

Nordson

SELECT

MRT-1071 (10/23/13) Standard Solder Pot Gen 2 Heater & T/C Replacement

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!

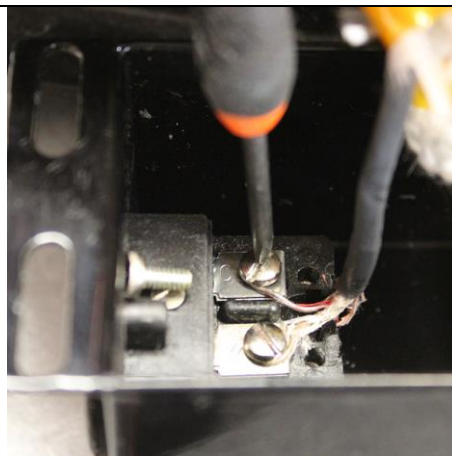
“Always wear safety glasses while performing maintenance on Nordson SELECT solder pots”

1. Heater & T/C Removal

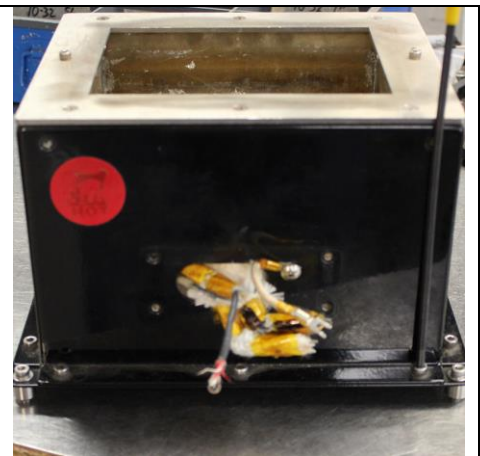
<p>Remove flat blade plug using a 3/32nd Allen wrench removing the 4-40 3/8” screw w/ washer (2X) Save all parts!</p>	<p>Remove wires (3X) using a Phillips screwdriver Loosen screws ONLY! Save plug - P/N E0429</p>	<p>Remove J box from shell Using a 9/64 Allen wrench 8-32 5/16 screw w/washer (4X) Save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



Remove cover from T/C Jack Using a precision screwdriver as seen.
Save all parts!

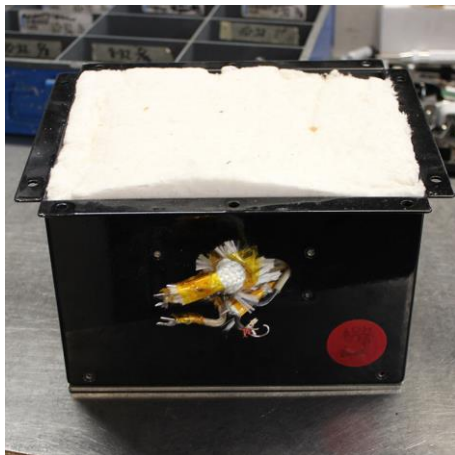


Remove wires from T/C Jack using a precision screwdriver and set **J box** aside.
Save all parts!
T/C Jack P/N E0060



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

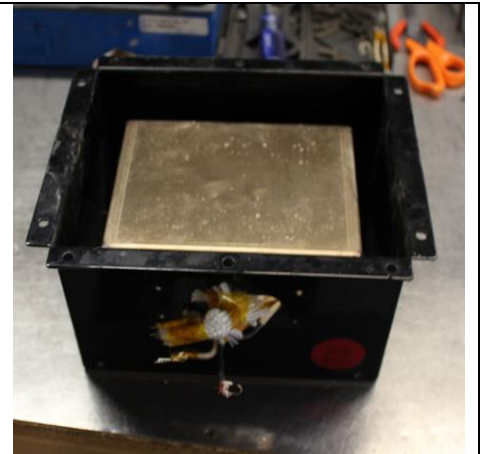
"Always wear safety glasses, dust mask and rubber gloves while working with insulation"



