

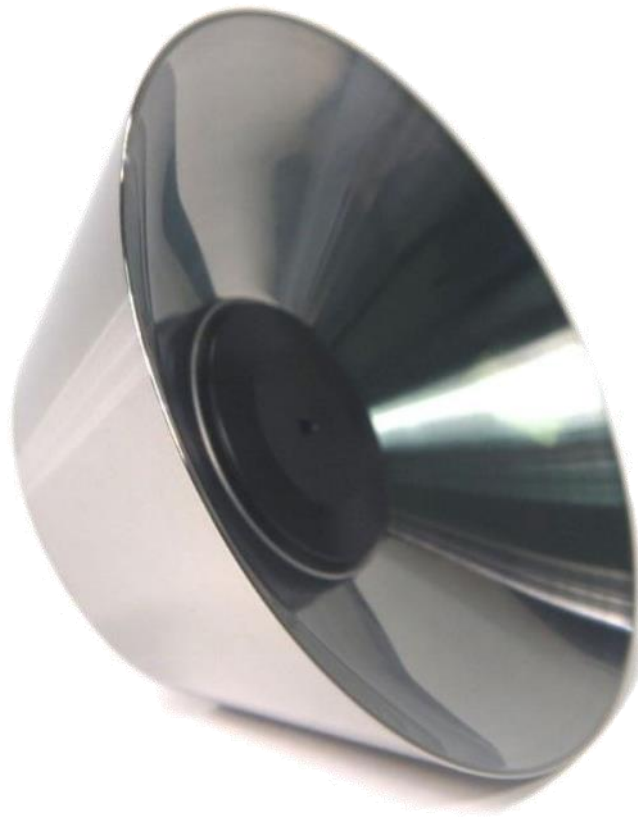


***Spraying Tomorrow's Technology®***

## **ENGINEERING NOTICE**

Date: 5/31/16

Subject: Inspection/Cleaning Procedures for 25-2A48, 25-2A58, 25-2H61, 25-2H72 & 25-2H83 Bell Cup Assemblies including all variations of bell cups ending in K & DK





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### **Important:**

It is absolutely critical that all safety procedures are followed in regards to robots and applicators. Consider safety factors such as proper ventilation, machine safeties, electrostatics and operating personnel. Make sure that the bell cups are not rotating before beginning cleaning process.

See *General Instructions > Cleaning of Painting Equipment* in the OEM applicator manual and all other related documentation in all regards, including safety and cleaning intervals.

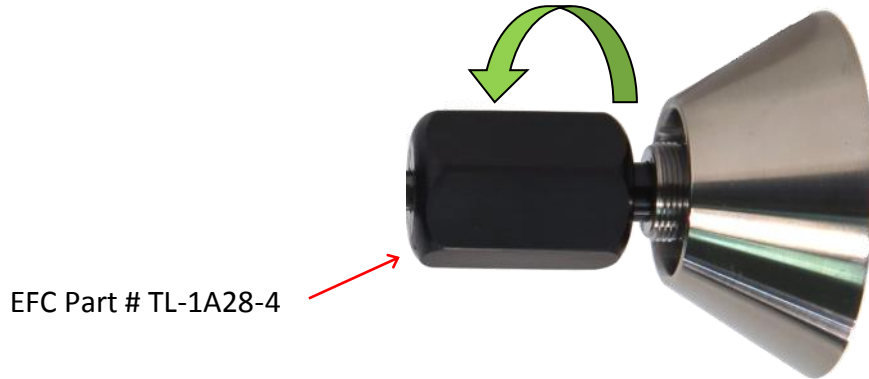
### **Disassembly:**

Refer to the applicator manual to engage locking shaft so that the bell cup can be removed. Carefully remove the bell cup from the air bearing motor by unscrewing the cup counter-clockwise.



### Insert Removal:

Insert bell cup removal tool into back of insert. Turn tool clockwise while holding bell cup to loosen and remove insert.

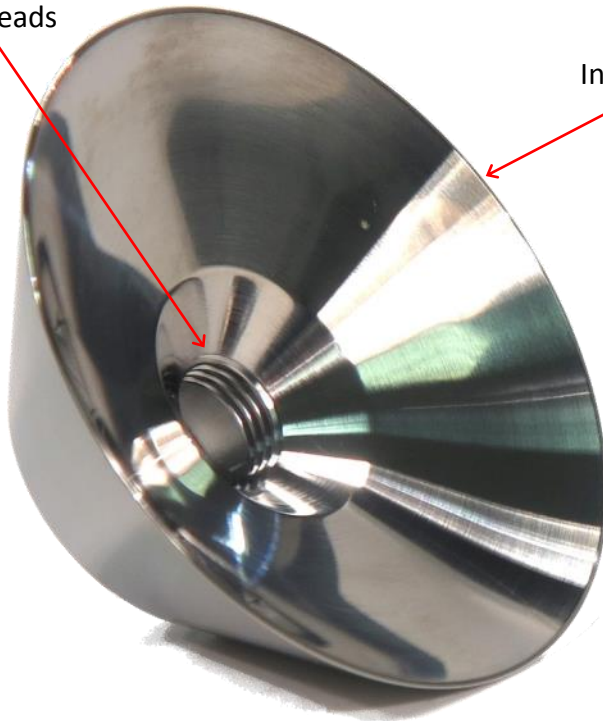


### Inspection:

Inspect all components for damage and wear, replacing them as necessary.

