



# **GKF 2000/2500**

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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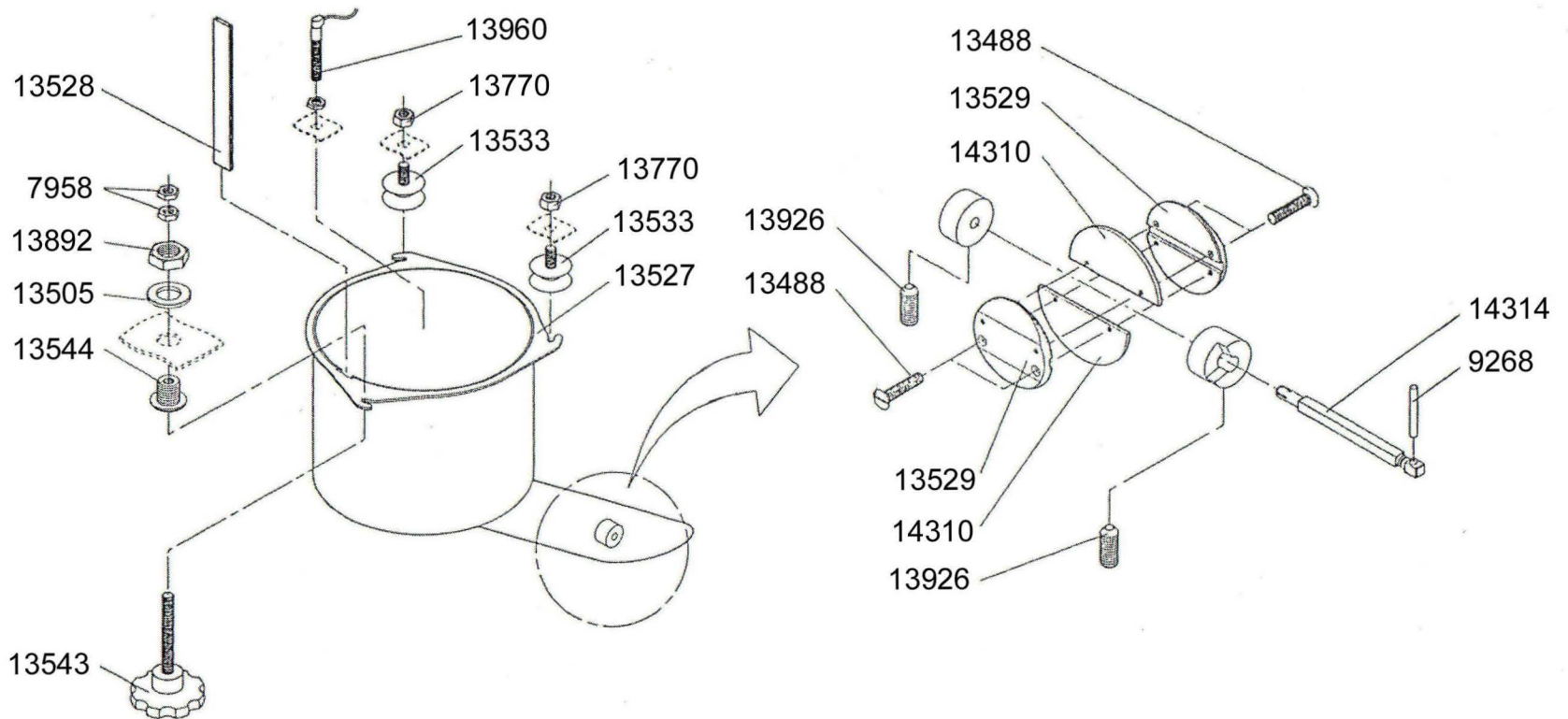
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IIM

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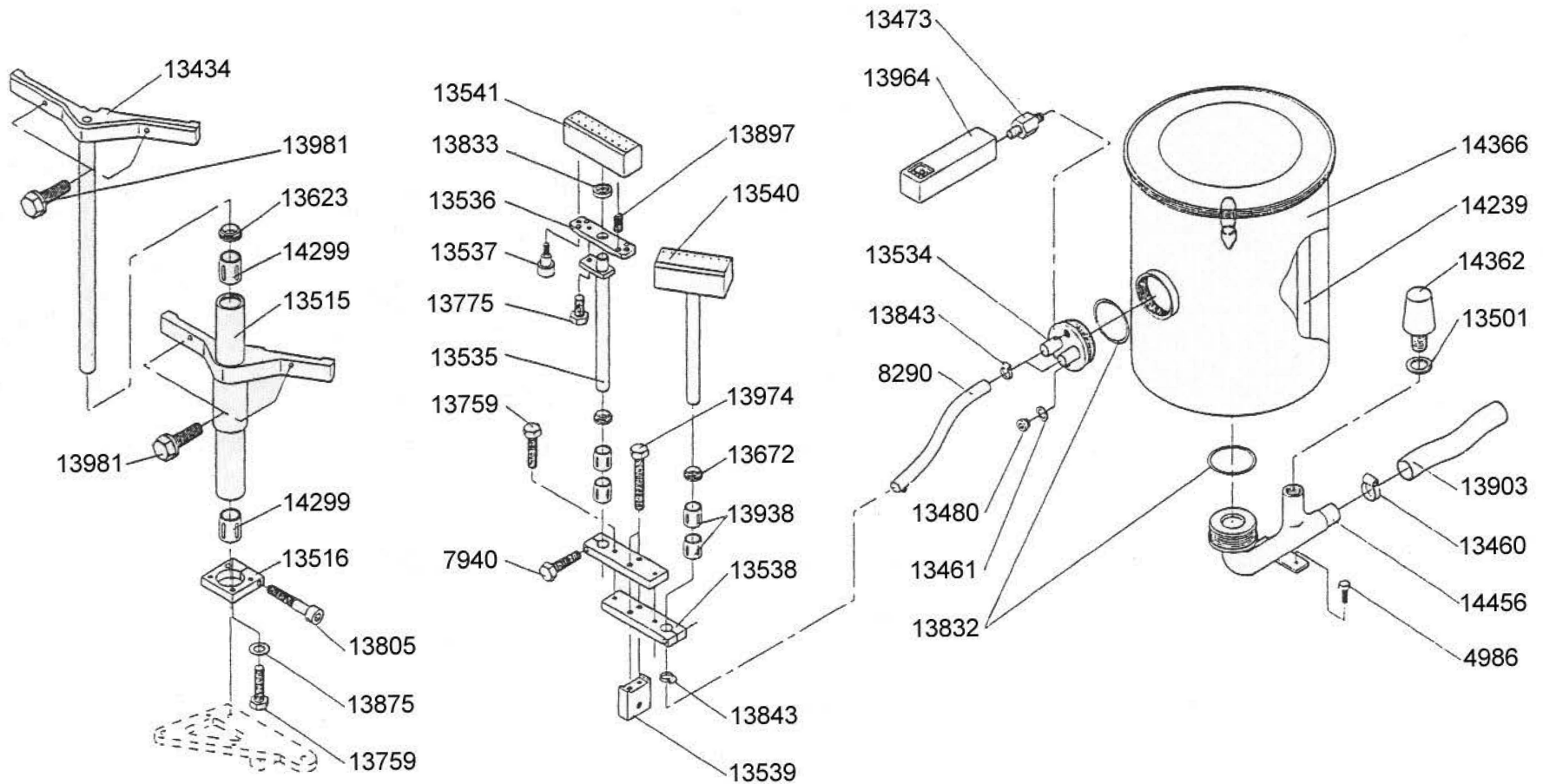
# Section 1: capsule hopper



## Section 1: capsule hopper

IIM no.	Description
7958	NUT
9268	DOWEL PIN
13488	SCREW
13505	WASHER
13527	CAPSULE HOPPER
13528	SIGHT GLASS
13529	GATE, CAPSULE HOPPER
13533	MOUNTING DEVICE
13543	HAND KNOB
13544	THREADED INSERT
13770	HEX NUT
13892	NUT
13926	BALL PLUNGER
13960	PROX SWITCH
14310	SILICONE TONGUE, CAPSULE SHUTOFF
14314	SHAFT, CAPSULE SHUTOFF

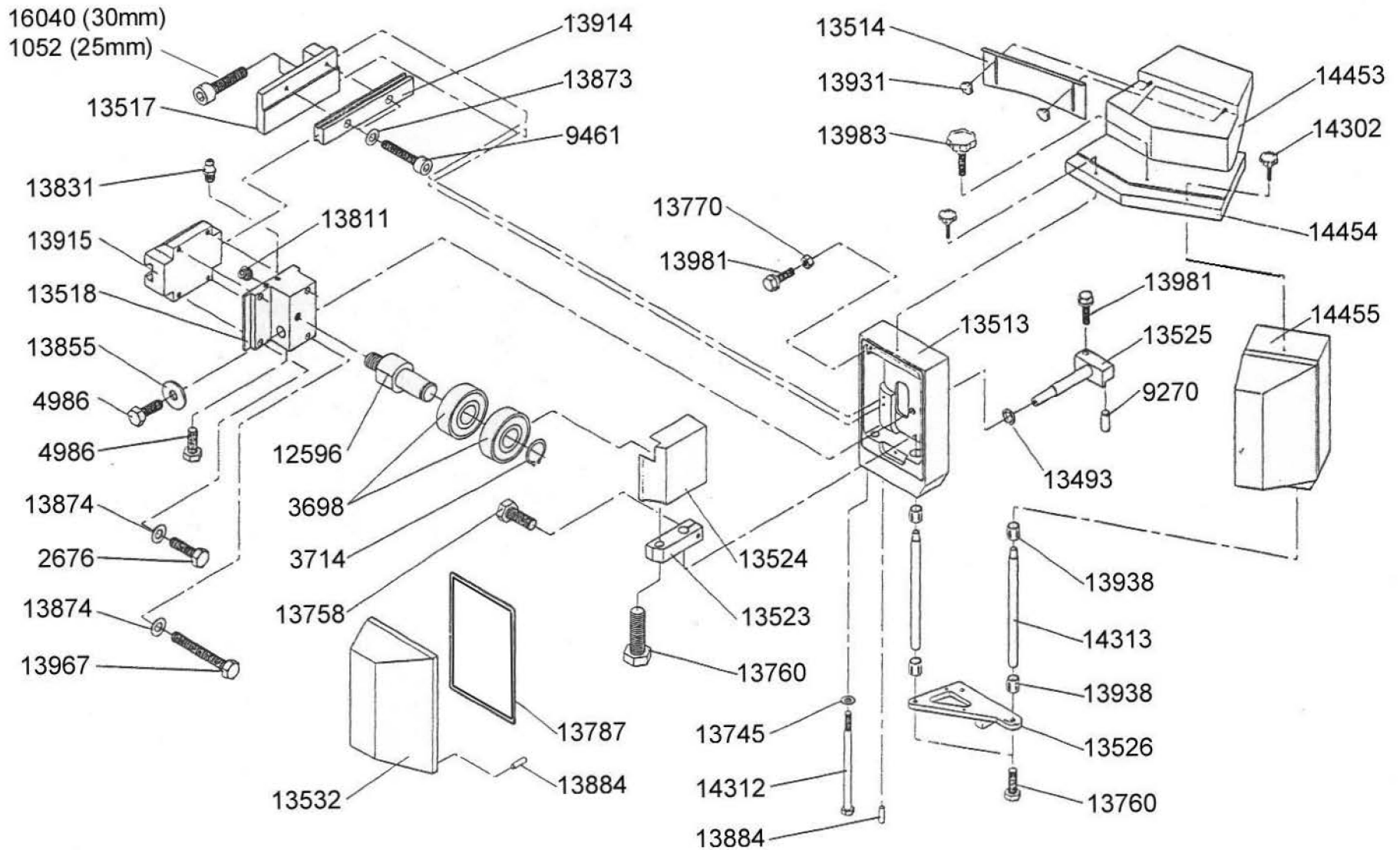
# Section 2: capsule separating



## Section 2: capsule separating

IIM no.	Description
4986	SCREW, VACUUM TUBE
7940	SCREW
8290	HOSE, VACUUM
13434	BRACKET, LIFTING
13460	HOSE CLAMP
13461	WASHER
13473	STUD, CONNECTING
13480	PLUG
13501	GASKET, COPPER
13515	HOLDER, SORTING BLOCK
13516	BRACKET
13534	MANIFOLD, VACUUM
13535	SHAFT, DRIVE, SEPARATION
13536	PLATE
13537	SCREW, SHOULDER
13538	PLATE, DRIVE
13539	PLATE, CONNECTING
13540	SUCTION SHOE LEFT
13541	SUCTION SHOE RIGHT
13623	SEAL
13672	SEAL
13759	SCREW, HEX
13775	SCREW, HEX
13805	SCREW, SOCKET HEAD CAP
13832	WASHER
13833	SEAL
13843	HOSE CLAMP
13875	WASHER, M8, SERRATED
13897	SPRING, COMPRESSION
13903	TUBING, WIRE REINFORCED
13938	BEARING, LINEAR
13964	PRESSURE SWITCH
13974	SCREW
13981	SCREW M8 X 26
14239	FILTER
14299	BEARING, LINEAR
14362	VALVE, VACUUM
14366	HOUSING, FILTER
14456	PIPE, VACUUM

# Section 3: capsule orienting

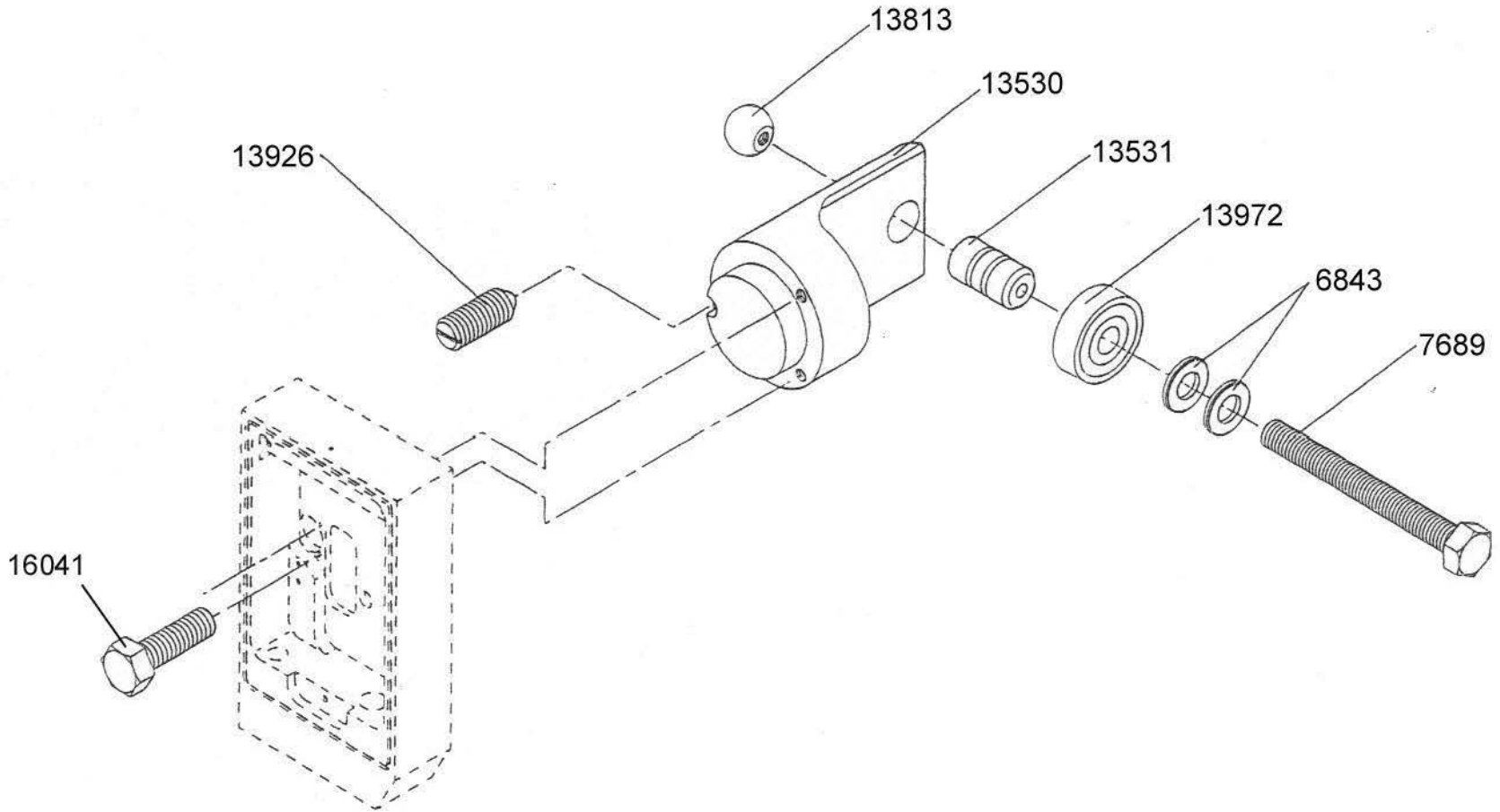




### Section 3: capsule orienting

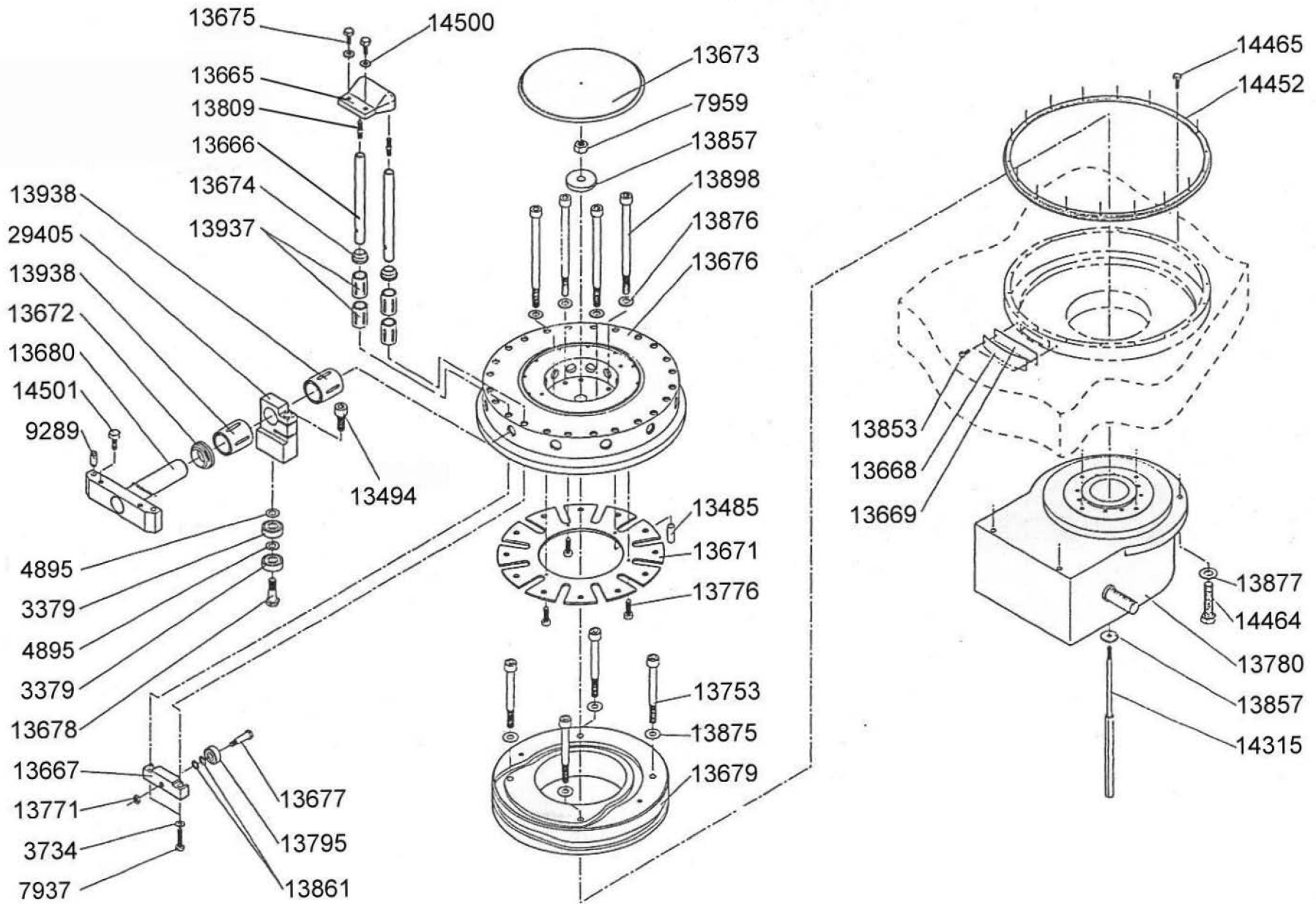
IIM no.	Description
1052	SCREW, SOCKET HEAD CAP
2676	SCREW, HEX
3698	BEARING
3714	RETAINING RING, EXTERNAL
4986	SCREW, VACUUM TUBE
9270	DOWEL PIN
9461	SCREW, SOCKET HEAD CAP
12596	SCREW, SHOULDER
13493	SEAL
13513	HOUSING, SORTING STATION
13514	GATE, CAPSULE FLOW
13517	BLOCK, ORIENTATION FINGERS
13518	BLOCK, SORTING DRIVE
13523	BLOCK, CLAMPING
13524	COVER
13525	SHAFT, DRIVE, ORIENTATION FINGERS
13532	COVER, SORTING STATION
13745	WASHER, M8, SERRATED
13758	SCREW
13760	SCREW, HEX
13770	NUT, HEX
13787	SEAL, BLUE
13811	SCREW, SET
13831	FITTING, GREASE
13855	WASHER
13873	WASHER, M5, SERRATED
13874	WASHER, M6, SERRATED
13884	PIN, DOWEL
13914	GUIDEWAY, BEARING SLIDE
13915	BEARING, LINEAR, CARRIAGE
13931	KNOB, THUMB
13938	BEARING, LINEAR
13967	SCREW, HEX
13981	SCREW, M8 X 26
13983	SCREW, THUMB
14302	SCREW, THUMB
14312	SCREW, HEX
14313	SHAFT, DRIVE, ORIENTATION
14453	HOPPER, CAPSULE, OVER MAGAZINES
14454	GUIDE
14455	HOUSING
16040	SCREW, SOCKET HEAD CAP

