

SELECT

MRT-1073 (02/26/14) **Z Screw Maintenance Gen 2 Gantry**

Tool List:

Safety Glasses
 Standard Allen Wrench Set
 Precision Screwdriver Slotted
 Phillips Screwdriver
 Sharp Knife
 Wire Strippers
 Dust Mask
 Rubber Gloves
 Soldering Iron




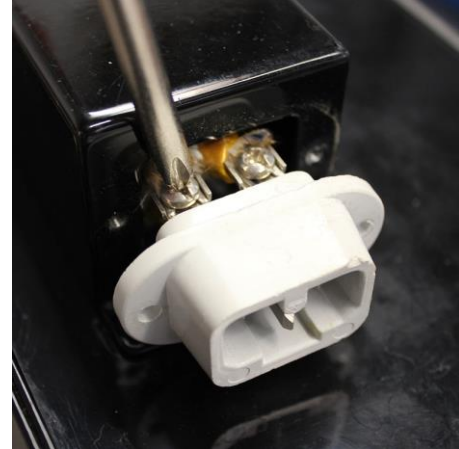
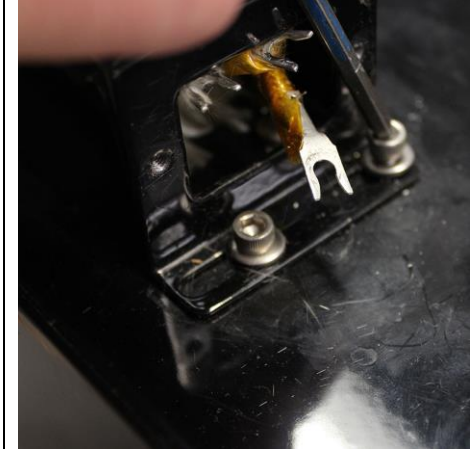
NOTE: If the solder pot will not heat see heater trouble shooting ATD-1072

“Before starting this procedure empty the Solder from the Pot.”

MAKE SURE TO SAVE ALL PARTS!

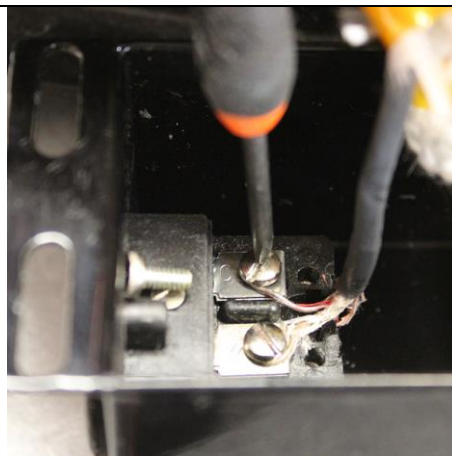
“Always wear safety glasses while performing maintenance on Nordson SELECT solder pots”

1. Heater & T/C Removal

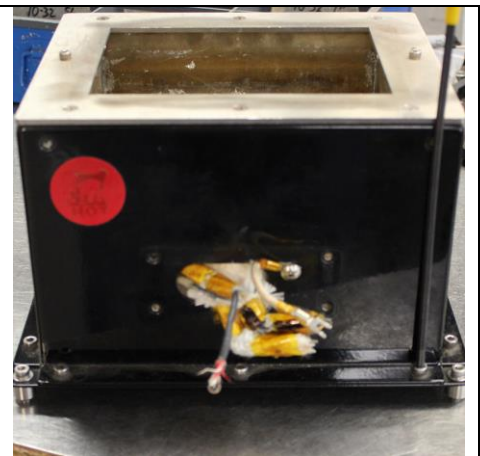
		
<p> Remove flat blade plug using a 3/32nd Allen wrench removing the 4-40 3/8” screw w/ washer (2X) Save all parts! </p>	<p> Remove wires (3X) using a Phillips screwdriver loosen screws ONLY! Save plug - P/N E0429 </p>	<p> Remove J Box from shell using a 9/64 Allen wrench 8-32 5/16 screw w/washer (4X) Save all parts! </p>