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

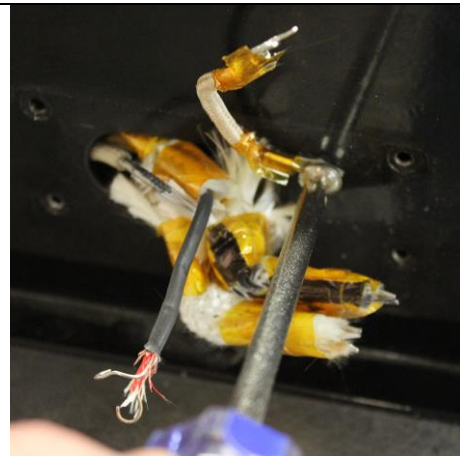


Remove insulation from tank. Use a large screwdriver to slide pieces out as seen.
Save all insulation.
Wear dust mask and rubber gloves!

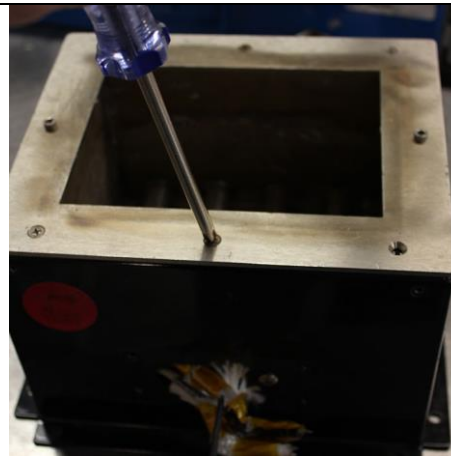


Remove all insulation, as shown.
Save all insulation.

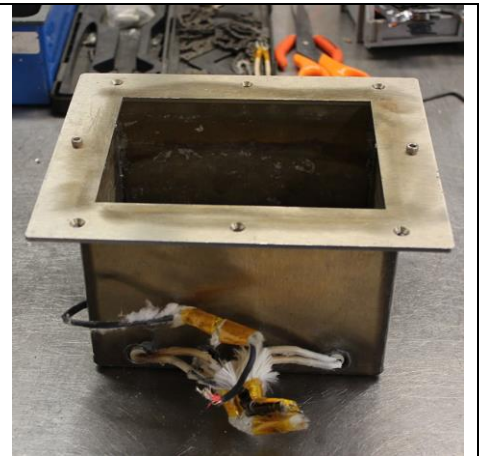
“Always wear safety glasses, dust mask and rubber gloves while working with insulation.”



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

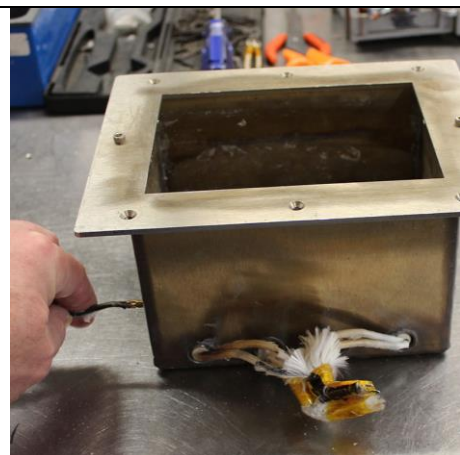


Remove screws from tank
Using Phillips screwdriver
removing 8-32 3/8 phil flat
screws. (6X) Save screws.