# Section 4: capsule clearing at magazine





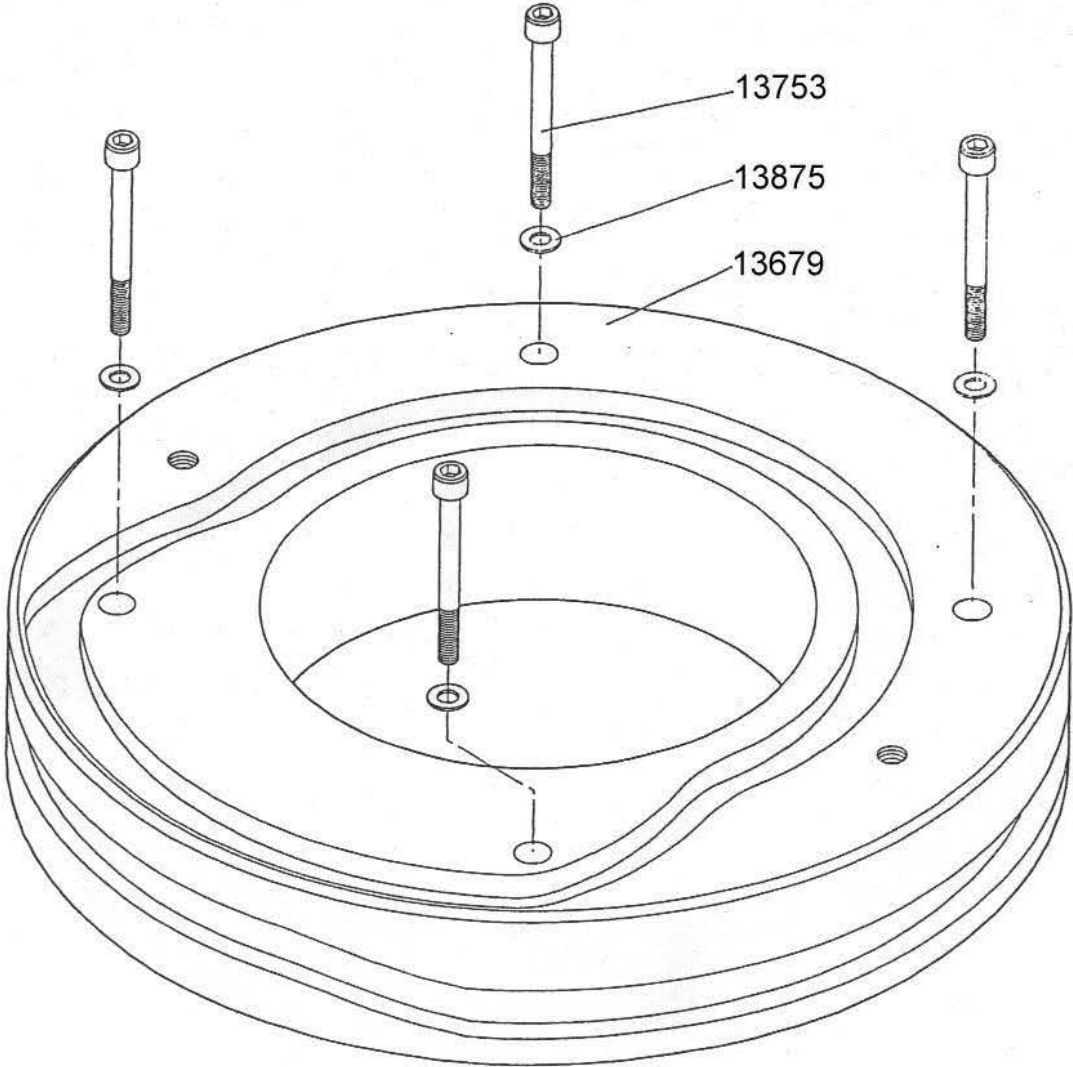
# Section 5: segment rotation



## Section 5: segment rotation

IIM no.	Description
3379	BEARING
3734	WASHER
4895	SHIM
7937	SCREW, HEX
7959	NUT, HEX
9289	DOWEL PIN
13485	DOWEL PIN
13494	SCREW, SOCKET HEAD CAP
13665	BLOCK, UPPER SEGMENT MOUNT
13666	SHAFT, LINEAR, UPPER SEGMENT MOVEMENT
13667	BLOCK,UPPER SEGMENT CAM FOLLOWER MOUNT
13668	COVER PLATE
13669	GASKET
13671	PLATE,GENEVA,SEGMENT TURRET
13672	SEAL,RED
13673	COVER
13674	SEAL
13675	SCREW,HEX,CAPT DESIGN,FOR UPPER SEGMENT BLOCKS
13676	DOUGHNUT,SEGMENT TURRET,LINEAR BEARING HOUSING
13677	SCREW,SHOULDER,HEX,UPPER SEGMENT CAM FOLLOWER STUD
13678	SCREW,SHOULDER,HEX,LOWER SEGMENT CAM FOLLOWER STUD
13679	CAM,SEGMENT TRAVERSING,W/O FILLING AT STATION 4
13680	SHAFT,LINEAR,LOWER SEGMENT MOVEMENT,IMPROVED
13753	SCREW,SOCKET HEAD CAP,SEGMENT TRANVERSING CAM
13771	NUT,JAM,HEX
13776	SCREW,SOCKET HEAD CAP
13780	GEARBOX,SEGMENT GENEVA
13795	BEARING
13809	STUD,UPPER SEGMENT LINEAR SHAFT
13853	SCREW, HEX
13857	WASHER
13861	WASHER
13875	WASHER,M8,SERRATED,STAINLESS
13876	WASHER,M10,SERRATED
13877	WASHER,M12,SERRATED
13898	SCREW, SOCKET HEAD CAP
13937	BEARING
13938	BEARING,LINEAR
14315	ROD,THREADED
14452	RING
14464	BOLT
14465	BOLT
14500	WASHER,W/ FEMALE THREAD,FOR CAPT SCREW,UPPER SEGMENT
14501	SCREW,HEX,W/CAPT WASHER,LOWER SEGMENT
29405	CLAMP, LOWER SEGMENT MOUNT

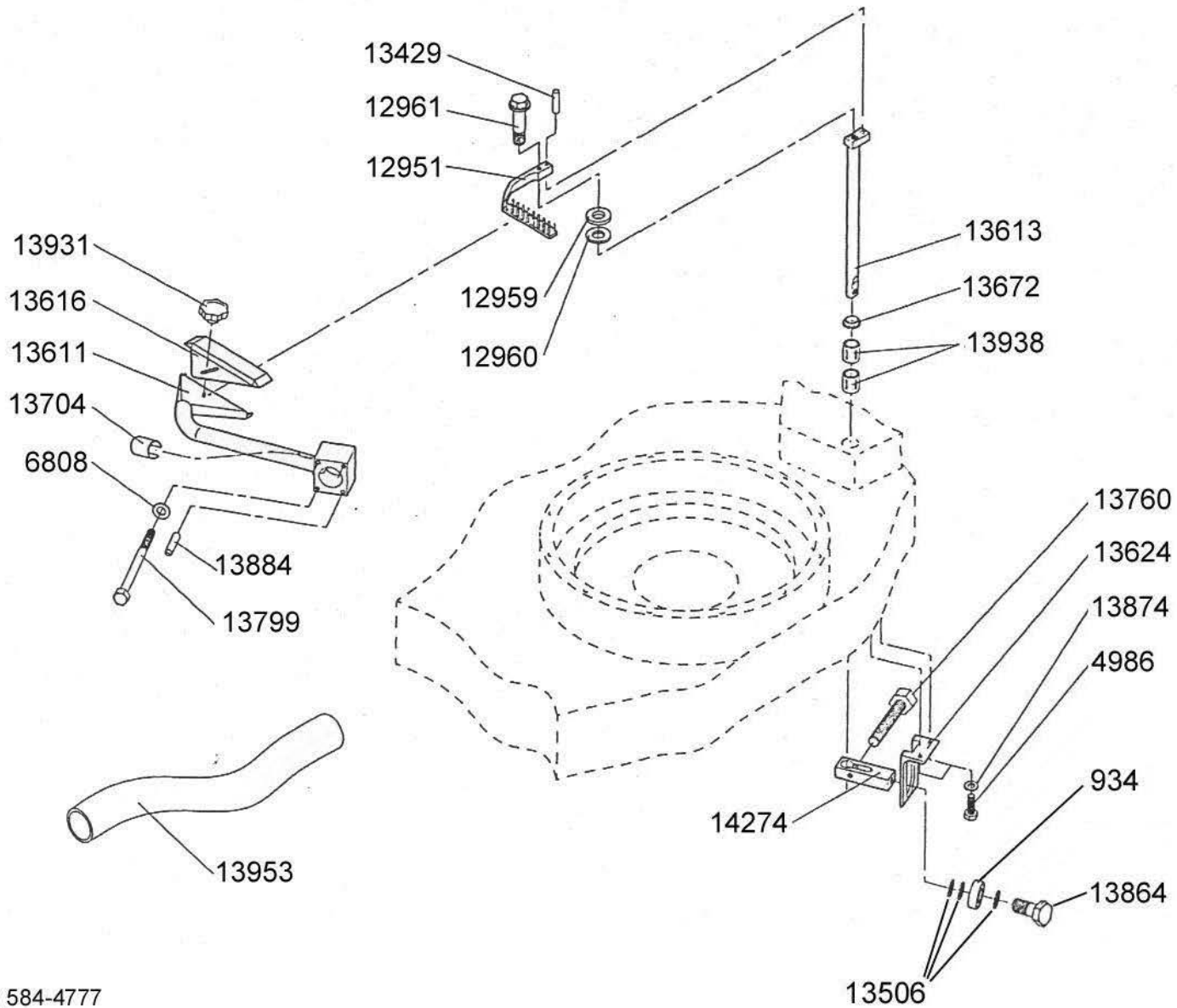
# Section 6: top cam



Section 6: top cam

IIM no.	Description
13679	TOP CAM
13753	SCREW, SOCKET HEAD CAP
13875	WASHER

# Section 7: faulty capsule ejection

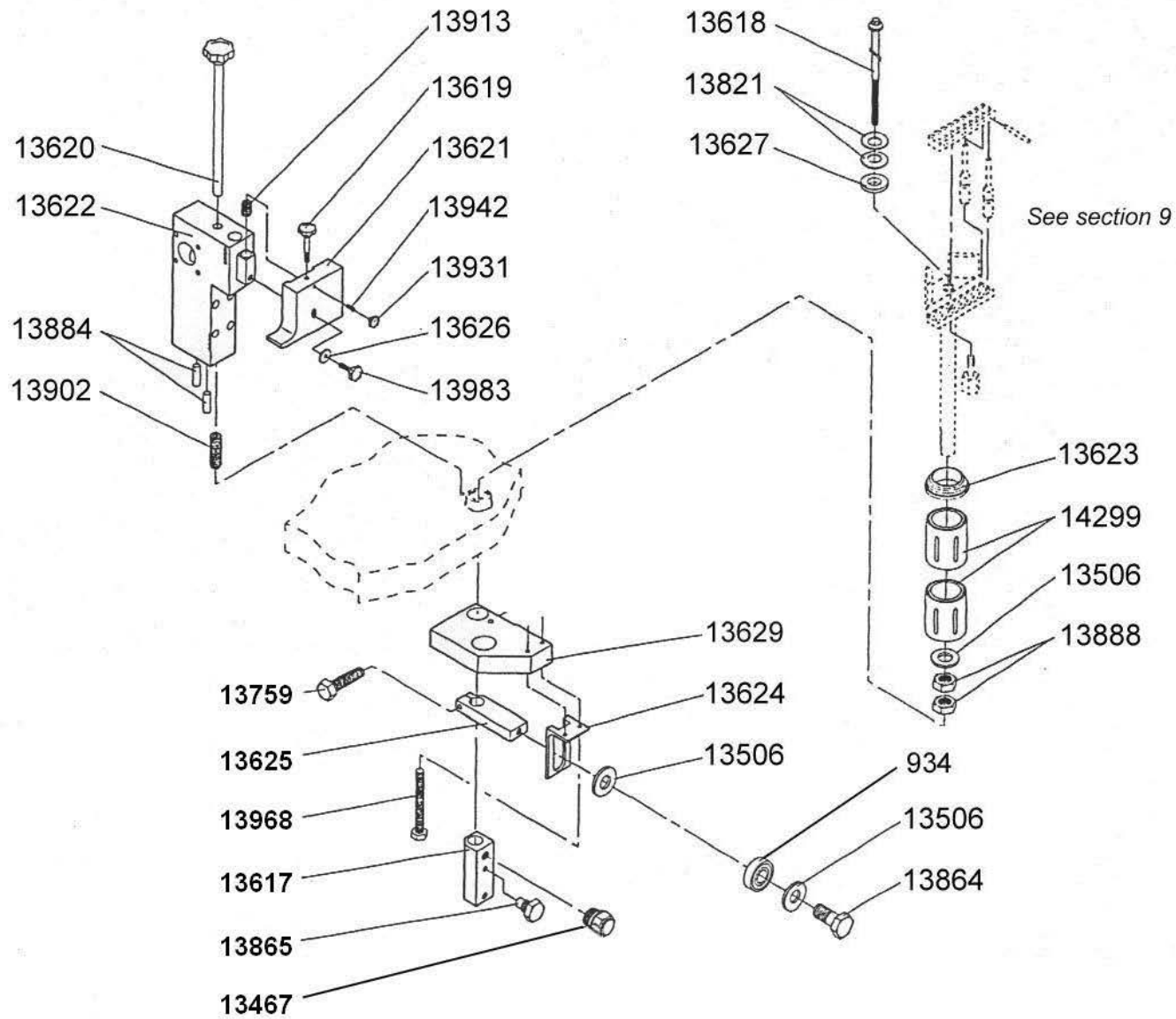




## Section 7: faulty capsule ejection

IIM no.	Description
934	BEARING,BALL
4986	SCREW,VACUUM TUBE
6808	WASHER
12951	ARM,FAULTY CAPSULE,18 CT
12959	RING,FORMAT,FAULTY CAP EJECTION ARM,3MM,SIZES 2/1/00/000
12960	RING,FORMAT,FAULTY CAP EJECTION ARM,2MM,SIZES 3/0/00/000
12961	BOLT,SHOULDER,HEX,FAULTY CAP EJECTION ARM
13429	DOWEL PIN
13506	WASHER
13611	MANIFOLD, VACUUM, FAULTY CAPS
13613	SHAFT, MOUNT, FAULTY CAPS
13616	COVER, VACUUM
13624	BRACKET,GUIDE,FAULTY CAPSULE CAM FOLLOWER
13672	SEAL,RED
13704	COLLAR,SLIDE,VACUUM ADJUSTMENT
13760	SCREW,HEX
13799	SCREW,HEX,FAULTY CAPSULE
13864	SCREW,SHOULDER,HEX,FAULTY CAPSULE CAM FOLLWER
13874	WASHER,M6,SERRATED
13884	DOWEL PIN
13931	KNOB, THUMB
13938	BEARING, LINEAR
13953	HOSE, VACUUM
14274	BRACKET,CLAMPING,FAULTY CAPSULE EJECTION DRIVE

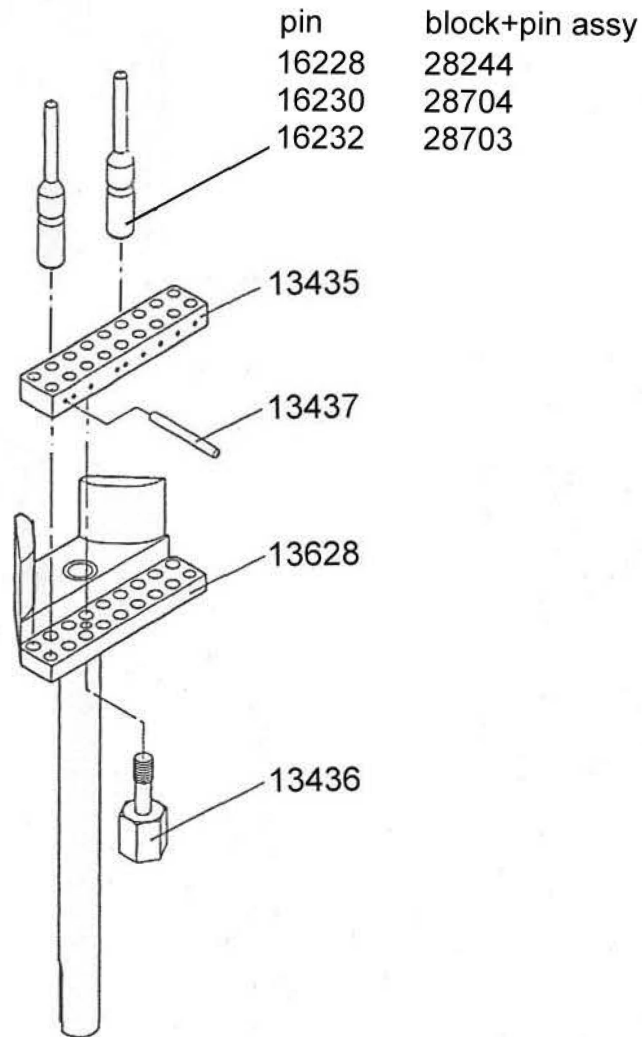
# Section 8: closing station



## Section 8: closing station

IIM no.	Description
934	BEARING, BALL
13467	PLUG
13506	WASHER
13617	BLOCK,CAM FOLLOWER,ADJUSTABLE STOP,LOWER CLOSING
13618	SCREW,HEX,WITH INTEGRAL WASHER,LOWER CLOSING
13619	KNOB,HAND
13620	KNOB,HAND,STUD,CLOSING STATION
13621	BLOCK,UPPER CLOSING,CAPSULE STOP
13622	BLOCK,UPPER CLOSING
13623	SEAL,RED
13624	BRACKET,GUIDE,FAULTY CAPSULE CAM FOLLOWER
13625	BLOCK,LOWER CLOSING,CAM FOLLOWER MOUNT
13626	WASHER
13627	RING,FORMAT,CLOSING
13629	BLOCK,LOWER CLOSING GUIDE
13759	SCREW,HEX
13821	SPRING,WASHER,BELLVILLE,CLOSING ADJUSTMENT
13864	SCREW,SHOULDER,HEX,FAULTY CAPSULE CAM FOLLWER
13865	SCREW,HEX
13884	DOWEL PIN
13888	NUT, HEX, JAM
13902	STUD
13913	SPRING,COMPRESSION
13931	KNOB, THUMB
13942	SCREW,STUD
13968	SCREW,HEX
13983	SCREW,THUMB
14299	BEARING,LINEAR

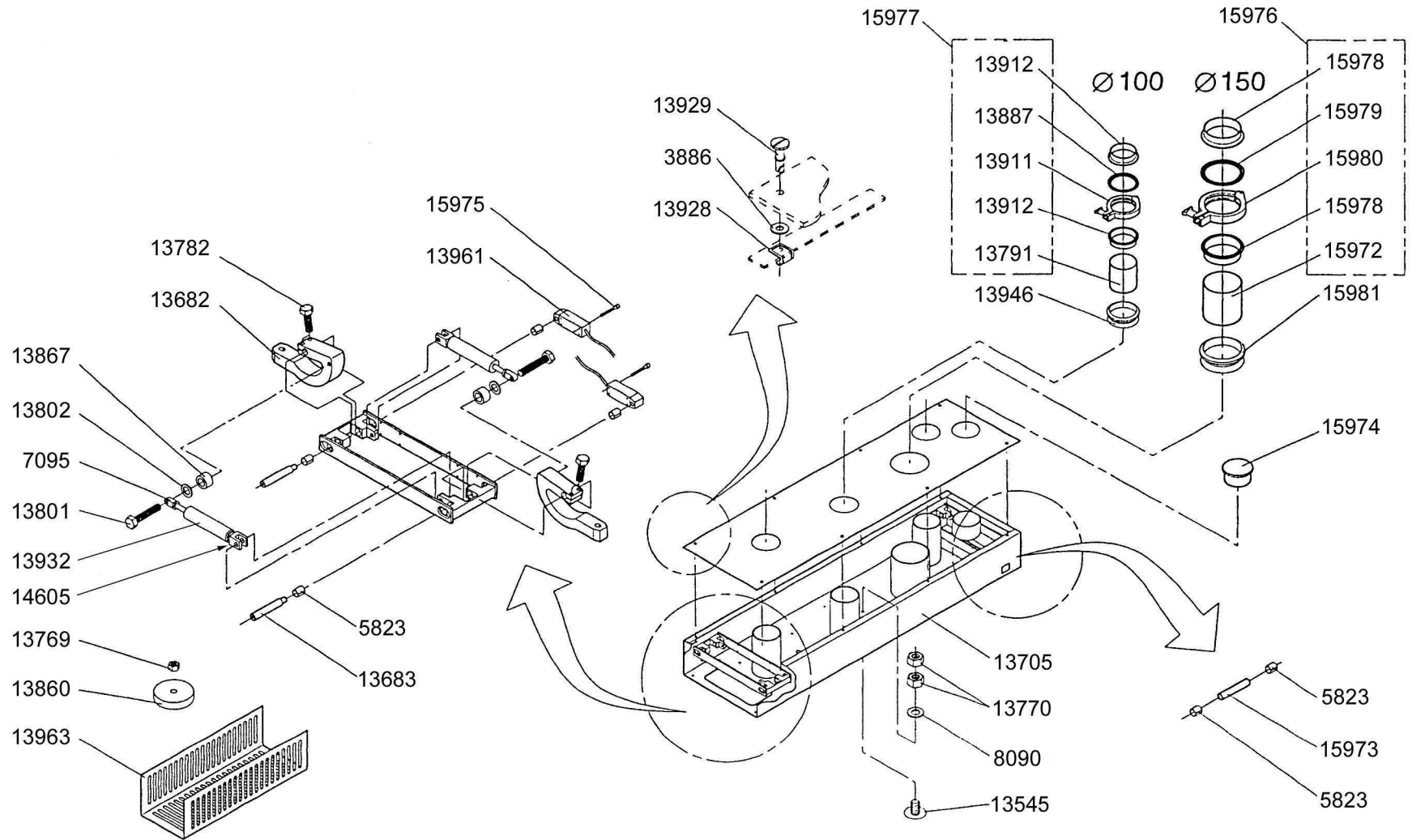
# Section 9: closing station



## Section 9: closing station

IIM no.	Description
13435	CLOSING PIN BLOCK
13436	BOLT
13437	CROSS PIN
13628	CLOSING BLOCK SUPPORT
16228	PIN, CLOSING, SZ 0&00
16230	PIN, CLOSING, SZ 1&2
16232	PIN, CLOSING, SZ 3&4
28121	PIN, CLOSING, SZ 0&00, ALUMINUM
28122	PIN, CLOSING, SZ 1&2, ALUMINUM
28123	PIN, CLOSING, SZ 3&4, ALUMINUM
28244	CLOSING PIN ASSY SZ 0&00
28704	CLOSING PIN ASSY SZ 1&2
28703	CLOSING PIN ASSY SZ 3&4

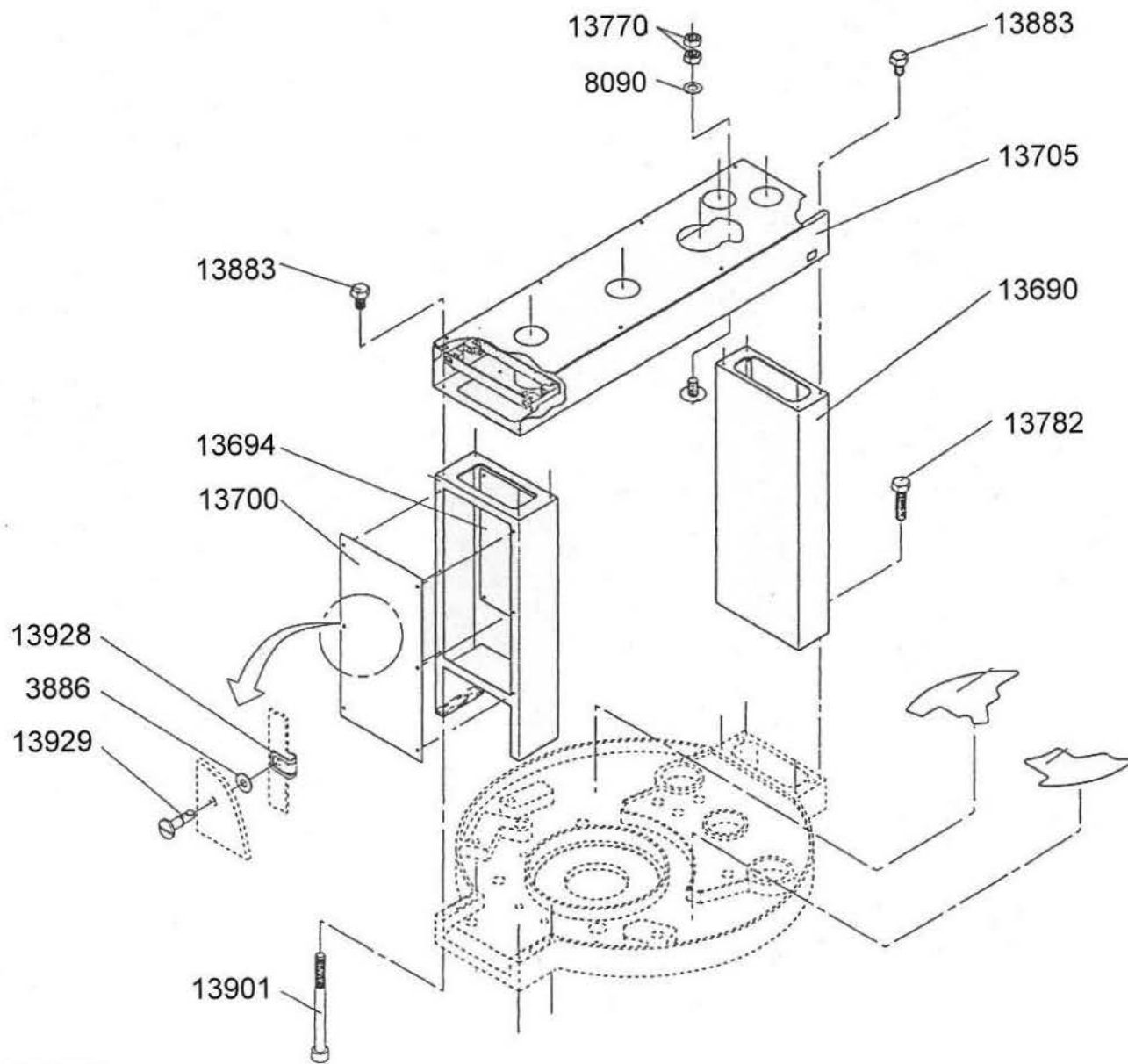
# Section 10: machine frame, upper



## Section 10: machine frame, upper

IIM no.	Description
3886	WASHER, NYLON
5823	BUSHING, SPLIT
7095	ROD END,M10,RIGHT HAND
8090	WASHER
13545	SCREW,BUTTONHEAD
13682	ARM,PIVOT,ACRYLIC GUARD DOOR
13683	PIN,PIVOT,UPPER GUARD
13705	FRAME,UPPER MACHINE
13769	NUT,HEX
13770	NUT,HEX
13782	SCREW,HEX
13791	TUBE,110MM OD,CAPSULE SUPPLY
13801	SCREW,HEX
13802	WASHER
13860	SPACER
13863	SCREW, SHOULDER
13887	GASKET
13911	CLAMP
13912	FERRULE
13928	CLIP,RETAINING
13929	FASTENER,1/4 TURN
13932	CYLINDER,GAS,GUARD DOORS
13946	V-RING
13961	SWITCH,SAFETY
14605	CLEVIS CLIP,FOR GAS STRUT
15972	TUBE,CAPSULE SUPPLY
15973	PIN
15974	STOPPER
15975	SCREW
15977	CAPSULE HOPPER TUBE/SEAL ASSY
15978	FERRULE
15979	GASKET
15980	CLAMP
15981	V-RING