**Remove Cover from
T/C Jack** Using a Precision
screwdriver as seen.
Save all parts!

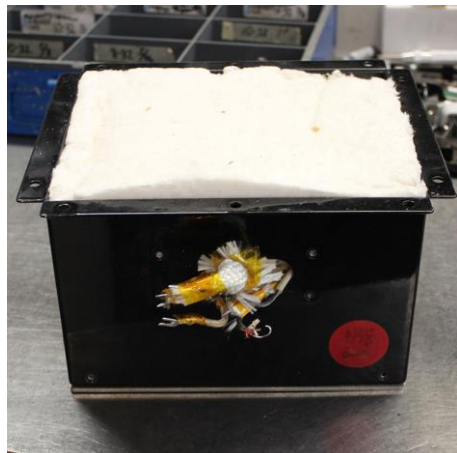


**Remove wires from
T/C Jack** Using a Precision
screwdriver and set **J box**
aside.
Save all parts!
T/C Jack P/N E0060



Remove screws 10-32 1/4"
(10X) from bottom cover.
Using a 5/32 Allen wrench
As shown.
Save ALL parts!

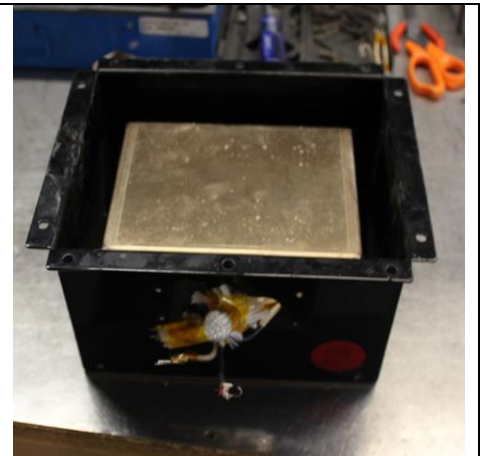
"Always wear safety glasses, dust mask and rubber gloves while working with insulation."



**Turn pot over and remove
bottom cover.**
The insulation will be exposed.
**Wear dust mask and rubber
gloves!**

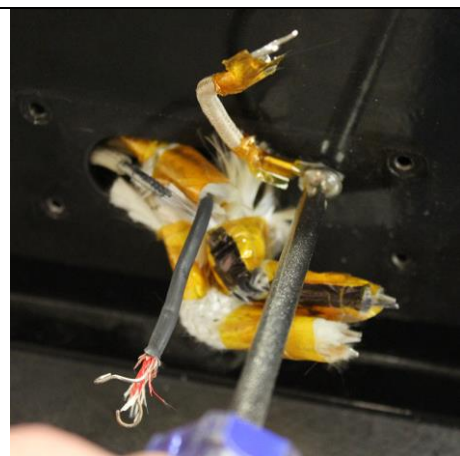


Remove insulation from tank.
Use a large screwdriver to slide
pieces out as seen.
Save all insulation.
**Wear dust mask and rubber
gloves!**

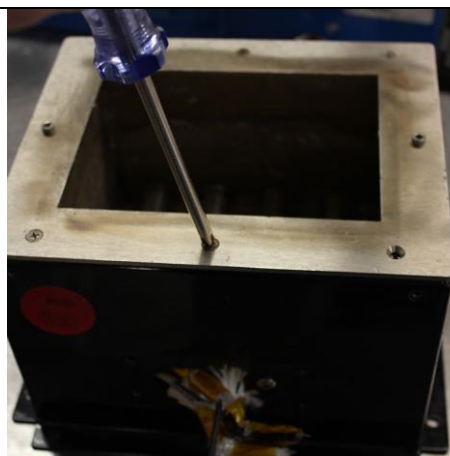


Remove all insulation,
As shown.
Save all insulation.

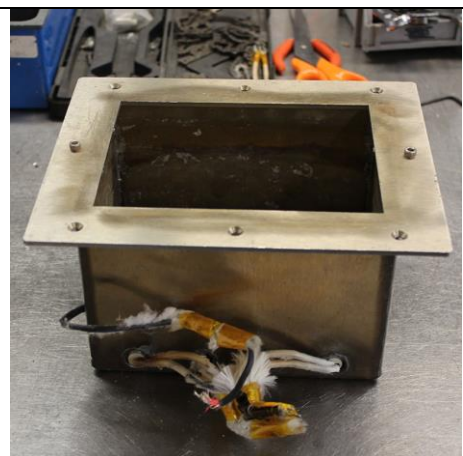
"Always wear Safety Glasses, Dust Mask and Rubber Gloves while working with insulation."