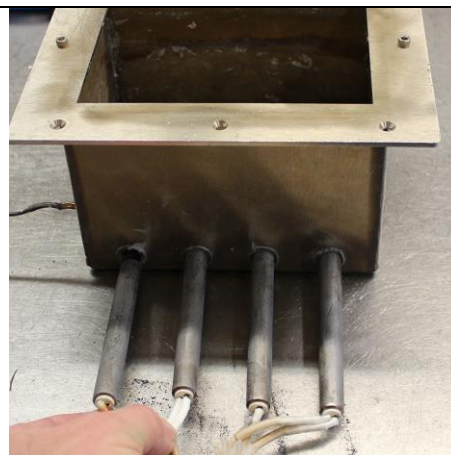


**Remove tank from shell,
wear dust mask and rubber
gloves!**

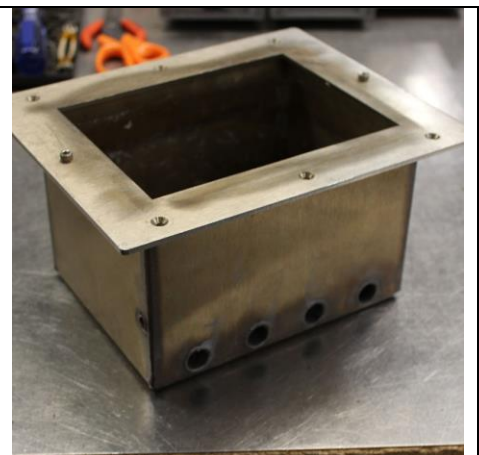
NOTE: When replacing thermocouple ONLY – do not remove heaters!



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

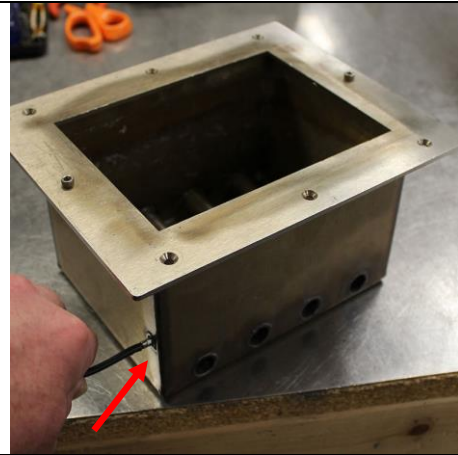


**When replacing heaters,
remove heaters from tank
and throw away.
P/N E0058**

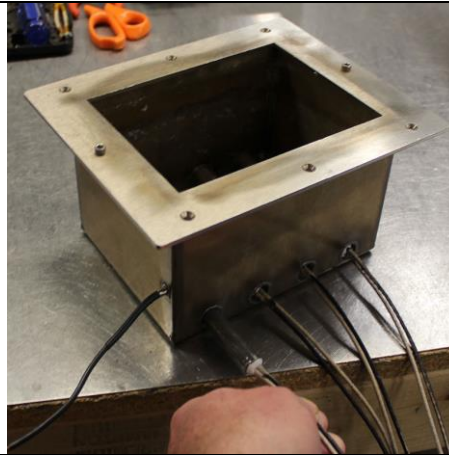


**Check tank for any visible
solder leaks!**
P/N 10000201 Lead Alloy
P/N 10000201T Lead Free

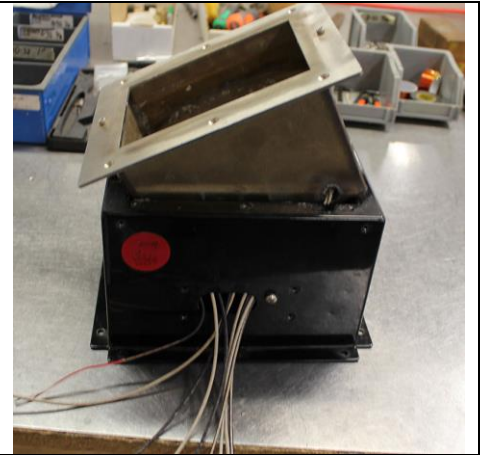
2. Installing Heaters & Thermocouple (put a light coat of anti-seize on the heaters & T/C)



