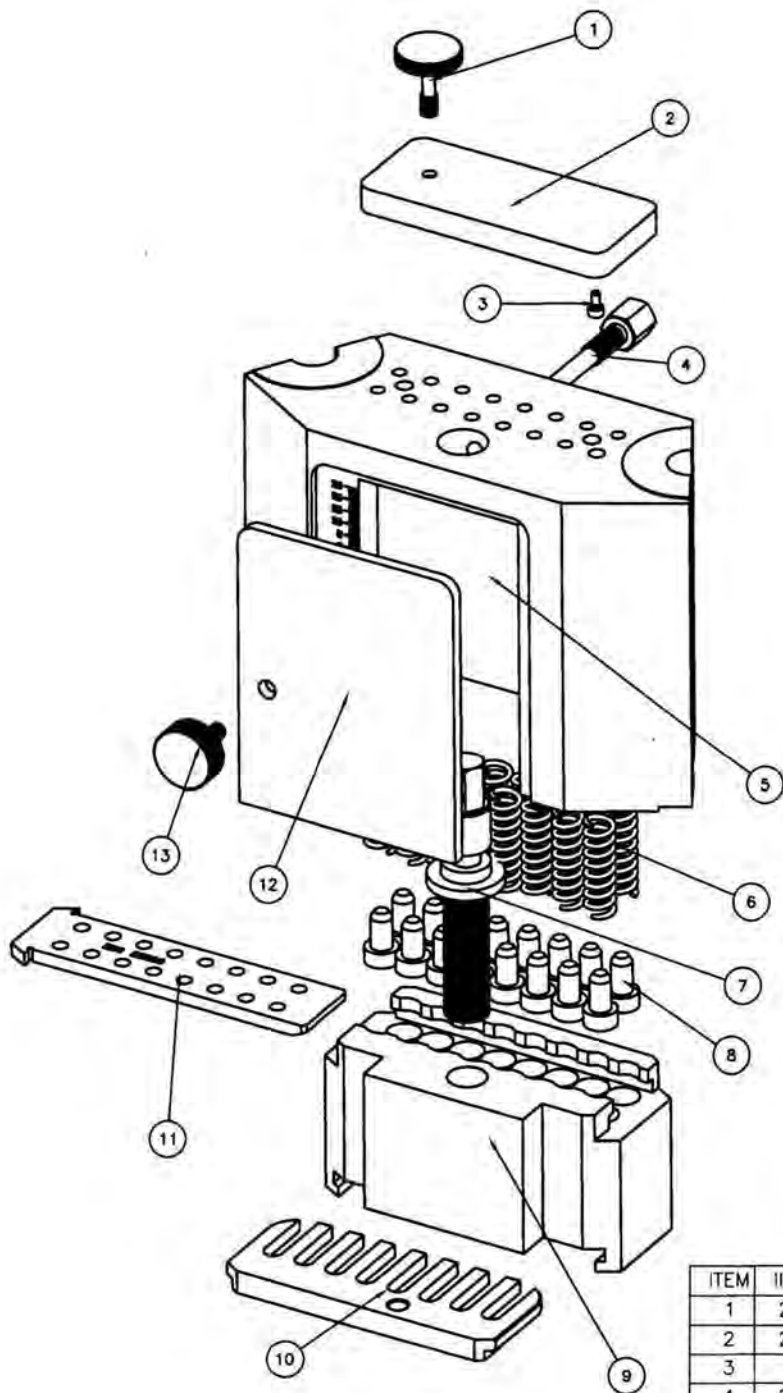
# Section 27.3: fixed/transfer tamping block - IIM 2100



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

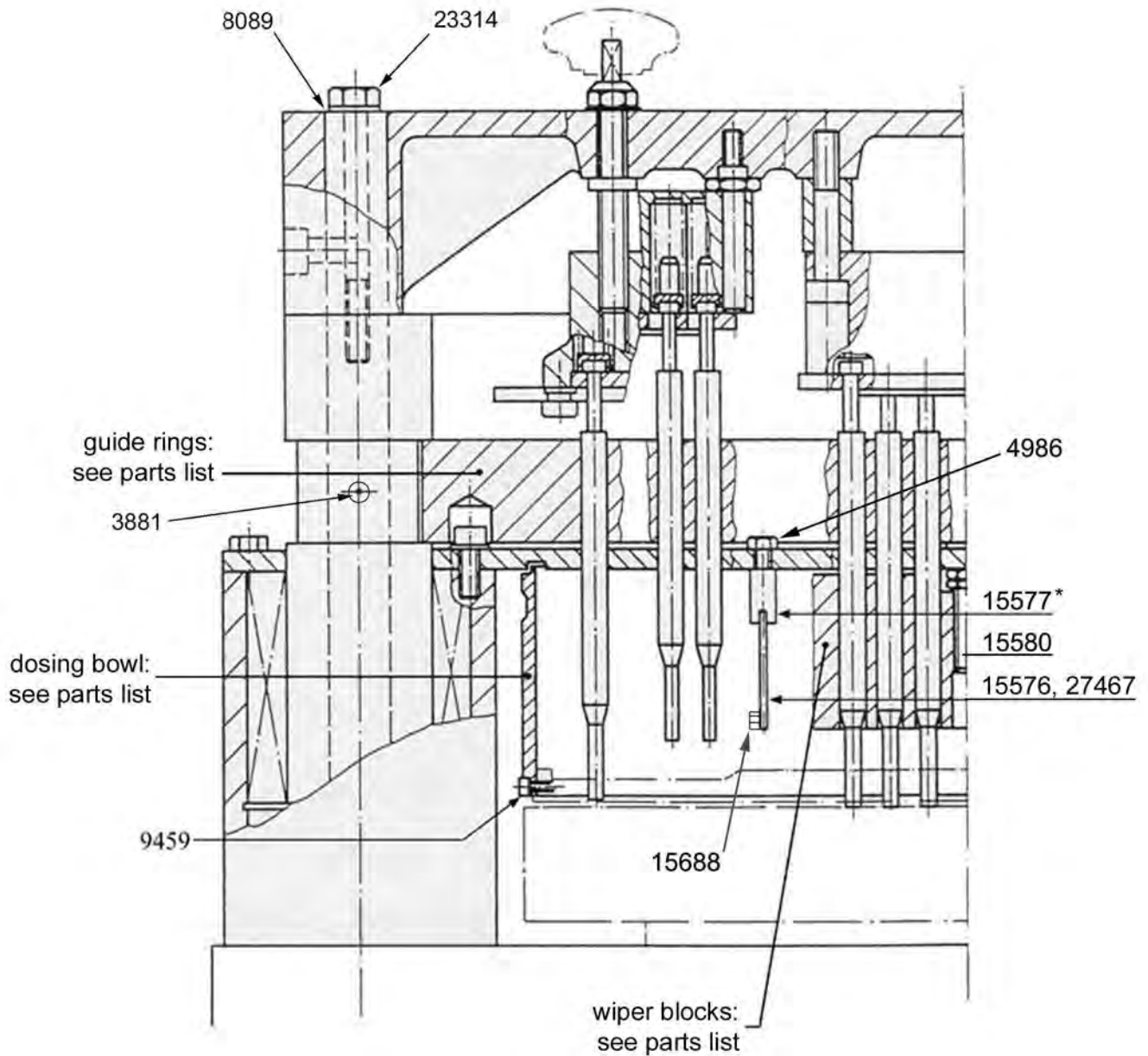


# Section 27.4: adjustable tamping block - IIM 2100



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

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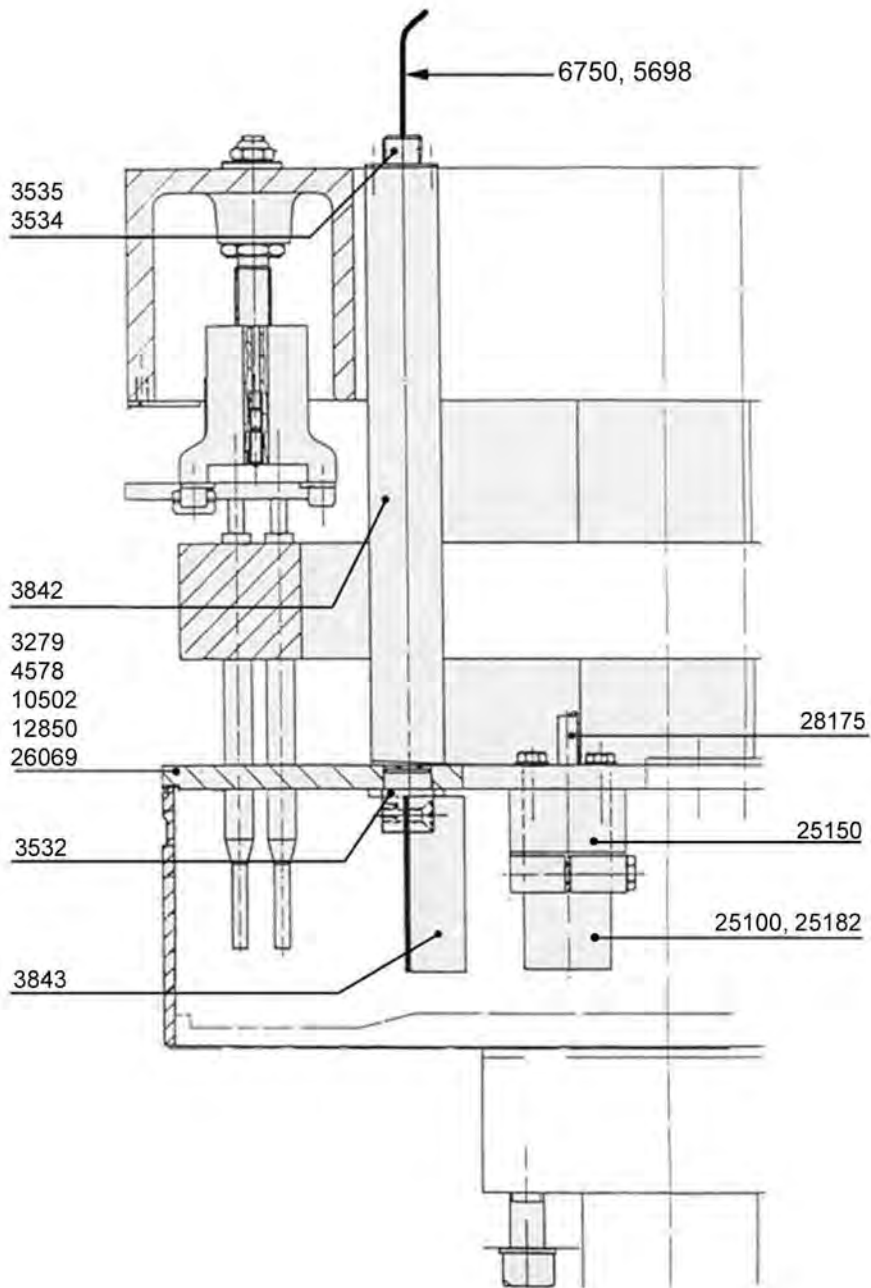
IIM No.	Description
3881	CAPTIVE BOLT FOR GUIDE RING MOUNT
4986	SCREW, TOP OF STUD 15577
8089	WASHER, M10, TAMPING HEAD MOUNT
9459	SCREW, SOCKET HEAD CAP
12880	GUIDE, 15MM, OLD STYLE, BRONZE GUIDE RING
12881	GUIDE, 10MM, NEW STYLE
15321	NUT, LOCK, WIPER BLOCK GUIDES, M8
15576	PLATE, POWDER MIXING
15577	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
3880	DOSING BOWL, 350MM OD X 100MM HIGH
5350	DOSING BOWL, 350MM OD X 105MM HIGH
7299	DOSING BOWL, 350MM OD X 104.5MM HIGH
15579	DOSING BOWL, 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, 70MM TALL, BRZ GUIDE RING
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 28.1: guide rings

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<b>Description</b>	<b>IIM No.</b>
Guide ring, 12ct, alum, bushed	25381
Guide ring, 12ct, alum, bushed & sealed	3500
Guide ring, 12ct, alum, refurb, bushed & sealed to bushed & sealed	8125
Guide ring, 12ct, alum, refurb, bushed to bushed	16411
Guide ring, 12ct, alum, refurb, bushed to bushed, TPS version, 4 corner broached	15436-R
Guide ring, 12ct, alum, refurb, bushed to bushed, DMW version (has screws)	15436
Guide ring, 12ct, alum, refurb, bushed to bushed, DMW version (no screws)	16411
Guide ring, 12ct, alum, refurb, std to bushed	5570
Guide ring, 12ct, alum, refurb, std to bushed & sealed	8469
Guide ring, 12ct, alum, refurb, std to bushed & sealed, reanodize	8126
Guide ring, 12ct, alum, special 25mm thick	10436
Guide ring, 12ct, alum, special 25mm thick, bushed & sealed	12866
Guide ring, 12ct, alum, special 40mm thick, refurb, std to bushed & sealed	24694
Guide ring, 12ct, alum, std version	3280
<hr/>	
Guide ring, 12ct, bronze, refurb with plastic ring, metric screws	5347
Guide ring, 12ct, bronze, refurb with plastic ring, std screws	25188
Guide ring, 12ct, bronze, refurb with plastic ring, TPS version	25314
Guide ring, 12ct, bronze, std version	16382
Guide ring, 12ct, bronze, with plastic ring	25189
<hr/>	
Guide ring, 16ct, alum, bushed	24918
Guide ring, 16ct, alum, bushed & sealed	13091
Guide ring, 16ct, alum, refurb, bushed & sealed to bushed & sealed	-
Guide ring, 16ct, alum, refurb, bushed to bushed, DMW version	24700
Guide ring, 16ct, alum, refurb, std to bushed	24968
Guide ring, 16ct, alum, refurb, std to bushed & sealed, DMW version	29364
Guide ring, 16ct, alum, std version	10475
Guide ring, 16ct, Index version, 25mm thick, ELC version	12576
Guide ring, 16ct, Index version, for Index conversion kit	12575
Guide ring, 16ct, Index version, rework with PET blocks over hole patterns	13751
Guide ring, 16ct, Index version, with bushings & seals + crown	27327
Guide ring, 16ct, Index version, with bushings + crown	14999

# Section 29: powder level sensing

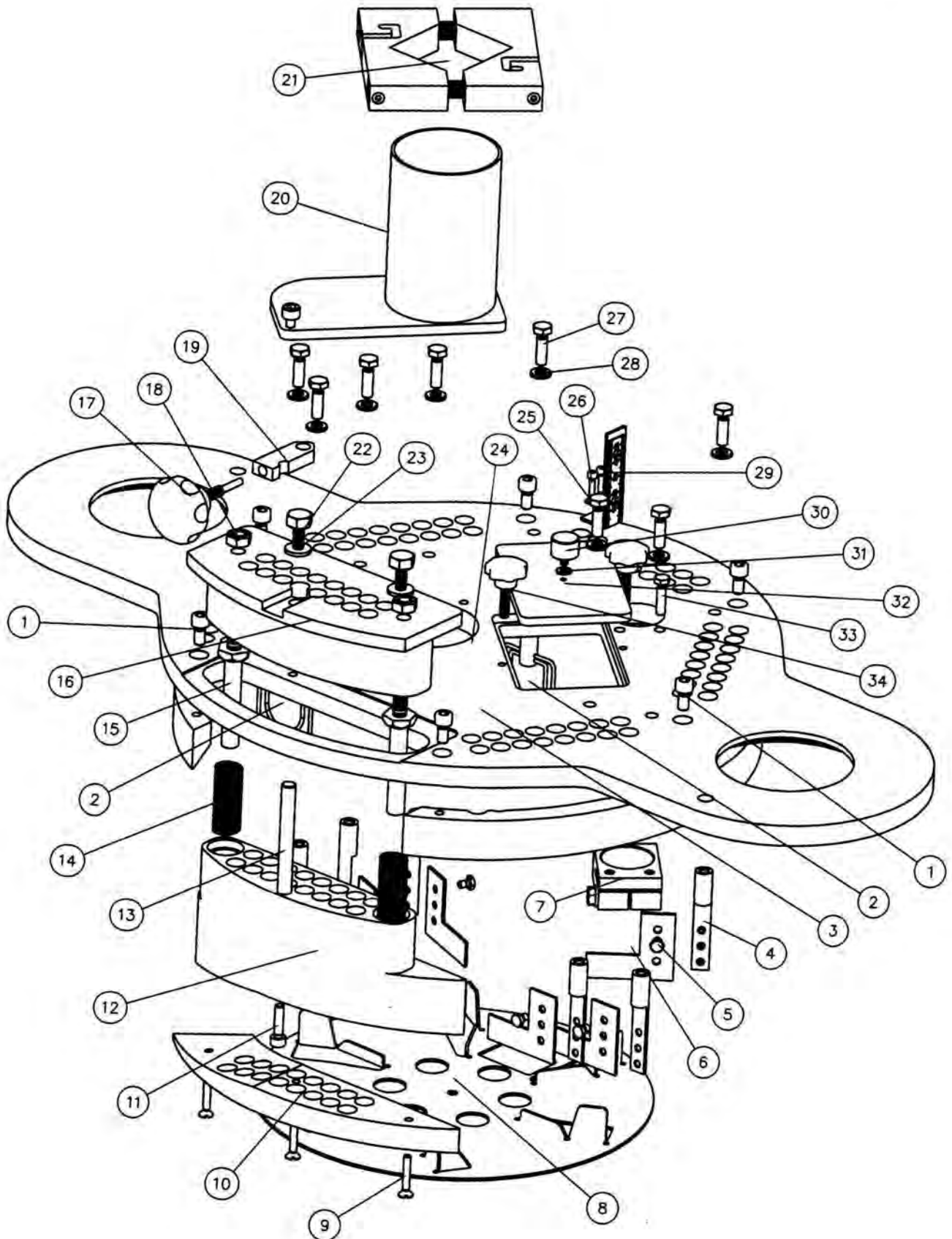


## Section 29: Powder level sensing

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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
25100	POWDER LEVEL SENSOR
25150	HOLDER, SENSOR, PLASTIC
25182	ENT ELIMINATOR KIT
28175	CABLE, FOR POWDER LEVEL BARREL SENSOR IIM 25100
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
30006	LEVEL SENSOR PLATE,16 COUNT,DMW
12850	LEVEL SENSOR PLATE,16 COUNT,INDEX
25021	LEVEL SENSOR PLATE,16 COUNT,W/SKIRT