Loosen ground wire screw and remove ground wire. Save ground wire!



Remove screws from tank using Phillips screwdriver removing 8-32 3/8 phil flat screws. (6X) Save Screws.

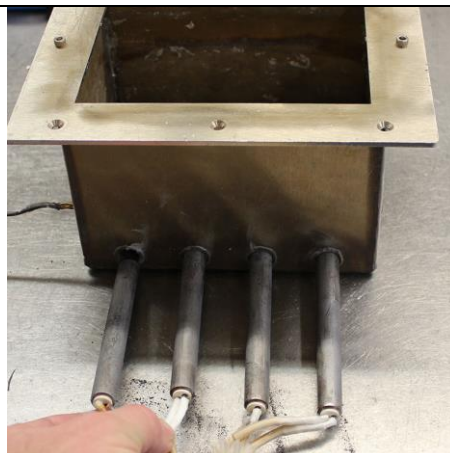


Remove tank from shell. Wear dust mask and rubber gloves!

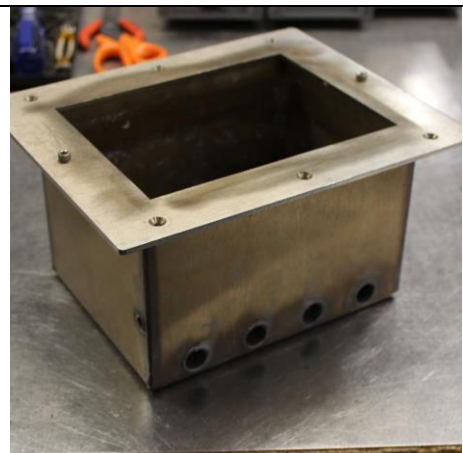
NOTE: When replacing thermocouple ONLY- Do not remove heaters!



When replacing thermocouple remove T/C from tank and throw away. P/N E0059.1

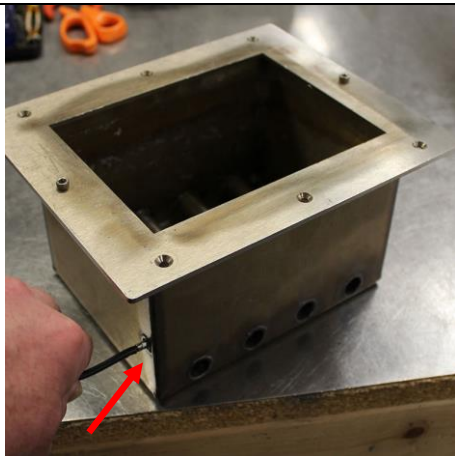


When replacing heaters remove heaters from tank and throw away. P/N E0058

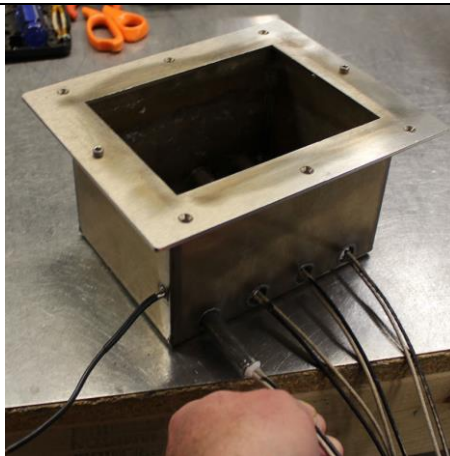


Check tank for any visible solder leaks! P/N 10000201 Lead Alloy P/N 10000201T Lead Free