# Section 11: machine frame, sides





## Section 11: machine frame, sides

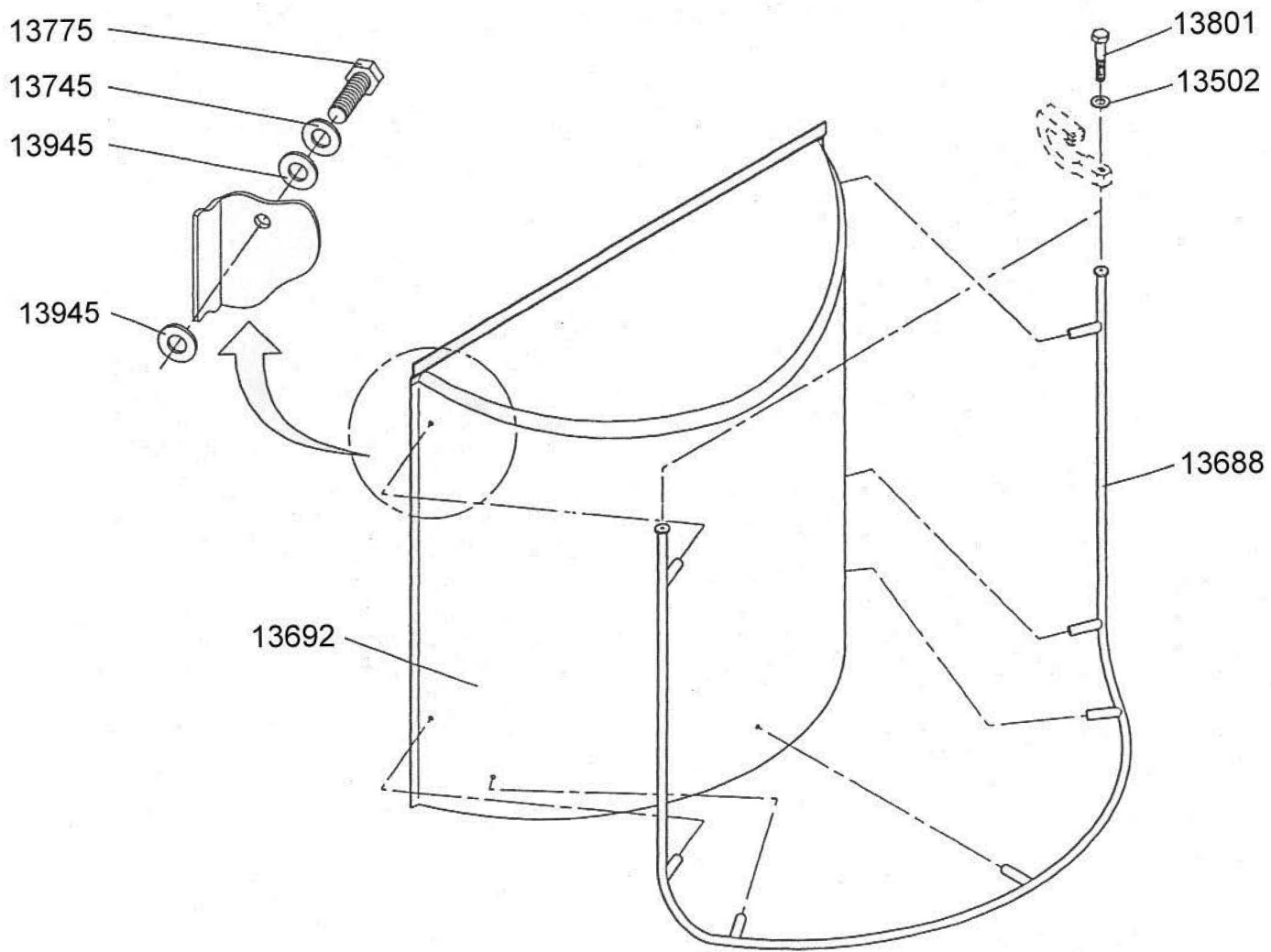
IIM no.	Description
3886	WASHER,NYLON
8090	WASHER
13690	FRAME,MACHINE TOP
13694	GUARD,SMALL
13700	GUARD
13705	FRAME,UPPER MACHINE
13770	NUT,HEX
13782	SCREW,HEX
13883	SCREW,HEX
13901	SCREW
13928	CLIP,RETAINING
13929	FASTENER,1/4 TURN



## Section 12: machine frame, lower

IIM no.	Description
3734	WASHER
6843	WASHER
12966	SCREW,COUNTERSINK
13462	WASHER
13468	HOSE BARB
13492	HUT,HEX,JAM
13508	LOCK MECHANISM,GUARDS
13548	COVER,STATION 4,BEAD FEED
13549	COVER,STATION6,BEAD FEED
13550	SCREW,HEX
13551	COVER,STATION 8, BEAD FEED POSITION
13684	BRACKET,I-BRACE,TO TABLETOP
13685	COVER,LOWER RIGHT,CURVED
13686	COVER,LOWER LEFT,CURVED
13687	BRACKET,HINGE,GUARD PIVOT
13691	PLATE,BASE,MAIN MACHINE
13693	TABLE TOP,MAIN MACHINE
13695	BOX,JUNCTION,LEFT
13696	BOX,JUNCTION,RIGHT
13701	SHROUD,DUST
13702	HEADER,VACUUM
13708	CAP
13709	BLOCK,SPACER,LEVELING DEVICE
13759	SCREW,HEX
13769	NUT,HEX
13782	SCREW,HEX
13783	SCREW,HEX,I-BRACE,TO TABLETOP
13787	SEAL,BLUE,4.2MM X 4.2MM
13792	MOLDING,EDGE
13793	HOSE
13794	MOLDING,EDGE
13805	SCREW,SOCKET HEAD CAP
13880	PAWL,LOCK MECHANISM,GUARD DOORS
13910	CAP
13919	PIN,HINGE,GUARD,UNDERTABLE
13927	BLOCK,SPACER,LEVELING DEVICE
13933	WASHER
13934	STUD
13935	FASTENER,QUICK DISKONNECT
13952	RING,SPLIT
13954	COUPLING,HOSE
13975	FITTING
14303	CONNECTOR
14339	BUSHING,WHITE NYLON,DOOR CATCH
14340	SCREW,HEX,M6X40
14457	FITTING

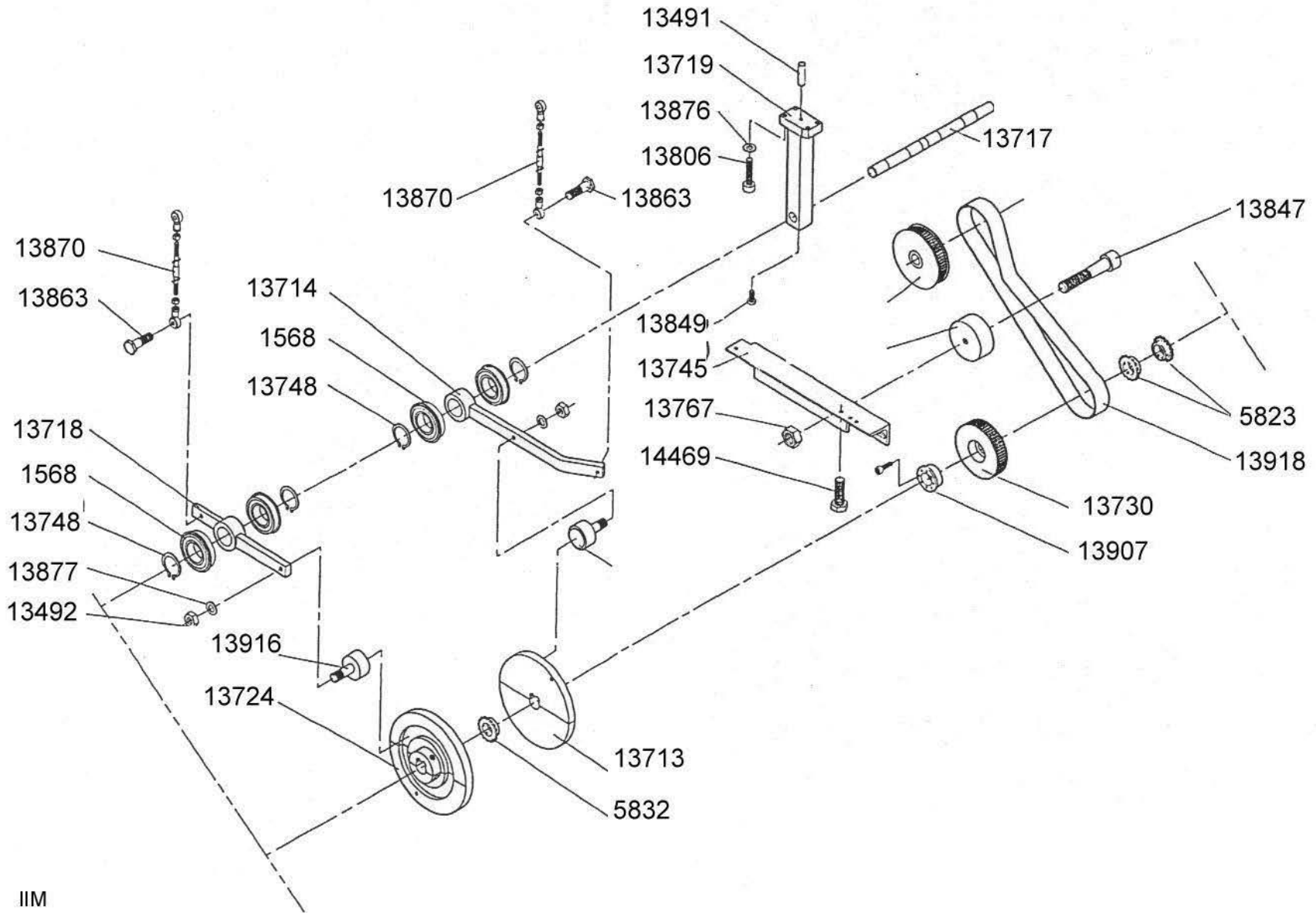
# Section 13: guard door assembly



## Section 13: guard door assembly

IIM no.	Description
13502	WASHER
13688	HANDLE,ACRYLIC GUARD,LIFTING
13692	GUARD,ACRYLIC HOOD,MOLDED
13745	WASHER,M8,SERRATED,ZINC PLATED
13775	SCREW,HEX
13801	SCREW,HEX
13945	WASHER

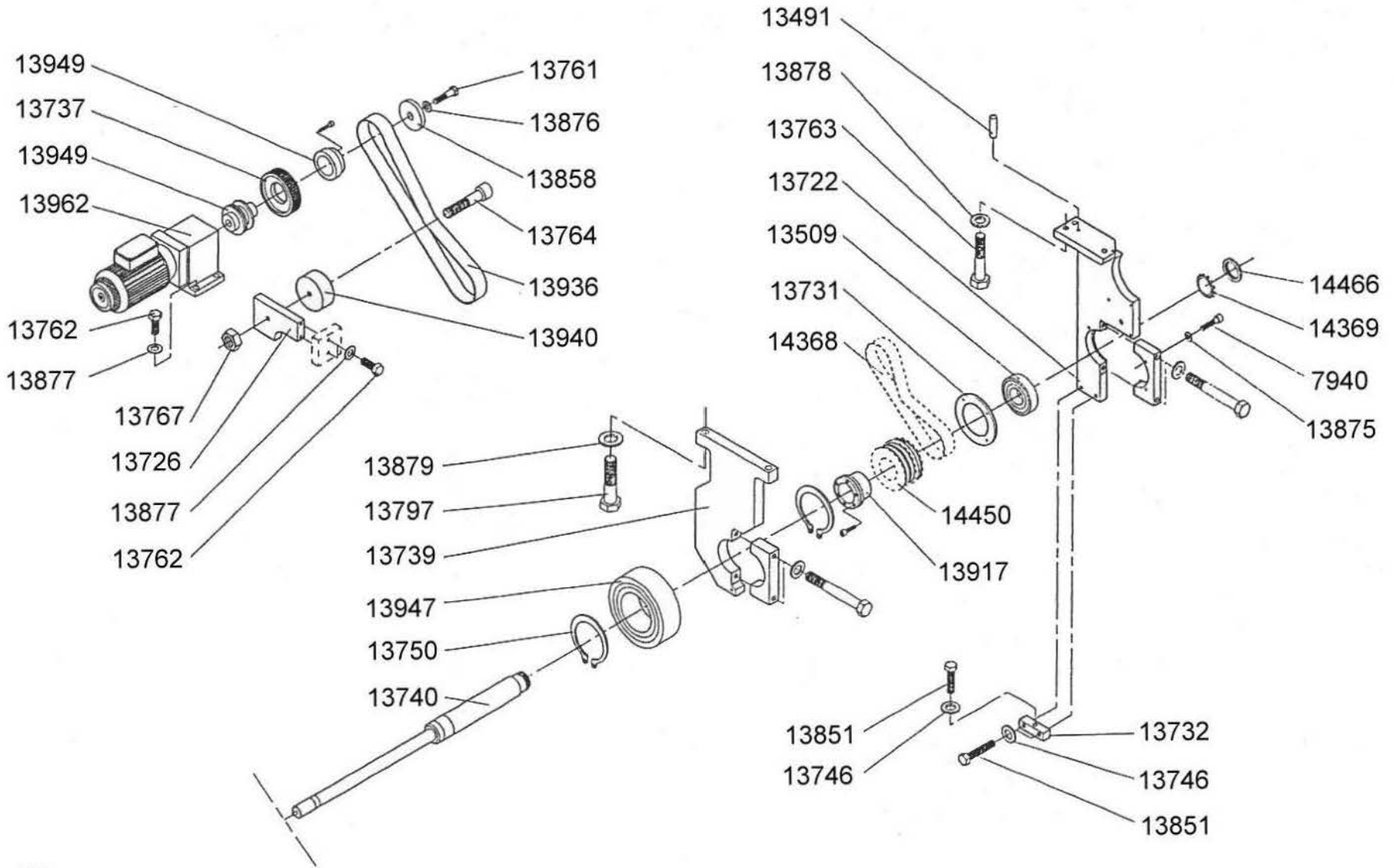
# Section 14.1: faulty capsule, separation drive



## Section 14.1: faulty capsule, separation drive

IIM no.	Description
1568	BEARING
5823	BUSHING,SPLIT
5832	WHEEL,CHAIN,BEAD FEED DRIVER
13491	PIN,DOWEL
13492	HUT,HEX,JAM
13713	CAM,FAULTY CAPSULE
13714	LEVER ARM,FAULTY CAPSULE STATION
13717	SHAFT,PIVOT,FOR LEVER ARMS
13718	LEVER ARM,CAPSULE SEPARATION STATION
13719	BLOCK,END PIVOT SHAFT SUPPORT,FOR FAULTY & SEPARATION
13724	CAM,SEPARATION
13730	PULLEY,TIMING
13745	WASHER,M8,SERRATED,ZINC PLATED
13748	CIRCLIP,EXTERNAL
13767	NUT,HEX
13806	SCREW,SOCKET HEAD CAP
13847	SCREW,SHOULDER,SOCKET HEAD CAP
13849	SCREW,HEX
13863	SCREW,SHOULDER,FOR TURN BUCKLE
13870	ROD,THREADED
13876	WASHER,M10,SERRATED
13877	WASHER,M12,SERRATED
13907	HUB,LOCKING,TIMING BELT,PULLEY
13916	CAM FOLLOWER
13918	BELT,TIMING
14469	BOLT

# Section 14.2: main drive

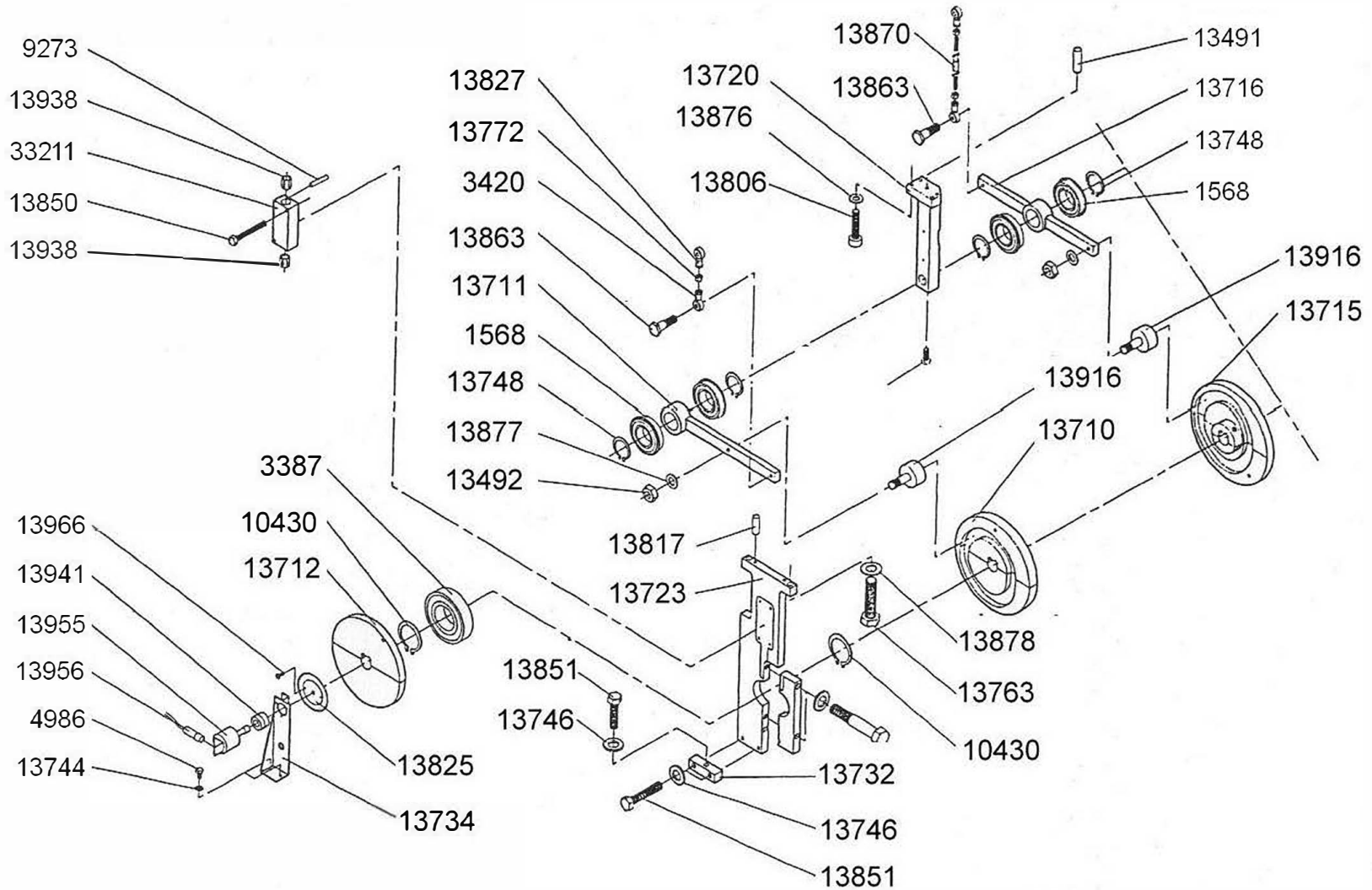




## Section 14.2: main drive

IIM no.	Description
7940	SCREW
13491	PIN,DOWEL
13509	BEARING,ROLLER
13722	SUPPORT,MAIN SHAFT
13726	PLATE,IDLER PULLEY
13731	PLATE,COVER
13732	BLOCK,BOTTOM MOUNT,MAIN SHAFT SUPPORT
13737	PULLEY,TIMING,MAIN DRIVE MOTOR
13739	SUPPORT PLATE,MAIN DRIVE
13740	SHAFT,MAIN DRIVE
13746	WASHER
13750	CIRCLIP,EXTERNAL
13761	SCREW
13762	SCREW
13763	SCREW,HEX
13764	SCREW,SOCKET HEAD CAP
13767	NUT,HEX
13797	SCREW
13851	SCREW,HEX
13854	SCREW
13858	SPACER
13875	WASHER,M8,SERRATED,STAINLESS
13876	WASHER,M10,SERRATED
13877	WASHER,M12,SERRATED
13878	WASHER,M16,SERRATED
13879	WASHER,M20,SERRATED
13917	HUB,COMPRESSION,MAIN DRIVE
13936	BELT,TIMING
13940	PULLEY,TENSIONING,TIMING BELT
13947	BEARING
13949	CLUTCH,MAIN DRIVE
13962	GEARMOTOR
14368	BELT,TIMING
14369	WASHER,TOOTHED
14450	PULLEY
14466	WASHER

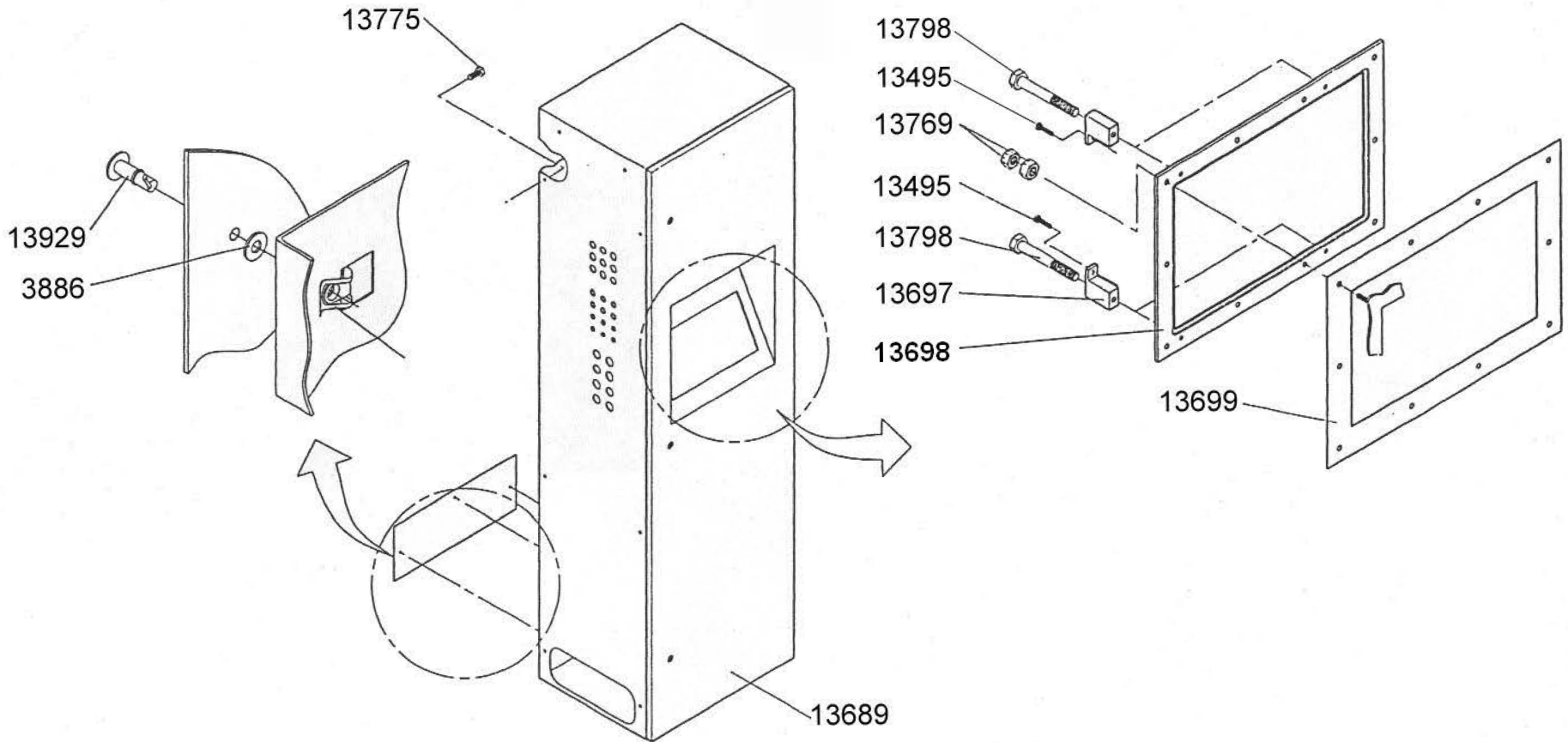
# Section 14.3: sorting, closing, ejection drive