# Section 29.1: powder level sensing - IIM 2100

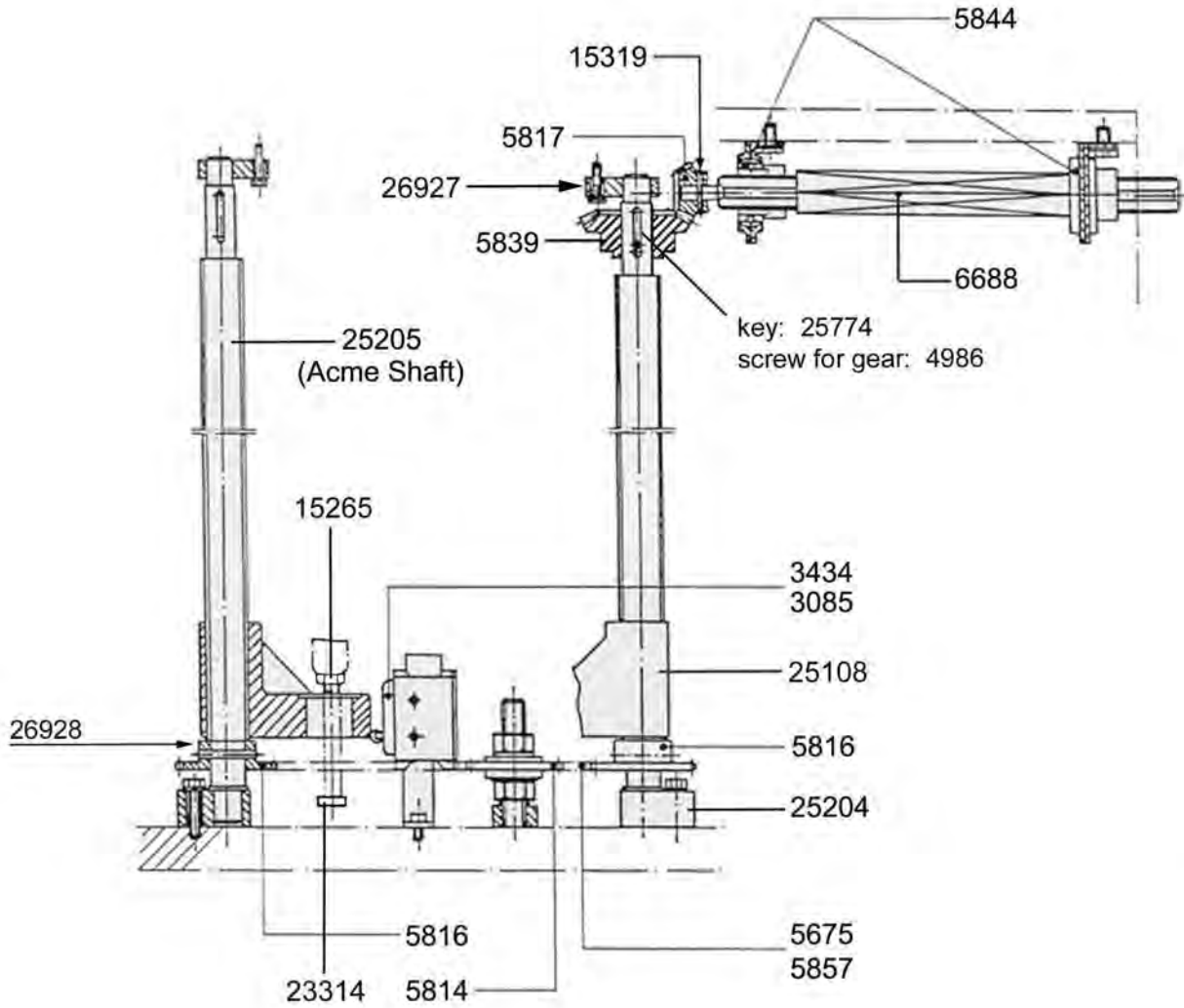


## Section 29.1: powder level sensing – IIM 2100

Pos	IIM No.	Qty	Description
1	4984	6	SCREW, SOCKET HEAD CAP
2	27467	2	STIRRER, POWDER
3	28769	1	LEVEL SENSOR PLATE
3	29168	1	SKIRT, LEVEL SENSOR PLATE
4	15577	6	STUD, MOUNT
5	13852	6	SCREW, HEX HEAD
6	15576	6	PLATE, POWDER LEVEL
7	28907	1	MOUNT, PROX SENSOR
8	28263	1	WATERWHEEL
9	24523	3	SCREW, FLAT HEAD SLOTTED, NYLON
10	28908	1	BASE, DEFLECTOR
11	5273	1	SCREW, CYLINDER HEAD CAP
12	28909	1	WIPER BLOCK
13	28295	1	SHAFT
14	28298	2	SPRING
15	12881	2	GUIDE, 10MM
16	28910	1	PLATE, TOP
17	13563	1	KNOB, WIPER BLOCK
18	15569	2	LOCKNUT
19	13562	1	BRACKET
20	28885	1	TUBE
21	28913	1	HOLDER, PROX-POWDER
22	28911	2	BOLT
23	14500	2	WASHER
25	8177	2	WASHER
26	9446	2	SCREW, SOCKET HEAD CAP
27	14349	8	SCREW, HEX HEAD
28	6039	8	WASHER
29	25161	1	SCALE
31	8088	1	WASHER
32	28912	1	COVER PLATE ASSY
32	28915	1	COVER PLATE
33	7934	2	SCREW, HEX HEAD
34	28914	1	KNOB, KNURLED



# Section 30: lifting for dosing device

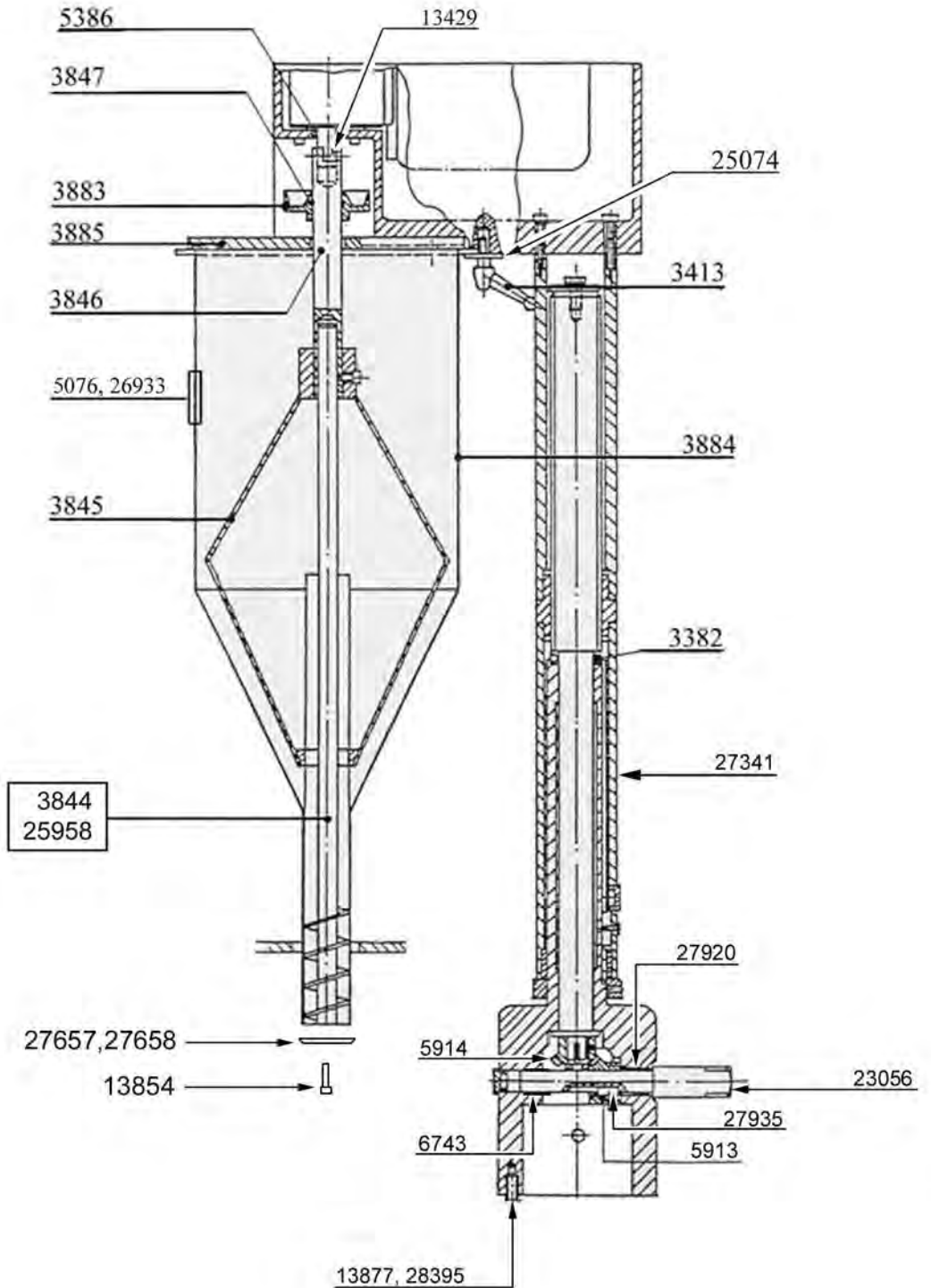


### Section 30: Lifting for dosing device

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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

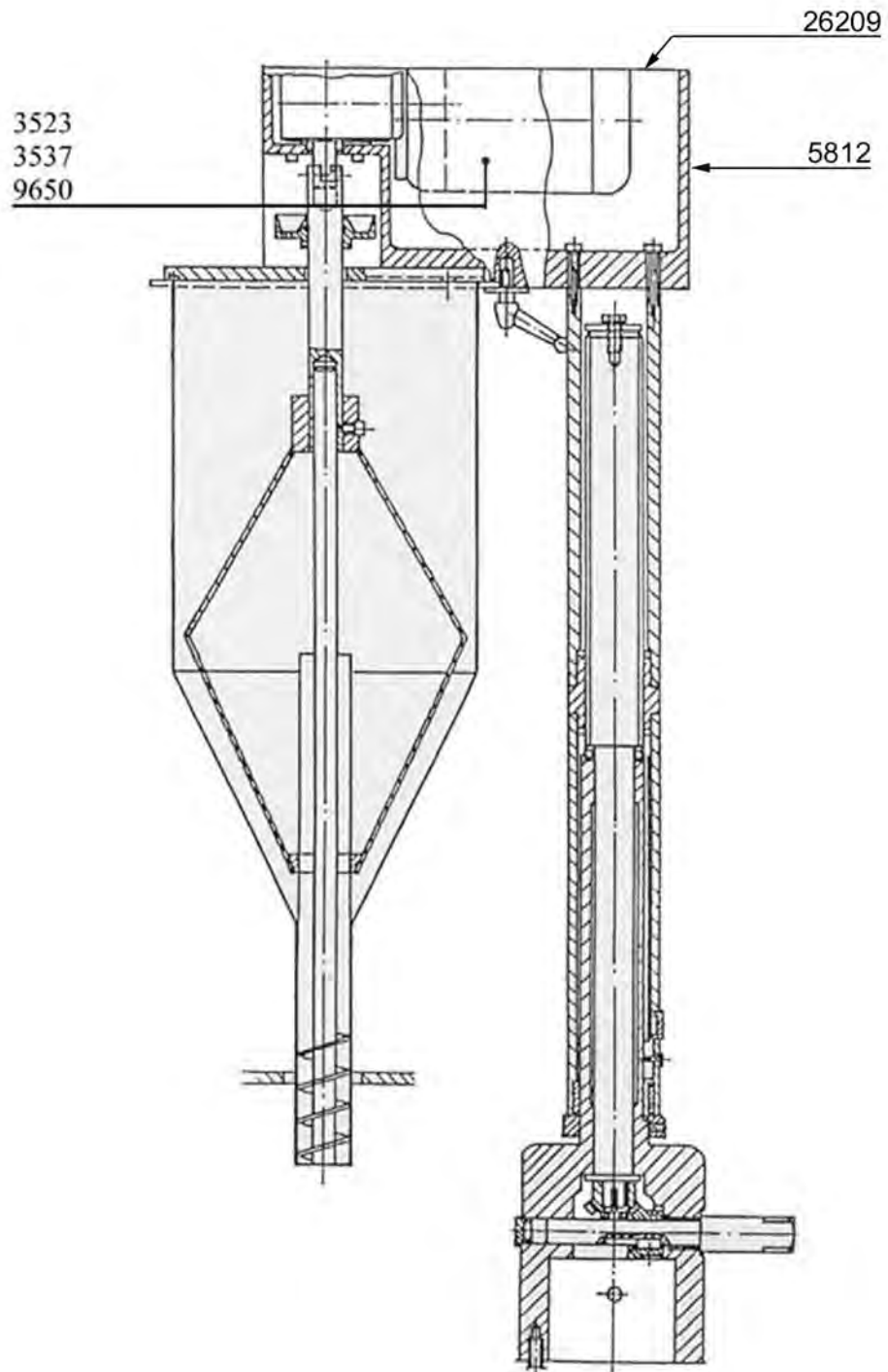


**Section 31: Powder infeed, vertical**

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<b>IIM No.</b>	<b>Description</b>
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
13854	BOLT
13877	WASHER M12 SERRATED
23056	SHAFT
25074	WASHER,OVERSIZED,POWDER HOPPER
25958	AUGER, 8 TWIST, FASTER FEED
26209	COVER, AUGER MOTOR HOUSING
26933	SIGHT GLASS,OLD STYLE
27341	COLUMN, POWDER HOPPER LIFT
27657	DISC,RESTRICTOR,S/STL
27658	DISC,RESTRICTOR,TEFLON
27935	KEY
28208	DOWEL PIN
28395	SCREW,POWDER HOPPER LIFT HOUSING

# Section 32: powder infeed gearmotor

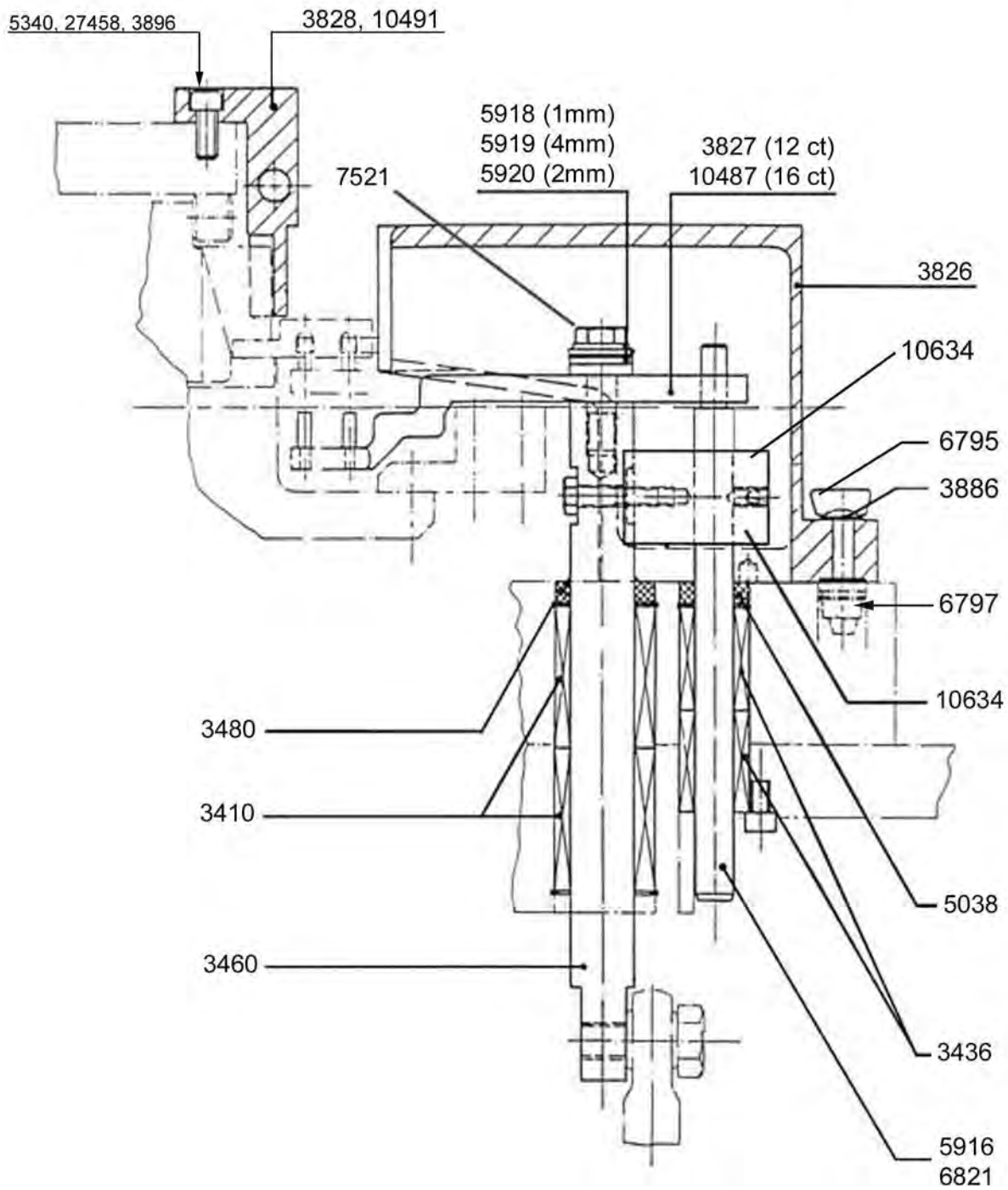


## Section 32: Powder infeed gearmotors

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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



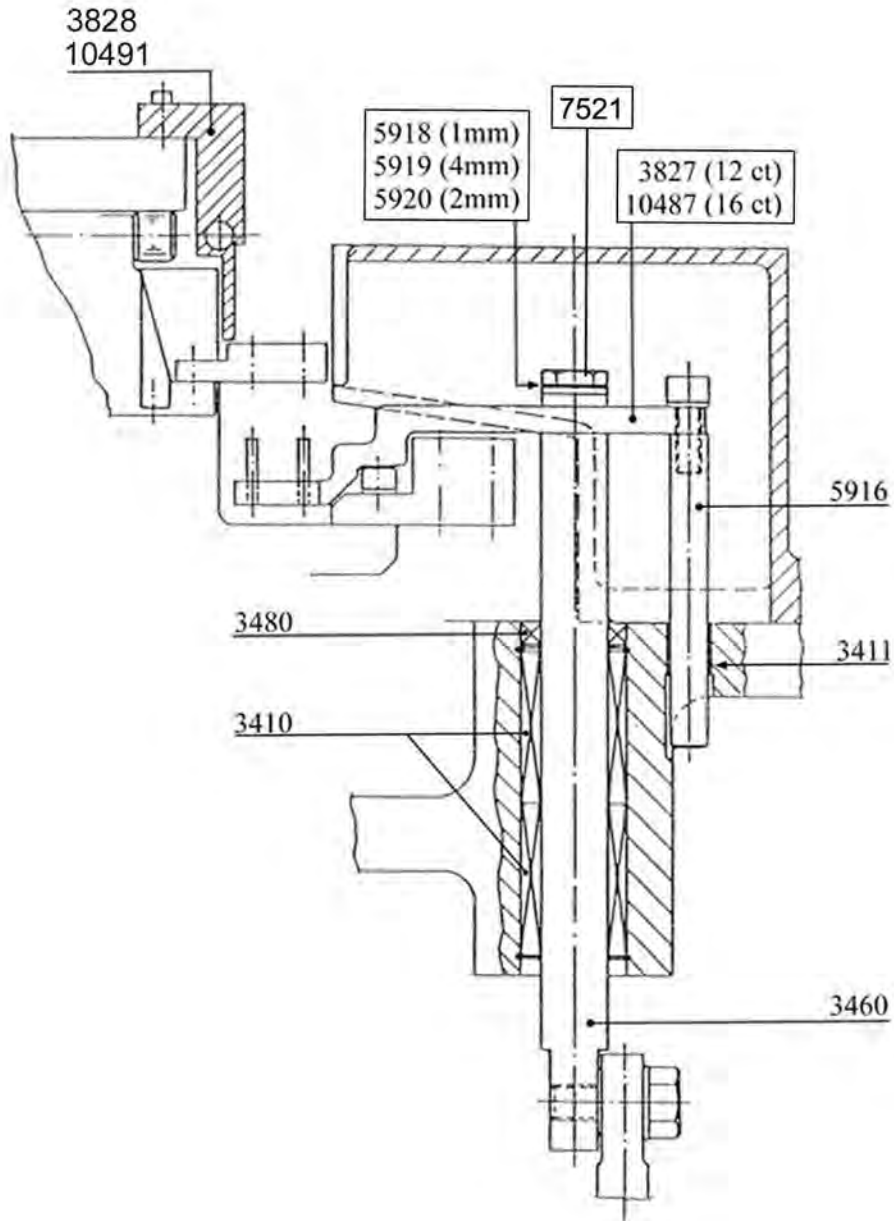
### Section 33: Faulty capsule ejection, new style