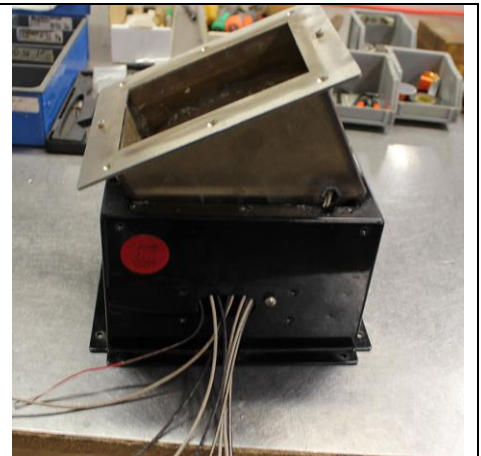
2. Installing Heaters & Thermocouple



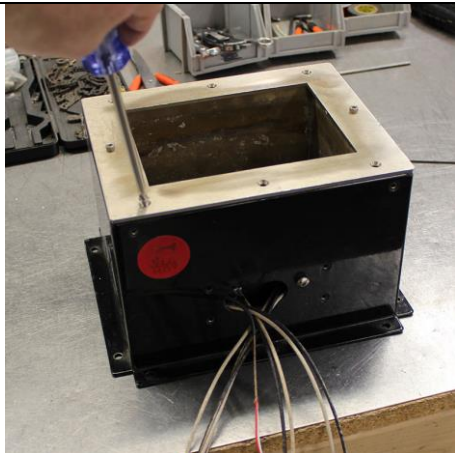
Install T/C to the proper side of the tank. As Shown



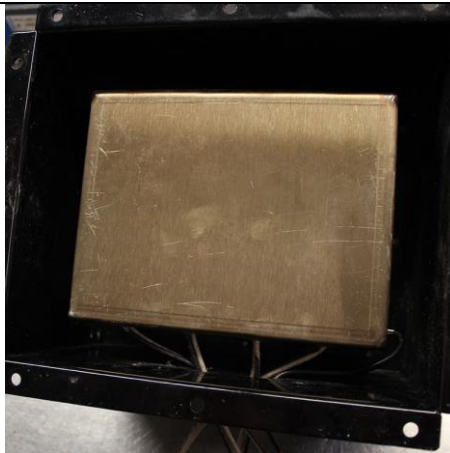
Slide the pre-coated heaters into the tank. The thermocouple tube must be facing front!



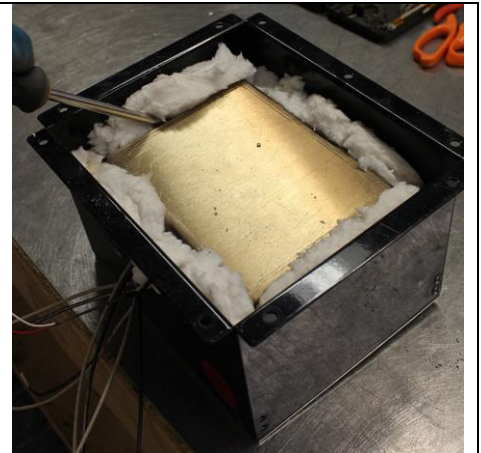
Form wires and T/C and slide tank into shell.



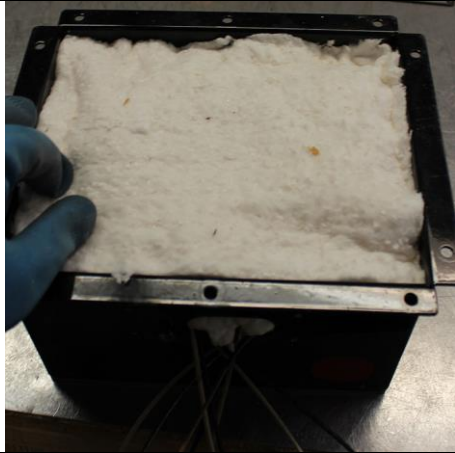
Secure tank to the shell using the 8-32 3/8" phil flat screws. (6X)



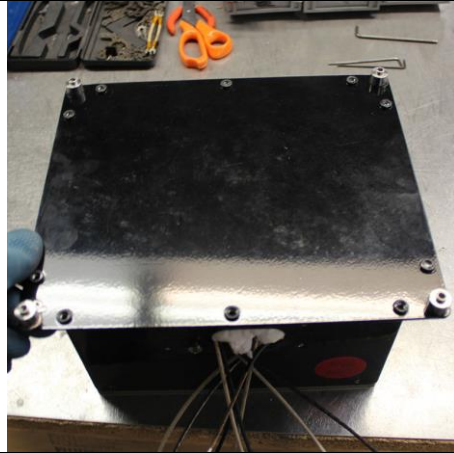
Turn pot over and adjust wires if needed. Make sure heaters are properly aligned.



