SYSTEMS, INC.

ENGINEERING NOTICE

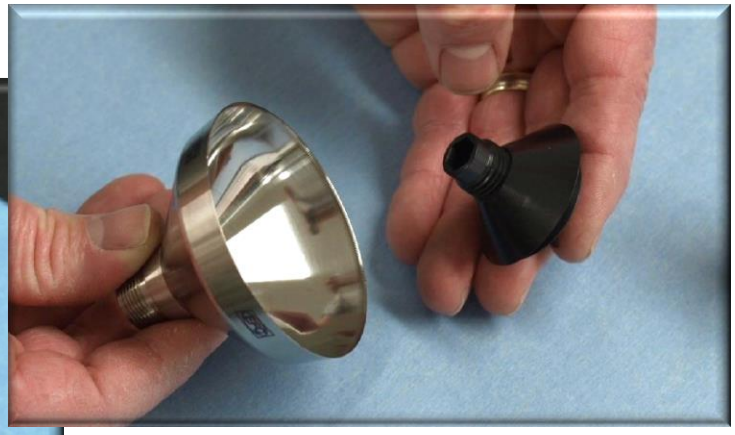
Date: 2/17/05

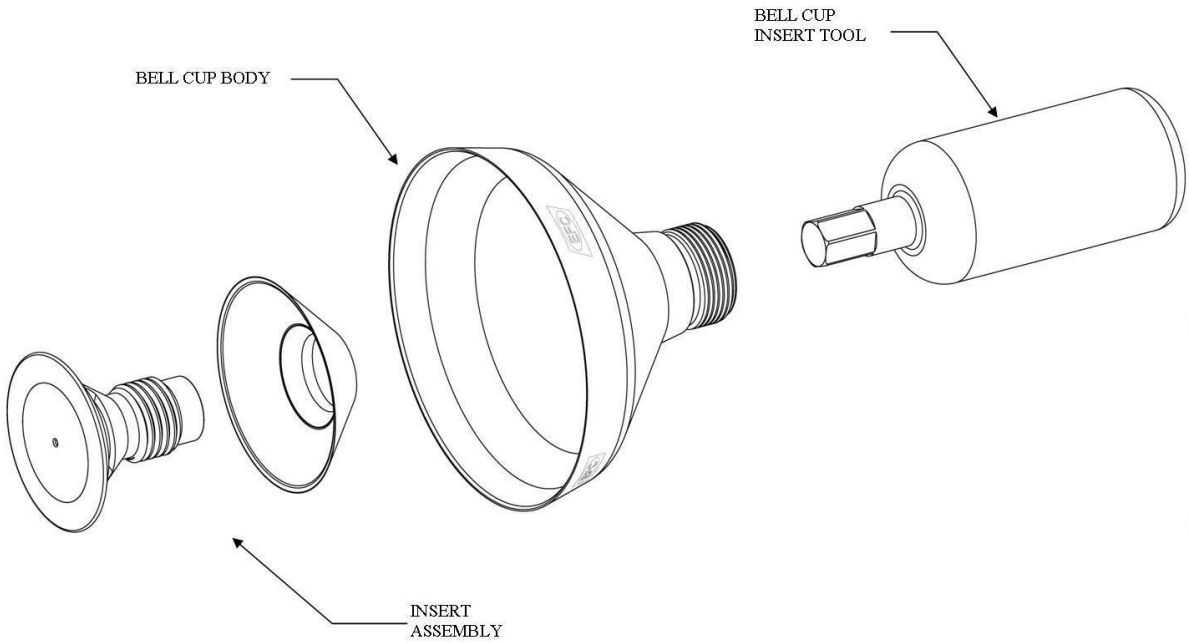
Subject: Inspection / Cleaning Procedures for:
25-2A77 & 25-5A77K and all variations ending in K, KV, DK & FC
bell cup assemblies

Disassembly

Carefully remove the bell cup from the atomizer (air bearing motor) by holding the atomizer shaft stationary with the proper tooling, EFC PN: TL-1A31, and unscrewing the cup counterclockwise.