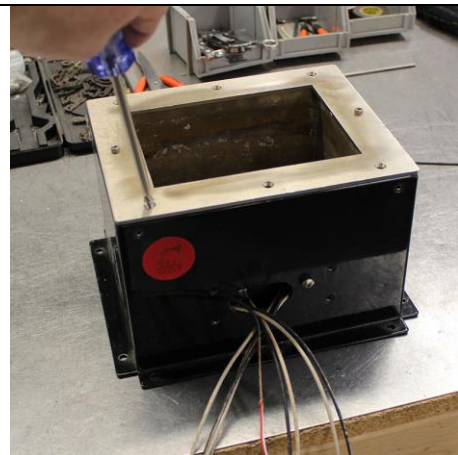
Install coated T/C to the proper side of the tank.
As Shown



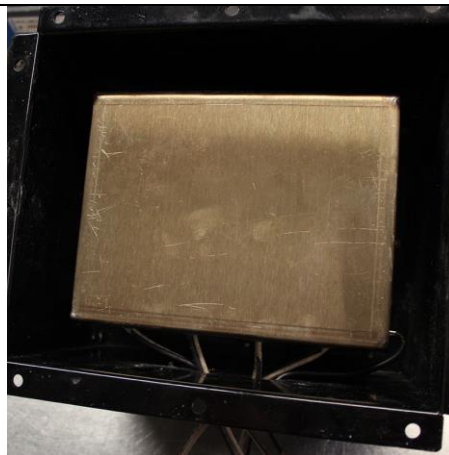
Slide the coated heaters into the tank. The thermocouple tube must be facing front!



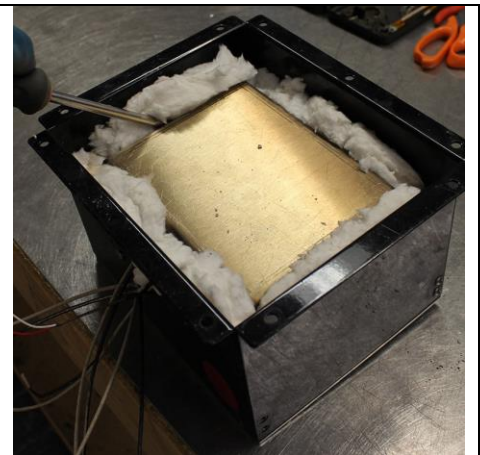
Form wires and T/C and slide tank into shell.



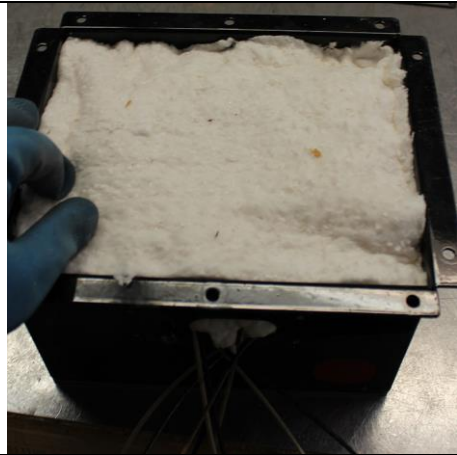
Secure tank to the shell
using the 8-32 3/8" phil flat screws. (6X)



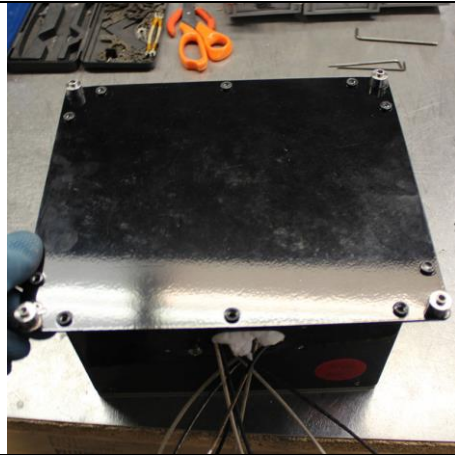
Turn pot over and adjust wires if needed.
Make sure heaters are properly aligned.