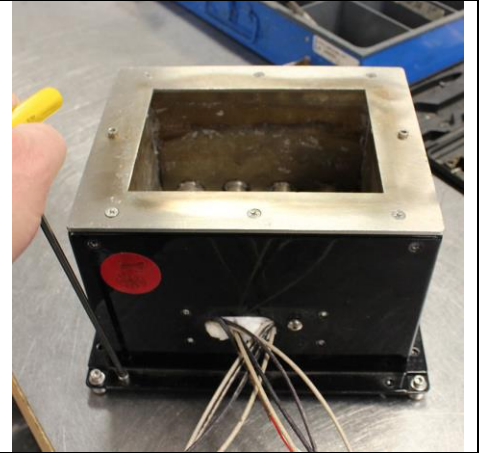
Insert Insulation
Use a large screwdriver to slide pieces in as seen.
Form the wires away from the tank!



Place bottom section of insulation in solder pot.

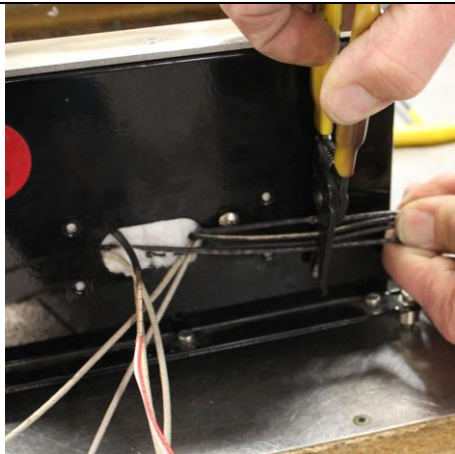


Place bottom cover on solder pot and flip over.

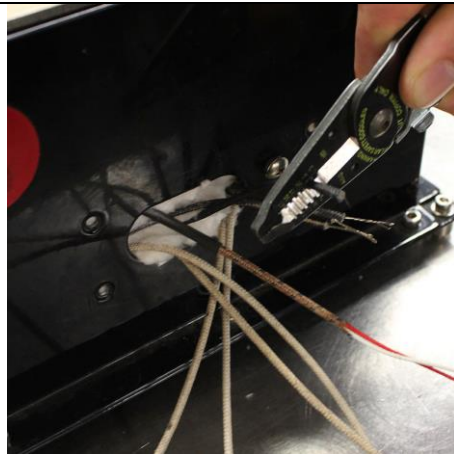


Secure bottom cover to solder pot using 5/32" Allen wrench using 10-32 1/4 screws. (10X)

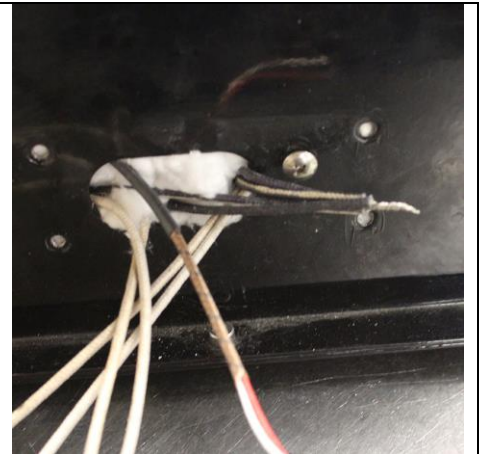
NOTE: Separate black wires from the white wires!



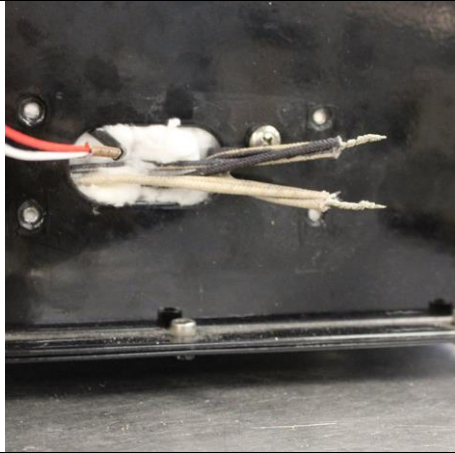
Cut Heater Wires
Wires must extend past the J Box holes 1 inch.
As shown.