Place the cup on a surface that will not damage the cup and carefully remove the cup's insert assembly using the proper tool, EFC PN: TL-2A77. The insert assembly contains more than one component so exercise caution when removing the insert assembly.

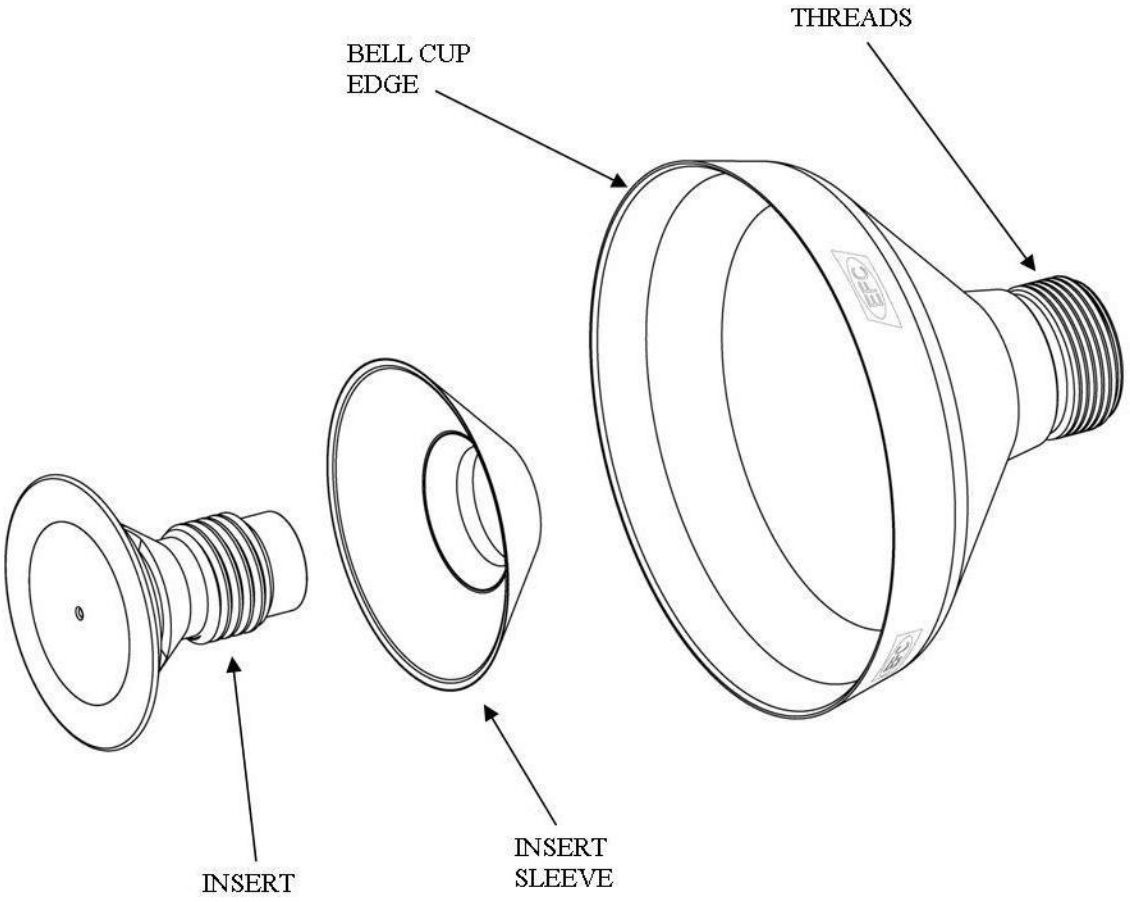




Fit the bell cup insert tool into the back of the bell cup as shown above. Turn the wrench clockwise to loosen the insert from the bell cup body.