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IIM No.	Description
3410	BEARING,LINER,FOR 20 MM DRIVE SHAFT
3436	BEARING,LINER
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

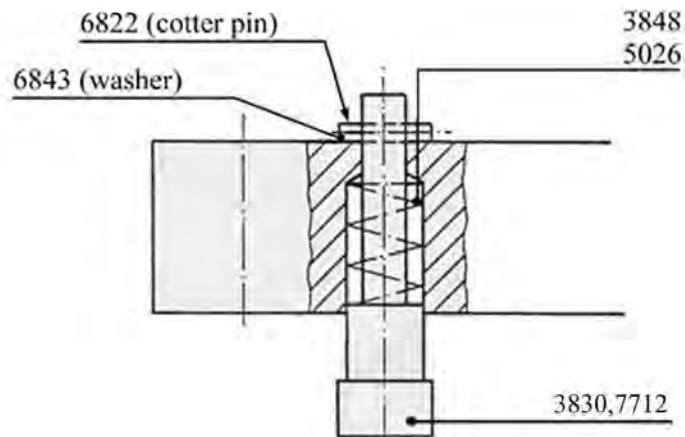
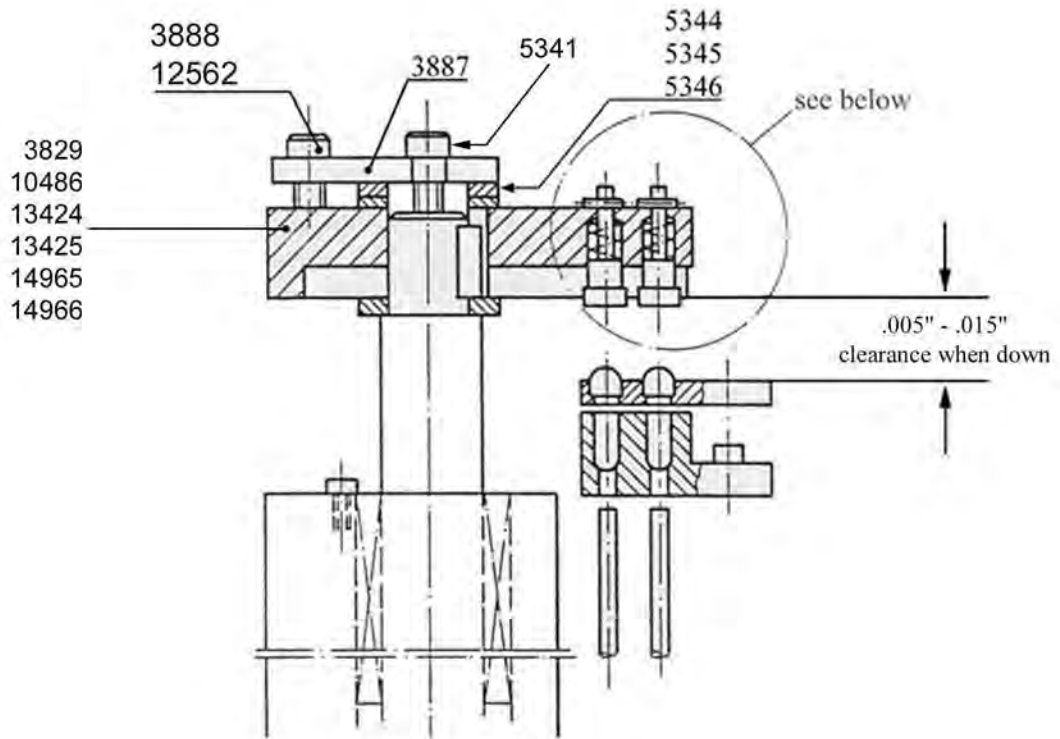


### Section 34: Faulty capsule ejection, old style

---

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

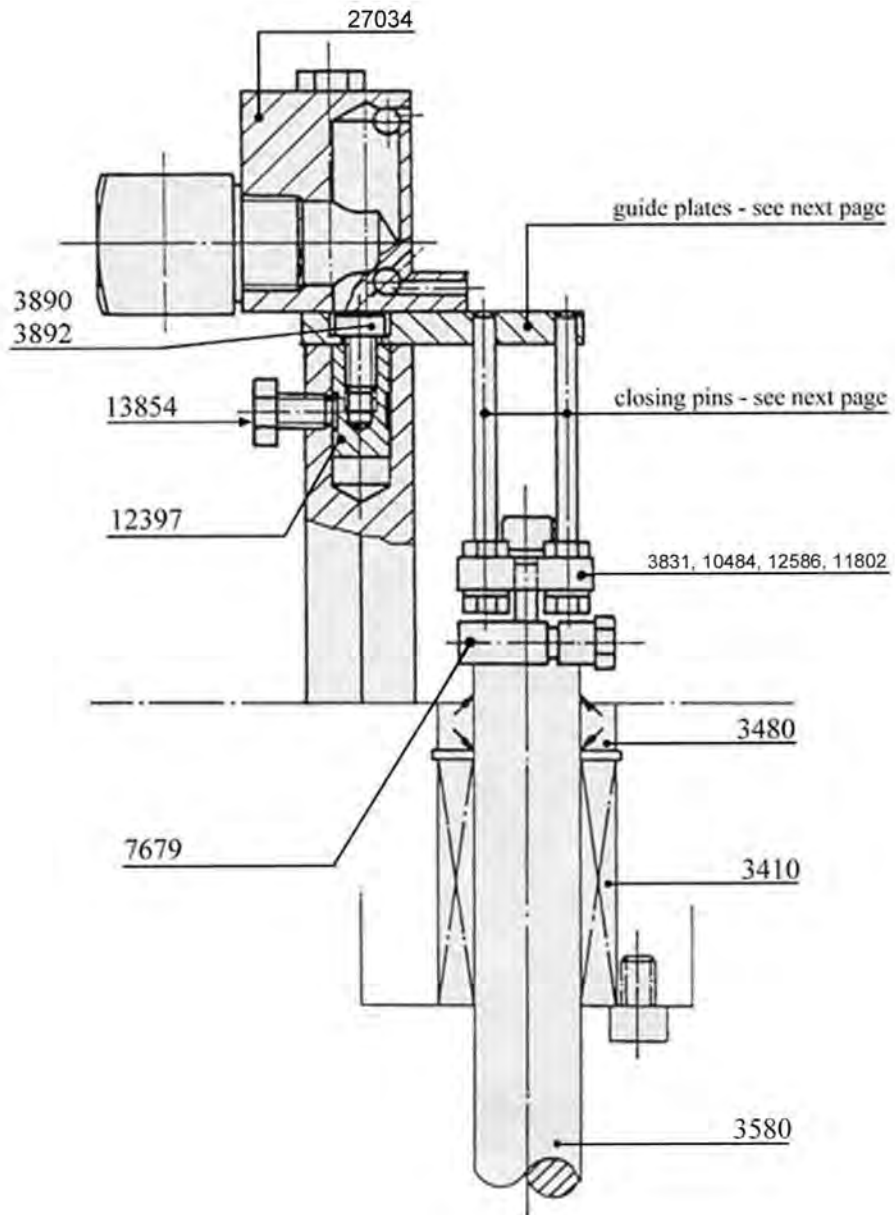


## Section 35: Upper closing

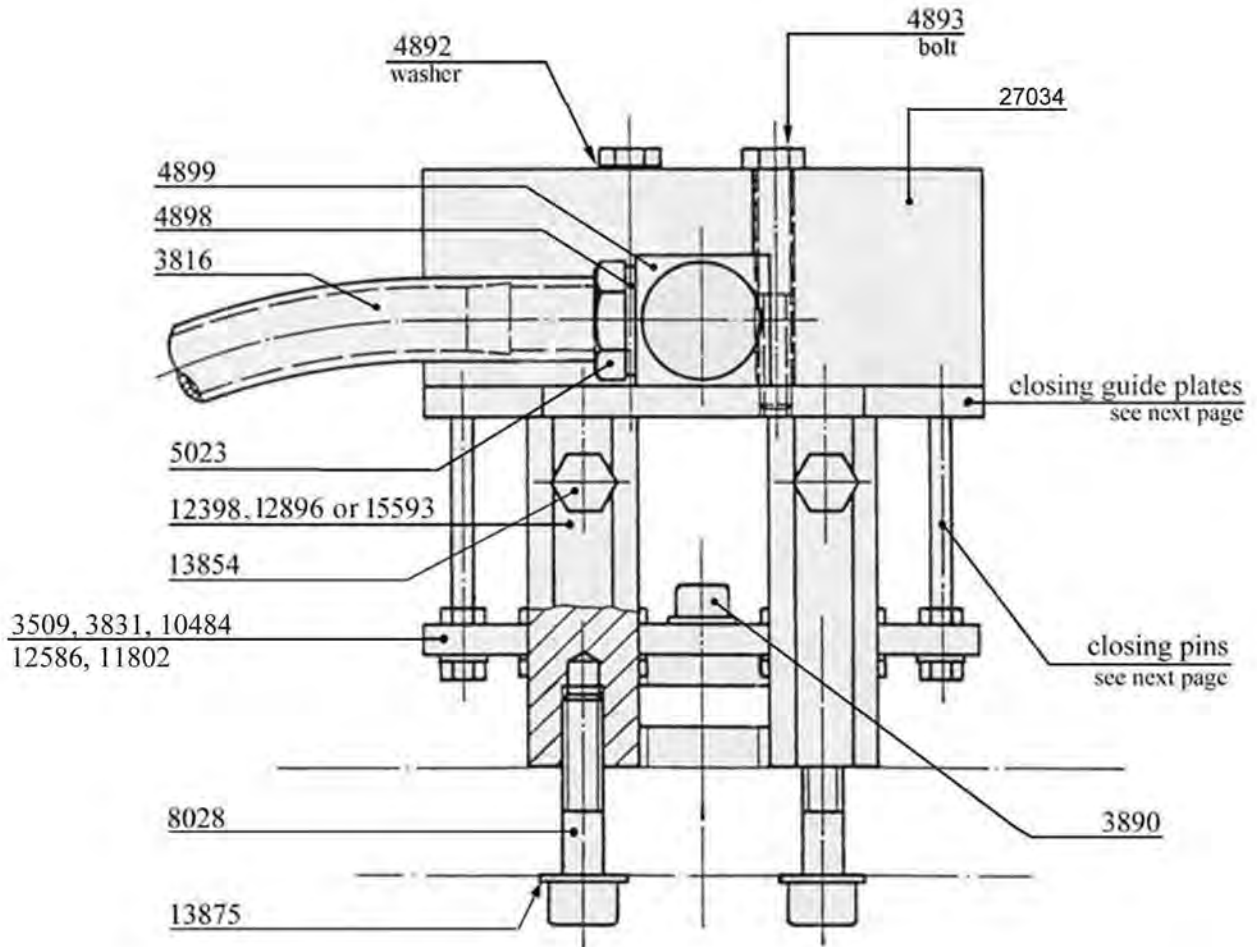
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IIM No.	Description
3830	SEALING PLUNGER
3848	COMPRESSION SPRING
3887	HOLD-DOWN,CLOSING,ARM
3888	SCREW,SHOULDER,SOCKET HEAD,HOLD-DOWN
5026	COMPRESSION SPRING, STAINLESS STEEL
5341	BOLT,INTEGRAL WASHER
6822	PIN,COTTER,S/S,CLOSING PLUNGER
6843	WASHER, M5
7709	KEY
7712	BLOCK,CLOSING,DELTRIN (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

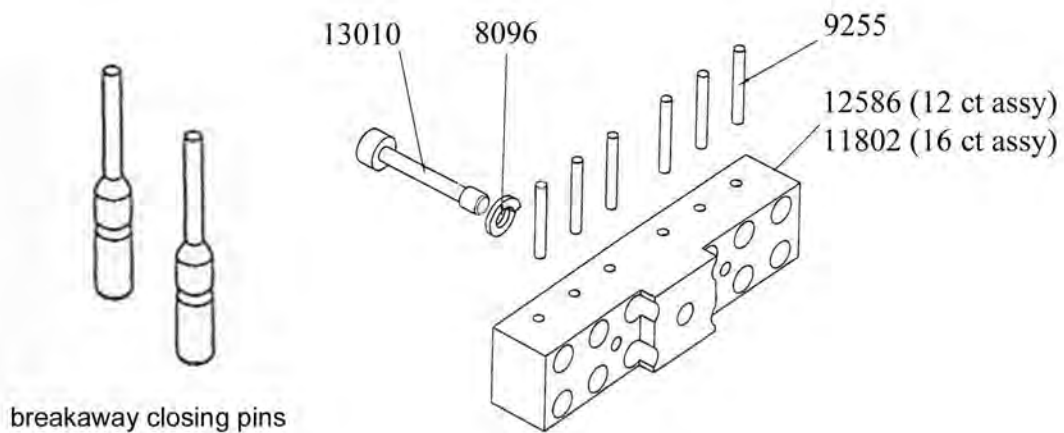
## Section 36.1: lower closing



## Section 36.2: lower closing



Breakaway closing block - accepts pins 16228, 16230, 16232



**Section 36: Lower closing**

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<b>IIM No.</b>	<b>Description</b>
3410	BEARING,LINEAR,FOR 20 MM DRIVE SHAFT
3480	RING, SCRAPER
3509	PLATE,EJECTION W/M6 HOLE,4 DIA ALIGN.HOLES,W/BOLTS,12CT,NEW STYLE
3816	HOSE, SUCKER BLOCK
3831	PLATE,CLOSING/LIFTING,THREADED,12 CT,OLD STYLE
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,62mm long
12896	STANDOFF,OLD STYLE,63.5mm long - part of 15593
13010	CAPTIVE SCREW
13854	SCREW,M6 X 12
13875	WASHER,SERRATED
15593	STANDOFF ASSY,ADJUSTABLE,NEW STYLE
27034	BLOCK,VACUUM,FINAL CLOSING STATION,W/FITTING
31639	GUIDE PLATE,CLOSING,SIZE 000,12 COUNT,M6 CAPTIVE SCREWS
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
3849	GUIDE PLATE,CLOSING,SIZE 3 & 4,12 COUNT,M6 CAPTIVE SCREWS
14517	GUIDE PLATE,CLOSING,SIZE 3 & 4,16 COUNT,M6 CAPTIVE SCREWS
12586	BLOCK,CLOSING PIN,UPGRADE,12 COUNT (does not include closing pins)
11802	BLOCK,CLOSING PIN,UPGRADE,16 COUNT (does not include closing pins)

**SEE NEXT PAGE FOR CLOSING PINS**

## Section 36: lower closing

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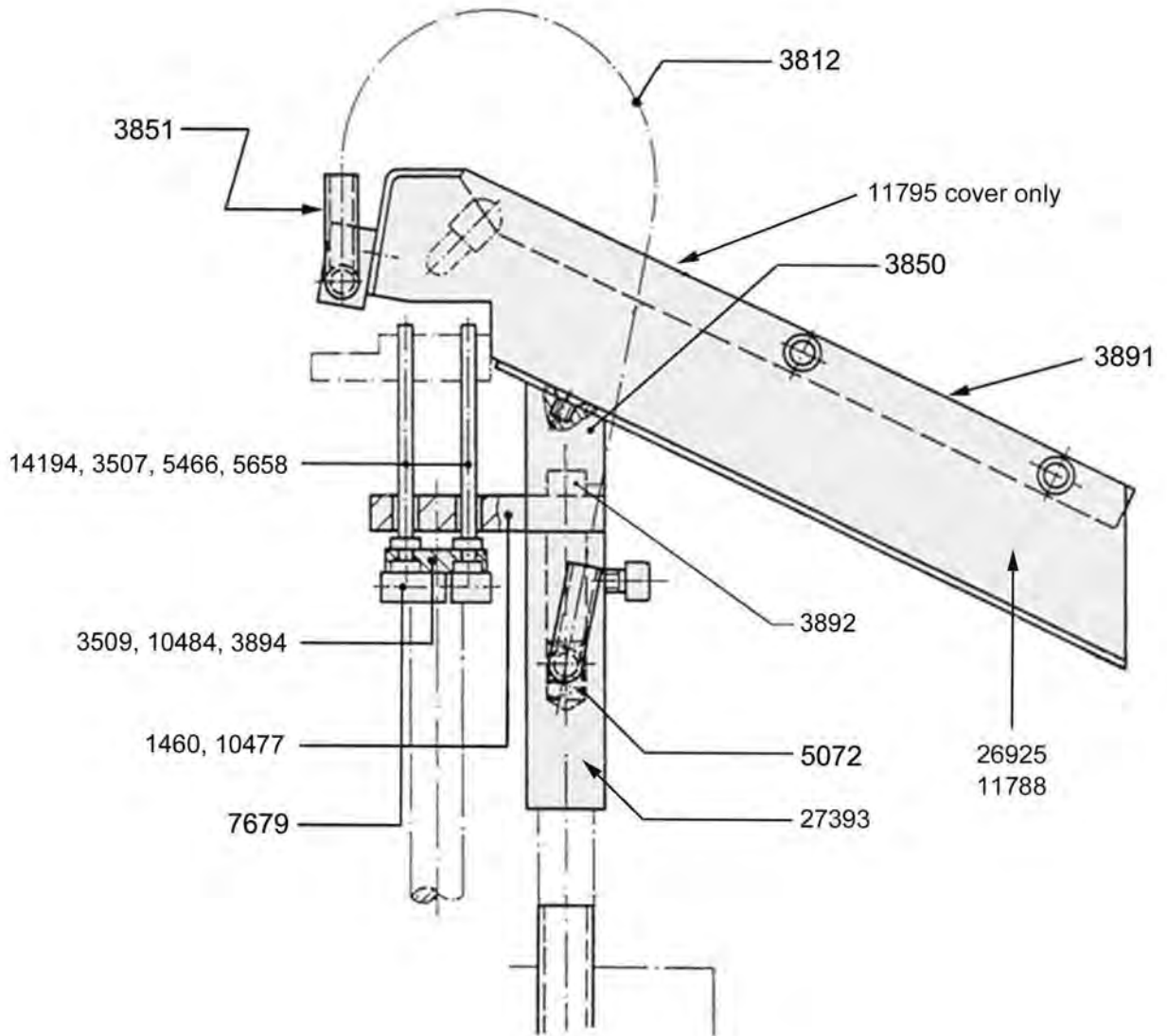
IIM No.	Description
31638	PIN,CLOSING,SZ 000,53MM LONG,OLD STYLE
7320	PIN,CLOSING,SZ 0/00,49MM LONG,NEW STYLE
13414	PIN,CLOSING,SZ 0/00,53MM LONG,OLD STYLE
7323	PIN,CLOSING,SZ 0/00,55MM LONG,OLD STYLE,POWDER SHEDDING
16228	PIN,CLOSING,SZ 0/00,NEW STYLE,NO GUIDE,POWDER SHEDDING,BREAKAWAY
28121	PIN,CLOSING,SZ 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 1/2,49MM LONG,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 3/4,49MM LONG,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