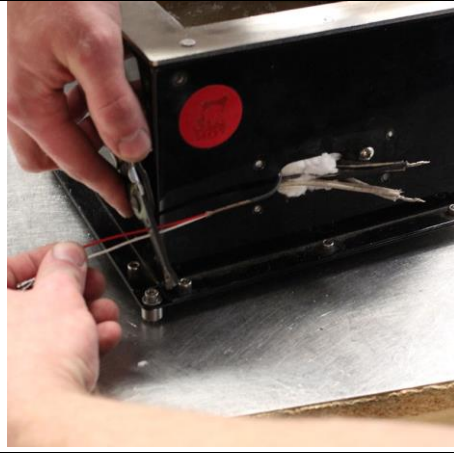
Trim to expose approx. 1/2" of each wire.
As shown.



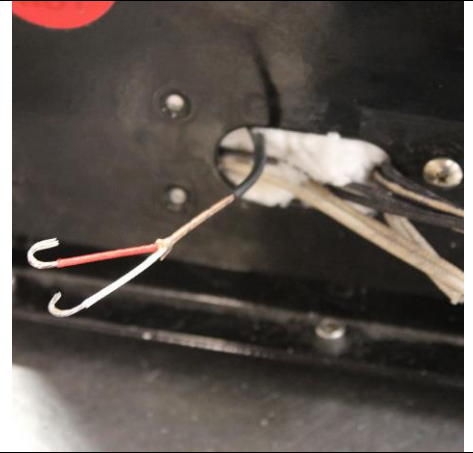
Twist wires firmly together.
NOTE: Only the black wires and they must go past the J Box holes to the right!



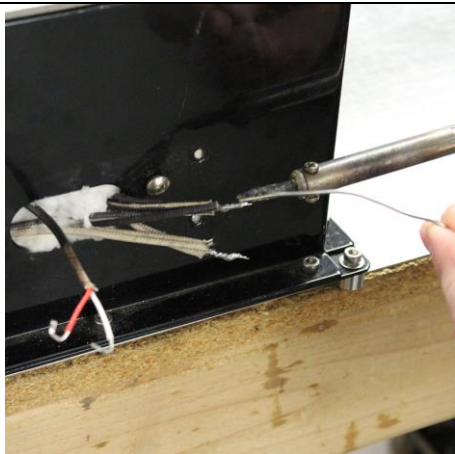
Repeat above steps to the **white Wires!**
NOTE: The direction of that the wires are formed!



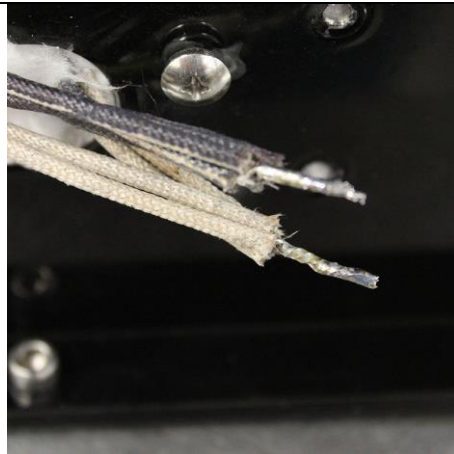
Cut the T/C wire approx. 4 inches long, as shown.



Trim ¼ inch and form the T/C wires as seen.



Add flux then solder wires (2X) to make a proper connection.

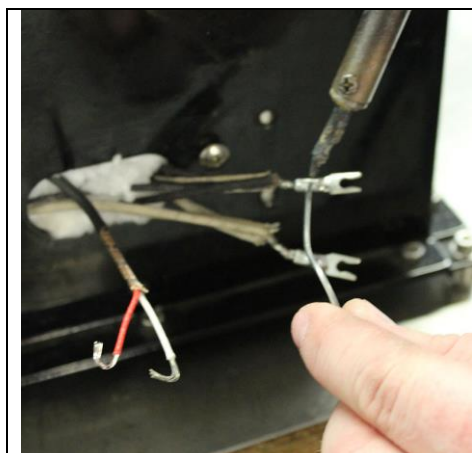


Verify both wires are properly soldered! And let cool.