### Section 14.3: sorting, closing, ejection drive

IIM no.	Description
1568	BEARING
3387	BEARING, BALL
3420	ROD END, M12, RIGHT HAND
4986	SCREW,VACUUM TUBE
9273	PIN,DOWEL
10430	RING,EXTERNAL RETAINING,40MM OD
13491	PIN,DOWEL
13492	HUT,HEX,JAM
13710	CAM,SPLIT,CLOSING STATION,WITH ALIGNMENT HOLE
13711	LEVER ARM,CLOSING STATION
13712	CAM,SPLIT,EJECTION STATION,WITH ALIGNMENT HOLE
13715	CAM,SPLIT,SORTING STATION,WITH ALIGNMENT HOLE
13716	LEVER ARM,SORTING STATION
13720	BLOCK,CENTER PIVOT SHAFT,CLOSING AND SORTING CAMS
33211	BLOCK,LINEAR BEARING SUPPORT
13723	PLATE,MAIN SHAFT SUPPORT,CENTER
13732	BLOCK,BOTTOM MOUNT,MAIN SHAFT SUPPORT
13734	BRACKET,MAIN SHAFT
13744	WASHER
13746	WASHER
13748	CIRCLIP,EXTERNAL
13763	SCREW,HEX
13772	NUT,JAM
13806	SCREW,SOCKET HEAD CAP
13817	PIN,DOWEL
13825	DIAL,TIMING,MAIN SHAFT
13827	ROD END,MALE
13850	SCREW,HEX
13851	SCREW,HEX
13863	SCREW,SHOULDER,FOR TURN BUCKLE
13870	ROD,THREADED
13876	WASHER,M10,SERRATED
13877	WASHER,M12,SERRATED
13878	WASHER,M16,SERRATED
13916	CAM FOLLOWER
13938	BEARING,LINEAR
13941	COULPING,FLEX,SHAFT ENCODER
13955	ENCODER,SHAFT
13966	SCREW,HEX

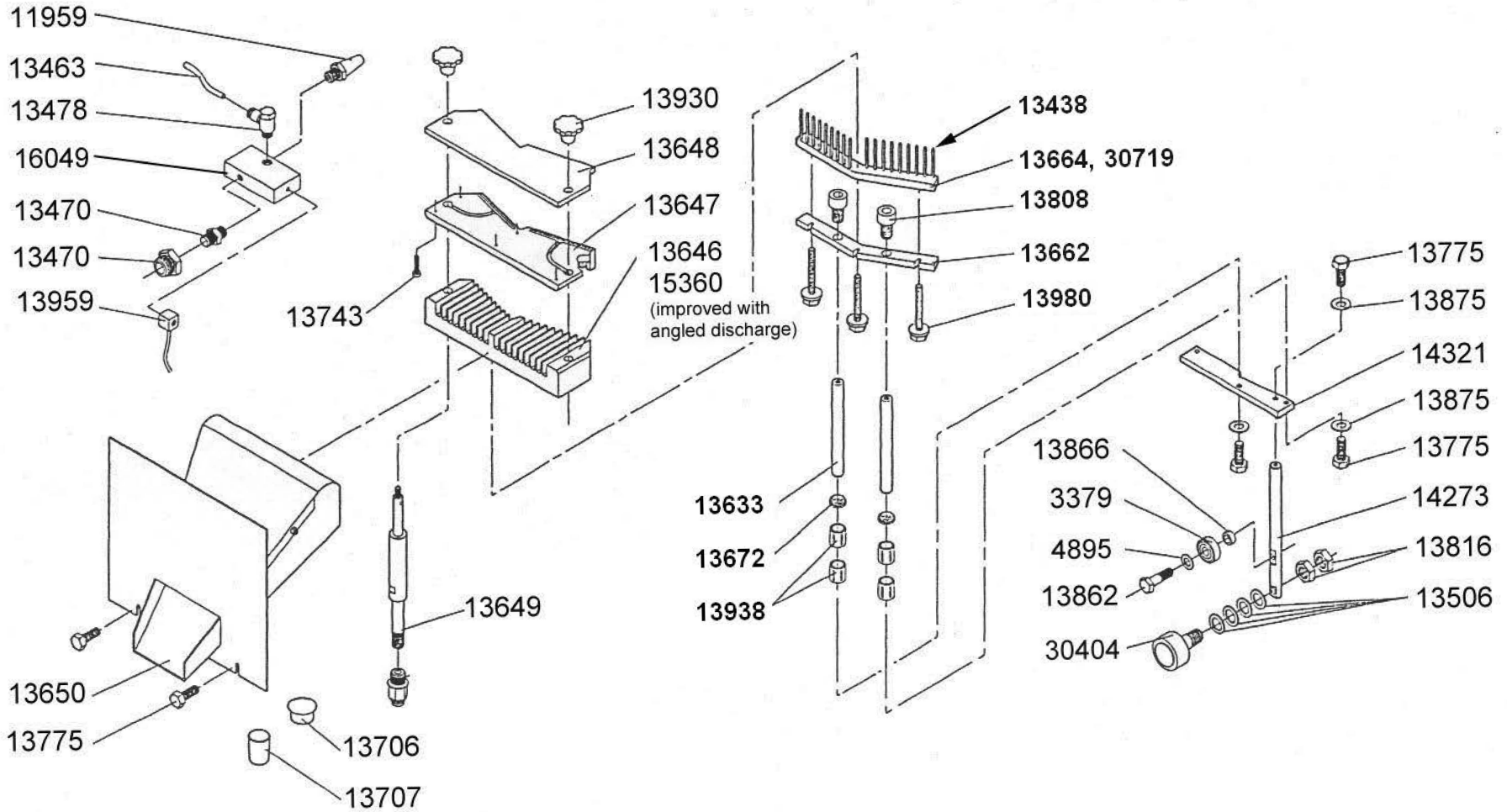
# Section 15: operator panel box



## Section 15: operator panel box

IIM no.	Description
3886	WASHER, NYLON
13495	SCREW
13689	CABINET,ELECTRICAL
13697	BLOCK,SECURING
13698	FRAME
13699	GASKET
13769	NUT,HEX
13775	SCREW,HEX
13798	SCREW
13929	FASTENER,1/4 TURN

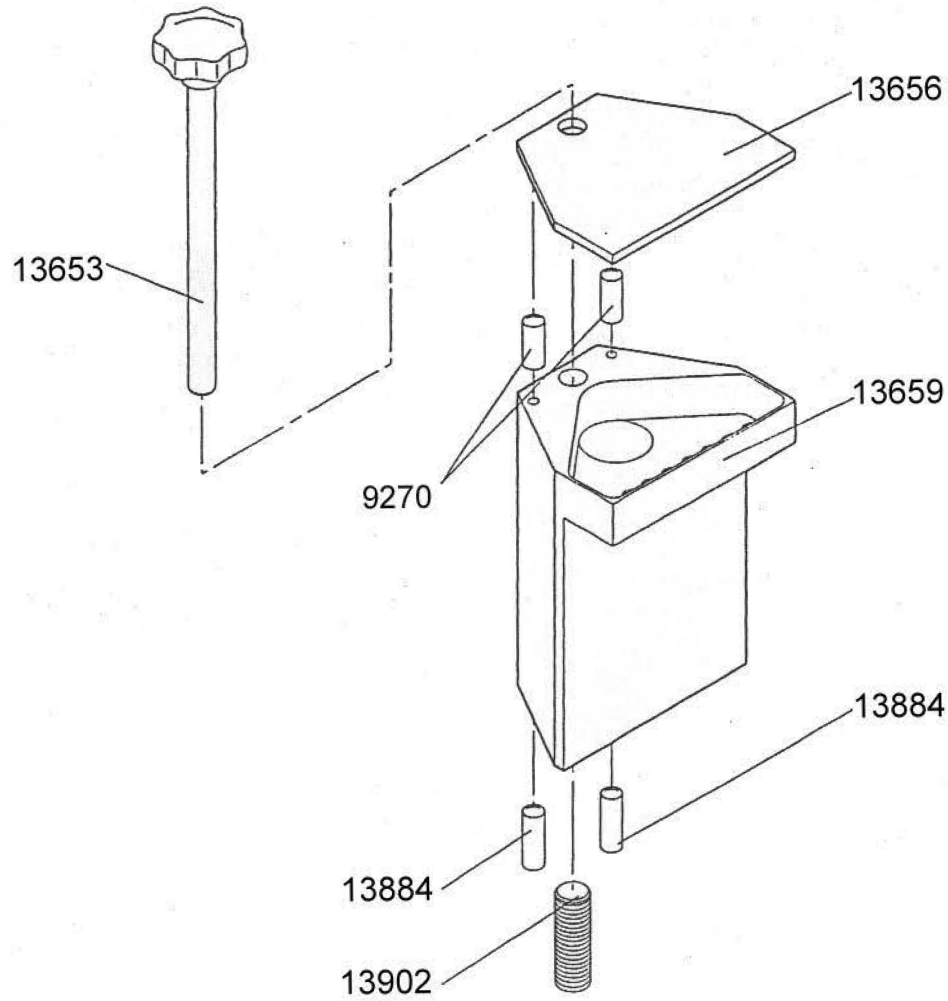
# Section 16: ejection station



## Section 16: ejection station

IIM no.	Description
3379	BEARING
4895	SHIM
11959	SILENCER
13438	PIN,EJECTION,18CT
13463	PIPE
13470	ADAPTER
13478	ELBOW UNION
13506	WASHER
13633	SHAFT,LINEAR,EJECTION DRIVE,ABOVE TABLE (DUAL)
13646	GUIDE,EJECTION DISCHARGE
13647	PLATE,EJECTION
13648	PLATE
13649	SHAFT,MOUNTING
13650	CHUTE,EJECTION
13662	PLATFORM,EJECTION STATION,W/O BLOW-OUT STATION
13664	PLATE,BASE,EJECTION STATION,W/O BLOW-OUT
13672	SEAL,RED
13706	PLUG
13707	CAP
13743	SCREW
13775	SCREW,HEX
13808	SCREW,SOCKET HEAD CAP
13816	NUT,JAM
13862	SCREW,SHOULDER
13866	SPACER
13875	WASHER,M8,SERRATED,STAINLESS
13930	SCREW,THUMB
13938	BEARING,LINEAR
13959	SENSOR
13980	SCREW
14273	SHAFT,LINEAR,EJECTION DRIVE,BELOW TABLE (SINGLE)
14321	PLATE,LOWER DRIVE,EJECTION STATION
15360	GUIDE,EJECTION DISCHARGE,IMPROVED WITH ANGLE
16049	VACUUM VALVE
30404	CAM FOLLOWER

# Section 17: segment cleaning station, standard

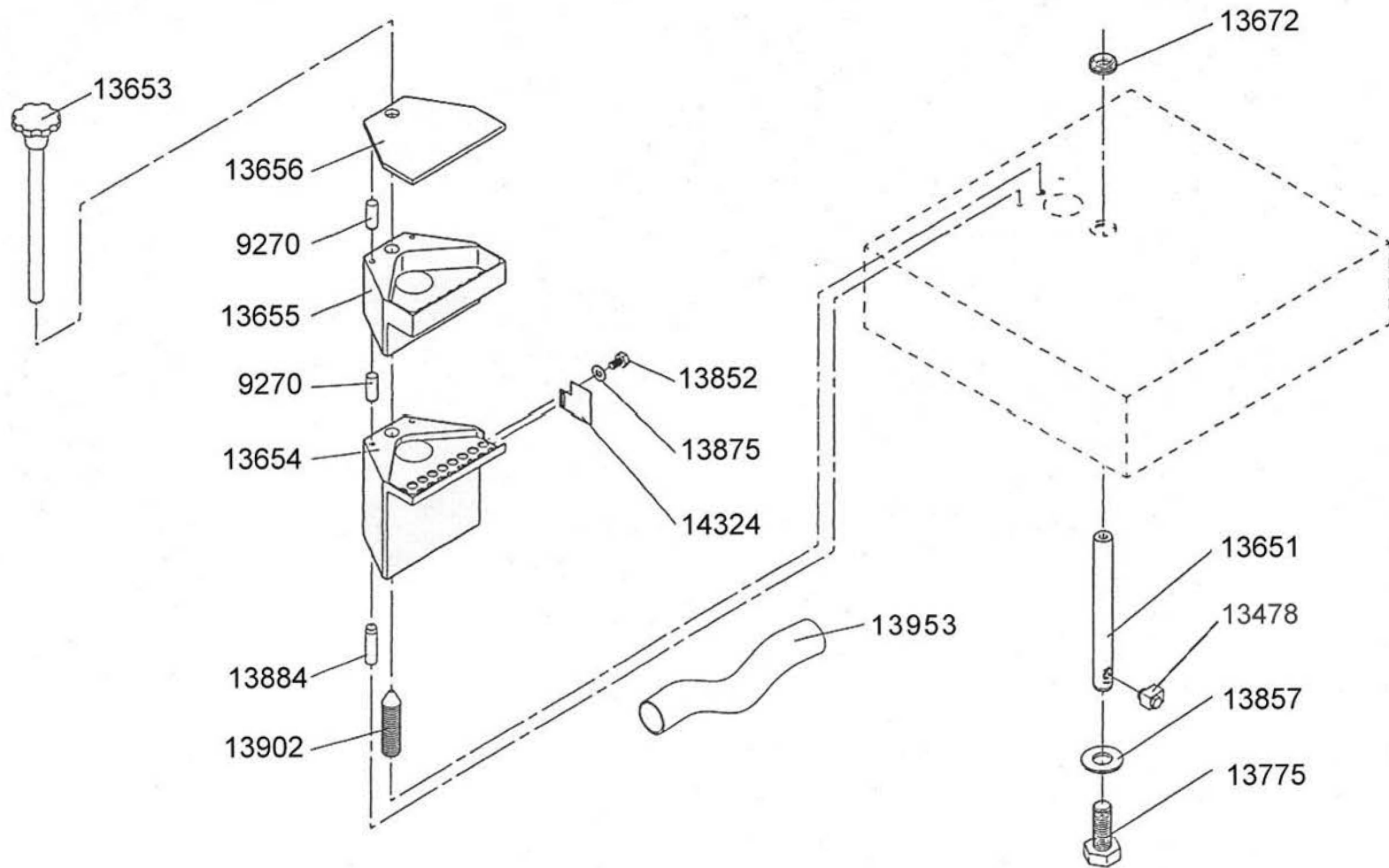




## Section 17: cleaning station, standard

IIM no.	Description
9270	DOWEL PIN
13653	ROD,HAND SECURING
13656	COVER
13659	HOUSING
13884	DOWEL PIN
13902	STUD (SET SCREW)

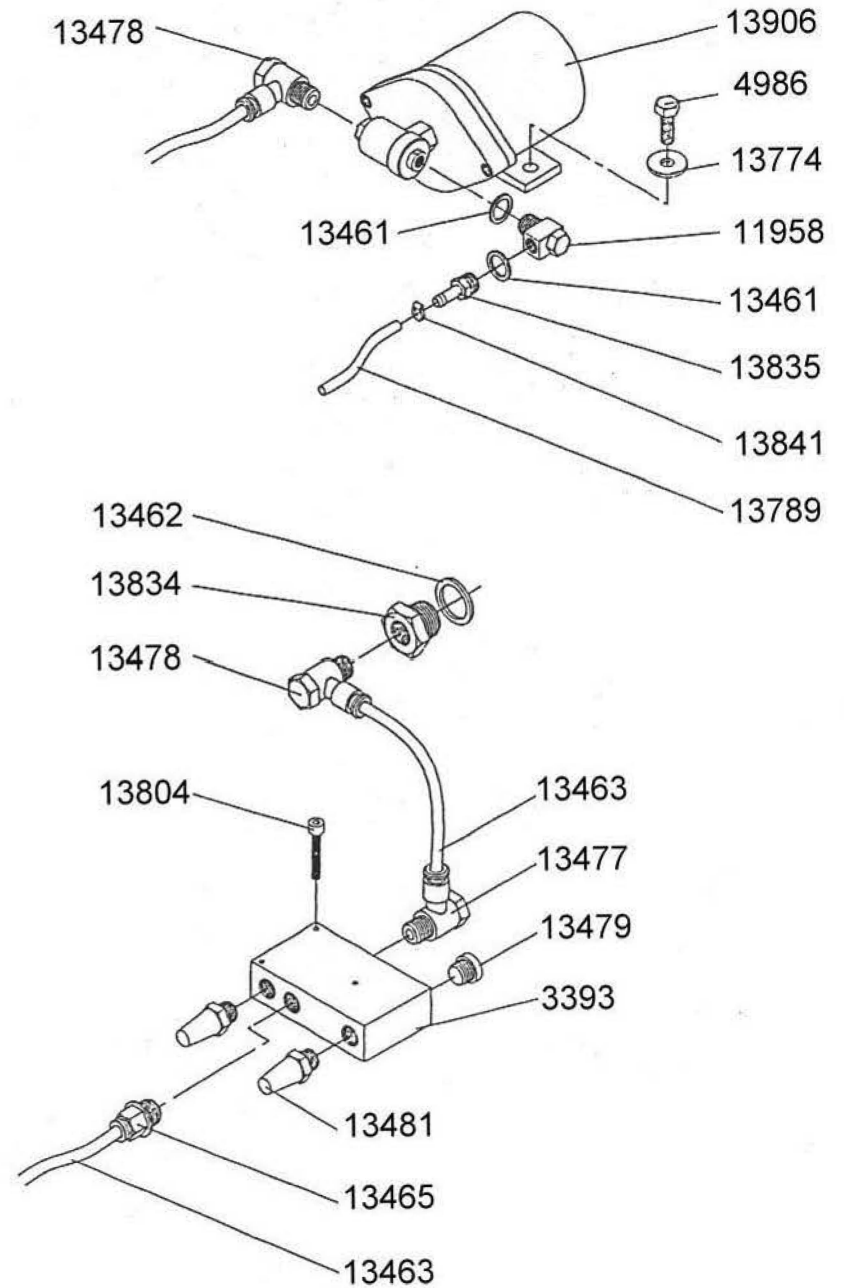
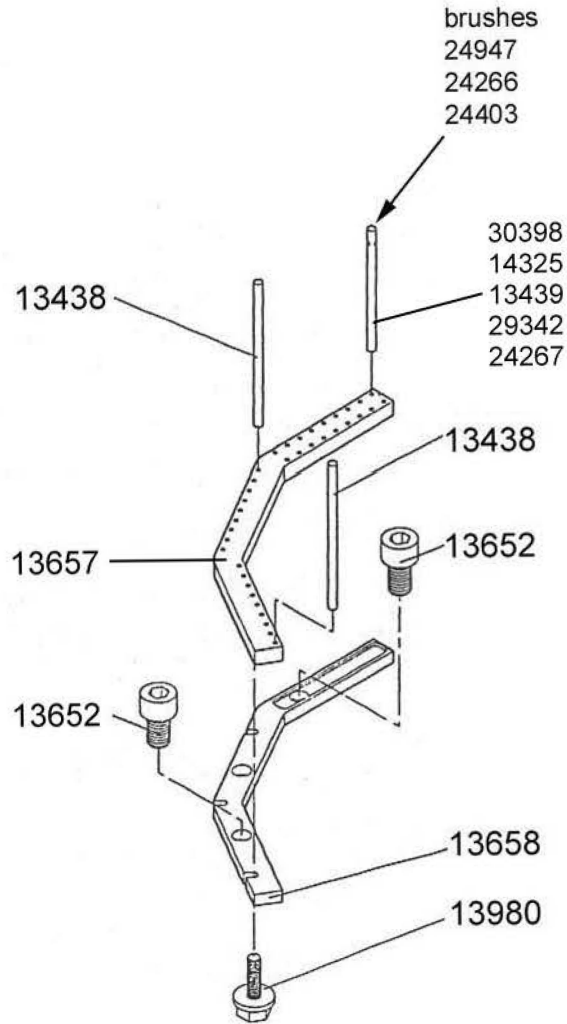
# Section 18: segment cleaning, strengthened



## Section 18: cleaning station, strengthened

IIM no.	Description
9270	DOWEL PIN
13478	ELBOW UNION
13651	SHAFT,DRIVE,SEGMENT CLEANING
13653	ROD,HAND SECURING
13654	MANIFOLD,BASE
13655	MANIFOLD,UPPER
13656	COVER
13672	SEAL,RED
13775	SCREW,HEX
13852	SCREW
13857	WASHER
13875	WASHER,M8,SERRATED,STAINLESS
13884	DOWEL PIN
13902	STUD (SET SCREW)
13953	HOSE,VACUUM
14324	PLATE,AIR DEFLECTOR,BLOW-OUT BLOCK