Picture	IIM p/n	Description
	7320	Size 0&00, 49mm long, new style  Guide: 6820 (12ct) or 14556 (16ct) Mount plate: 3509 (12ct) or 10484 (16ct)
	13414	Size 0&00, 53mm long, old style  Guide: 6820 (12ct) or 14556 (16ct) Mount plate: 3831 (12ct) or 10484 (16ct)
	7323	Size 0&00, 53mm long, old style, powder shedding  Guide: 6820 (12ct) or 14556 (16ct) Mount plate: 3831 (12ct) or 10484 (16ct)
	16228	Size 0&00, breakaway, powder shedding  Mount block: 12586 (12ct) or 11802 (16ct)
	31458	With larger bore for difficult products
	10493	Size 1&2, 49mm long, new style  Guide: 3120 (12ct) or 10496 (16ct) Mount plate: 3509 (12ct) or 10484 (16ct)
	7319	Size 1&2, 53mm long, old style  Guide: 3120 (12ct) or 10496 (16ct) Mount plate: 3831 (12ct) or 10484 (16ct)
	7322	Size 1&2, 53mm long, old style, powder shedding  Guide: 3120 (12ct) or 10496 (16ct) Mount plate: 3831 (12ct) or 10484 (16ct)

Picture	IIM p/n	Description
	16230	Size 1&2, breakaway, powder shedding  Mount block: 12586 (12ct) or 11802 (16ct)
	12041	Size 3&4, 49mm long, new style  Guide: 3849 (12ct) or 14517 (16ct) Mount plate: 3509 (12ct) or 10484 (16ct)
	3448	Size 3&4, 53mm long, old style  Guide: 3849 (12ct) or 14517 (16ct) Mount plate: 3831 (12ct) or 10484 (16ct)
	7321	Size 3&4, 53mm long, old style, powder shedding  Guide: 3849 (12ct) or 14517 (16ct) Mount plate: 3831 (12ct) or 10484 (16ct)
	16232	Size 3&4, breakaway, powder shedding  Mount block: 12586 (12ct) or 11802 (16ct)

# Section 37: ejection



## Section 37: ejection

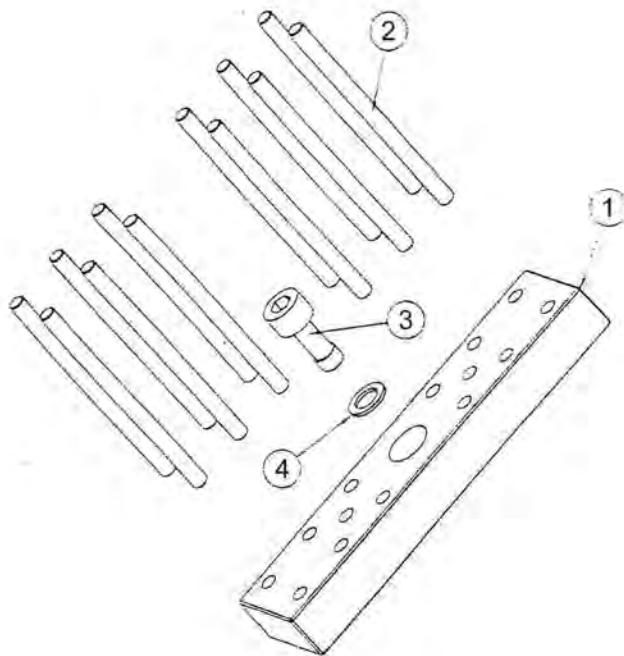
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IIM No.	Description
1460	PLATE, EJECTION GUIDE, W/ALIGNMENT HOLES
3507	PIN, EJECTION, 62MM TALL, NEW STYLE, FLAT TIP
3509	PLATE, EJECTION W/M6 HOLE, 4 DIA ALIGN.HOLES, W/BOLTS,NEW STYLE,12 CT
3812	HOSE, VACUUM, DISCHARGE
3850	BRACKET, HOLDING CHUTE
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

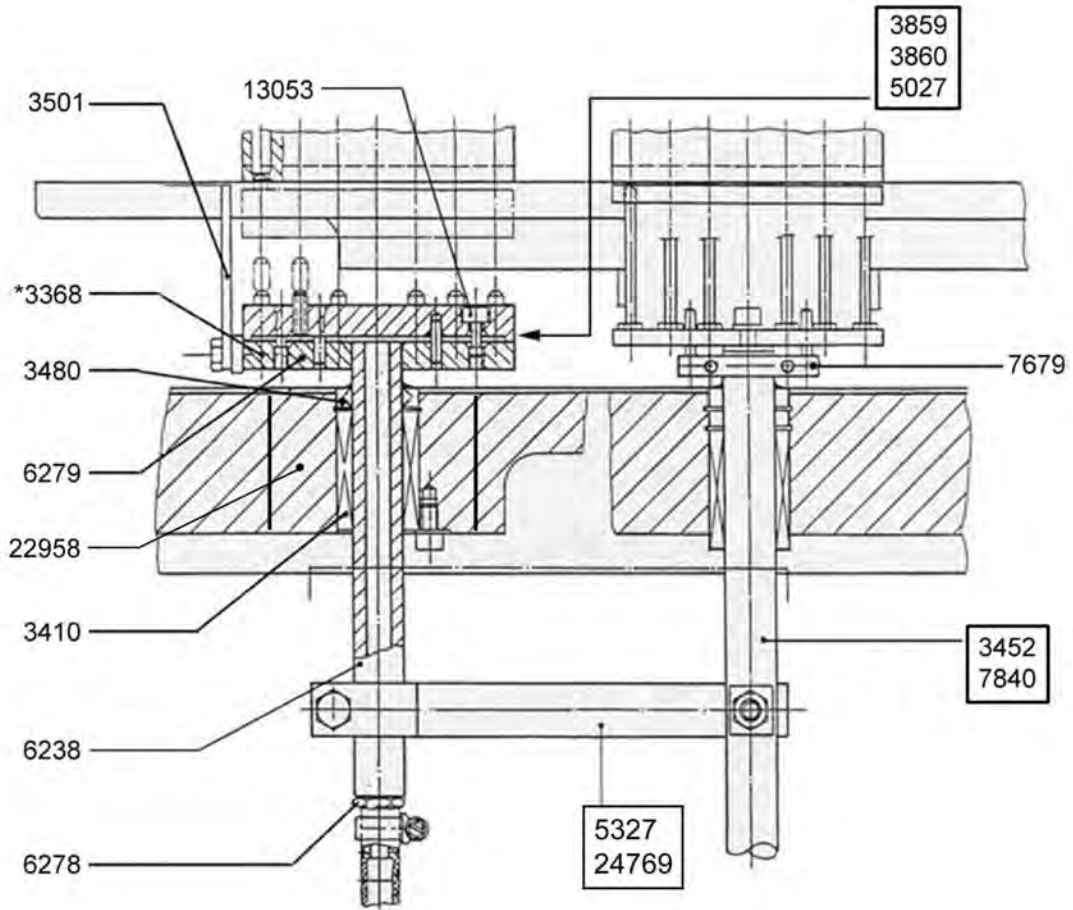
## Section 37.2: Breakaway ejection

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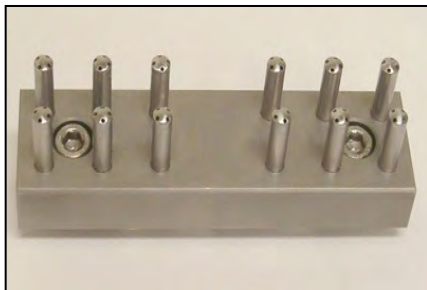
Pos	Description	P/n
0	Assembly (12 count)	14265
0.1	Assembly (16 count)	14196
1	Base, breakaway ejection pin (12 count)	14266
1.1	Base, breakaway ejection pin (16 count)	14192
2	Pin, ejection, breakaway	14194
3	Captive screw	13053
4	Lock washer	13874



# Section 38: blowout and cleaning



Standard blowout block



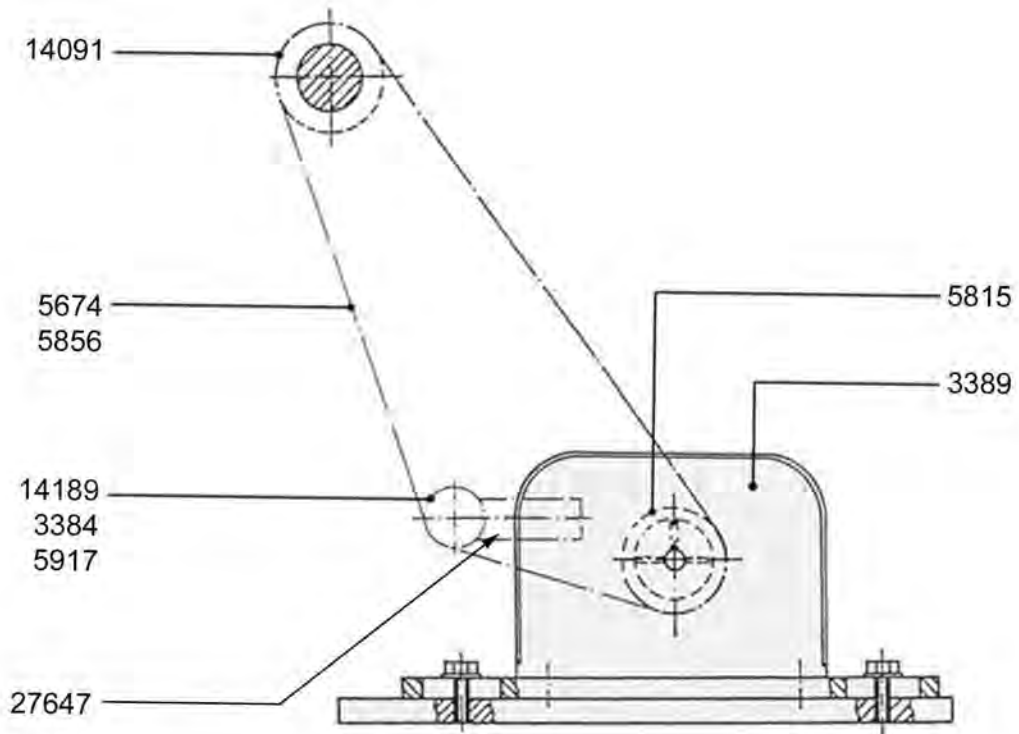
Brushed blowout block



## Section 38: blowout and cleaning

<b>Description</b>	<b>IIM No.</b>		
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		
		<b>12ct</b>	<b>16ct</b>
			<b>16ct 8 hole</b>
BLOWOUT BLOCK, SIZE 0, 00	3859	13408	25374
BLOWOUT BLOCK, SIZE 1, 2	3860	10478	25703
BLOWOUT BLOCK, SIZE 3, 4	5027	12855	25701
		<b>12ct</b>	<b>16ct</b>
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	
		<b>std ver</b>	<b>8 hole</b>
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

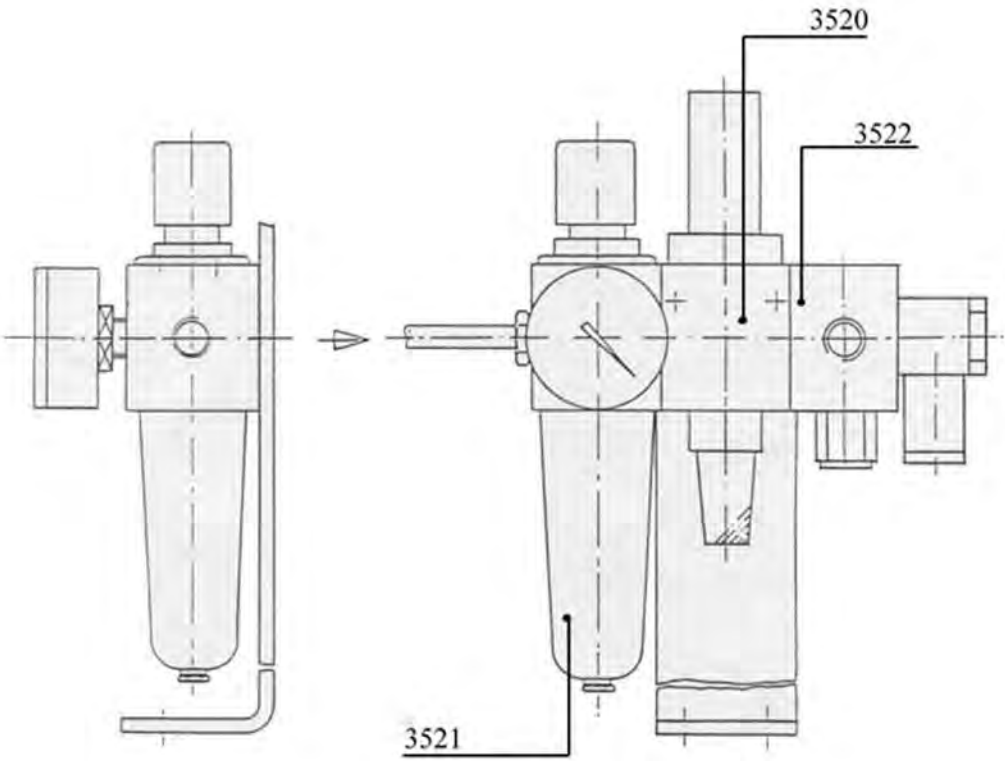


## Section 39: Cam box

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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

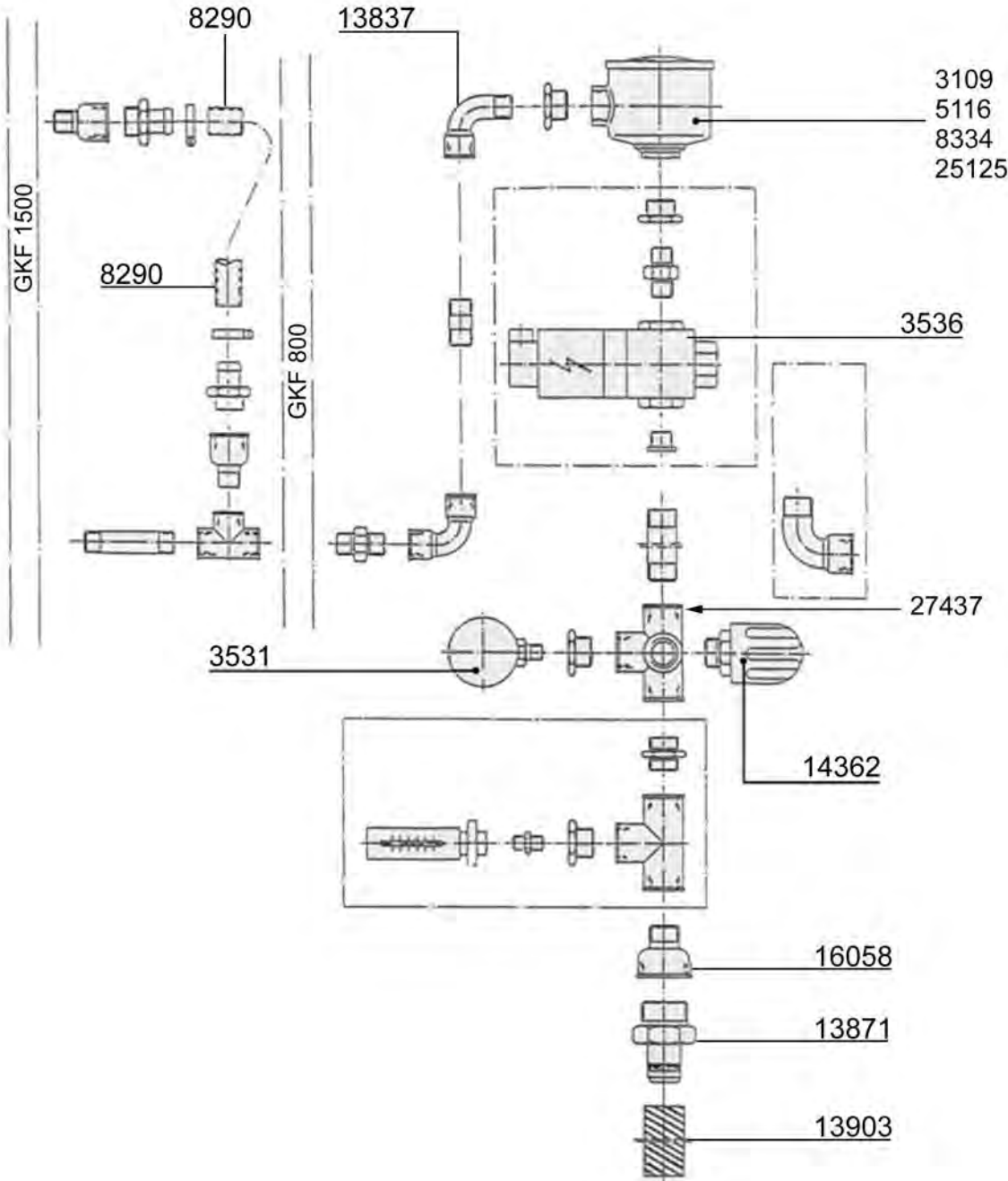


## Section 40: Compressed air components

---

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

# Section 41: vacuum system with filter



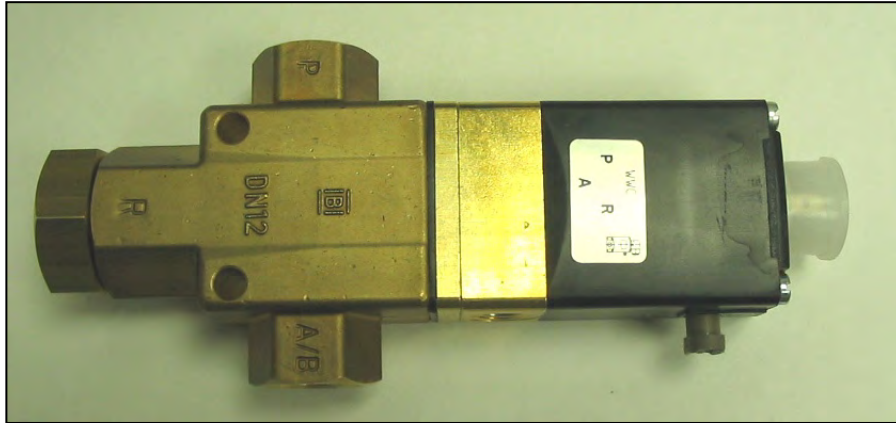
**Section 41: Vacuum system with filter**