Inspection

Inspect all components for damage and wear and replace as necessary. Carefully inspect the outer edge of the bell cup (where the paint exits) for damage. Inspect the bell cup threads for damage.



Cleaning

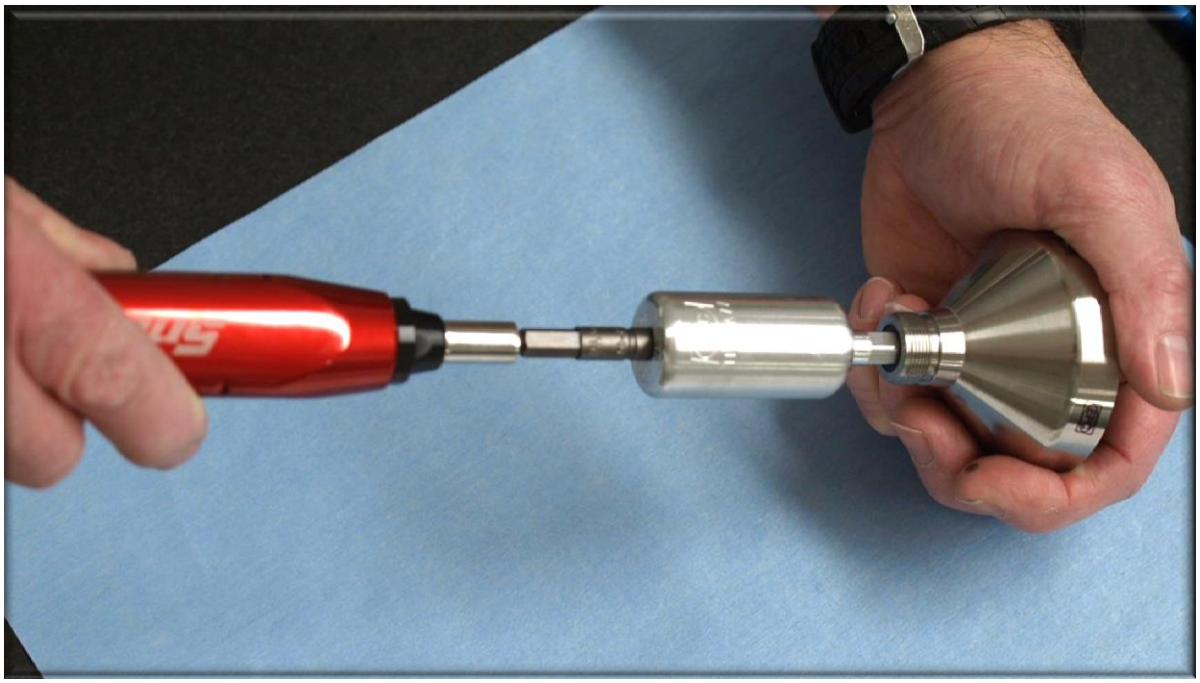
Using a plant approved solvent, clean the entire cup. The cup may be placed in an ultrasonic cleaner for additional cleaning.

Use only soft bristled brushes and lint-free cloths to clean the cup. Remove all debris from the entire cup, paying particular attention to the bell cup threads. Remove all debris from within the serrations (if the cup has serrations) at the inner exiting edge of the cup.

Remove any paint build-up on the bell cup's taper. The taper engages the motor shaft and should be carefully inspected and cleaned to prevent motor imbalance after reassembling it to the motor.

Assembly

Carefully re-assemble the cup with the proper tooling. With a torque wrench attached to the insert tool, insert the bell cup insert tool into the back of the cup and turn the insert counterclockwise (when viewed from



the back of the cup).

Set the torque wrench to 15 in-lbs. The insert will come to a stop when it is inserted properly.

Store the bell cups in a safe place, preferably in their original packaging to prevent damage.

NOTE:
Recommended torque setting for bell cup to atomizer shaft connection is **5 newton meters / 44 inch pounds**