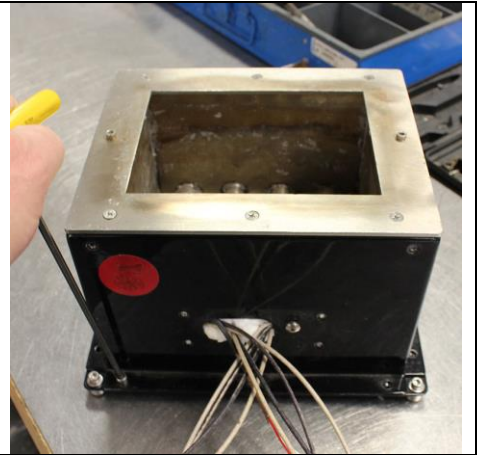
Insert Insulation
Use a large screwdriver to slide pieces in as seen.
Form the wires away from the tank!



Place bottom section of insulation in solder pot.

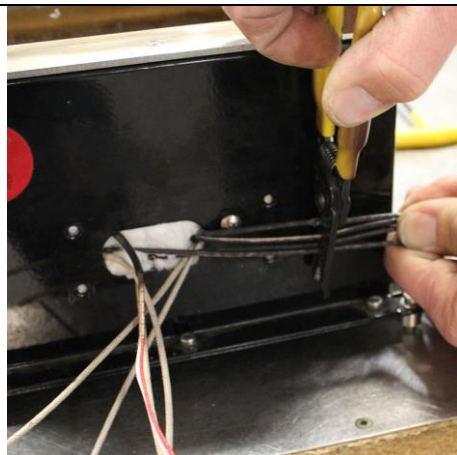


Place bottom cover on solder pot and flip over.

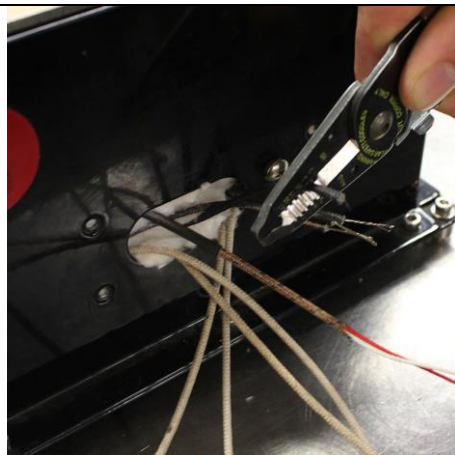


Secure bottom cover to solder pot using 5/32" Allen wrench and 10-32 1/4 screws. (10X)

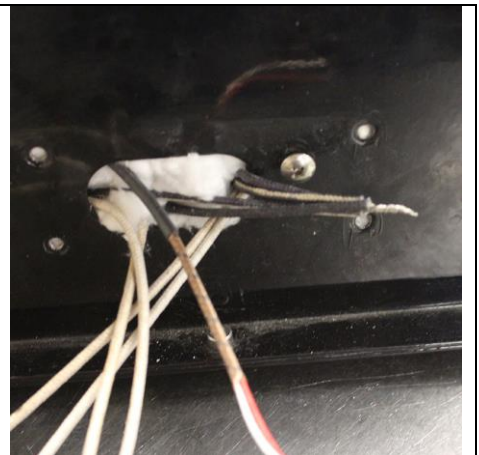
NOTE: Separate black wires from the white wires!



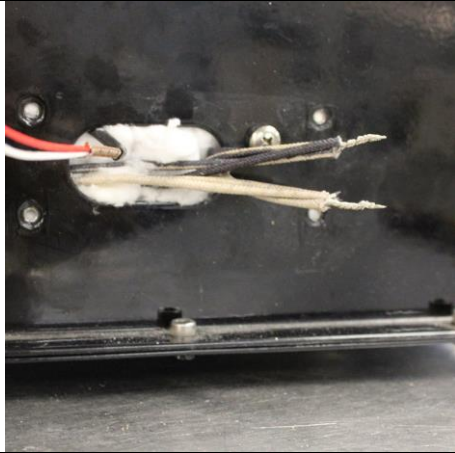
Cut Heater Wires
Wires must extend passed the J box holes 1 inch.
As shown.