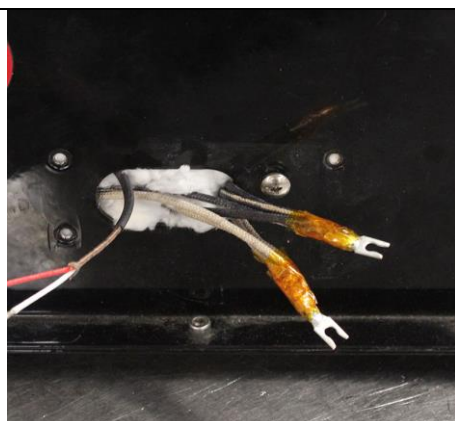


Crimp #6 spades (2X) onto each soldered wire as seen.

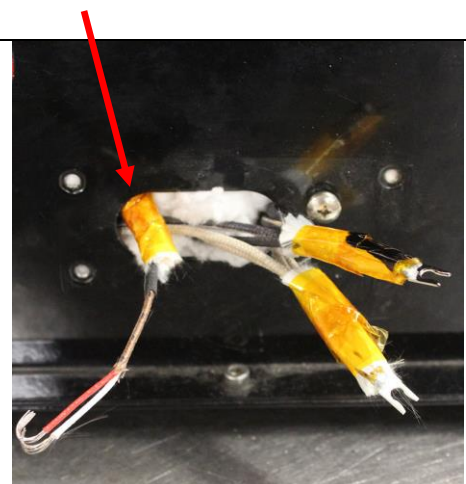
NOTE: Position T/C insulation braid into tank as seen!



**Add flux then solder spades to wires. (2X)
Let Cool!**

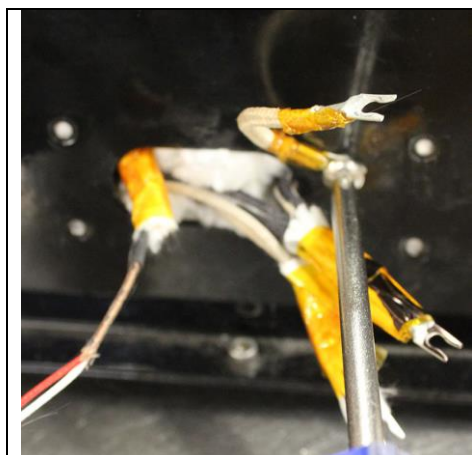


Wrap exposed wires in Kapton tape as seen. (2X)

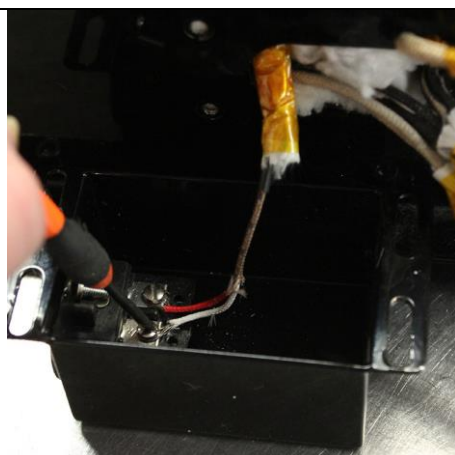


Slide insulation braid over the 3 wires. Wrap with Kapton tape and mark the **black wires with a **black** marker. Position T/C braid, as shown.**

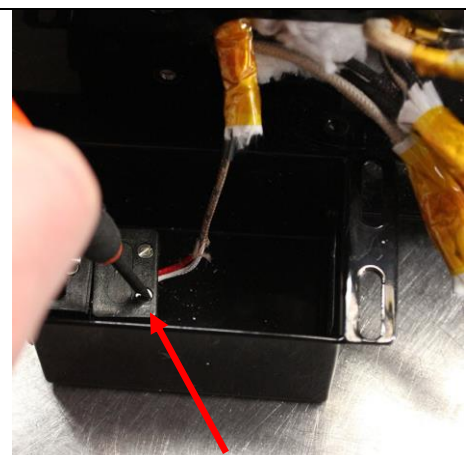
NOTE: When adding J Box make sure the T/C Jack is to the left!