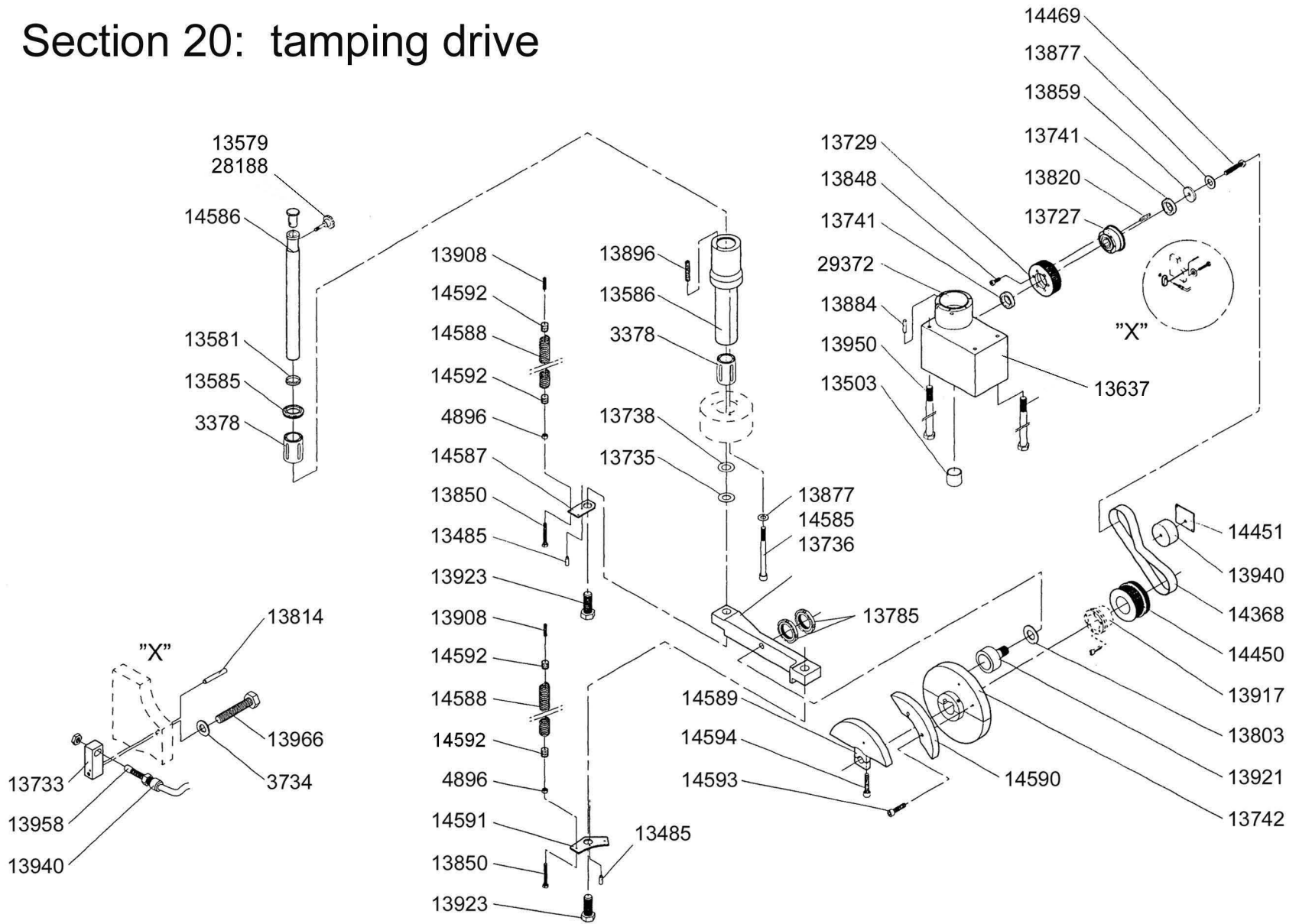
# Section 19: segment cleaning



## Section 19: segment cleaning

IIM no.	Description
3393	VALVE,VACUUM,5/2
4986	SCREW,VACUUM TUBE
11958	BRANCH
13438	PIN, EJECTION
13461	WASHER
13462	WASHER
13463	PIPE
13465	ADAPTER
13477	ADAPTER
13478	ELBOW UNION
13479	PLUG
13481	BUFFER
13652	SCREW,SOCKET HEAD CAP
13657	BASEPLATE,EJECTION & BLOW-OUT
13658	PLATFORM,EJECTION & BLOW-OUT
13774	WASHER
13789	TUBING,BRAID REINFORCED
13804	SCREW,SOCKET HEAD CAP
13834	REDUCING BUSHING
13835	BARB,HOSE
13841	CLAMP,HOSE
13906	ACCUMULATOR
13980	SCREW
30398	PIN, BLOWOUT, 40mm
14325	PIN, BLOWOUT, 47.5mm
13439	PIN, BLOWOUT, 64mm
29342	PIN, BLOWOUT, 75mm
24267	PIN, BLOWOUT, FOR IIM BRUSHES
29341	PIN, BLOWOUT, FOR IIM BRUSHES, LONGER
24947	BRUSH, SIZE 0&00
24266	BRUSH, SIZE 1&2
24403	BRUSH, SIZE 3&4
30722	BOOMERANG COMPLETE, SIZE 0&00
30723	BOOMERANG COMPLETE, SIZE 1&2
30724	BOOMERANG COMPLETE, SIZE 3&4
28269	BOOMERANG COMPLETE WITH BRUSHES, SIZE 0&00
28305	BOOMERANG COMPLETE WITH BRUSHES, SIZE 1&2
28306	BOOMERANG COMPLETE WITH BRUSHES, SIZE 3&4

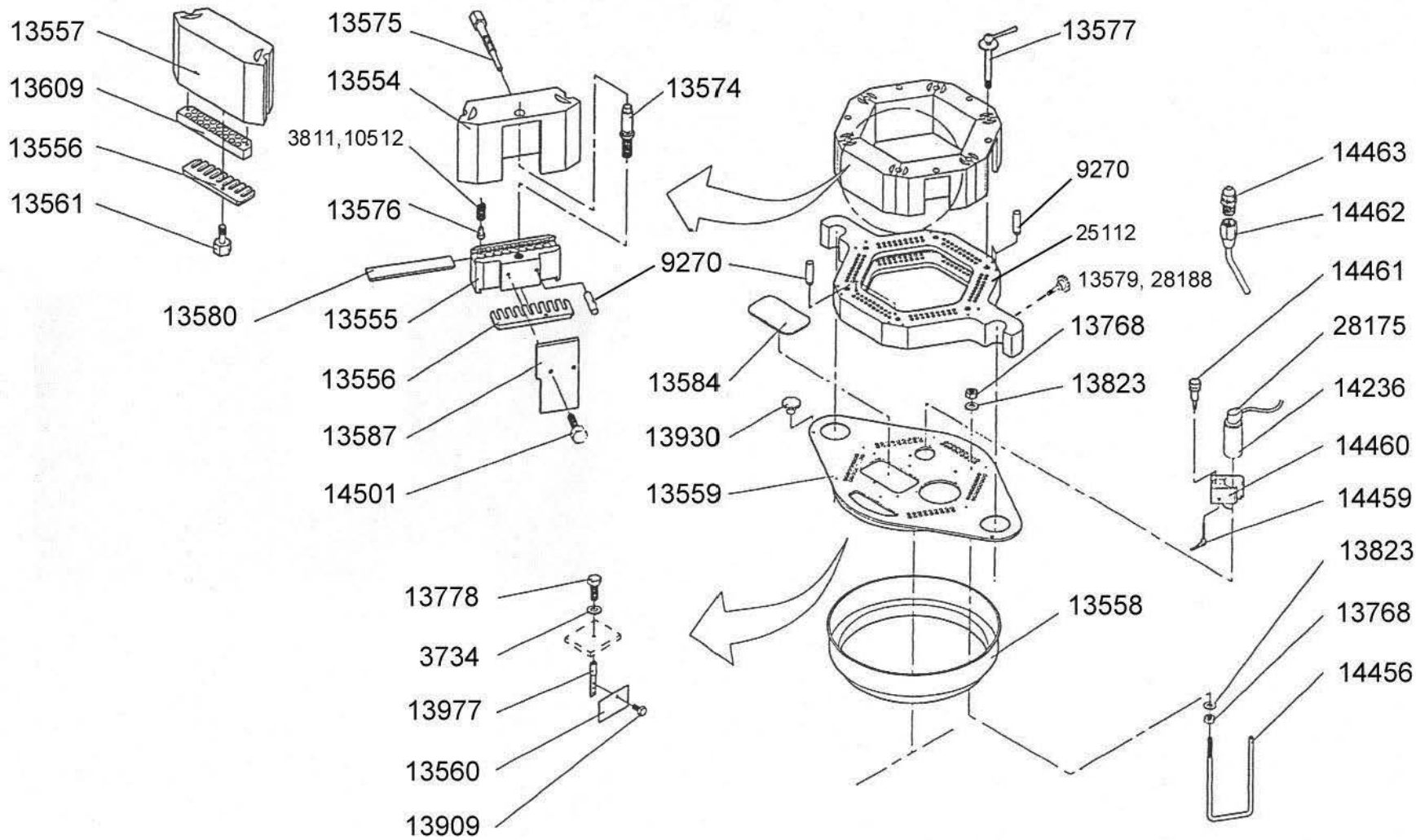
# Section 20: tamping drive



## Section 20: tamping drive

IIM no.	Description
3378	BEARING,LINER
3734	WASHER
4896	NUT,M8
13485	PIN,DOWEL,DOUGHNUT,SEGMENT TURRET
13503	BUSHING
13579	KNOB,HAND
13581	SEAL
13585	SEAL
13586	HOUSING,TAMPING SHAFT COLUMN
13637	GEARBOX,GENEVA
13727	CLUTCH,SLIP
13729	PULLEY,TIMING
13733	BRACKET,MOUNTING,SENSOR
13735	SPACER
13736	ARM,CROSS MEMBER,TAMPING
13738	SPACER
13741	COLLAR
13742	CAM,DOSING/TAMPING
13785	NUT,CAM FOLLOWER,TAMPING CROSS MEMBER
13803	SHIM,TAMPING CAM FOLLOWER
13814	PIN
13820	KEY
13848	SCREW
13850	SCREW,HEX
13859	SPACER
13877	WASHER,M12,SERRATED
13884	PIN,DOWEL
13896	STUD
13908	ROD,THREADED
13917	HUB,COMPRESSION,MAIN DRIVE
13921	CAM FOLLOWER
13923	SCREW,HEX
13940	PULLEY,TENSIONING,TIMING BELT
13950	SCREW
13958	SENSOR
13966	SCREW,HEX
14368	BELT,TIMING
14450	PULLEY
14451	PLATE
14469	BOLT
14585	SCREW,TAMPING COLUMN
14586	SHAFT,TAMPING
14587	BRACKET,TAMPING EXTENSION SPRING
14588	SPRING,EXTENSION,TAMPING
14589	COUNTERWEIGHT,FOR SHAFT
14590	COUNTERWEIGHT,FOR CAM
14591	BRACKET,FOR TAMPING EXTENSION SPRING
14592	INSERT,THREADED,EXTENSION SPRING
14593	SCREW
14594	SCREW
28188	BOLT, CAPTIVE
29372	HUB, DOSING GEARBOX

# Section 21: powder dosing

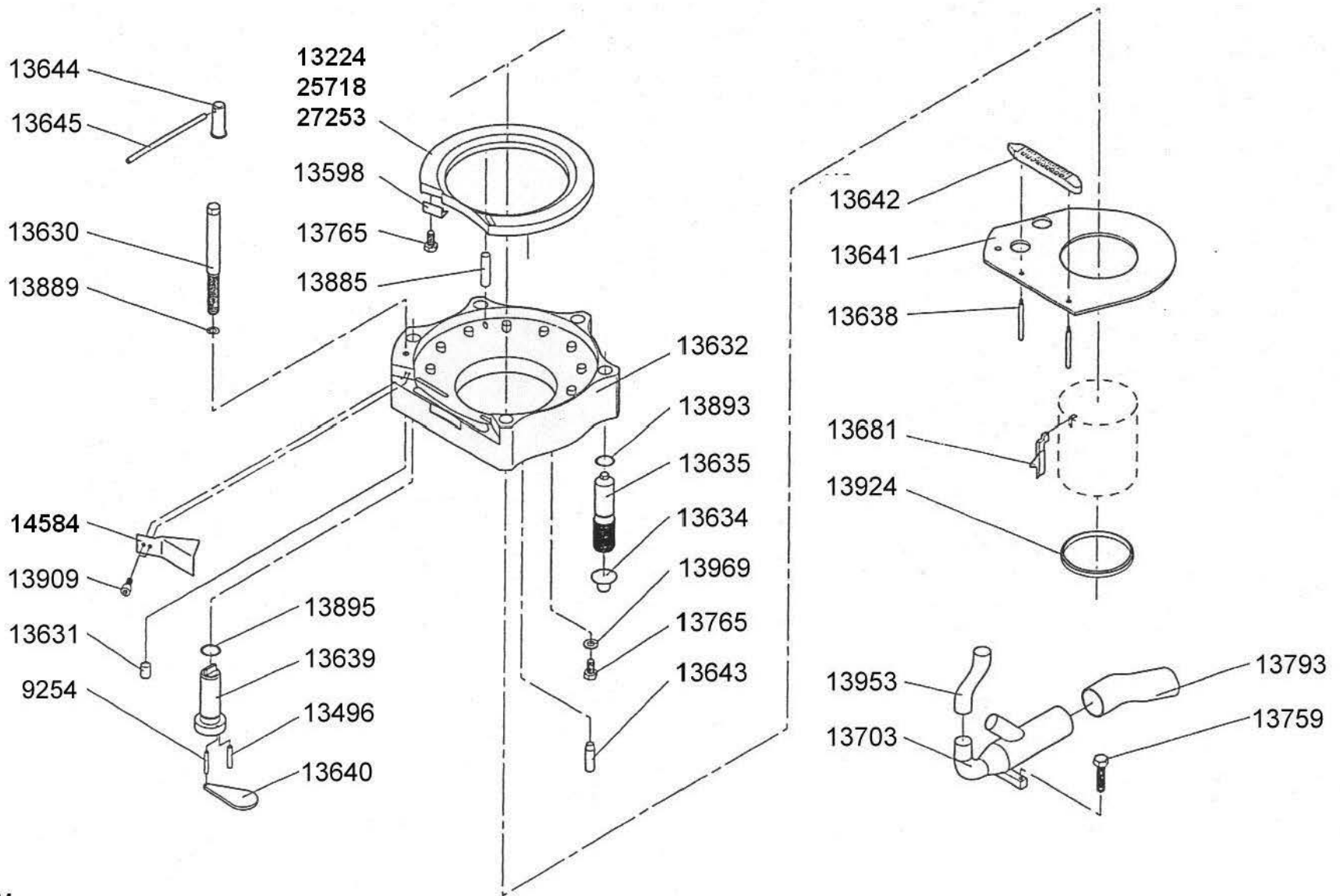




## Section 21: powder dosing

IIM no.	Description
3734	WASHER
3811	SPRING, COMPRESSION
9270	PIN,DOWEL
9271	PIN,DOWEL
10512	SPRING, COMPRESSION
13554	BLOCK,HOLDING,FOR TAMPING BLOCKS
13555	BLOCK,TAMPING
13556	PLATE,RETAINING FINGER
13557	BLOCK,TRANSFER
13558	SIDEBOWL,DOSING
13559	PLATE,LEVEL SENSOR
13560	PLATE,DEFLECTOR
13561	STUD
13574	GUIDE,BOLT,TAMPING HEAD
13575	SCREW,RETAINING,TAMPING BLOCK
13576	CAP,TAMPING,PLASTIC
13577	SCREW,RETAINING,TAMPING HEAD
13579	KNOB,HAND
13580	PLATE,TOP,TAMPING BLOCK
13584	PLATE,COVER
13587	PLATE,SIDE RETAINING,TAMPING BLOCK
13609	GUIDE,UPPER,TRANSFER BLOCK
13768	NUT
13778	SCREW
13823	WASHER
13909	SCREW
13930	SCREW,THUMB
13977	SHAFT,DEFLECTOR
14236	SWITCH,CAPACITIVE PROX,WITH TEFLON BODY
14456	PIPE,VACUUM
14459	FITTING
14460	HOUSING,SENSOR
14461	SCREW,LEVEL SENSOR SECURING HAND KNOB
14462	CABLE
14463	SENSOR
14501	SCREW,HEX,W/CAPT WASHER,LOWER SEGMENT
25112	GUIDE RING
28175	CABLE, POWDER LEVEL SENSOR
28188	BOLT, CAPTIVE, GUIDE RING

# Section 21.1: powder dosing



IIM

tel (336) 584-4777  
fax (336) 584-9540

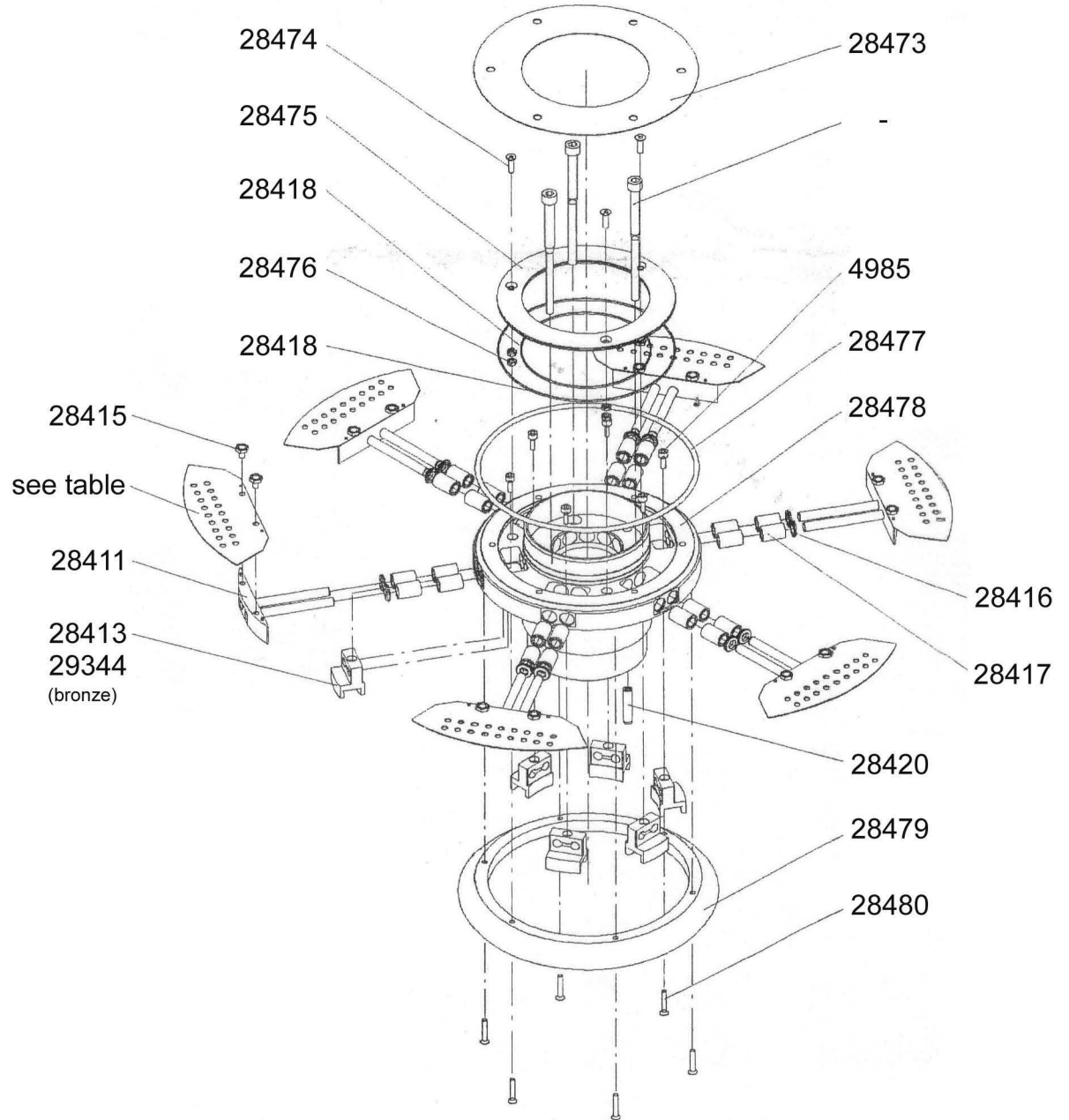
## Section 21.1: powder dosing

IIM no.	Description
9254	PIN,DOWEL
13224	TAMPING RING, BRONZE, POWDER
13496	PIN,DOWEL
13598	SCRAPER,TAMPING RING
13630	STUD,THREADED
13631	PIN
13632	HOUSING,DOSING BOWL
13634	CAP
13635	SCREW,JACK
13638	PIN,THREADED
13639	SHAFT
13640	PLATE
13641	PLATE,BASE,DOSING AREA
13642	BRIDGE,VACUUM,DOSING AREA
13643	PIN
13644	SOCKET,HEX
13645	HANDLE
13681	FIXTURE,WING,DOSING AREA
13703	MANIFOLD,VACUUM
13759	SCREW,HEX
13765	SCREW
13793	HOSE
13885	PIN,DOWEL
13889	WASHER
13893	SHIM
13895	SHIM
13909	SCREW
13924	SEAL
13953	HOSE,VACUUM
13969	WASHER
14584	DEFLECTOR,TAMPING POWDER
25718	TAMPING RING, PLASTIC
27253	TAMPING RING, STAINLESS STEEL

# Section 21.2 - dosing sliders

Dosing sliders

Capsule size	Part no.
00	28421
0	28422
1	28423
2	28424
3	28425
4	28426
5	28427



## Section 21.2: dosing sliders

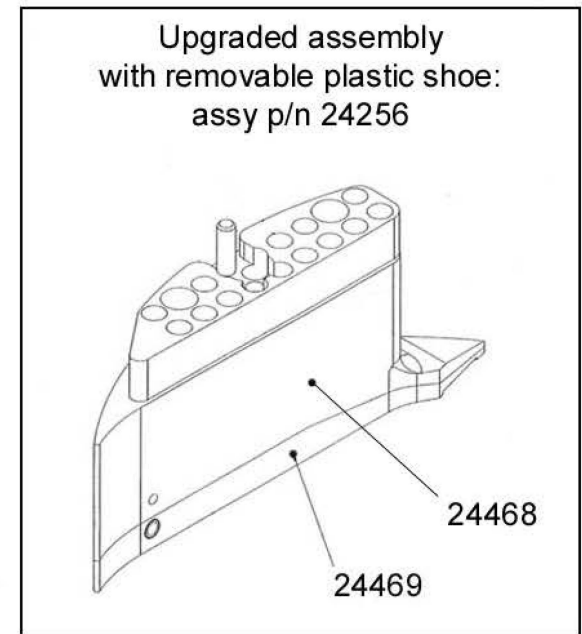
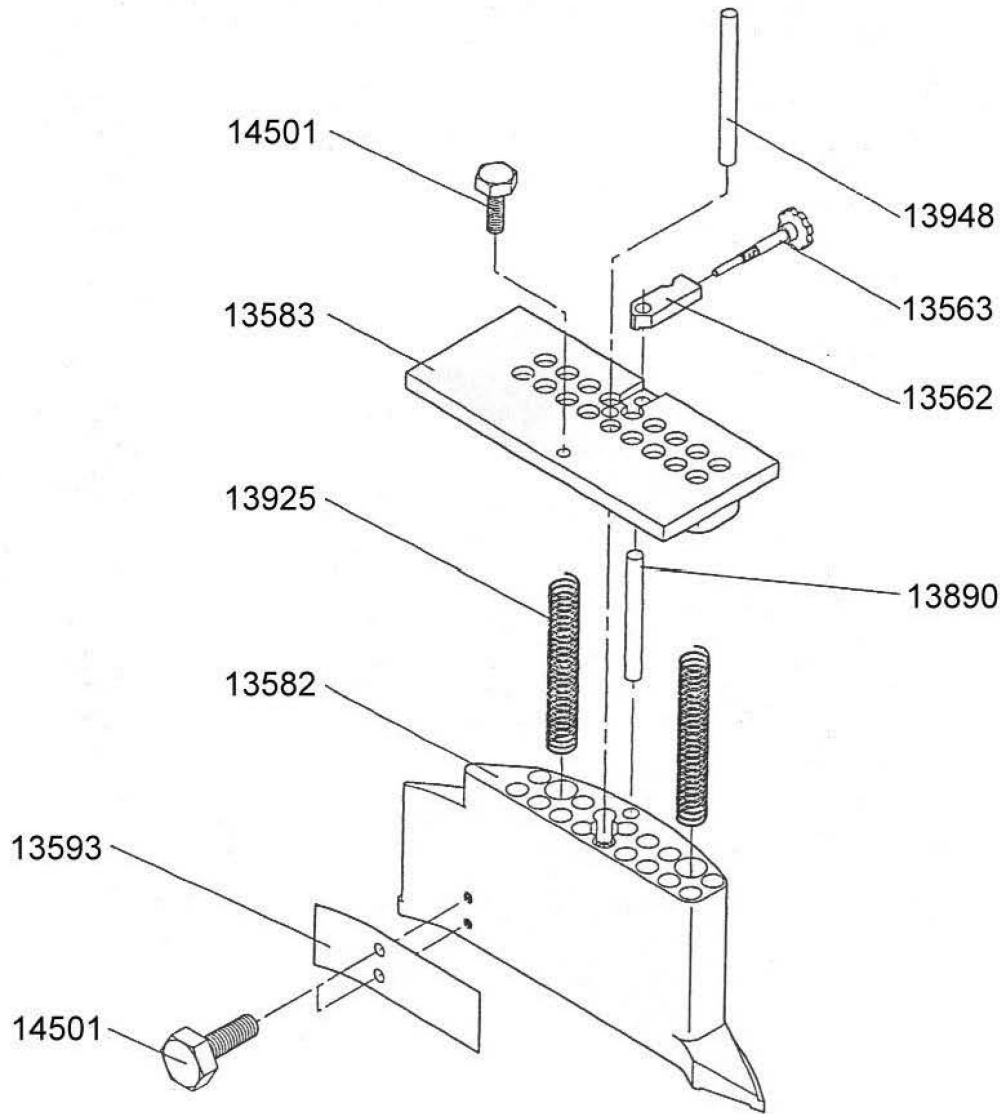
Item no.	Description
4985	SCREW, SOCKET LOW HEAD
28411	CARRIER, DOSING SLIDE
28413	CARRIER, RAIL
28415	BOLT, SPECIAL, SLIDER HOLD-DOWN
28416	SEAL, RED
28417	BEARING, LINEAR
28418	O-RING, SILICONE
28420	DOWEL PIN
28473	COVER
28474	SCREW
28475	COVER
28476	NUT
28477	O-RING
28478	HOUSING, SLIDER TURRET
28479	GUARD, POWDER, TEFLON
28480	SCREW
29344	CARRIER, RAIL, BRONZE