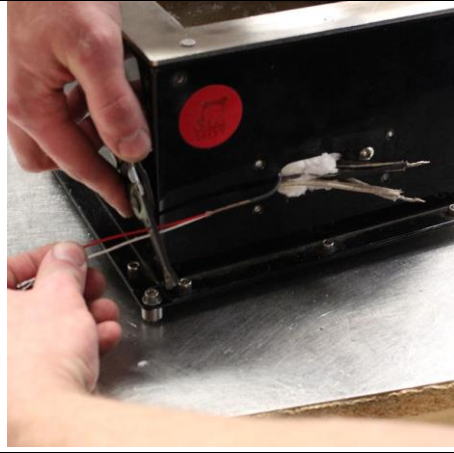
Trim to expose approx. 1/2" of each wire.
As shown.



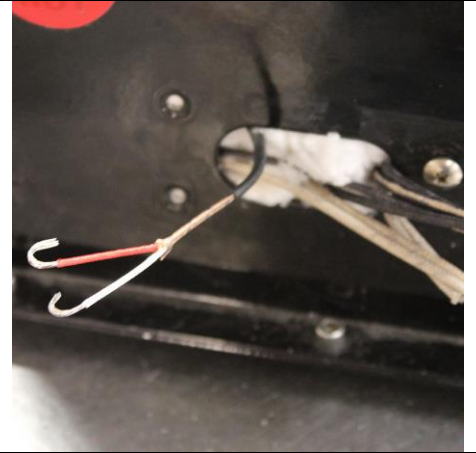
Twist wires firmly together.
NOTE: Only the black wires and they must go past the J box holes to the right!



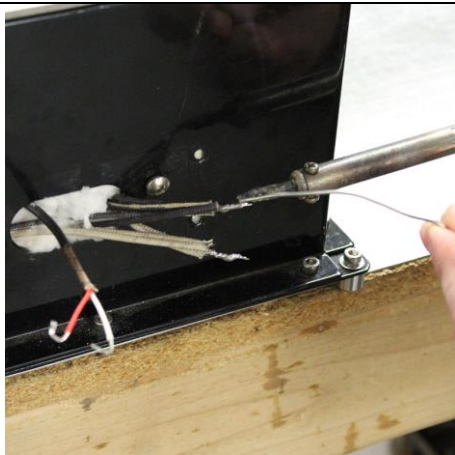
Repeat above steps to the **white** wires!
NOTE: The direction of that the wires are formed!



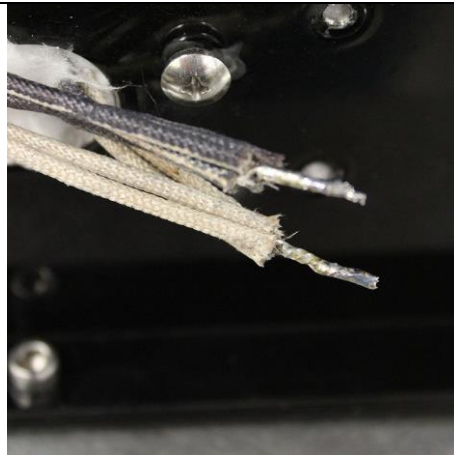
Cut the T/C wire approx. 4 inches long, as shown.



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



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

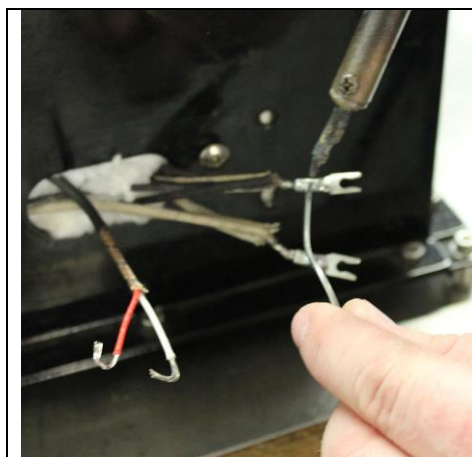


Verify both wires are properly soldered! Let cool.