---

<b>IIM No.</b>	<b>Description</b>
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

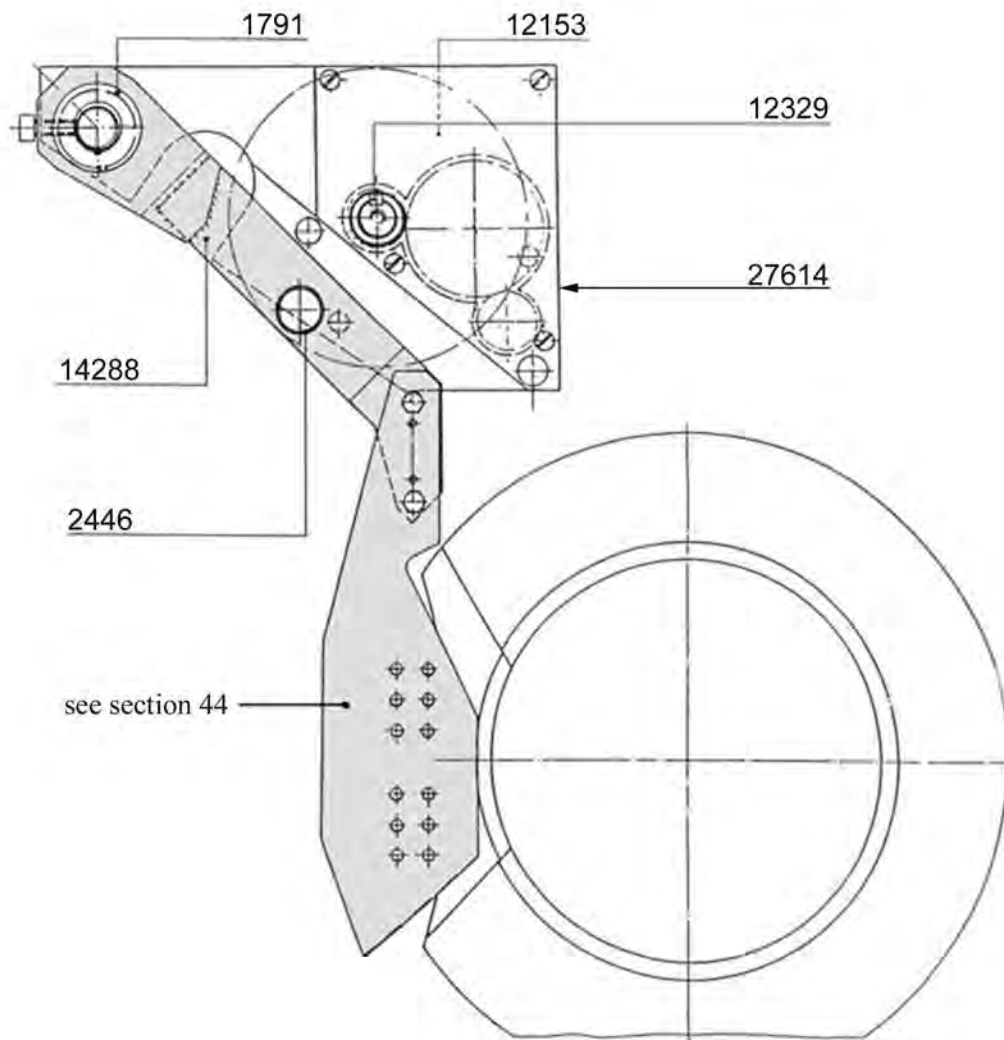
## Section 42: vacuum valve

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





## Section 43.2: pellet filling with dosing disc



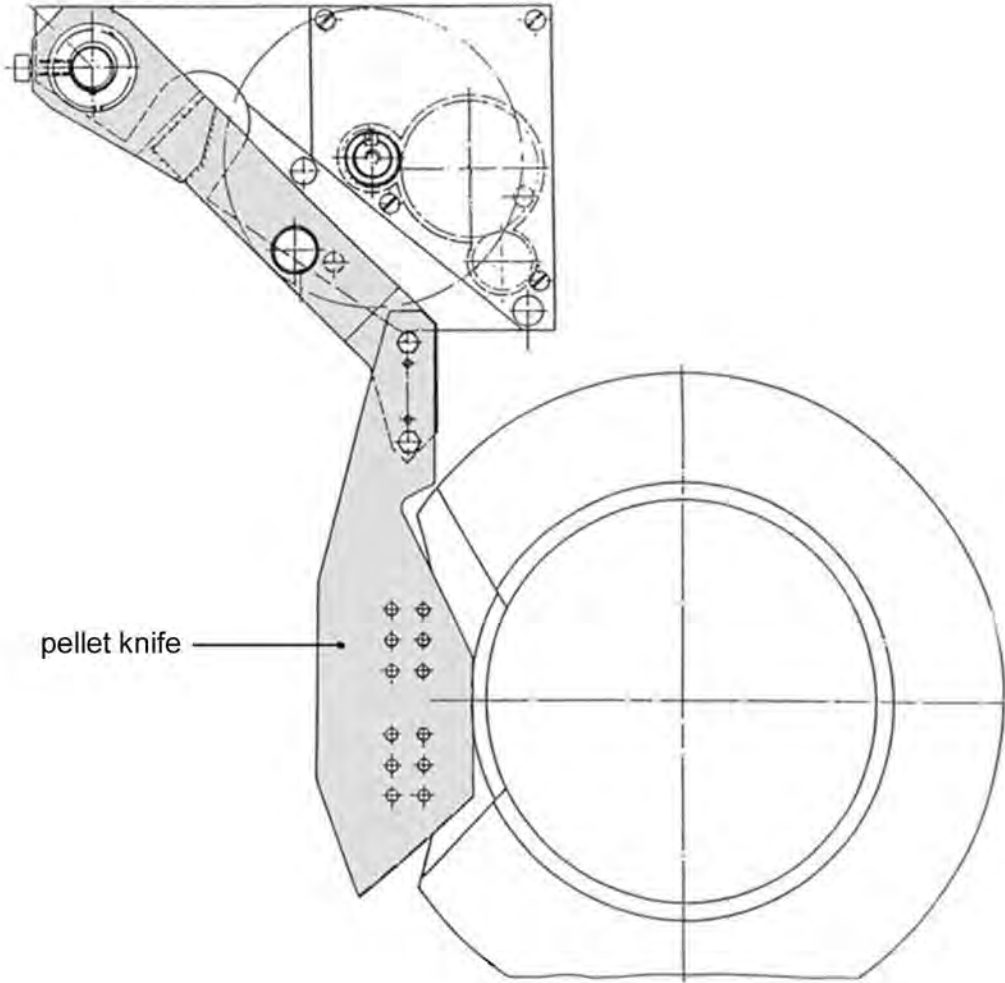


### Section 43: Pellet filling with dosing disc

---

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, PELLETT KNIFE
14288	LEVER
21615	BEAD FEED MECHANISM COMPLETE,INCLUDES TAMPING RING
27614	DRIVE ASSY, TABLETOP, PELLETT KNIFE

## Section 44: pellet knife



**Section 44: pellet knife**

---

<b>IIM No.</b>	<b>Description</b>
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

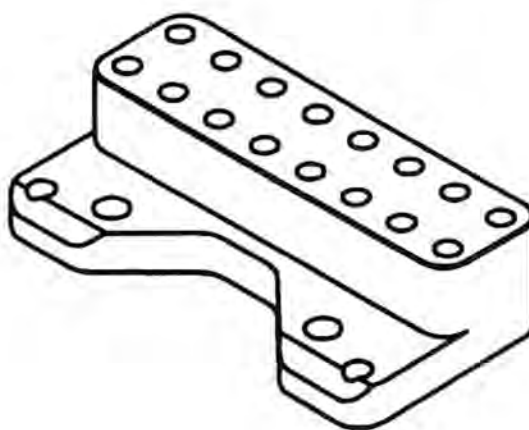
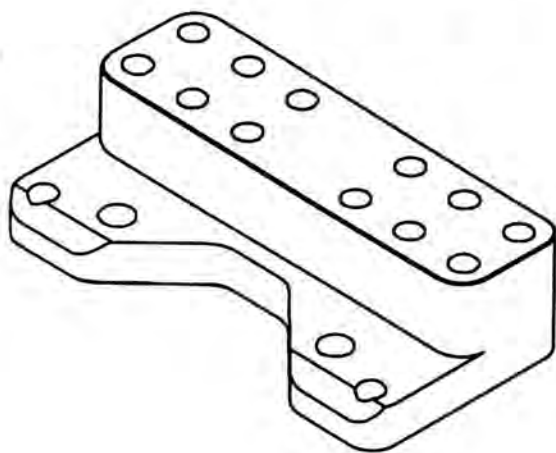
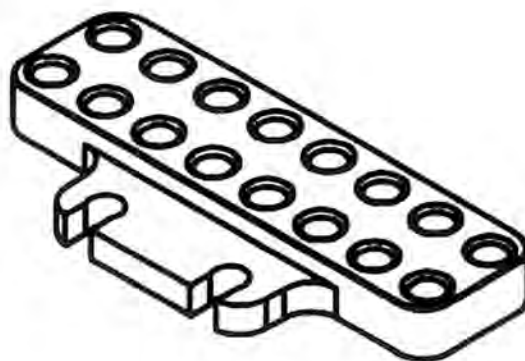
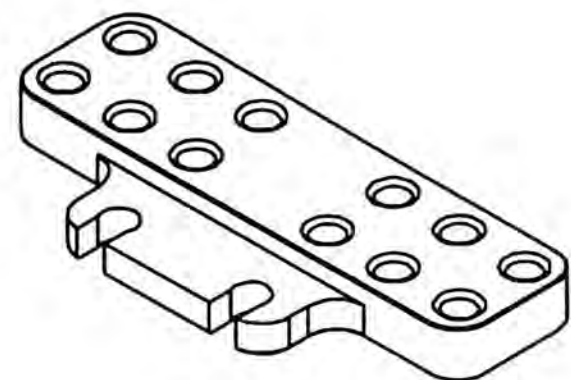
Image	Description	IIM p/n
	<p>Ejection cam Key Screw</p>	<p><b>3371</b> <b>13056</b> <b>8036</b></p>
	<p>Upper closing cam Key Screw</p>	<p><b>3366</b> <b>13056</b> <b>8036</b></p>
	<p>Lower closing cam Key Screw</p>	<p><b>3282</b> <b>13056</b> <b>8036</b></p>
	<p>Separation cam Key Screw</p>	<p><b>3365</b> <b>14477</b> <b>8036</b></p>

Image	Description	IIM p/n
	Sorting cam Key Screw	<b>3367</b> <b>13056</b> <b>8036</b>
	Faulty capsule cam Key Screw	<b>3372</b> <b>13056</b> <b>8036</b>
	Tamping/dosing cam Key Screw	<b>3364</b> <b>13089</b> <b>8039</b>
	Cam alignment rod	<b>14107</b>

# Section 46: change parts - segment blocks, alignment pins

12 count

16 count



segment alignment pin



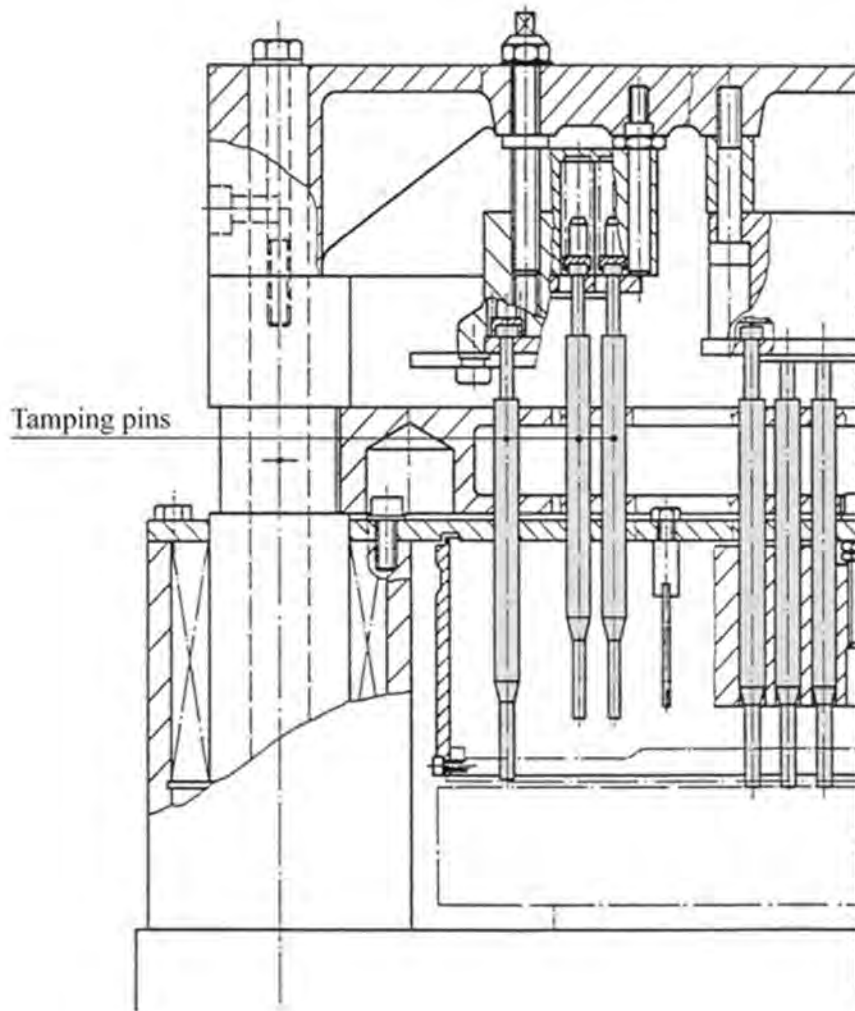
## Section 46: Change parts: segment blocks, alignment pins

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

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

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

## Section 47: change parts - tamping pins





## Section 47: tamping pins, dosing alignment pins

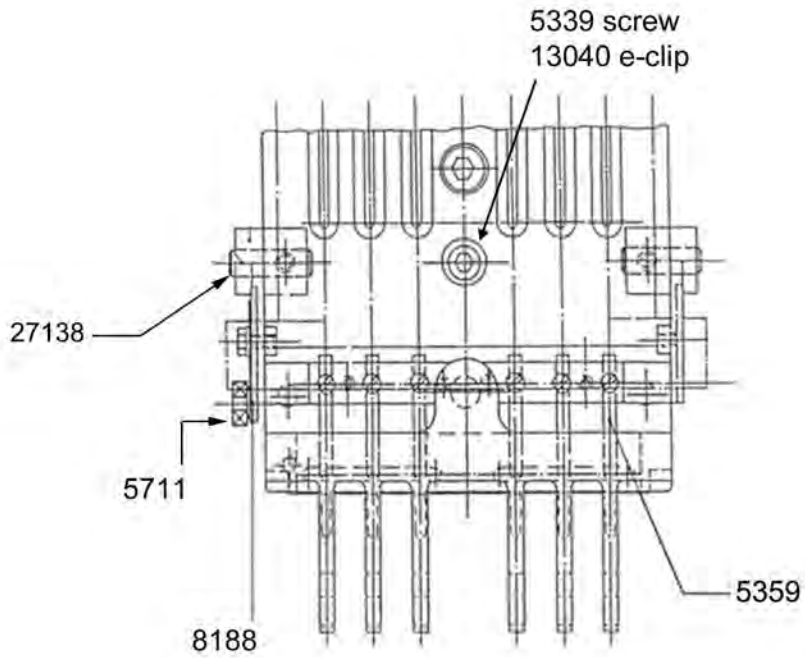
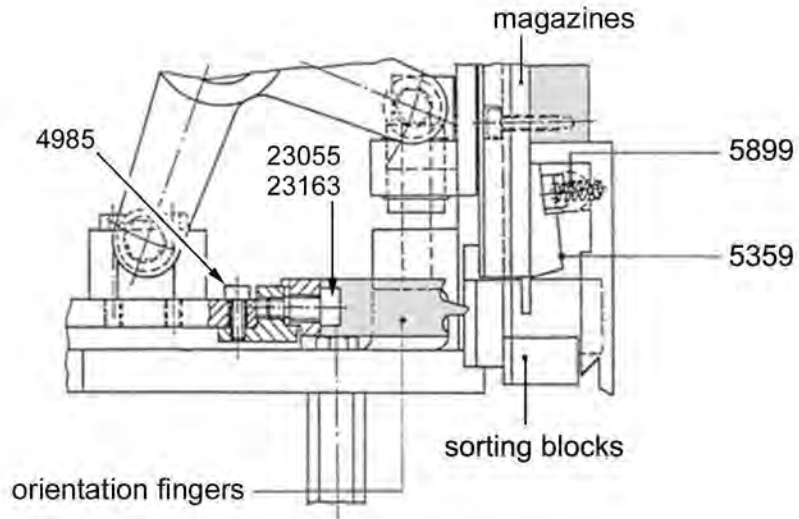
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Description	Standard	Mirrored tip	Adj dosing disc
Tamping pin size 000	13165	29850	13358
Tamping pin size 00	3879	29849	7533
Tamping pin size 0	3839	29723	7534
Tamping pin size 1	3840	29845	7535
Tamping pin size 2	3878	29694	7536
Tamping pin size 3	5150	29846	7537
Tamping pin size 4	5126	29847	7538
Tamping pin size 5	11312	29848	13359

Description	Standard	Polished tip	Adj dosing disc
Tamping pin size 000 - IIM 2100	13065	29851	13060
Tamping pin size 00 - IIM 2100	13066	29852	13061
Tamping pin size 0 - IIM 2100	12953	29853	13062
Tamping pin size 1 - IIM 2100	13062	29737	13063
Tamping pin size 2 - IIM 2100	13067	29854	13064
Tamping pin size 3 - IIM 2100	13068	29736	13071
Tamping pin size 4 - IIM 2100	13069	29855	13072
Tamping pin size 5 - IIM 2100	13070	29856	-