## Section 21.3: rail carrier ring

IIM no.	Description
4896	NUT, M8
14298	RETAINING RING, EXTERNAL
14558	RETAINING RING, INTERNAL
27935	KEY 6X6X20
28472	TRACK, SADDLE GUIDE
29713	CAM FOLLOWER

# Section 22: wiper block with intermediate plate

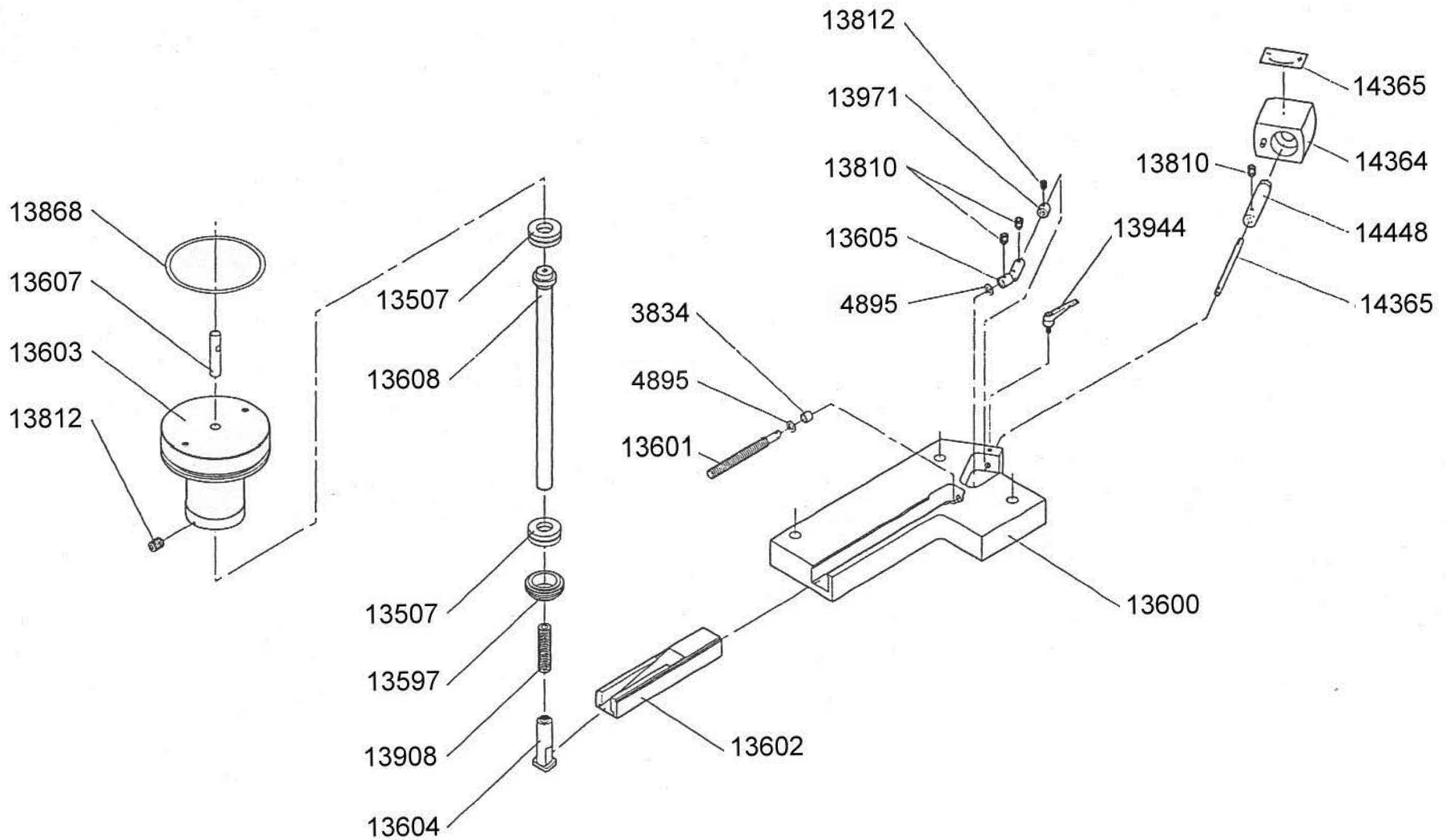




## Section 22: wiper block with intermediate plate

IIM no.	Description
13562	BRACKET,LIFTING DEVICE,FOR WIPER BLOCK
13563	SCREW,THUMB,WIPER BLOCK,RAISING/LOWER
13582	BLOCK,WIPER/TRANSFER,PLASTIC
13583	PLATE,TOP,ALUMINUM,WIPER BLOCK
13593	SHIELD,WIPER BLOCK
13890	PIN,DOWEL
13925	SPRING,COMP,WIPER BLOCK
13948	PIN,ALIGNMENT,WIPER BLOCK
14501	SCREW,HEX,W/CAPT WASHER,LOWER SEGMENT
24256	WIPER BLOCK ASSEMBLY WITH REMOVABLE SHOE
24469	SHOE FOR WIPER BLOCK ASSEMBLY, FDA PLASTIC
28770	SHOE FOR WIPER BLOCK ASSEMBLY, PEEK

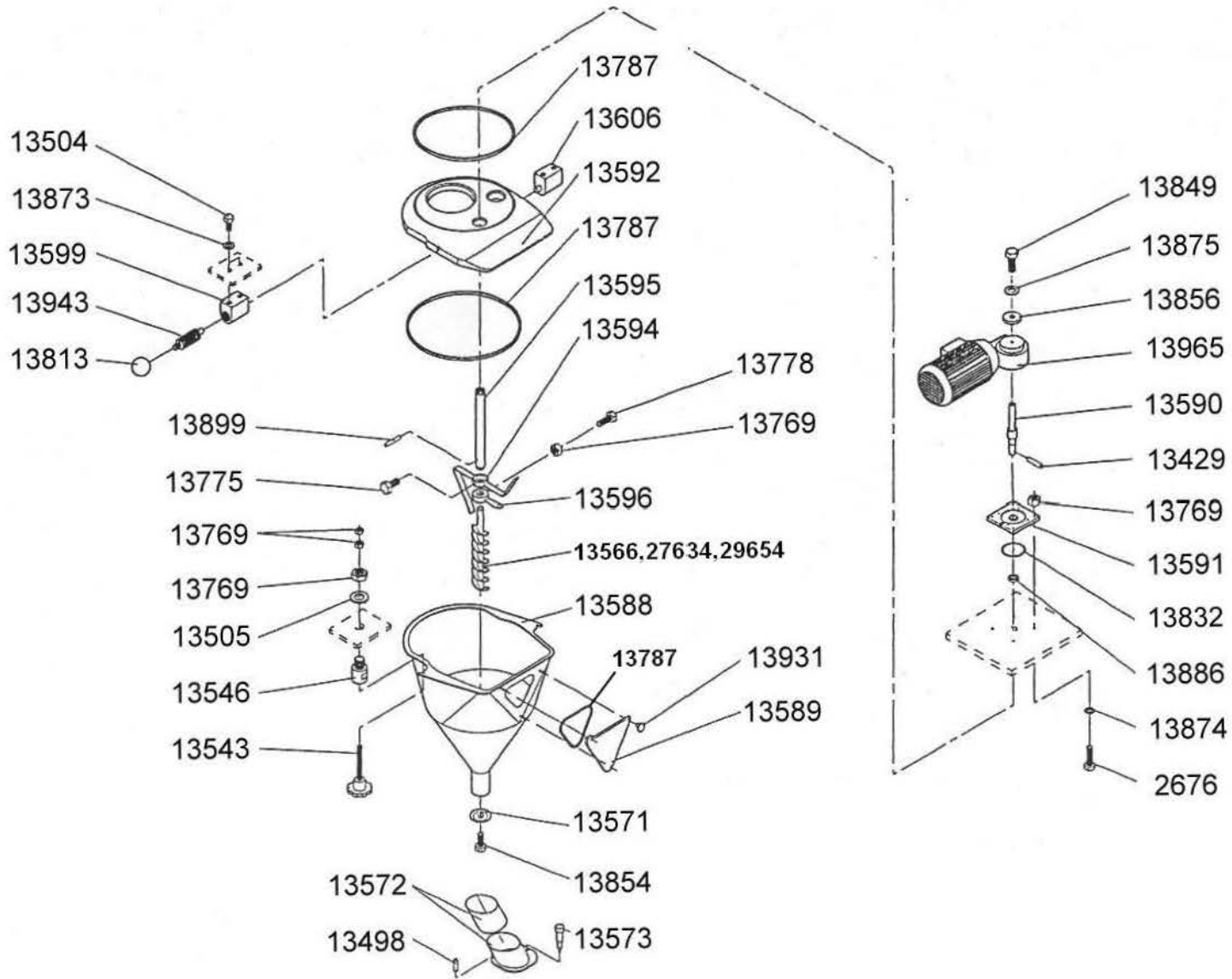
# Section 23: dosing station adjustment



## Section 23: dosing station adjustment

IIM no.	Description
3834	BUSHING
4895	SHIM
13507	BEARING
13597	SEAL
13600	BLOCK
13601	ROD,THREADED
13603	POST
13604	POST,THREADED
13605	ELBOW
13607	PIN,DOWEL,UPGRADED WITH M6 THREADED HOLE
13608	ROD
13810	SCREW,SET
13812	SCREW,SET
13868	O-RING
13908	ROD,THREADED
13944	HANDLE,LOCKING
13971	SLEEVE
14364	COUNTER
14365	PLATE,COUNTER
14448	U-JOINT

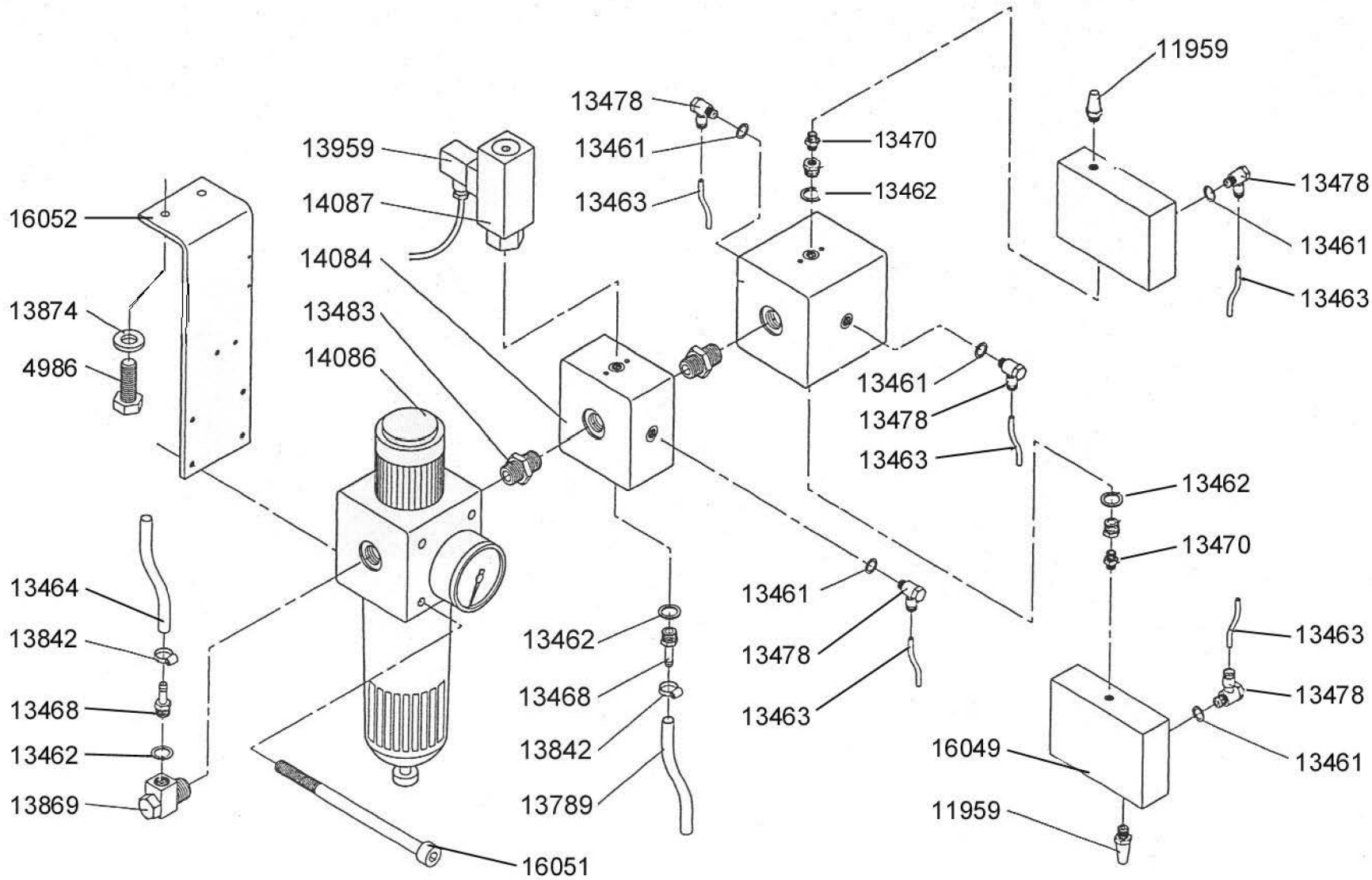
# Section 24: powder hopper



## Section 24: powder hopper

IIM no.	Description
2676	SCREW,HEX
13429	PIN,DOWEL
13498	PIN
13504	SCREW
13505	WASHER
13543	SCREW,HAND,CAPSULE HOPPER,94MM TOTAL LENGTH
13546	BLOCK,ROUND
13566	AUGER,POWDER
13571	GASKET
13572	SLEEVE,CONNECTOR,UNDER HOPPER
13573	SCREW,POWDER HOPPER SECURING BOLT
13588	HOPPER
13589	SIGHT GLASS
13590	SHAFT,DRIVE,POWDER AUGER
13591	PLATE,AUGER DRIVE BASE
13592	LID,HOPPER
13594	IMPELLER,BRACKET,POWDER AUGER
13595	SHAFT,POWDER AUGER
13596	CHOPPER,POWDER AUGER
13599	BLOCK
13606	BLOCK
13769	NUT,HEX
13775	SCREW,HEX
13778	SCREW
13787	SEAL,BLUE,4.2MM X 4.2MM
13813	KNOB
13832	WASHER
13849	SCREW,HEX
13854	SCREW
13856	WASHER
13873	WASHER,M5,SERRATED
13874	WASHER,M6,SERRATED
13875	WASHER,M8,SERRATED,STAINLESS
13886	WASHER
13899	PIN,DOWEL
13931	KNOB, THUMB
13943	PIN,SPRING-LOADED, FOR POWDER HOPPER
13965	MOTOR
27634	AUGER,POWDER,STAINLESS STEEL
29654	AUGER,POWDER,FASTER FEED

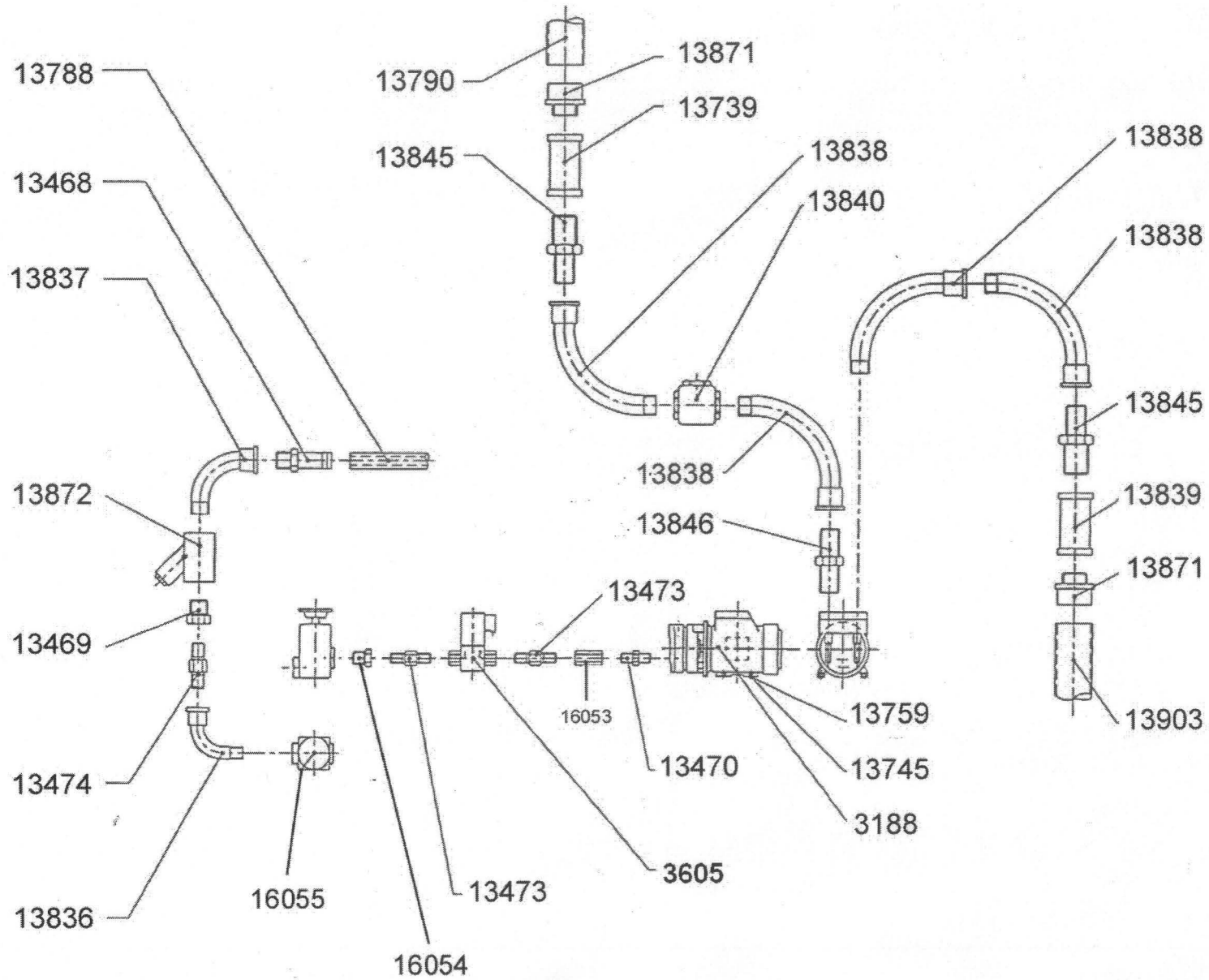
# Section 25: maintenance unit



## Section 25: maintenance unit

IIM no.	Description
4986	SCREW,VACUUM TUBE
11959	SILENCER
13461	WASHER
13462	WASHER
13463	PIPE
13464	TUBE
13468	HOSE BARB
13470	ADAPTER
13478	ELBOW UNION
13483	FITTING
13789	TUBING,BRAID REINFORCED
13842	CLAMP,HOSE
13869	ADAPTER
13874	WASHER,M6,SERRATED
13959	SENSOR
14084	BLOCK
14086	VALVE
14087	SWITCH,PRESSURE
16051	SCREW
16052	PLATE

# Section 26: vacuum system

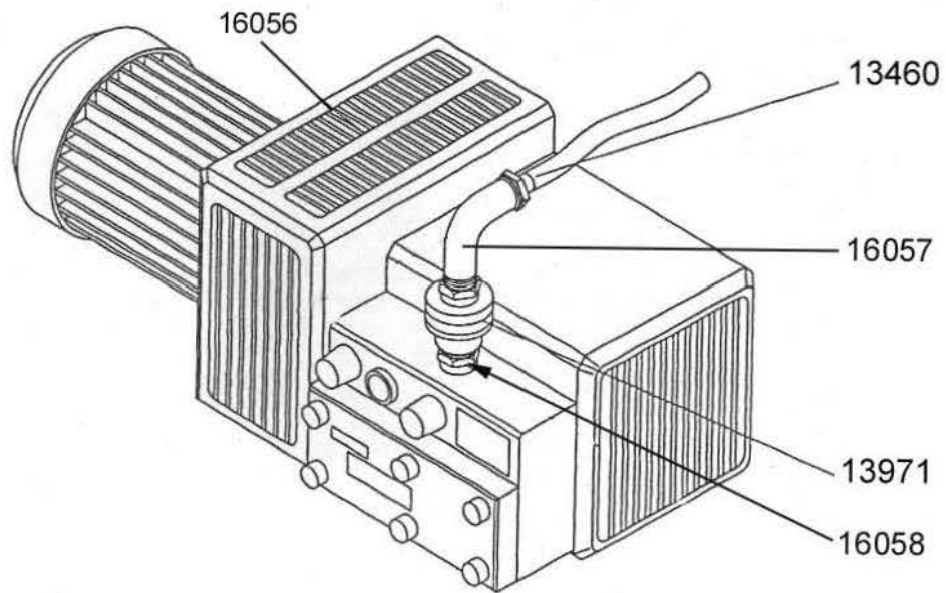




## Section 26: vacuum system

IIM no.	Description
3605	VALVE,SOLENOID,OPERATED
13468	HOSE BARB
13469	ADAPTER
13470	ADAPTER
13473	STUD,CONNECTING
13474	FITTING
13739	SUPPORT PLATE,MAIN DRIVE
13745	WASHER,M8,SERRATED,ZINC PLATED
13759	SCREW,HEX
13788	HOSE
13790	FITTING
13836	ELBOW
13837	ELBOW
13838	ELBOW
13839	ADAPTER
13840	CONNECTOR
13845	REDUCER
13846	FITTING
13871	ADAPTER
13872	Y-SCREEN
13903	TUBING,WIRE REINFORCED
16053	FITTING
16054	ADAPTER
16055	CONNECTOR

## Section 27: vacuum pump



IIM

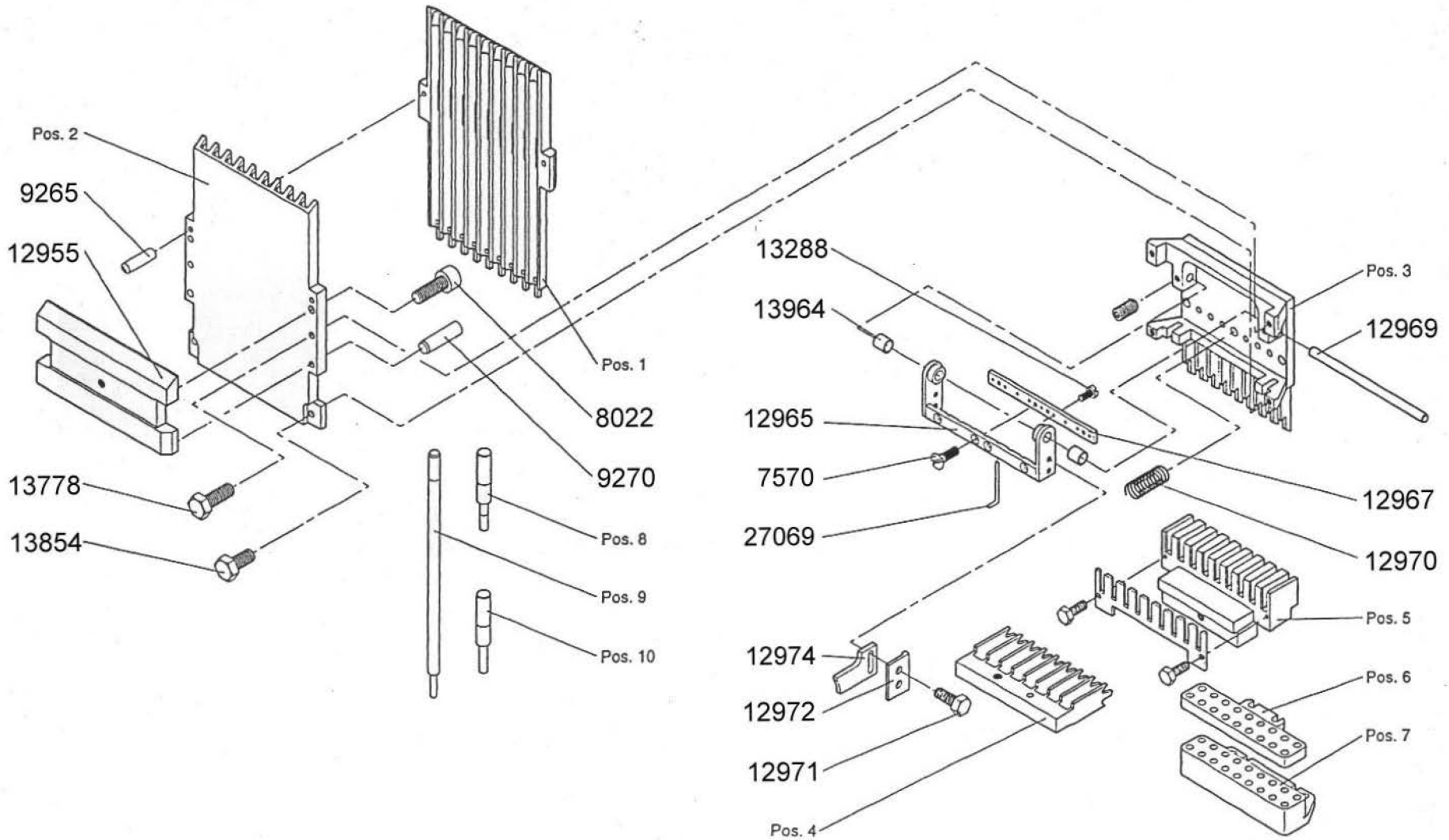
tel (336) 584-4777

fax (336) 584-9540

## Section 27: vacuum pump

IIM no.	Description
13460	HOSE CLAMP
13971	SLEEVE
16056	PUMP,VACUUM
16057	HOSE, ELBOW
16058	NUT