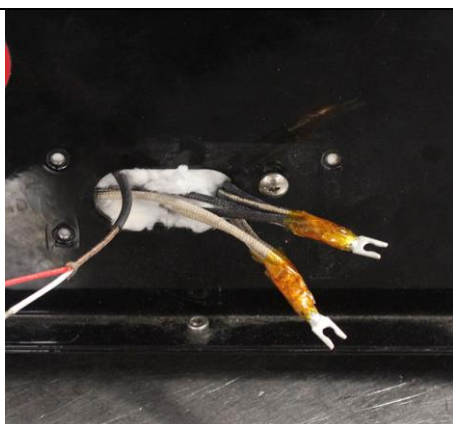


Crimp #6 spades (2X) onto each soldered wire as seen.

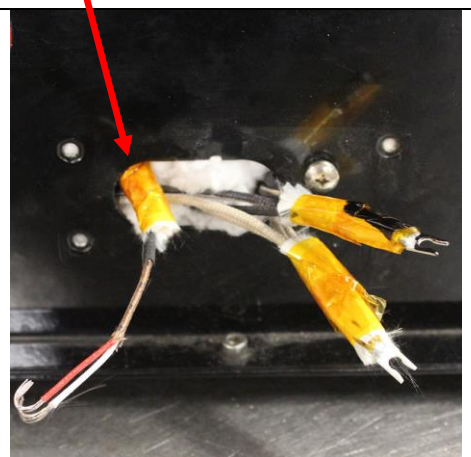
NOTE: Position T/C insulation braid into tank as seen!



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

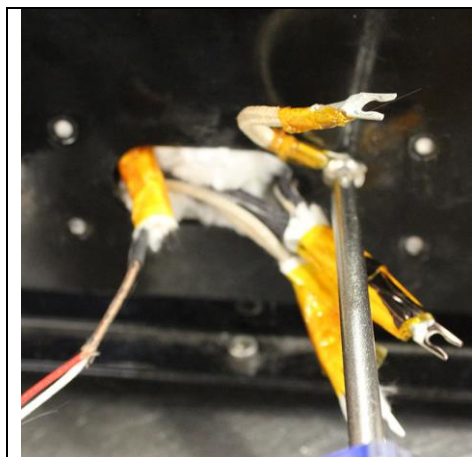


Wrap exposed wires in Kapton tape as seen. (2X)

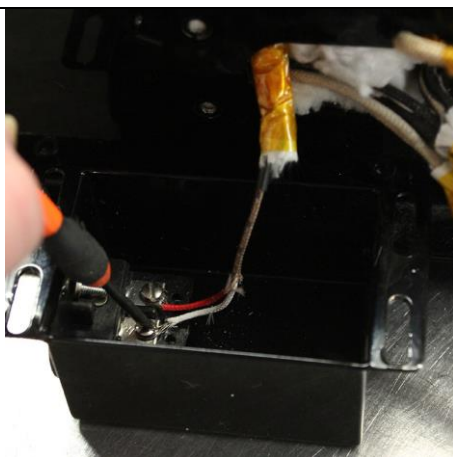


Slide insulation braid over the 3 wires. Wrap with Kapton tape and mark the **black wires with a **black** marker. Position T/C braid as shown.**

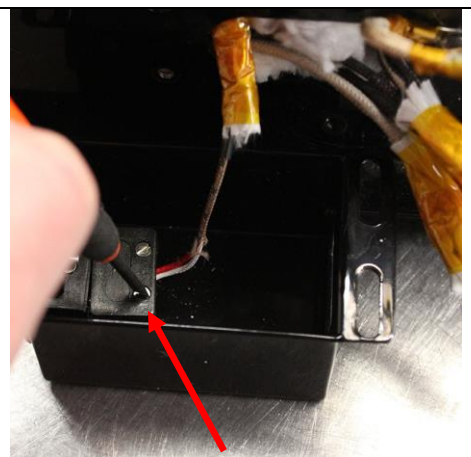
NOTE: When adding J box, make sure the T/C Jack is to the left!