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



## 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

	<b>12ct</b>	<b>12ct plastic</b>	<b>16ct</b>	<b>16ct plastic</b>
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	-	-	-	-

	<b>12ct</b>	<b>12ct plastic</b>	<b>16ct</b>	<b>16ct plastic</b>
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	-	-	-	-

	<b>12ct</b>	<b>16ct</b>
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

	<b>12ct</b>	<b>16ct</b>
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

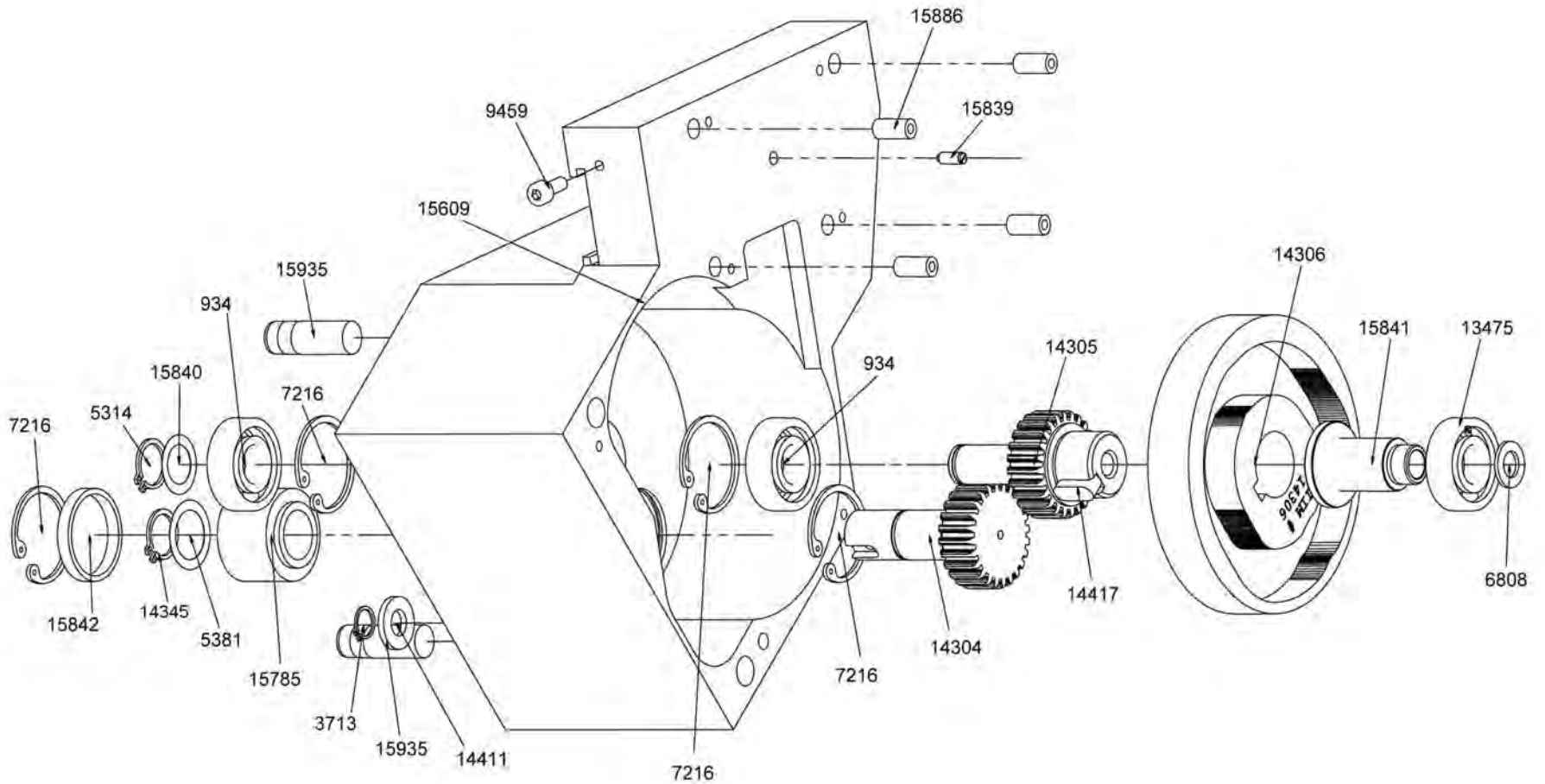
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### Pellet/Bead feed parts

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49.4	Dosing chamber assembly, 12 count, station 4, dual adjustment
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50.6	Exit plates, 12 and 16 count
50.7	Hopper and base

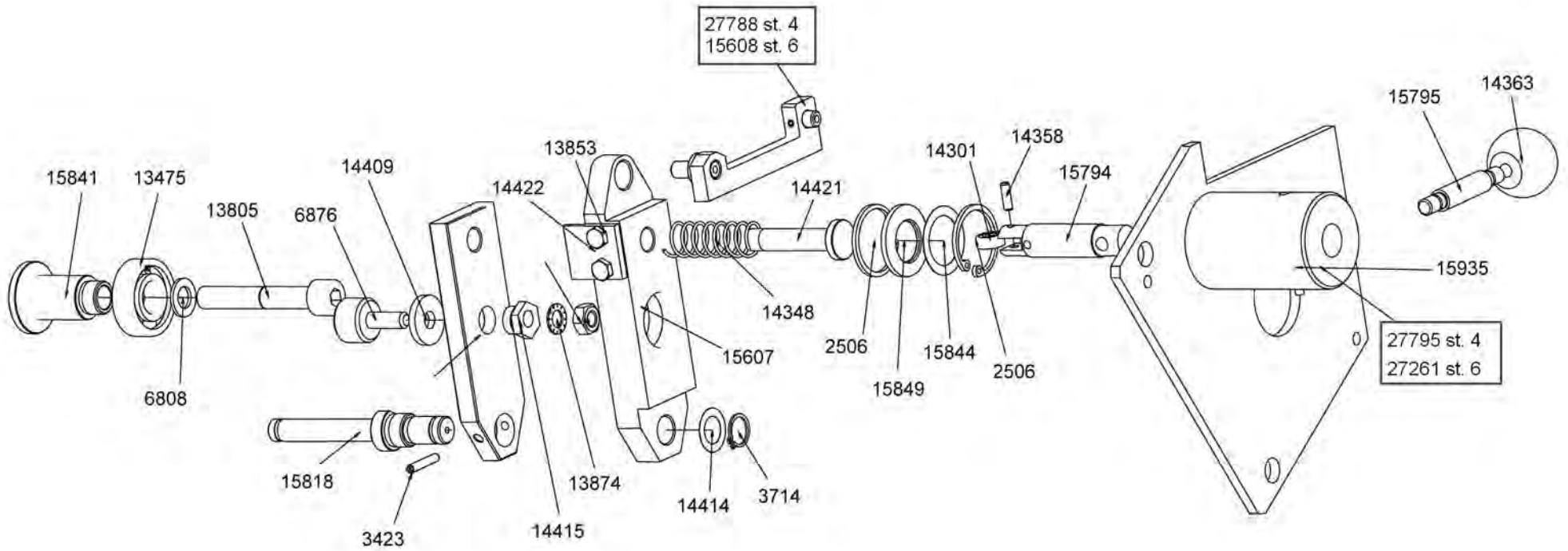
# Section 49.1: bead feed assembly



## Section 49.1: bead feed assembly

IIM no.	Description
934	BEARING
3713	SNAP RING, EXTERNAL
5314	SNAP RING, EXTERNAL
5381	SHIM
6808	WASHER, M8
7216	SNAP RING, INTERNAL
9459	SOCKET HEAD CAP SCREW
13475	BEARING
14304	PINION
14305	PINION
14306	CAM
14345	SNAP RING, EXTERNAL
14411	WASHER
14417	KEY
15609	HOUSING
15785	NEEDLE BEARING
15839	BALL PLUNGER
15840	SHIM
15841	SPACER
15842	SPACER
15886	BUSHING
15935	DOWEL PIN

# Section 49.2: bead feed assembly

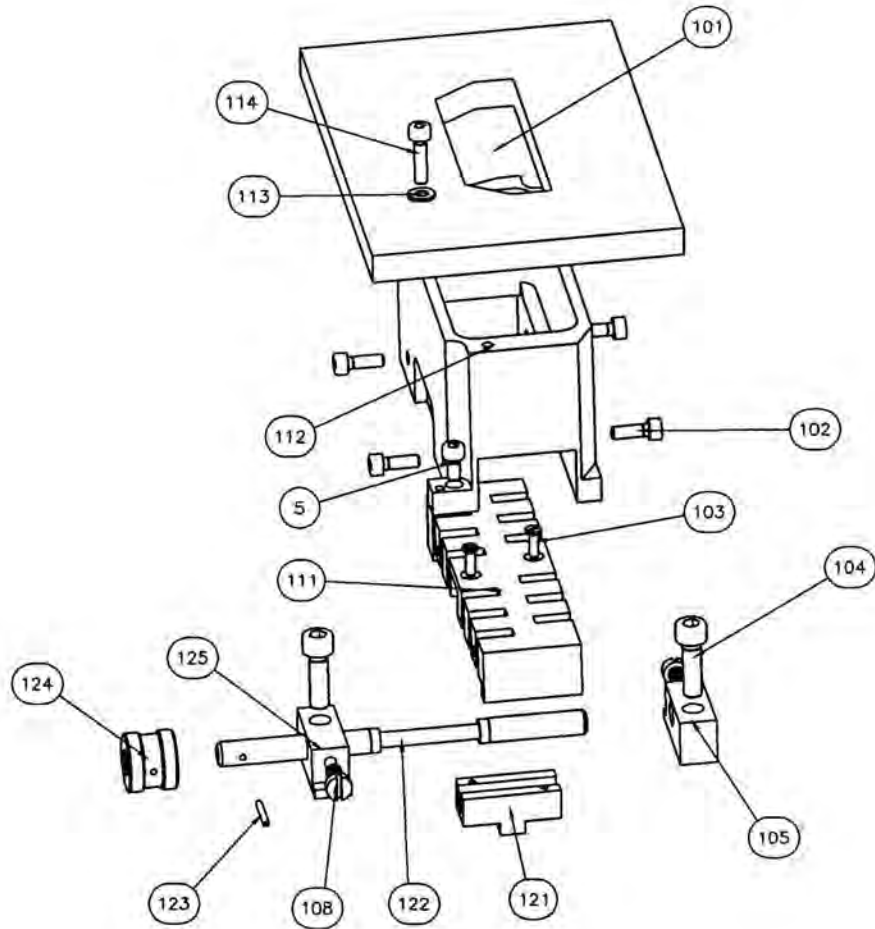


## Section 49.2: bead feed assembly

IIM no.	Description
2506	SNAP RING, INTERNAL
3423	ROLL PIN
3714	SNAP RING, EXTERNAL
6808	WASHER
6876	CAM FOLLOWER
13475	BEARING
13805	SCREW, SOCKET HEAD CAP
13853	SCREW, HEX
13874	WASHER, M6, SERRATED
14301	BEARING
14358	DOWEL PIN
14363	KNOB
14409	WASHER
14414	SHIM
14415	BUSHING, ECCENTRIC
14421	PIN
14422	LUG PLATE
15607	LEVER, DRIVEN
15608	LINK, ST6
15794	PLUNGER SHAFT
15795	CROSS SHAFT
15818	SHAFT
15820	LATCH
15841	SPACER
15844	SHIM
15849	WASHER
15935	DOWEL PIN
27261	GUARD ASSY, ST6
27788	LINK, ST4
27795	GUARD ASSY, ST4



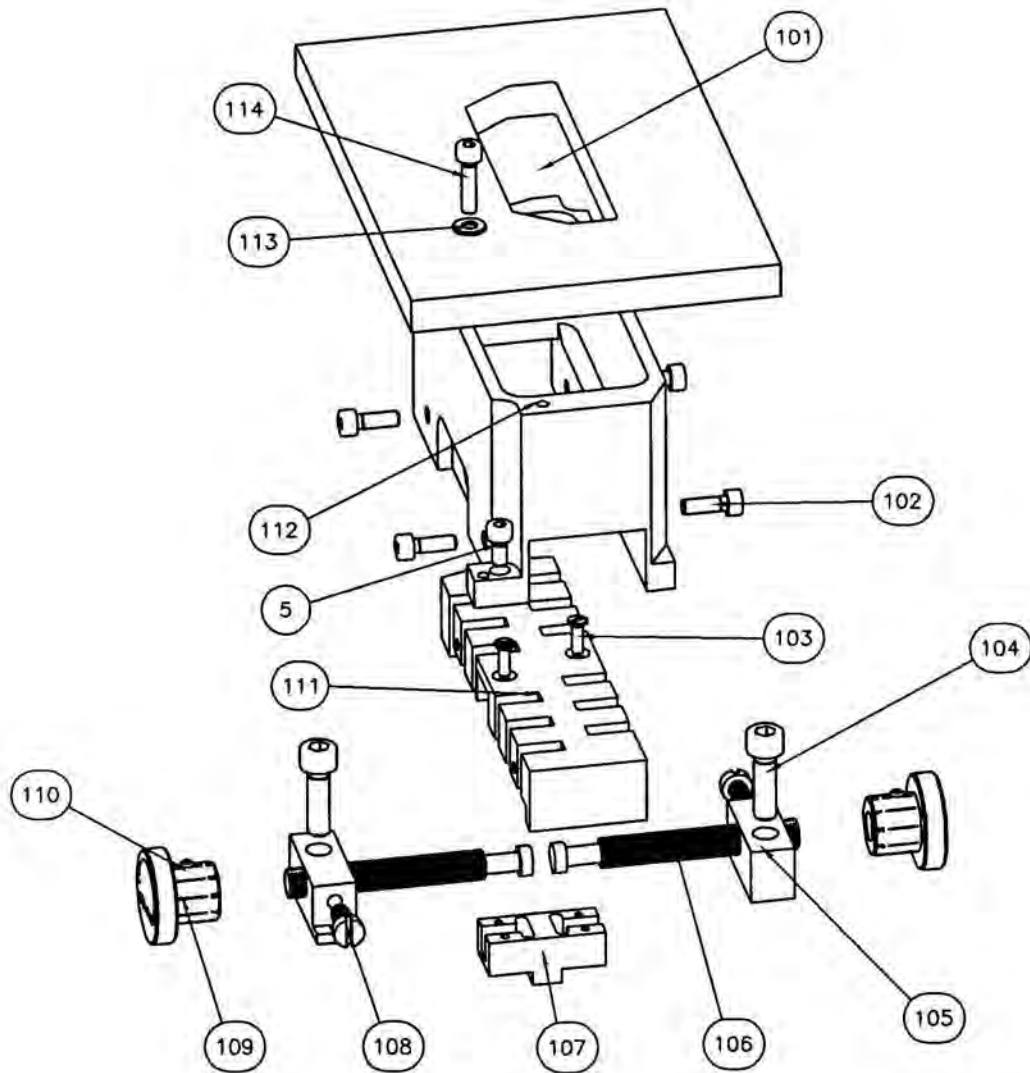
# Section 49.3: dosing chamber assembly, 12 count, station 4, single adjustment



**Section 49.3: dosing chamber assembly,  
12 count, station 4, single adjustment**

Position	IIM p/n	Description
101	27680	Cover, bead feed bowl
102	9463	Cylinder head cap screw
103	27242	Flat head slotted screw
104	3865	Cylinder head cap screw
105	15830	Guide block, right
108	15835	Plastic machine screw
111	16857	Bar, insert
112	16856	Bowl, dosing chamber
113	8088	Washer
114	9453	Cylinder head cap screw
121	15822	Insert, dosing chamber bar
122	15823	Adjusting screw
123	8535	Spring pin
124	15824	Adjustable knob
125	15831	Guide block, left

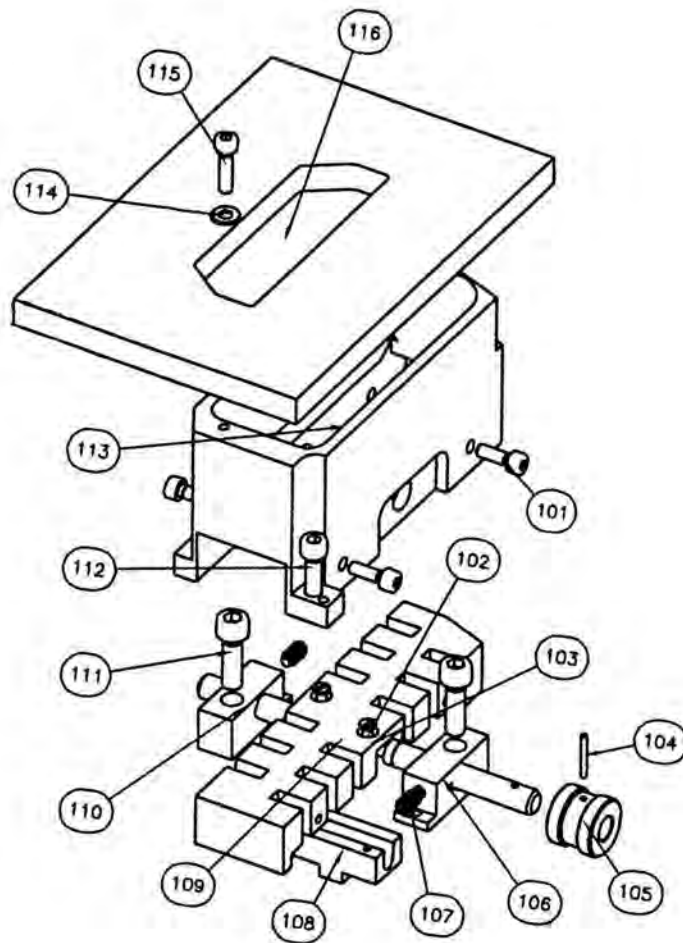
# Section 49.4: dosing chamber assembly, 12 count, station 4, dual adjustment



**Section 49.4: dosing chamber assembly,  
12 count, station 4, dual adjustment**

Position	IIM p/n	Description
101	27680	Cover, bead feed bowl
102	9463	Cylinder head cap screw
103	27242	Flat head slotted screw
104	3865	Cylinder head cap screw
105	15830	Guide block, right
106	23123	Adjusting screw
107	23122	Insert, dosing chamber bar
108	15835	Plastic machine screw
109	17428	Knob, adjustment, upgraded with numbers
110	8058	Socket set screw
111	16857	Bar, insert
112	16856	Bowl, dosing chamber
113	8088	Washer
114	9453	Cylinder head cap screw