# Section 28: size parts - sorting



## Section 28: size parts - sorting

IIM no.	Description
7570	SCREW, FLAT HEAD SLOTTED
8022	SCREW, SOCKET HEAD CAP
9265	DOWEL PIN
12955	BLOCK,REAR MOUNTING, ALIGNMENT,MAGAZINE
12965	MOUTHPIECE,MAGAZINE
12967	PLATE,SPRING FINGER CAPTURE
12969	SHAFT,S/S,PIVOT,MAGAZINE MOUTHPIECE
12970	SPRING,COMPRESSION,MOUTHPIECE RETURN
12971	SCREW,HEX
12972	PLATE,CAPTURE,MAG MOUTHPIECE TRIP,S/S
12974	CAM,MOUTHPIECE,MAGAZINE,PLASTIC
13288	SCREW,CHEESEHEAD
13778	SCREW
13854	SCREW
13964	SWITCH,PRESSURE
27069	RETAINING FINGER

## Section 28.1: size parts - sorting

<b>Part description</b>	<b>Pos</b>	<b>Size 000</b>	<b>Size 00</b>	<b>Size 0E</b>	<b>Size 0</b>	<b>Size 1</b>
Magazine complete	-	14280	13894	16060	15091	14276
Magazine front side	1	13984	13985	12956	12956	13986
Magazine rear side	2	13991	13992	12962	12962	13993
Magazine guide slider	3	13998	13999	12963	12963	14000
Orienting slider	4	-	14005	16061	12954	14006
Orienting block	5	-	14011	16062	12957	14012
Upper segment	6	13196	13221	9625	9625	13199
Lower segment	7	13197	9627	13198	13198	13200
Alignment pin, segment	8	13360	4923	8185	8185	4924
Alignment pin, dosing	9	7289	3539	7291	7291	4925
Alignment pin, ejector	10	-	-	-	-	-
Size change kit complete	-	14780	14781	28891	14782	14783

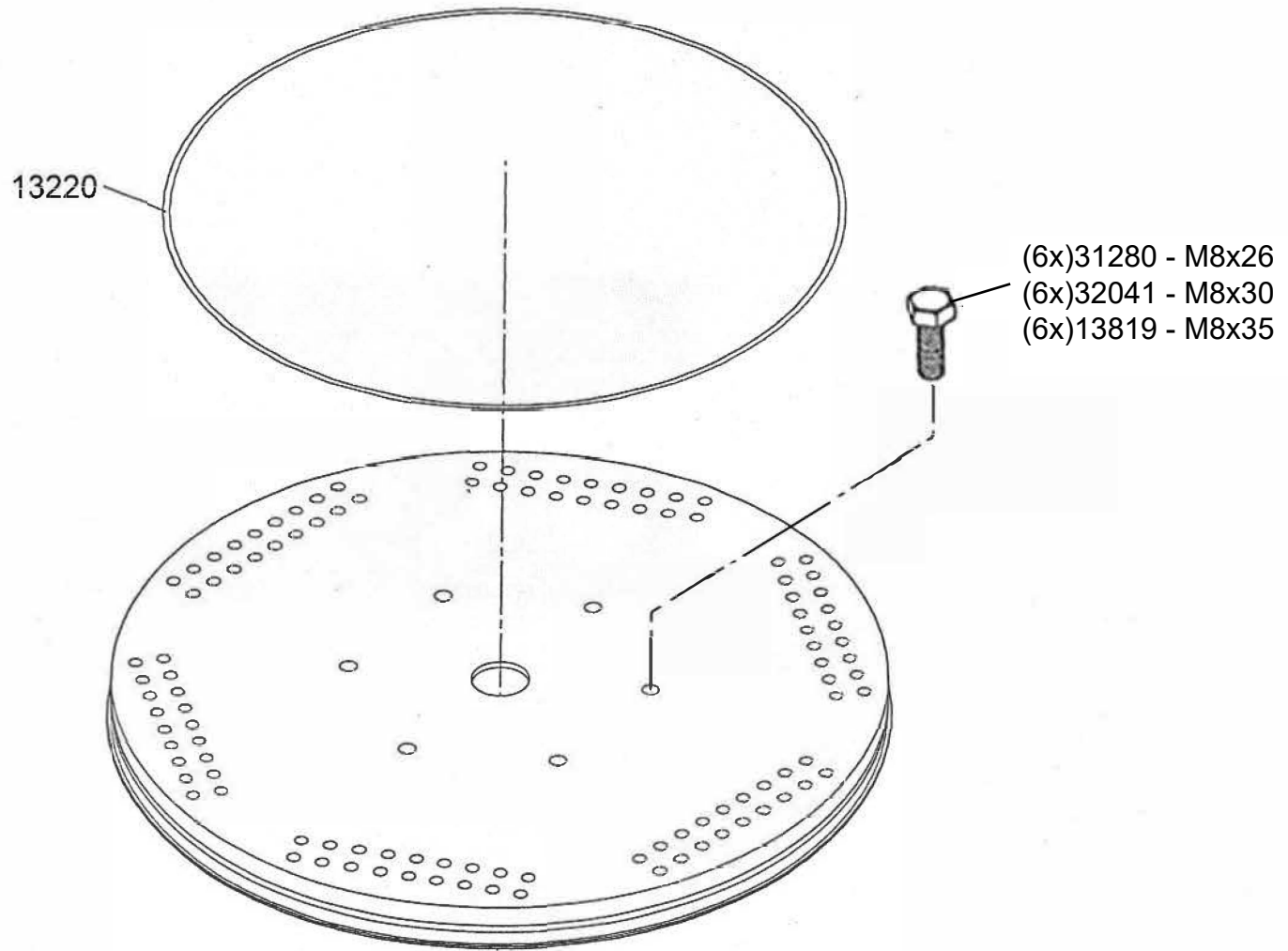
<b>Part description</b>	<b>Pos</b>	<b>Size 2</b>	<b>Size 3</b>	<b>Size 4</b>	<b>Size 5</b>	
Magazine complete	-	14277	14275	14278	14279	
Magazine front side	1	13987	13988	13989	13990	
Magazine rear side	2	13994	13995	13996	13997	
Magazine guide slider	3	14001	14002	14003	14004	
Orienting slider	4	14007	14008	14009	14010	
Orienting block	5	14013	14014	14015	14016	
Upper segment	6	13201	13203	13205	13207	
Lower segment	7	13202	13204	13206	13208	
Alignment pin, segment	8	5190	5191	13361	13362	
Alignment pin, dosing	9	5188	5189	7293	7294	
Alignment pin, ejector	10	-	-	14017	16059	
Size change kit complete	-	14784	14785	14786	14787	

## Section 29: tamping pins

Size	Standard pin	Standard with mirrored tips	For adjustable dosing disc
000	13065	29851	13060
00	13066	29852	13061
0	12953	29853	13062
1	13062	29737	13063
2	13067	29854	13064
3	13068	29736	13071
4	13069	29855	13072
5	13070	29856	-

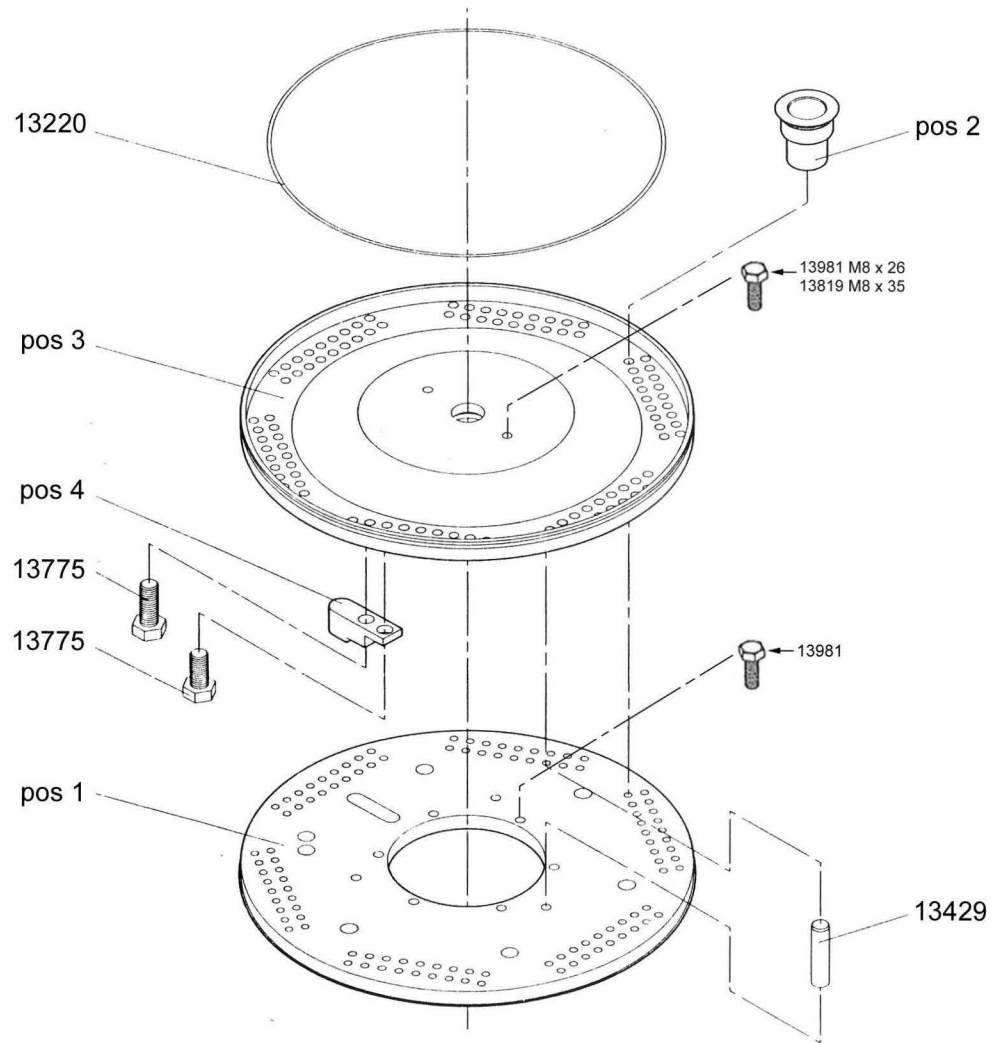


# Section 30: dosing disc, static





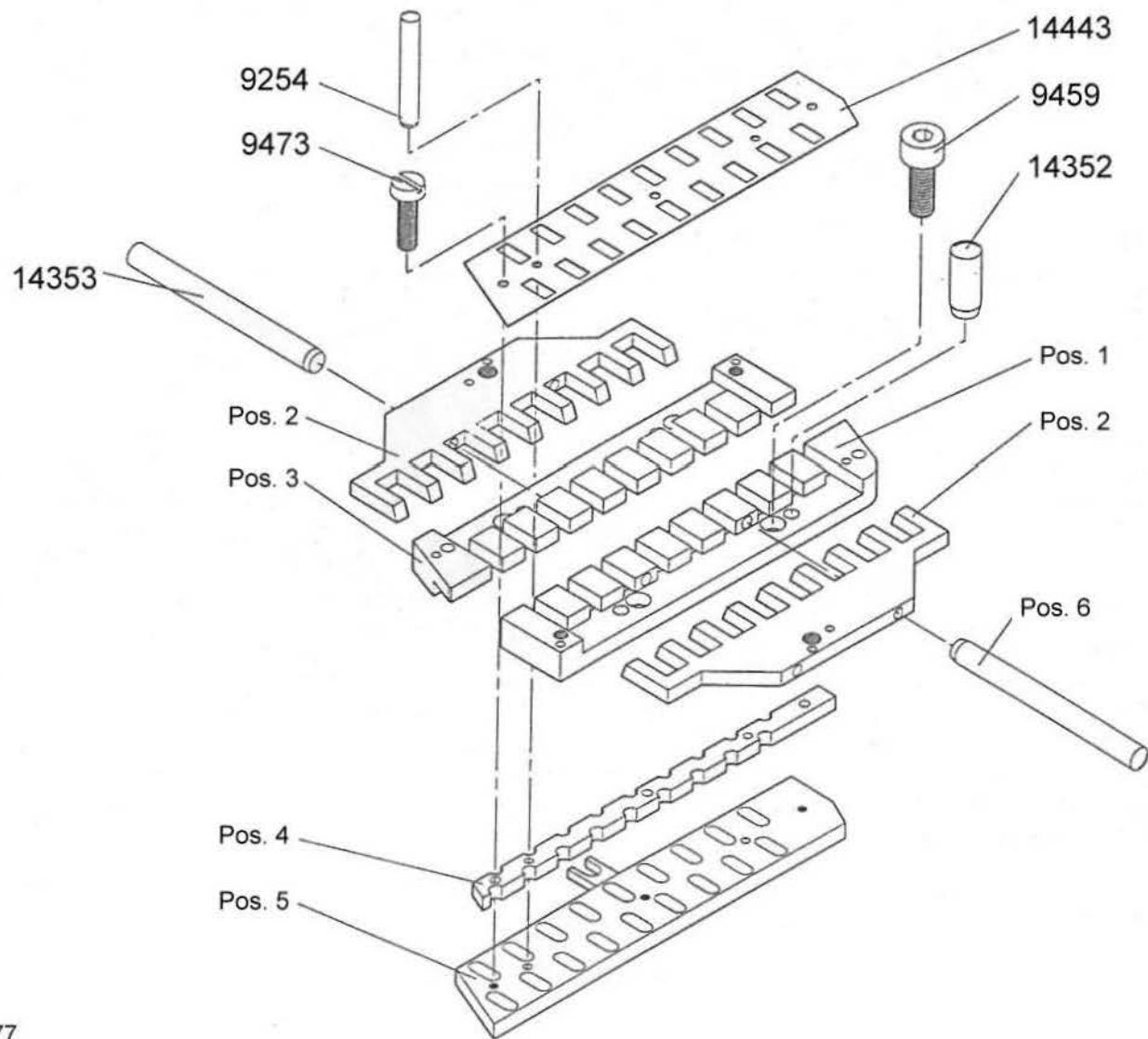
# Section 31: adjustable dosing disc



## Section 31.1: adjustable dosing disc

Capsule size	Dosing disc base (pos 1)	Dosing disc upper with ferrules (pos 3)	Ferrule (pos 2)	Key
00	14026	27053	13393	9621
0	14021	27054	9620	9621
1	14022	14023	13394	14018
2	14024	27055	13395	14018
3	14020	27056	13396	14018
4	14025	27057	13396	14018

# Section 32: dosing chamber after powder

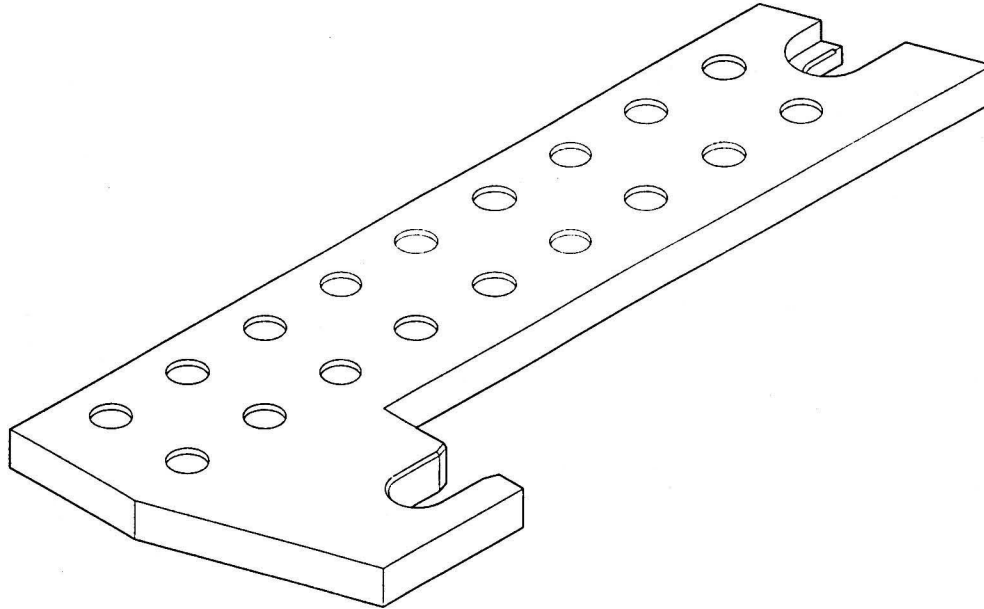


## Section 32.1: dosing chamber after powder

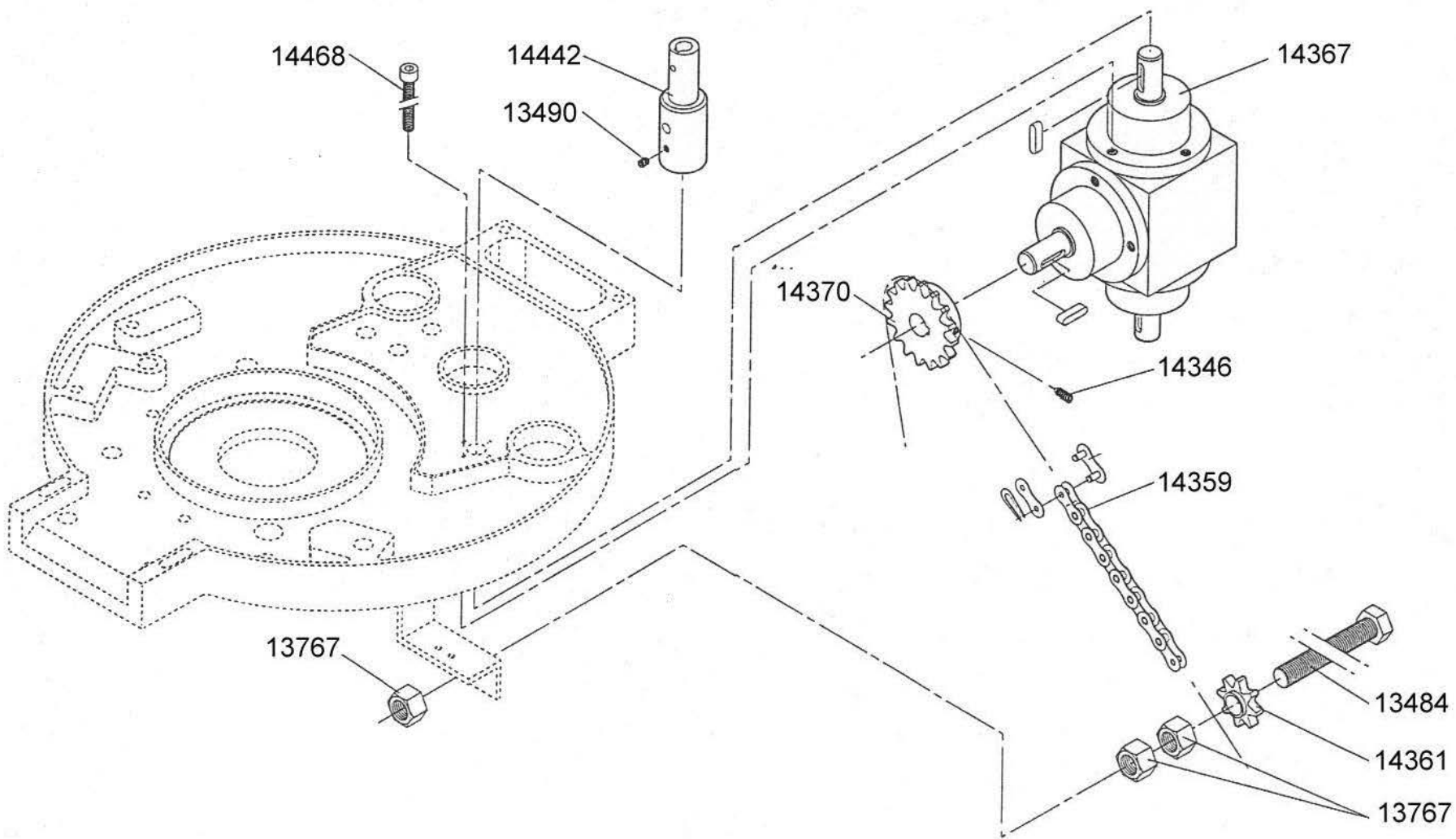
Part description	Pos.	5mm	8mm	10mm	15mm	20mm	21mm
Dosing chamber complete st 6	-	26999		30700	14393	30701	
Dosing chamber complete st 8	-	14375	14175	14394			14392
External guide	1	14391	14390	14389	14388		14387
Dosing comb	2	14386	14385	14384	14383		14382
Internal guide	3	14381	14380	14379	14378		14377
Spacer for slider	4	14376	14399	14398	14397		14396
Dosing slider	5	14395	14395	14395	14395		14395
Dowel pin	6	14353	9268	28208	28208		28208

## Section 33: exit plates, after powder

capsule size	IIM part no.
000	n/a
00	14444
0	14176
1	14445
2	14446
3	14177
4	14477



# Section 34: drive parts, pellet station 6



IIM

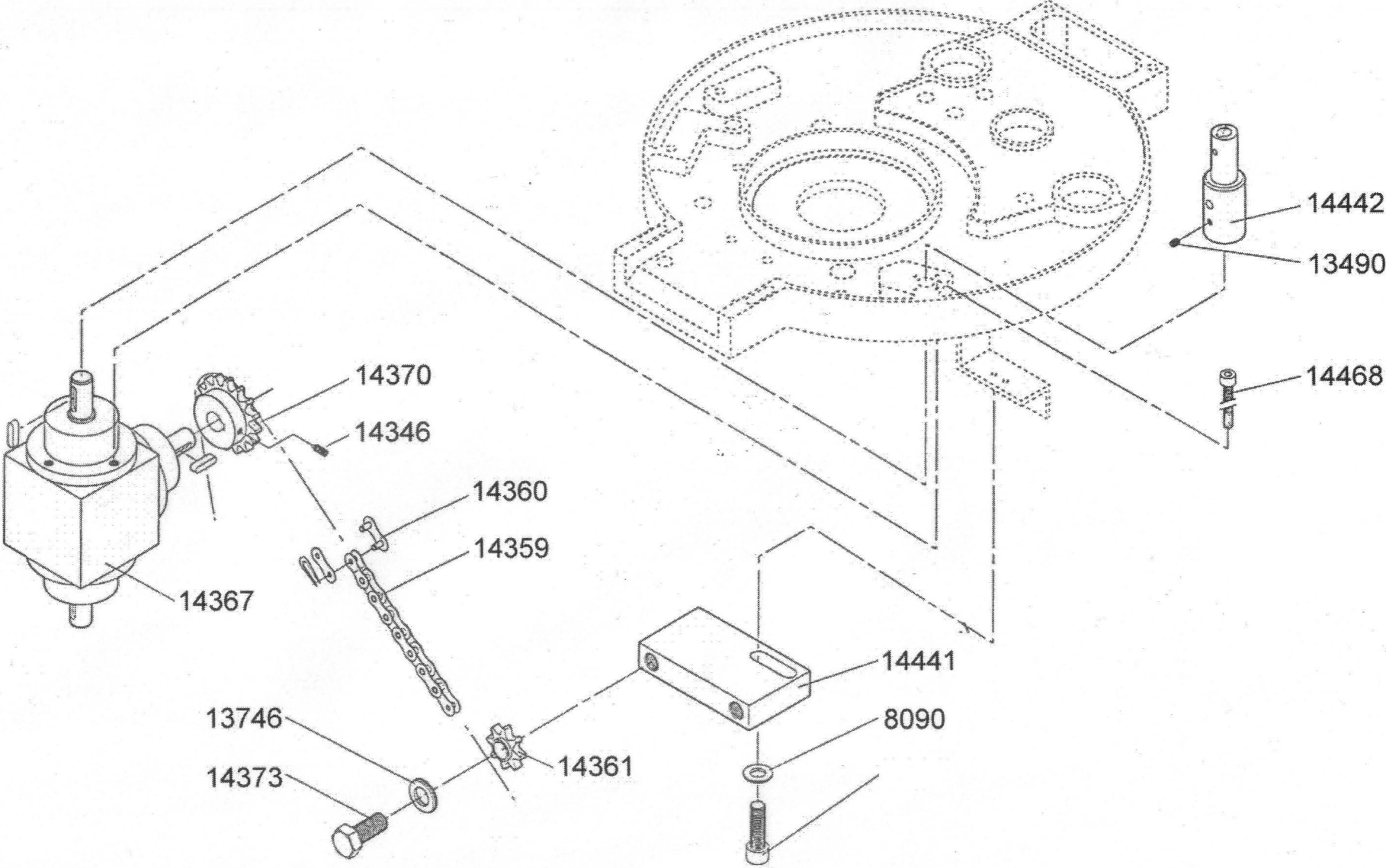
tel (336) 584-4777

fax (336) 584-9540

## Section 34: drive parts, pellet station 6

IIM no.	Description
13484	SCREW
13490	SET SCREW
13767	HEX NUT
14346	SET SCREW
14359	CHAIN
14361	SPROCKET
14367	GEARBOX
14370	SPROCKET
14442	POST
14468	SCREW, SOCKET HEAD CAP