Inspect threads

Inspect edge



Inspect sleeve

Inspect for paint build-up and/or contaminants

Inspect insert posts

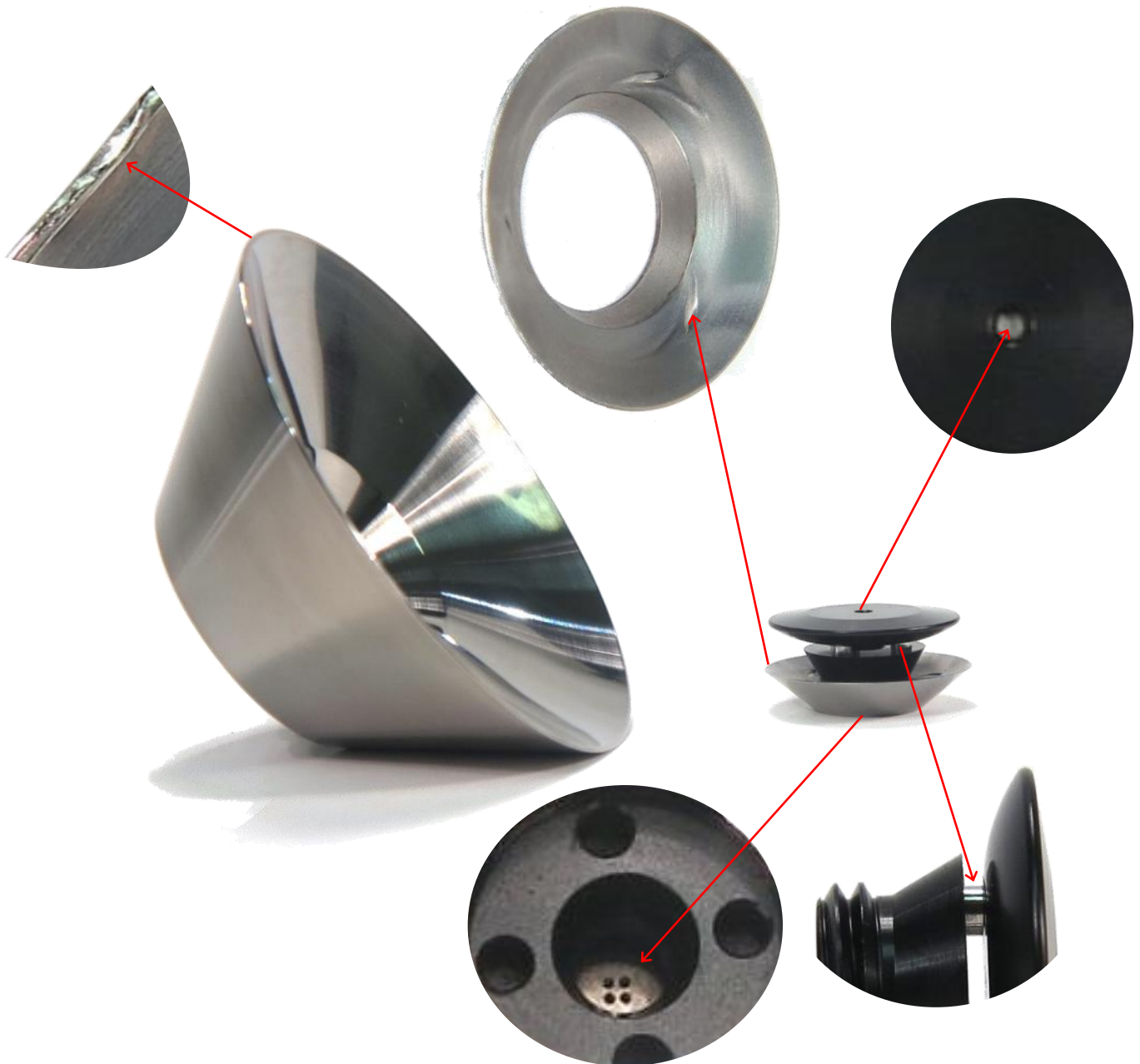




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## Visual Wear & Damage:

Visual wear and damage is an indication that it's time to replace a bell cup component. Shown below are area's to look at during inspection.





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## **Cleaning:**

Using a plant-approved solvent, clean entire bell cup body. 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 close attention to the bell cup threads and serrations (if present) at the inner exiting edge.

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





**Reassembly:**

Carefully reassemble the cup using the proper tooling. **Set torque wrench to 15 in/lbs.** EFC Part # TL-3A04 is preset to the correct torque and comes equipped with an insert tool. With the insert tool attached, insert the tool assembly into the back of bell cup and engage with insert assembly. Turn counter clockwise to torque. The insert will come to a stop when the proper torque is applied.



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

**Note:**

EFC bell cups are designed and engineered with the best materials available, however the life expectancy will vary from one application to another. EFC recommends replacing both the insert assembly and sleeve every 6 months keeping in mind this too will vary based on application.