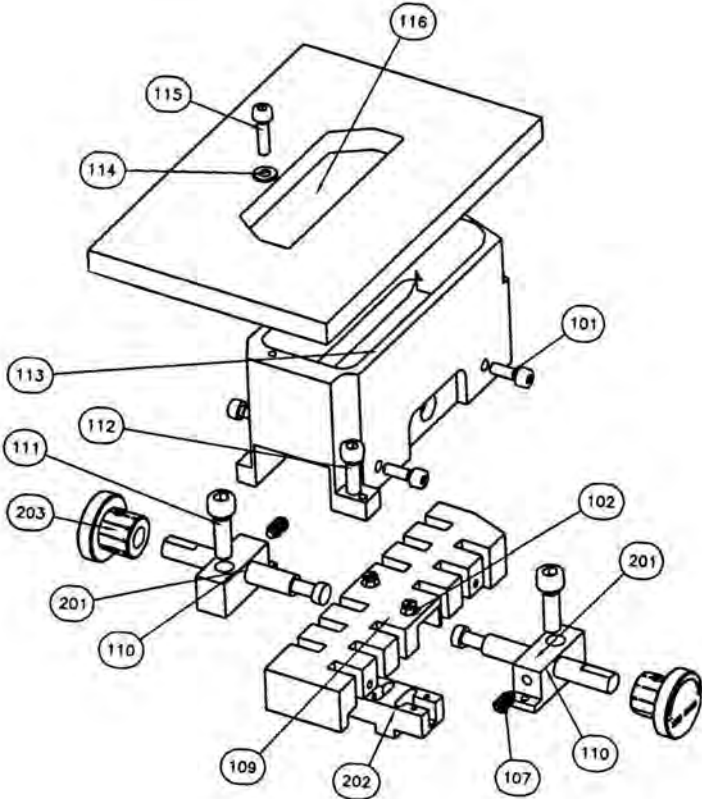
# Section 49.5: dosing chamber assembly, 12 count, station 6, single adjustment



**Section 49.5: dosing chamber assembly,  
12 count, station 6, single adjustment**

Position	IIM p/n	Description
101	9463	Cylinder head cap screw
102	27242	Flat head slotted screw
103	15823	Adjusting screw
104	8535	Spring pin
105	15824	Adjustment knob
106	15831	Guide block, left
107	15835	Set screw
108	15822	Insert, dosing chamber bar
109	15829	Bar, dosing chamber
110	15830	Guide block, right
111	3865	Cylinder head cap screw
112	9461	Cylinder head cap screw
113	15828	Bowl, dosing chamber
114	8088	Washer
115	9453	Cylinder head cap screw
116	27680	Cover, bead feed bowl

# Section 49.6: dosing chamber assembly, 12 count, station 6, dual adjustment

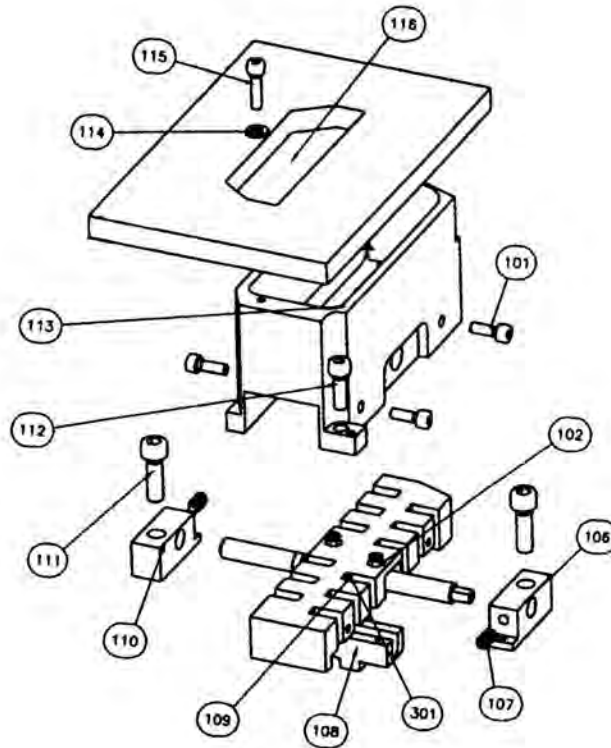


**Section 49.6: dosing chamber assembly,  
12 count, station 6, dual adjustment**

Position	IIM p/n	Description
101	9463	Cylinder head cap screw
102	27242	Flat head slotted screw
107	15835	Set screw
109	15829	Bar, dosing chamber
110	15830	Guide block, right
111	3865	Cylinder head cap screw
112	9461	Cylinder head cap screw
113	15828	Bowl, dosing chamber
114	8088	Washer
115	9453	Cylinder head cap screw
116	27680	Cover, bead feed bowl
201	23123	Adjusting screw
202	23122	Insert, dosing chamber bar
203	17428	Knob, adjustment, upgraded with numbers



# Section 49.7: dosing chamber assembly, 12 count, station 6, adjustment by motor control

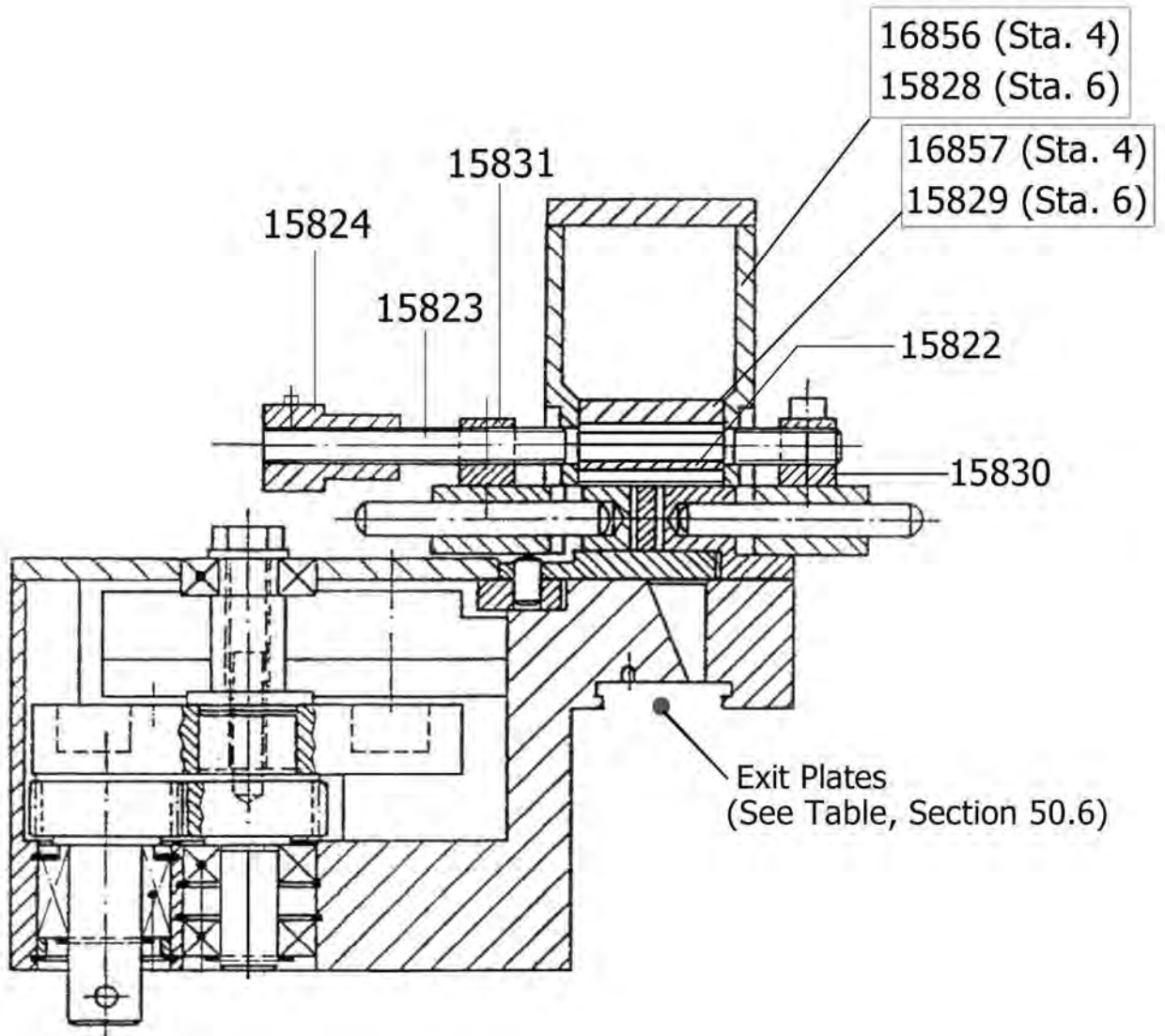


**Section 49.7: dosing chamber assembly,  
12 count, station 6, adjustment by motor control**

Position	IIM p/n	Description
101	9463	Cylinder head cap screw
102	27242	Flat head slotted screw
106	15831	Guide block, left
107	15835	Set screw
108	15822	Insert, dosing chamber bar
109	15829	Bar, dosing chamber
110	15830	Guide block, right
111	3865	Cylinder head cap screw
112	9461	Cylinder head cap screw
113	15828	Bowl, dosing chamber
114	8088	Washer
115	9453	Cylinder head cap screw
116	27680	Cover, bead feed bowl
301	27005	Adjusting screw, square end

# Section 50.1

## Pellet Hopper/Adjustment Mechanism for Station 4 and Station 6; 12 count

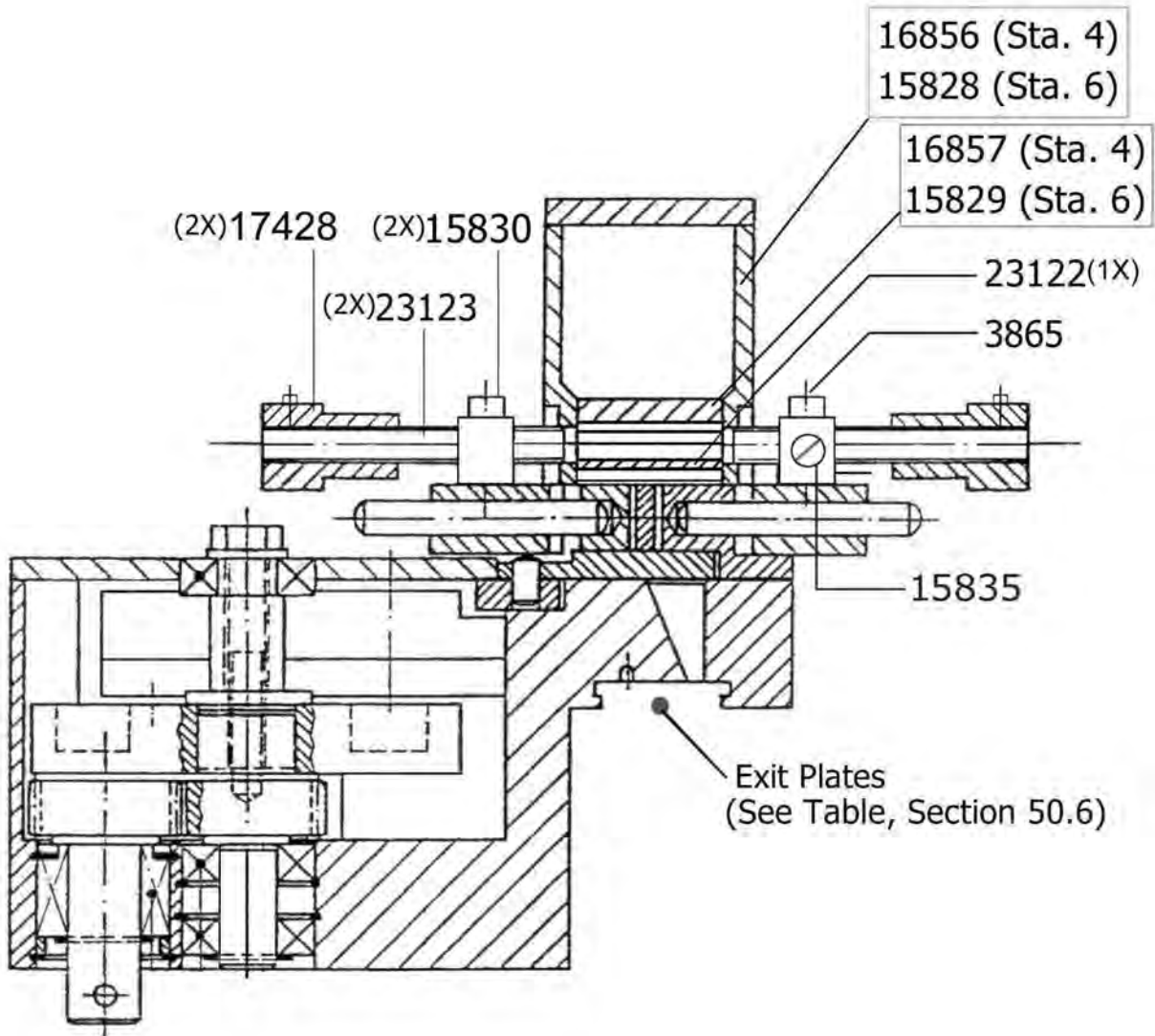


**Section 50.1: pellet hopper adjustment mechanism, station 4 and 6, 12 count**

<b>IIM No.</b>	<b>Description</b>
15822	BLOCK,INSERT,DOSING CHAMBER BAR
15823	SCREW,ADJUSTING
15824	HANDLE,FOR ADJUSTING SCREW
15828	BOWL,DOSING CHAMBER,STATION 6
15829	BAR,INSERT,DOSING CHAMBER,STATION 6
15830	BLOCK,GUIDE,RIGHT
15831	BLOCK,GUIDE,LEFT
16853	DOSING BOWL,COMPLETE,STATION 6
16854	DOSING BOWL,COMPLETE,STATION 4
16856	BOWL,DOSING CHAMBER,STATION 4
16857	BAR,INSERT,DOSING CHAMBER,STATION 4

## Section 50.2

Improved (Split) Pellet Hopper/Adjustment  
Mechanism for Station 4 and Station 6; 12 count

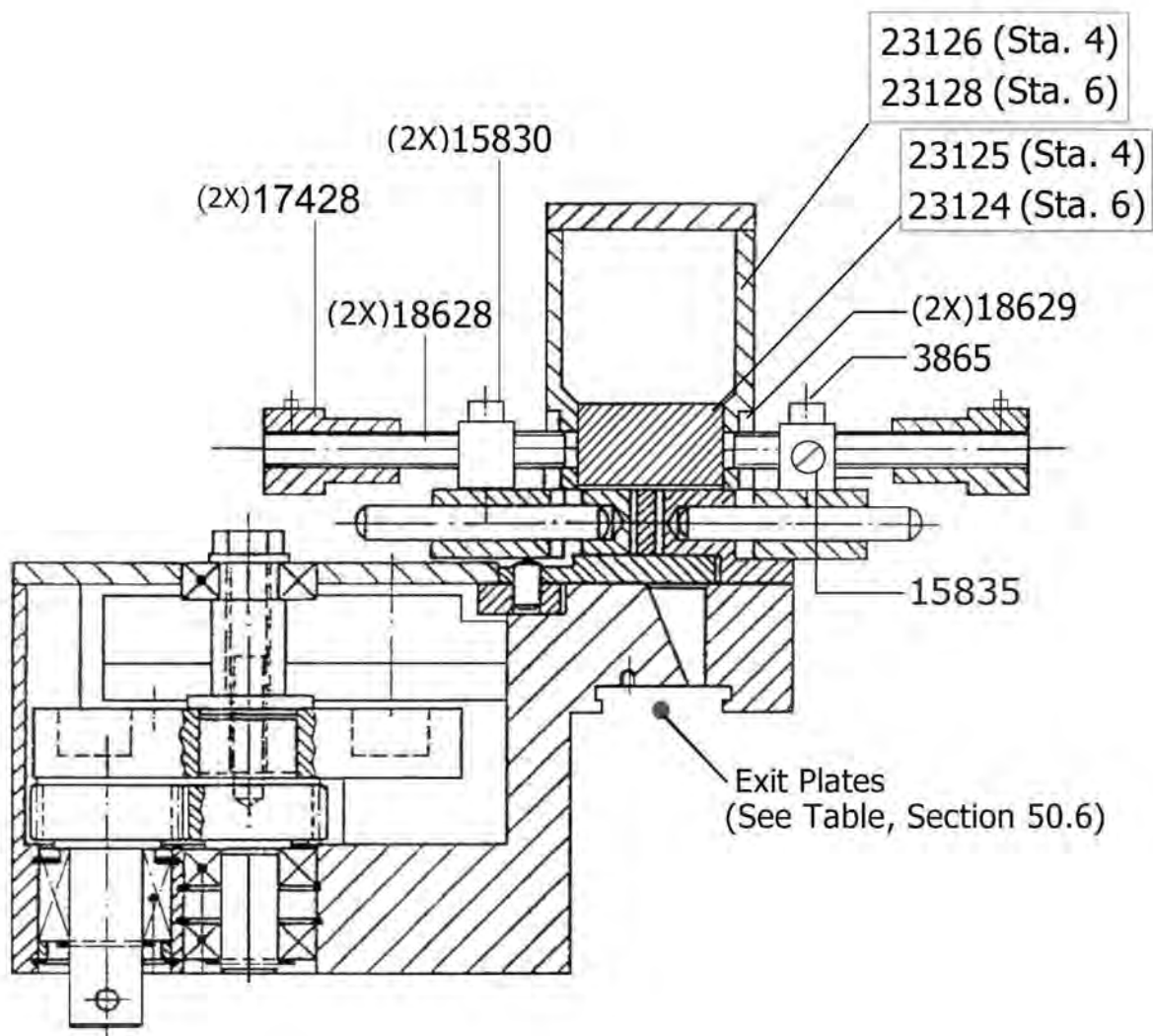


**Section 50.2: improved pellet hopper adjustment mechanism, station 4 and 6, 12 count**

<b>IIM No.</b>	<b>Description</b>
3865	SCREW, SOCKET HEAD
15828	BOWL, DOSING CHAMBER, STATION 6
15829	BAR, INSERT, DOSING CHAMBER, STATION 6
15830	BLOCK, GUIDE, RIGHT
15835	SCREW, LOCKING, PLASTIC
16856	BOWL, DOSING CHAMBER, STATION 4
16857	BAR, INSERT, DOSING CHAMBER, STATION 4
17428	HANDLE, FOR ADJUSTING SCREW
23062	DOSING BOWL, COMPLETE, SPLIT DESIGN, STATION 4
23064	DOSING BOWL, COMPLETE, SPLIT DESIGN, STATION 6
23122	BLOCK, INSERT, DOSING CHAMBER BAR, SPLIT SHAFT
23123	SCREW, ADJUSTING, SPLIT WITH CENTER BLOCK

# Section 50.3

Improved (Split) Pellet Hopper/Adjustment  
Mechanism for Station 4 and Station 6; 16 count