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

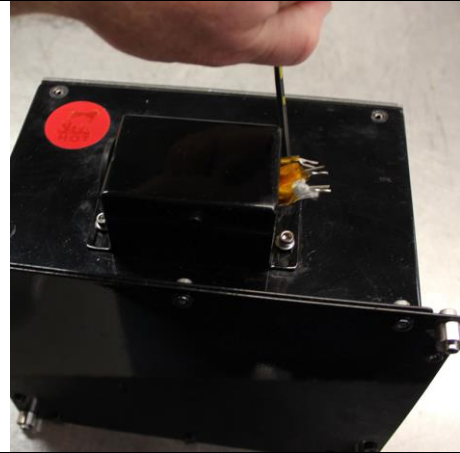


Attach T/C wires to T/C Jack on J box.
As shown. Using a precision screwdriver. **Red wire goes to large jack side!**

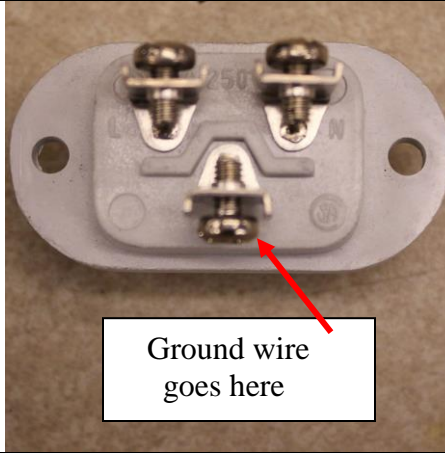


Attach cover to T/C Jack
using a precision screwdriver.
As shown.

NOTE: Slide J box in the down position!

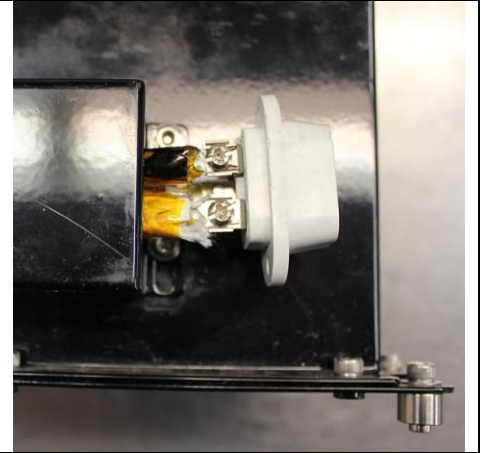


Install J box to solder pot
using 8-32 5/16 screws w/
washers (4X) also 9/64 Allen
wrench. Slide J box down!
Make sure wires go thru
hole!



Ground wire
goes here

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.

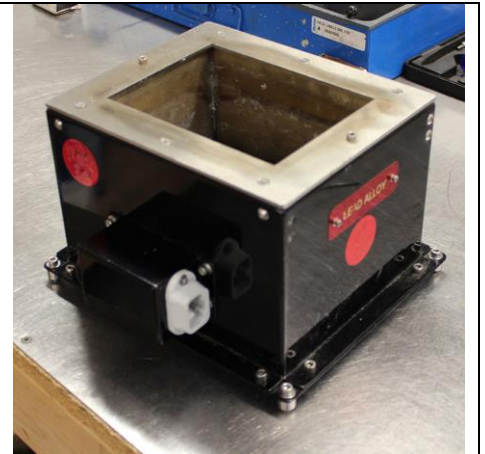
NOTE: Plug must be in the proper orientation!



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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