# Section 35: drive parts, pellet station 8

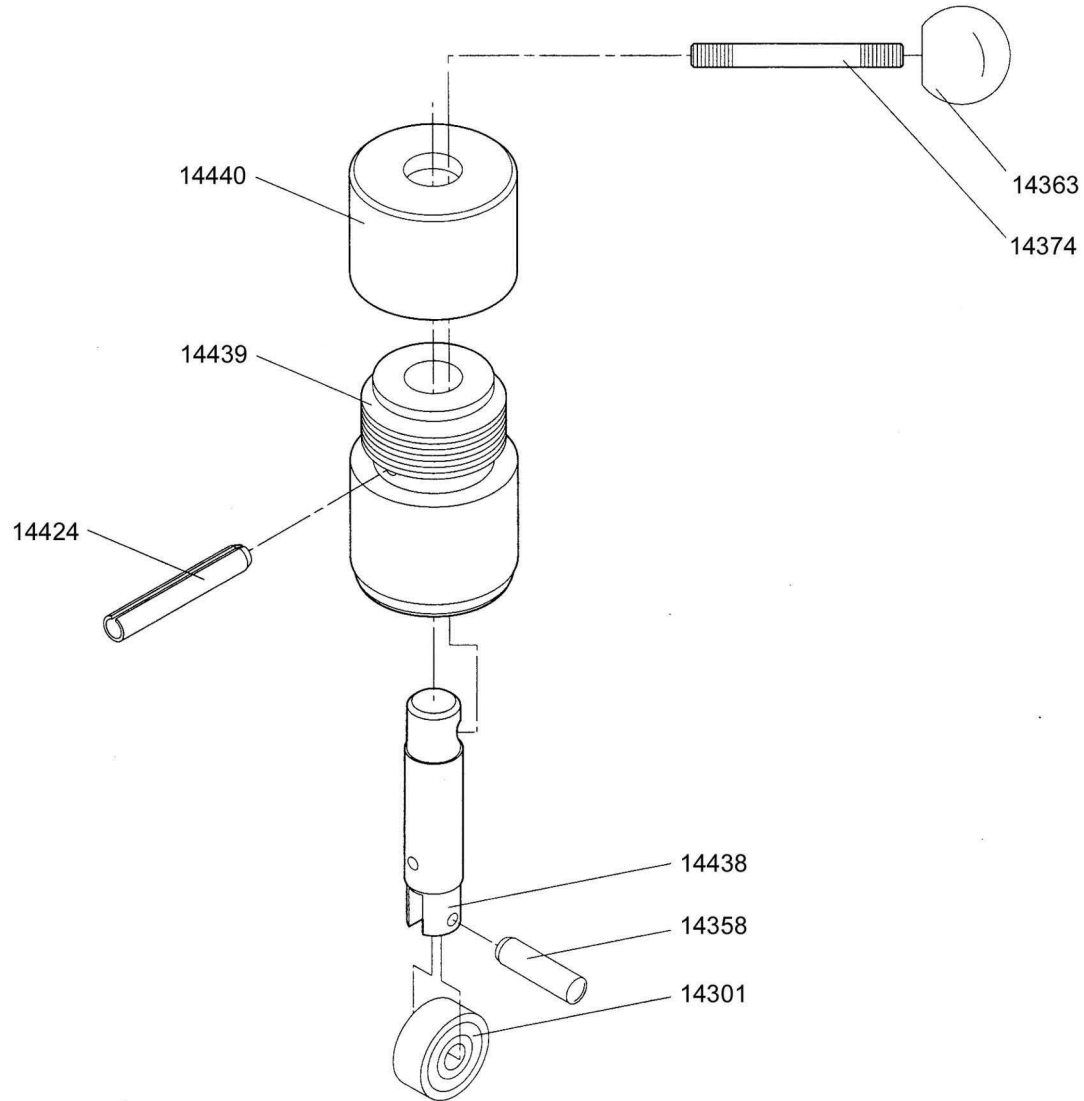




## Section 35: drive parts, pellet station 8

IIM no.	Description
8090	WASHER
13490	SCREW,SET
13746	WASHER
14346	SCREW,SET
14359	CHAIN
14360	CHAIN LINK
14361	SPROCKET
14367	GEARBOX
14370	SPROCKET
14373	SCREW
14441	BLOCK
14442	POST
14468	SCREW, SOCKET HEAD CAP

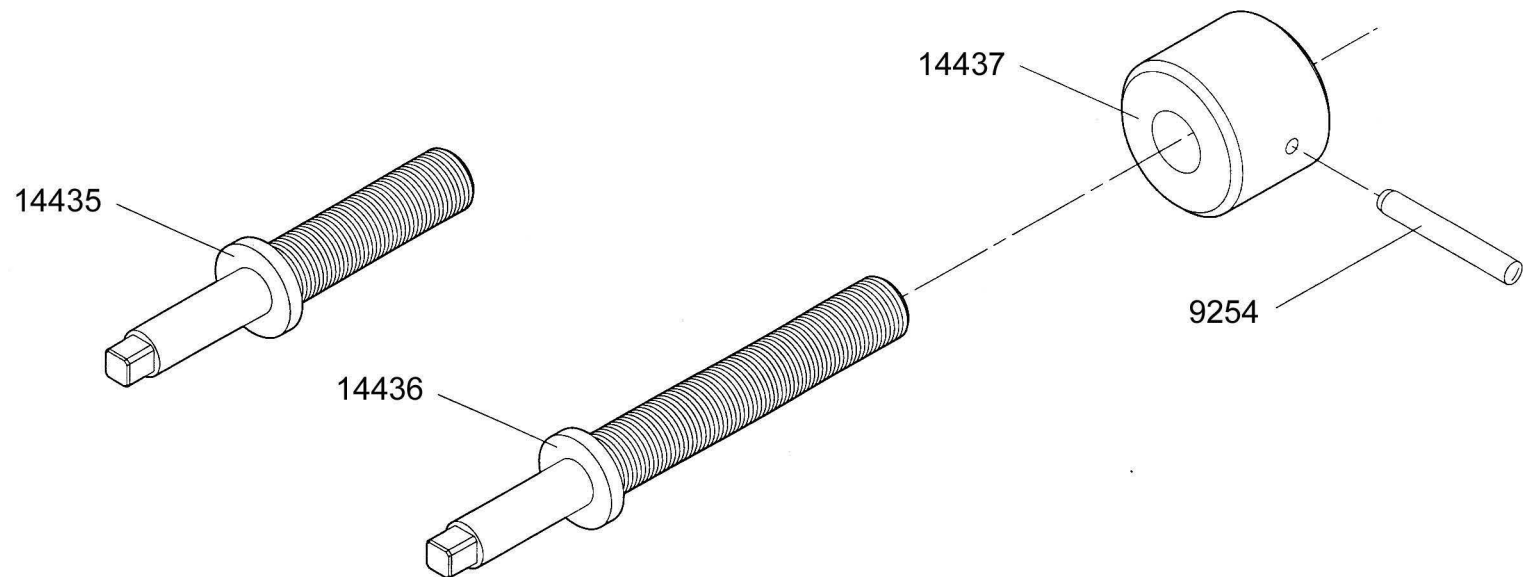
# Section 36: manual controls, pellet station



## Section 36: manual controls, pellet station

IIM no.	Description
14301	BEARING
14358	DOWEL PIN
14363	KNOB
14374	ROD,THREADED
14424	ROLL PIN
14438	SHAFT
14439	HOUSING
14440	COLLAR

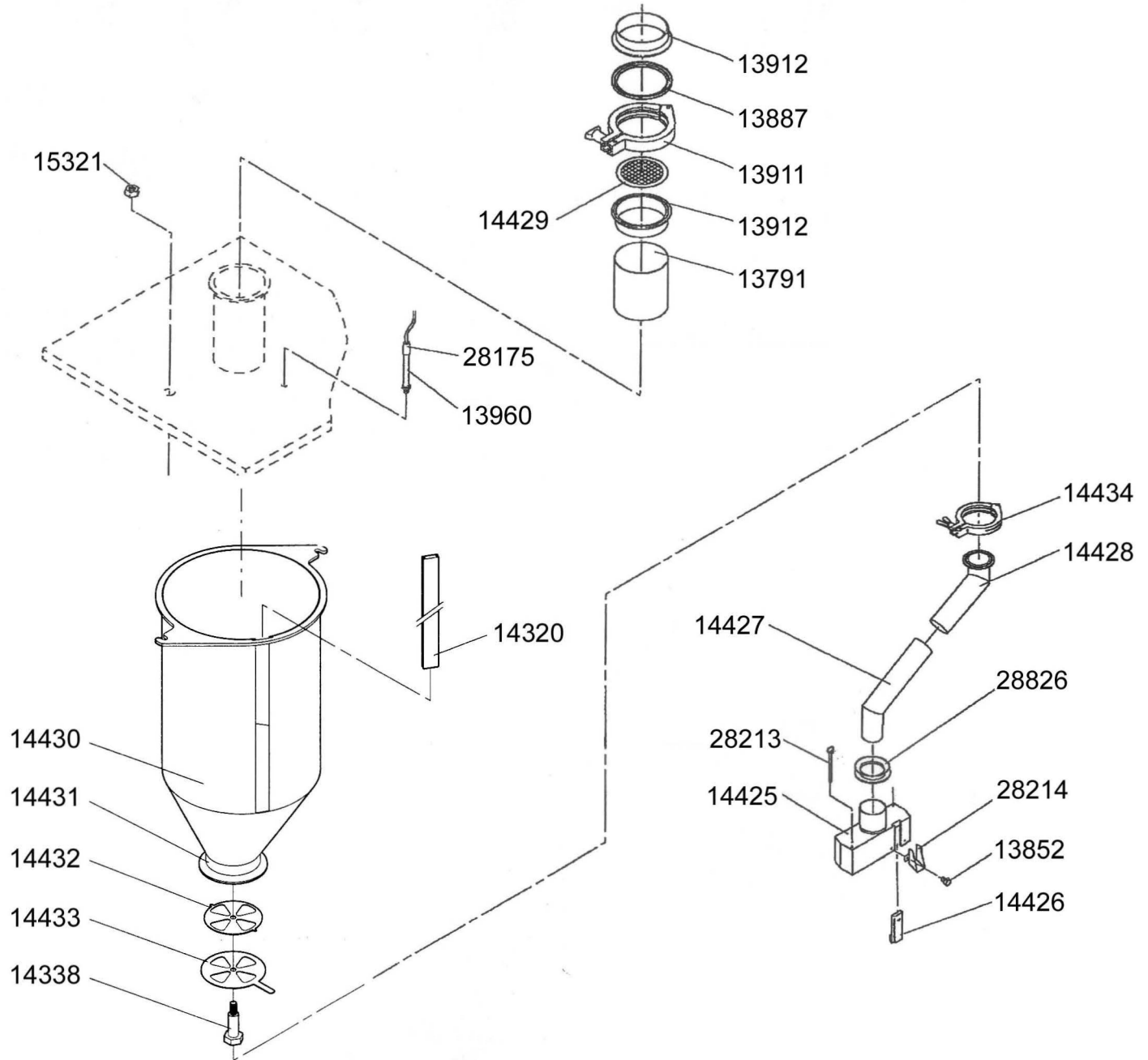
# Section 37: adjusting spindle, manual, before/after powder



Section 37: adjusting spindle, manual, before/after powder

IIM no.	Description
9254	DOWEL PIN
14435	SPINDLE, ADJUSTING
14436	SPINDLE, ADJUSTING
14437	COLLAR, ADJUSTING

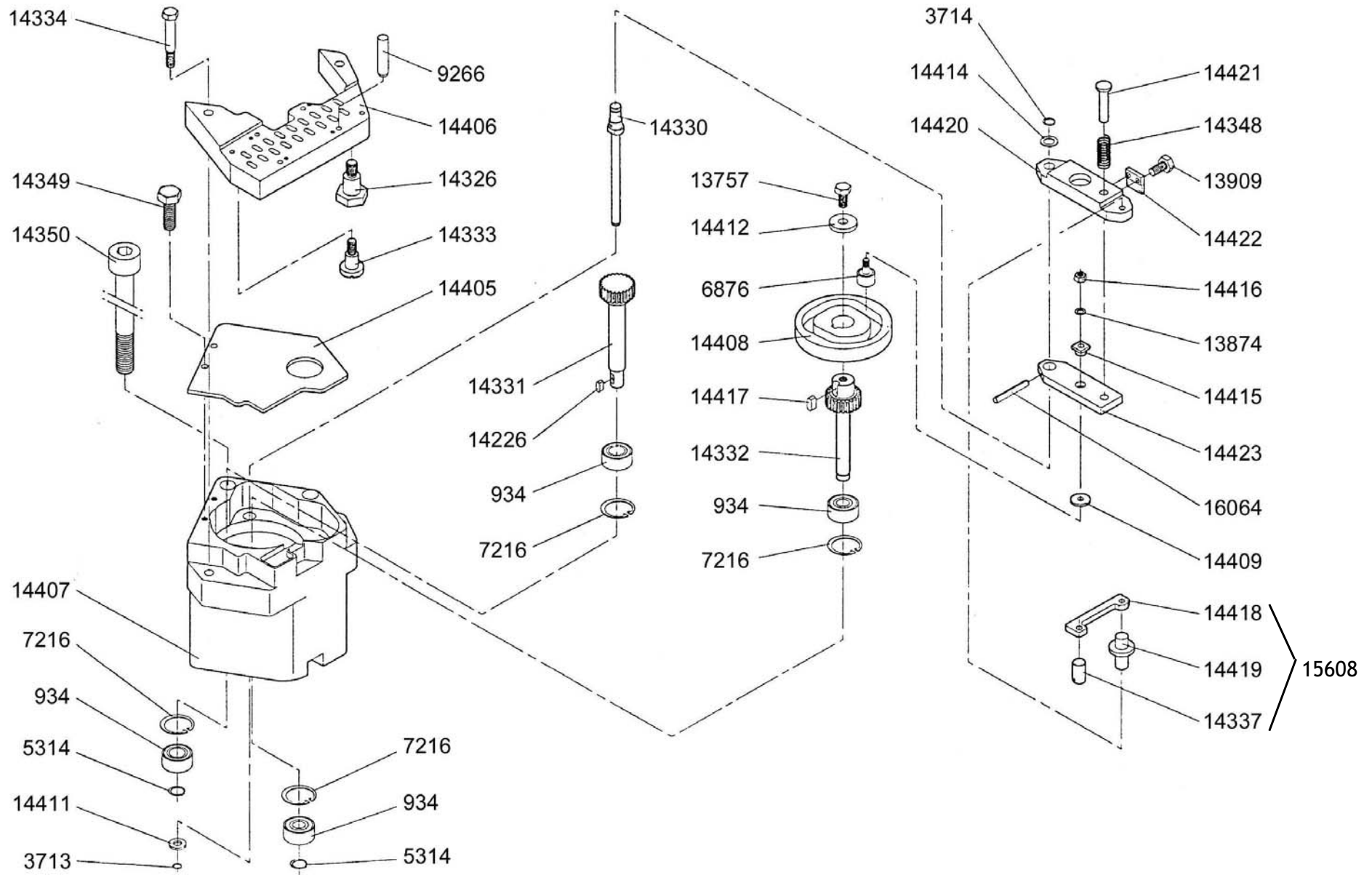
# Section 38: pellet infeed, station 6 or 8



## Section 38: pellet infeed, station 6 or 8

IIM no.	Description
13791	TUBE,110MM OD,CAPSULE SUPPLY
13852	SCREW
13887	GASKET
13911	CLAMP
13912	FERRULE
13960	SWITCH,PROX
14320	GLASS,SIGHT,PELLET HOPPER
14338	SCREW,SPECIAL,MODIFIED,HOPPER SHUT-OFF GATE
14425	ACCUMULATOR,INFEED,PELLET
14426	SIGHT GLASS
14427	TUBE,PELLET INFEED
14428	TUBE,PELLET INFEED
14429	SCREEN
14430	HOPPER,PELLET
14431	COLLAR,HOPPER
14432	DISK,FIXED,FEED CONTROL
14433	DISK,ADJ,FEED CONTROL
14434	CLAMP,TUBE
15321	NUT, M8, WITH NYLON INSERT
28175	CABLE, LEVEL SENSOR
28213	SCREW
28214	CHUTE, PELLET INFEED ACCUMULATOR
28826	V-RING, VITON

# Section 39: pellet filling station, after powder (pos 6 and pos 8)

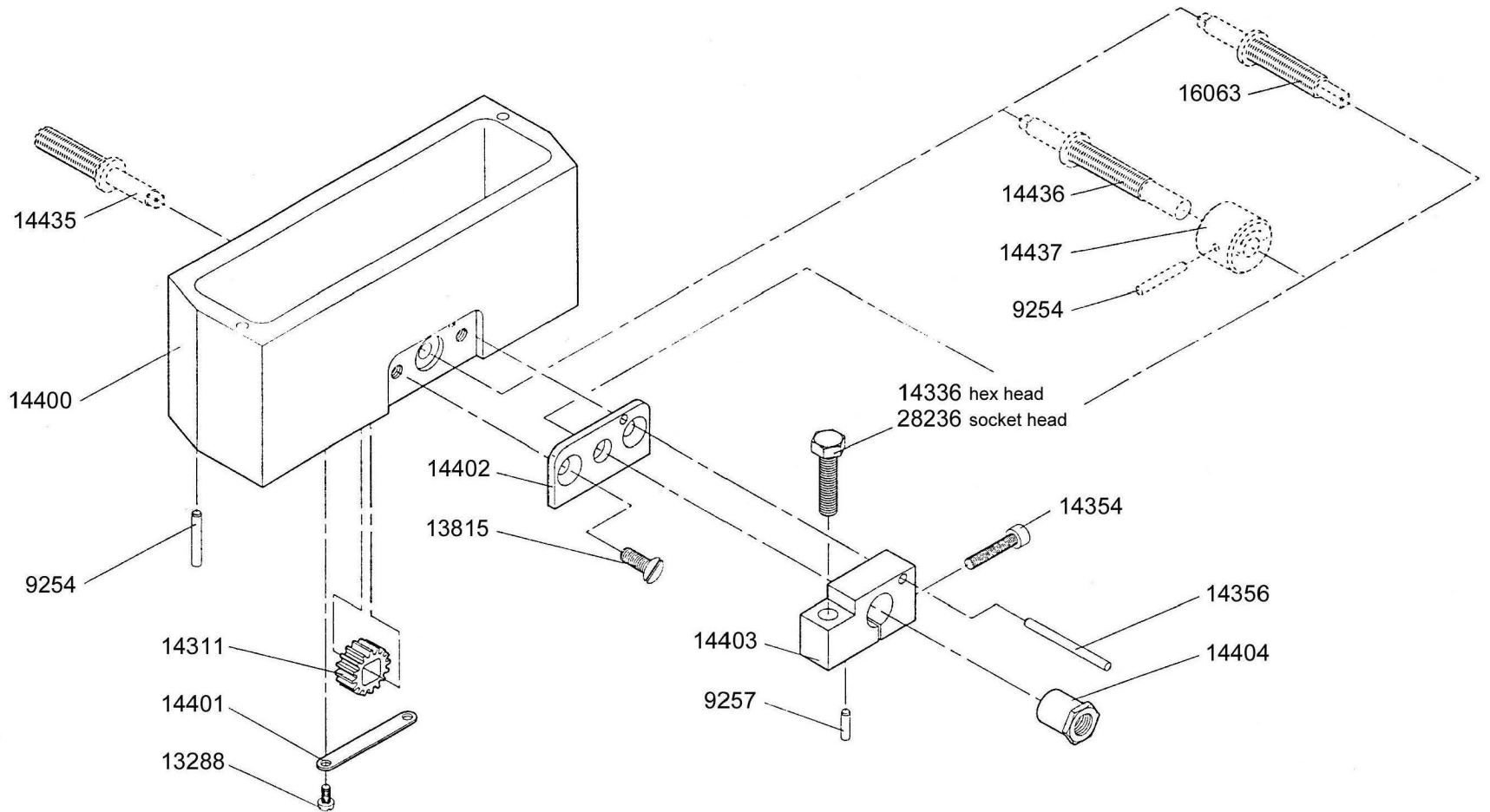




## Section 39: pellet filling, after powder (position 6 and 8)

IIM no.	Description
934	BEARING
3713	RETAINING RING, EXTERNAL
3714	RETAINING RING, EXTERNAL
5314	RETAINING RING, EXTERNAL
6876	CAM FOLLOWER
7216	RETAINING RING, INTERNAL
9266	DOWEL PIN
13757	SCREW,HEX
13874	WASHER,M6,SERRATED
13909	SCREW
14226	KEY,5 X 5 X 12
14326	SCREW,SHOULDER,8MM OD X 9MM LONG,S/S
14330	SHAFT, BEAD FEED
14331	SHAFT, WITH GEAR
14332	SHAFT, WITH GEAR
14333	SCREW,SHOULDER,6MM OD X 3MM LONG,S/S,M5
14334	SCREW,SHOULDER
14337	PIN,DOWEL,MODIFIED,BEAD FEED SHUTTLE (part of 15608)
14348	SPRING,COMPRESSION,PELLET FEED SHUTTLE
14349	SCREW,HEX
14350	SCREW,SOCKET HEAD CAP
14405	PLATE
14406	CHAMBER,LOWER,PELLET FEED
14407	HOUSING
14408	CAM
14409	WASHER
14411	WASHER
14412	WASHER
14414	SHIM
14415	SPACER
14416	NUT
14417	KEY
14418	ARM,LATERAL SLIDE (part of 15608)
14419	PIN (part of 15608)
14420	BLOCK
14421	PIN
14422	PLATE,LUG
14423	PLATE
16064	PIN
15608	LINK,BEAD FEED SHUTTLE ASSY,STA.6

# Section 40: pellet hopper complete, after powder



## Section 40: pellet hopper complete, after powder

IIM no.	Description
9254	PIN,DOWEL
9257	PIN,DOWEL
13288	SCREW,CHEESEHEAD
13815	SCREW
14311	GEAR,BEAD FEED CHAMBER ADJUSTMENT
14336	SCREW,HEX
14354	SCREW
14356	PIN,DOWEL
14400	HOPPER,FILL,PELLET
14401	CROSS PIECE
14402	PLATE
14403	BLOCK
14404	COLLAR,THREADED
14435	SPINDLE,ADJUSTING
14436	SPINDLE,ADJUSTING
14437	SPINDLE,ADJUSTING
16063	COLLAR,ADJUSTING
28236	SCREW, SHOULDER

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7095	10
7570	28
7689	4
7937	5
7940	2
7958	1
7959	5
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