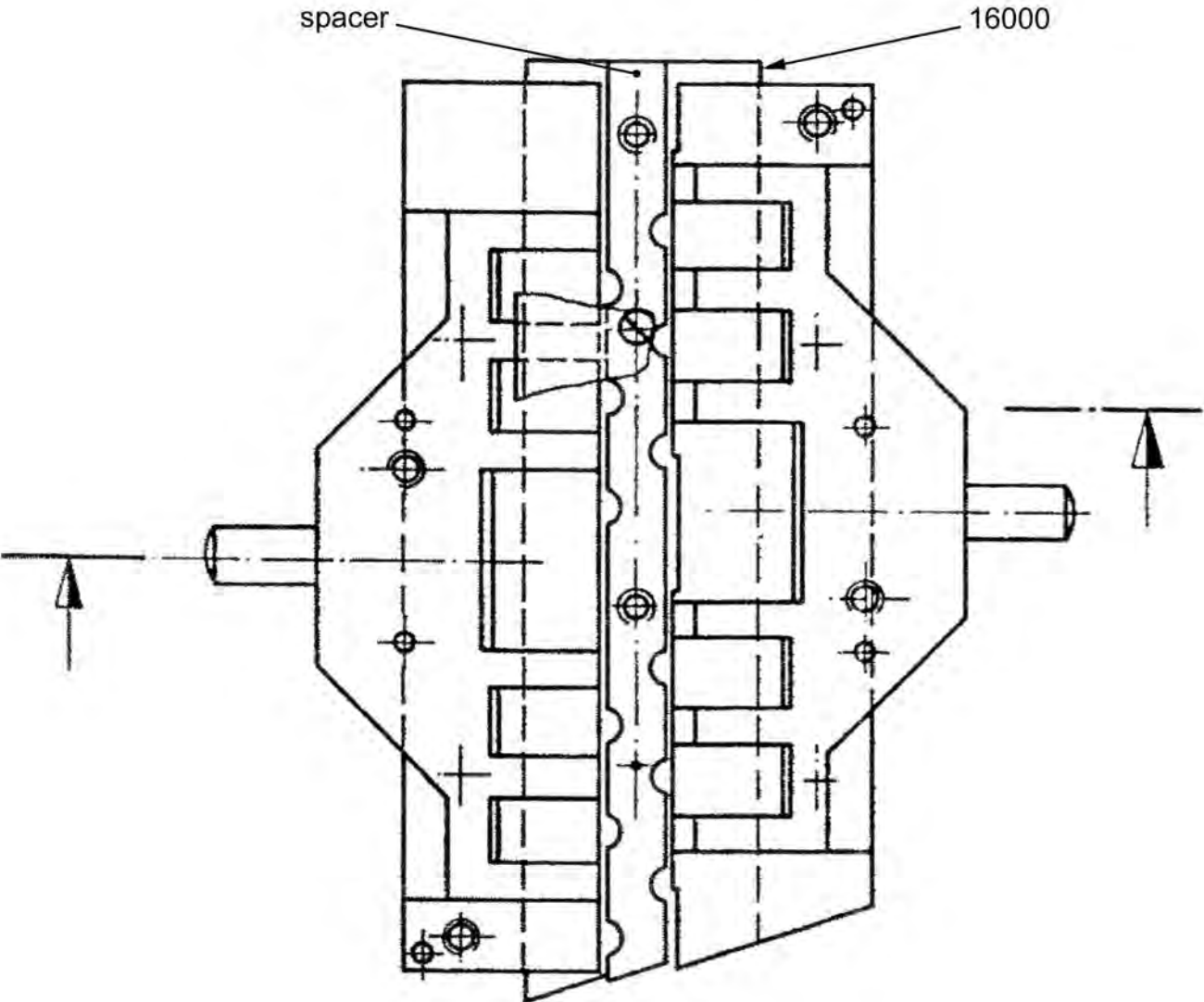
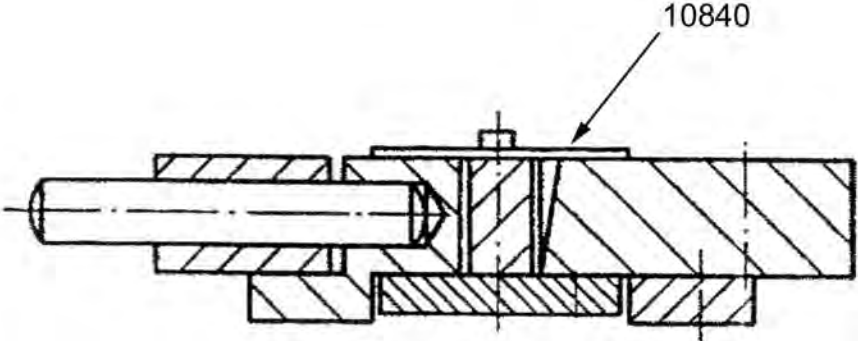


**Section 50.3: improved pellet hopper adjustment mechanism, station 4 and 6, 16 count**

<b>IIM No.</b>	<b>Description</b>
3865	SCREW, SOCKET HEAD
15830	BLOCK, GUIDE, RIGHT
15835	SCREW, LOCKING, PLASTIC
17428	HANDLE, FOR ADJUSTING SCREW
18628	SCREW, ADJUSTING, 16CT
18629	PLATE, CAPTURE, FOR ADJ SCREW, 16CT
23063	DOSING BOWL, COMPLETE, SPLIT DESIGN, STATION 4
23065	DOSING BOWL, COMPLETE, SPLIT DESIGN, STATION 6
23124	BAR, INSERT, DOSING CHAMBER, 16CT, STATION 6
23125	BAR, INSERT, DOSING CHAMBER, 16CT, STATION 4
23126	BOWL, DOSING CHAMBER, 16CT, STATION 4
23128	BOWL, DOSING CHAMBER, 16CT, STATION 6



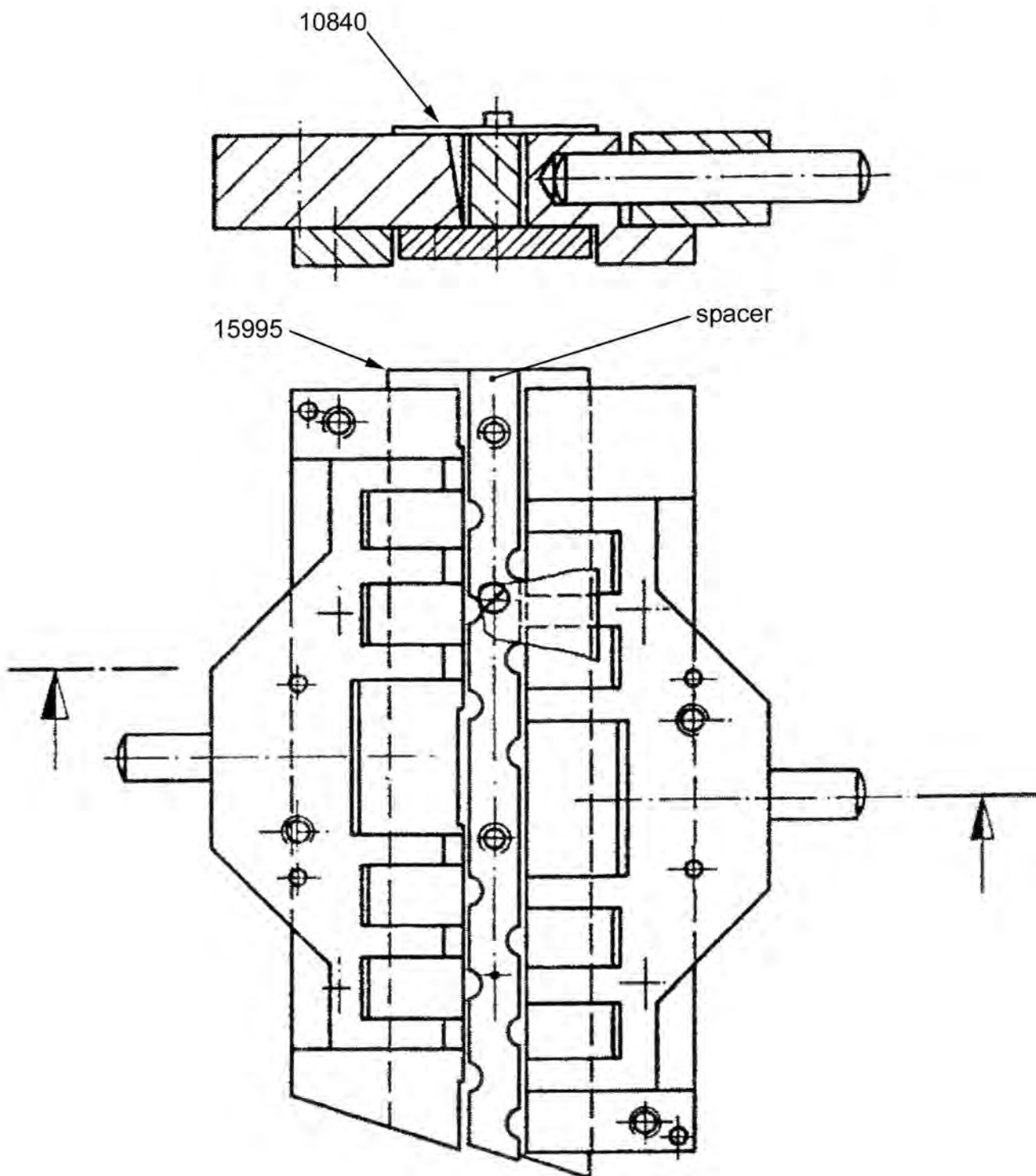
Section 50.4: station 4 dosing chambers



**Section 50.4: station 4 dosing chambers**

<b>IIM No.</b>	<b>Description</b>
10840	GATE,BEAD FEED
16027	DOSING CHAMBER,12CT,5MM
16019	DOSING CHAMBER,12CT,6MM
14924	DOSING CHAMBER,12CT,7MM
16820	DOSING CHAMBER,12CT,8MM
15999	DOSING CHAMBER,12CT,10MM
16022	DOSING CHAMBER,12CT,12MM
26247	DOSING CHAMBER,12CT,13MM
16840	DOSING CHAMBER,12CT,15MM
27362	DOSING CHAMBER,12CT,19MM
16003	DOSING CHAMBER,12CT,21MM
23084	DOSING CHAMBER,16CT,5MM
23085	DOSING CHAMBER,16CT,6MM
23086	DOSING CHAMBER,16CT,7MM
23087	DOSING CHAMBER,16CT,8MM
23088	DOSING CHAMBER,16CT,10MM
23089	DOSING CHAMBER,16CT,12MM
23090	DOSING CHAMBER,16CT,15MM
23091	DOSING CHAMBER,16CT,21MM
16000	DOSING SLIDER,STATION 4
29236	SPACER, STATION 4, 5MM
-	SPACER, STATION 4, 6MM
-	SPACER, STATION 4, 7MM
-	SPACER, STATION 4, 8MM
-	SPACER, STATION 4, 10MM
-	SPACER, STATION 4, 13MM
-	SPACER, STATION 4, 15MM
-	SPACER, STATION 4, 18MM
-	SPACER, STATION 4, 20MM
-	SPACER, STATION 4, 21MM
28431	SLIDER/SPACER ASSEMBLY,STATION 4,8MM
28430	SLIDER/SPACER ASSEMBLY,STATION 4,10MM
28429	SLIDER/SPACER ASSEMBLY,STATION 4,15MM
27803	SLIDER/SPACER ASSEMBLY,STATION 4,19MM
28428	SLIDER/SPACER ASSEMBLY,STATION 4,21MM

# Section 50.5: station 6 dosing chambers



**Section 50.5: station 6 dosing chambers**

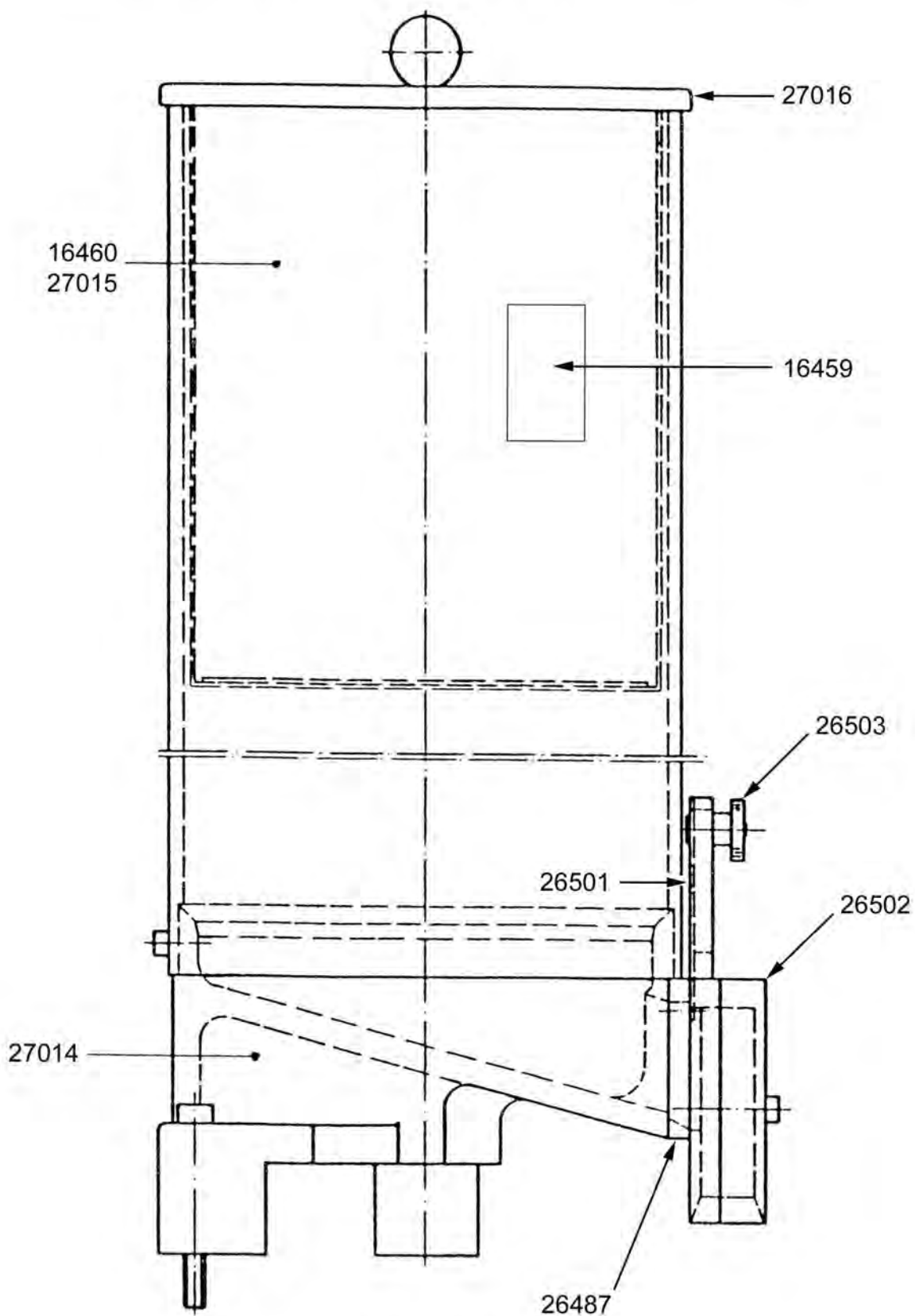
<b>IIM No.</b>	<b>Description</b>
10840	GATE,BEAD FEED
16030	DOSING CHAMBER,12CT,5MM
14923	DOSING CHAMBER,12CT,6MM
16014	DOSING CHAMBER,12CT,7MM
16821	DOSING CHAMBER,12CT,8MM
14922	DOSING CHAMBER,12CT,10MM
16011	DOSING CHAMBER,12CT,12MM
15991	DOSING CHAMBER,12CT,13MM
16841	DOSING CHAMBER,12CT,15MM
27714	DOSING CHAMBER,12CT,18MM
27363	DOSING CHAMBER,12CT,19MM
27785	DOSING CHAMBER,12CT,20MM
16006	DOSING CHAMBER,12CT,21MM
14925	DOSING CHAMBER,16CT,5MM
23092	DOSING CHAMBER,16CT,6MM
23093	DOSING CHAMBER,16CT,7MM
14926	DOSING CHAMBER,16CT,8MM
23094	DOSING CHAMBER,16CT,10MM
23095	DOSING CHAMBER,16CT,12MM
23096	DOSING CHAMBER,16CT,15MM
28191	DOSING CHAMBER,16CT,18MM
23097	DOSING CHAMBER,16CT,21MM
15995	DOSING SLIDER,STATION 6
16032	SPACER, STATION 6, 5MM
-	SPACER, STATION 6, 6MM
-	SPACER, STATION 6, 7MM
-	SPACER, STATION 6, 8MM
-	SPACER, STATION 6, 10MM
-	SPACER, STATION 6, 13MM
-	SPACER, STATION 6, 15MM
-	SPACER, STATION 6, 18MM
-	SPACER, STATION 6, 20MM
-	SPACER, STATION 6, 21MM
26518	SLIDER/SPACER ASSEMBLY,STATION 6,5MM
27853	SLIDER/SPACER ASSEMBLY,STATION 6,7MM
26519	SLIDER/SPACER ASSEMBLY,STATION 6,8MM
26520	SLIDER/SPACER ASSEMBLY,STATION 6,10MM
26628	SLIDER/SPACER ASSEMBLY,STATION 6,13MM
26521	SLIDER/SPACER ASSEMBLY,STATION 6,15MM
27747	SLIDER/SPACER ASSEMBLY,STATION 6,18MM
27802	SLIDER/SPACER ASSEMBLY,STATION 6,20MM
28432	SLIDER/SPACER ASSEMBLY,STATION 6,21MM

**Section 50.6: exit plates, 12 and 16 count**

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<b>IIM No.</b>	<b>Description</b>
14934	EXIT PLATE, 12 CT, SIZE 0
23213	EXIT PLATE, 12 CT, SIZE 0,00
14917	EXIT PLATE, 12 CT, SIZE 0,1,2
26867	EXIT PLATE, 12 CT, SIZE 00
14933	EXIT PLATE, 12 CT, SIZE 1
14932	EXIT PLATE, 12 CT, SIZE 2
14918	EXIT PLATE, 12 CT, SIZE 3
23112	EXIT PLATE, 12 CT, SIZE 3,4,5
14919	EXIT PLATE, 12 CT, SIZE 4
23113	EXIT PLATE, 16 CT, SIZE 0
23114	EXIT PLATE, 16 CT, SIZE 1
23115	EXIT PLATE, 16 CT, SIZE 2
14920	EXIT PLATE, 16 CT, SIZE 3
14921	EXIT PLATE, 16 CT, SIZE 4

# Section 50.7: bead hopper & base



**Section 50.7: bead hopper & base**

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<b>IIM No.</b>	<b>Description</b>
16459	SIGHT GLASS
16460	HOPPER
26487	BACK PLATE
26501	GATE
26502	FRONT PLATE
26503	KNOB, M5
27014	BASE
27016	HOPPER LID

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