**Connect ground wire securing the #8 spade to the pot.
As shown.**

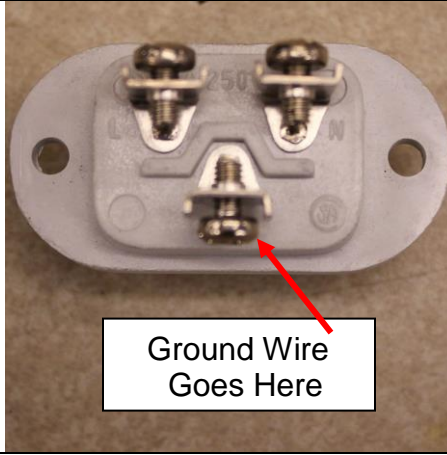
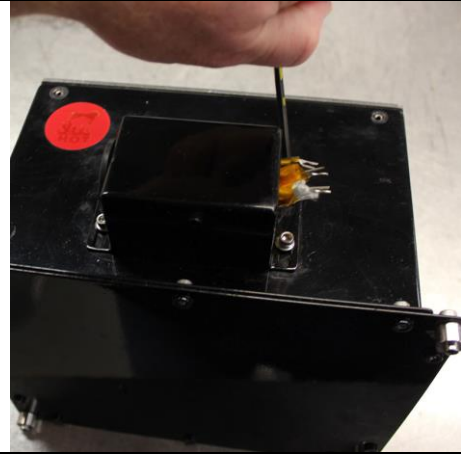


**Attach T/C wires to T/C Jack on J Box
As shown. Using a precision screwdriver.
Red wire goes to large jack side!**

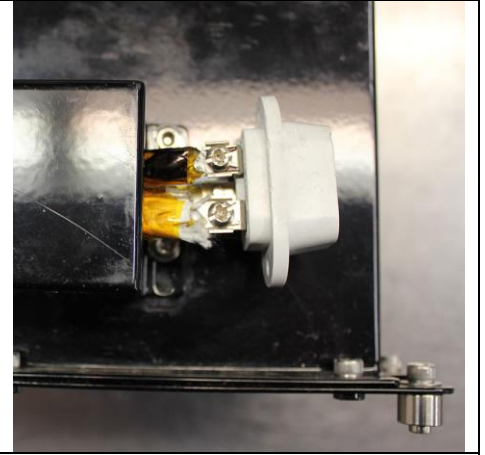


**Attach cover to T/C Jack using a precision screwdriver.
As shown.**

NOTE: Slide J Box in the down position!



Ground Wire
Goes Here

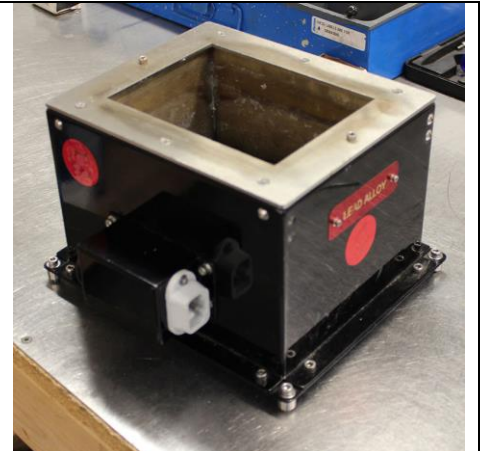


Install J Box to solder pot.
Using 8-32 5/16 screws w/
washers. (4X)
Also 9/64 Allen wrench
slide J Box down!
**Make sure wires go thru
hole!**

**Black wire goes to L
White wire goes to N
Ground wire goes to
Ground symbol**

**Attach flat blade plug to wires
(#6 Spades) using a Phillips
screwdriver, as seen.**

NOTE: Plug has to be in the proper orientation!



**Properly secure plug to J
Box using 4-40 5/16 screws
w/washers (2X) and 5/64th
Allen wrench.**

Using an Ohm Meter on **200
Ohm** setting measure the
plugs, as shown.
The range s/b **17-18 ohms.**

**Completed Nordson SELECT
solder pot!**

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