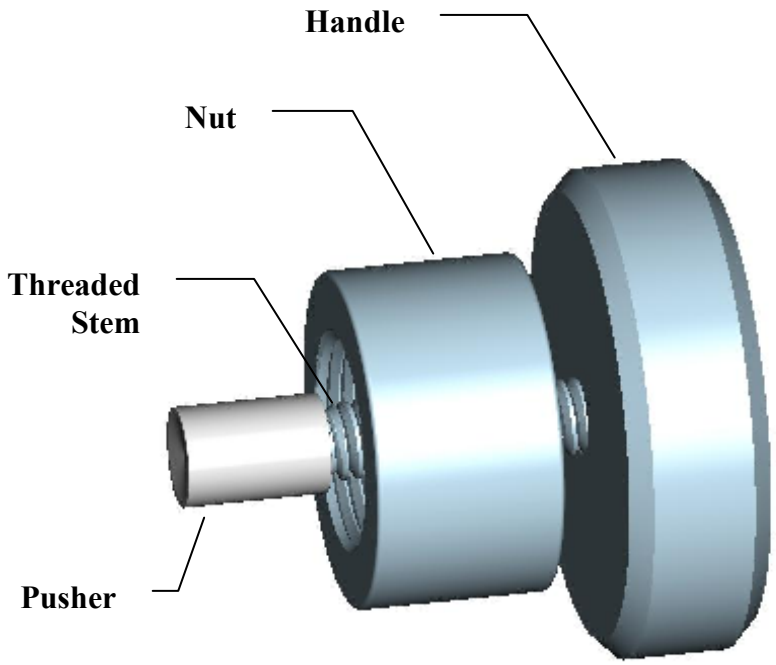
SYSTEMS, INC.

# ENGINEERING NOTICE

**Date:** 3/24/09

**Subject:** 25-9A26 Powder Bell Cup Assembly / Disassembly / Cleaning Procedures

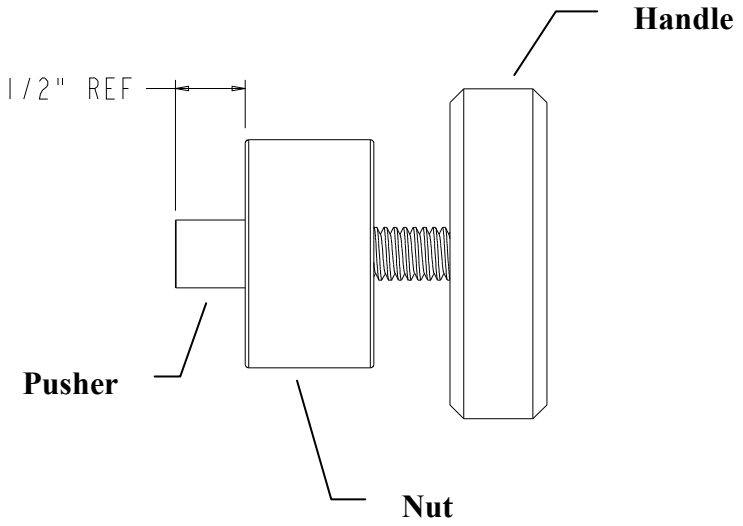
**Tooling:**



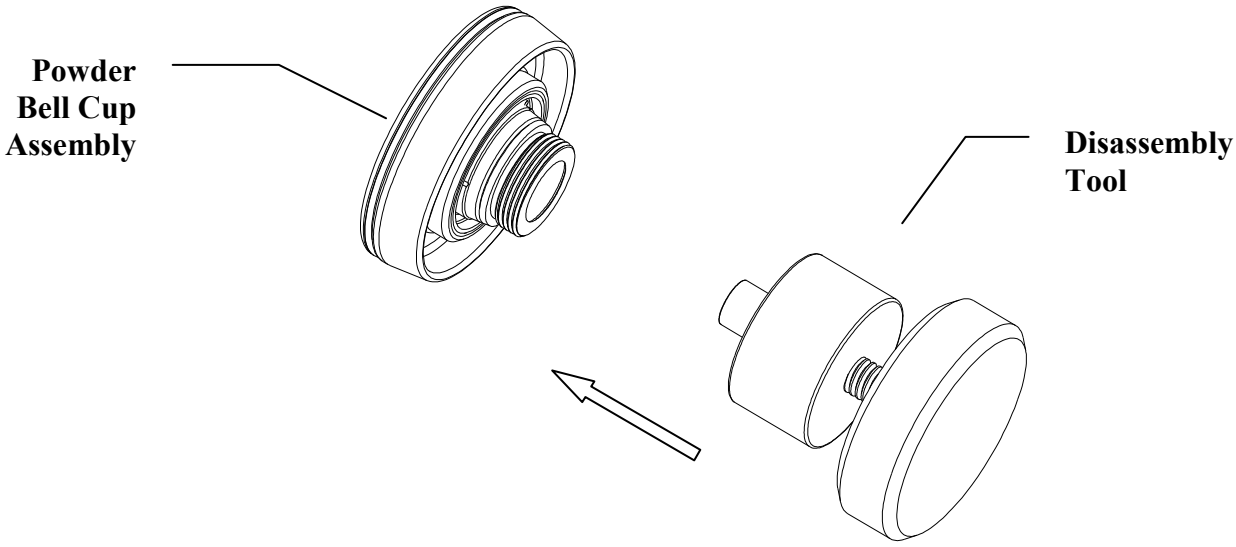

**Powder Bell Cup Disassembly Tool**
**EFC PN: TL-9A26**

**Procedure:** *Disassembly*

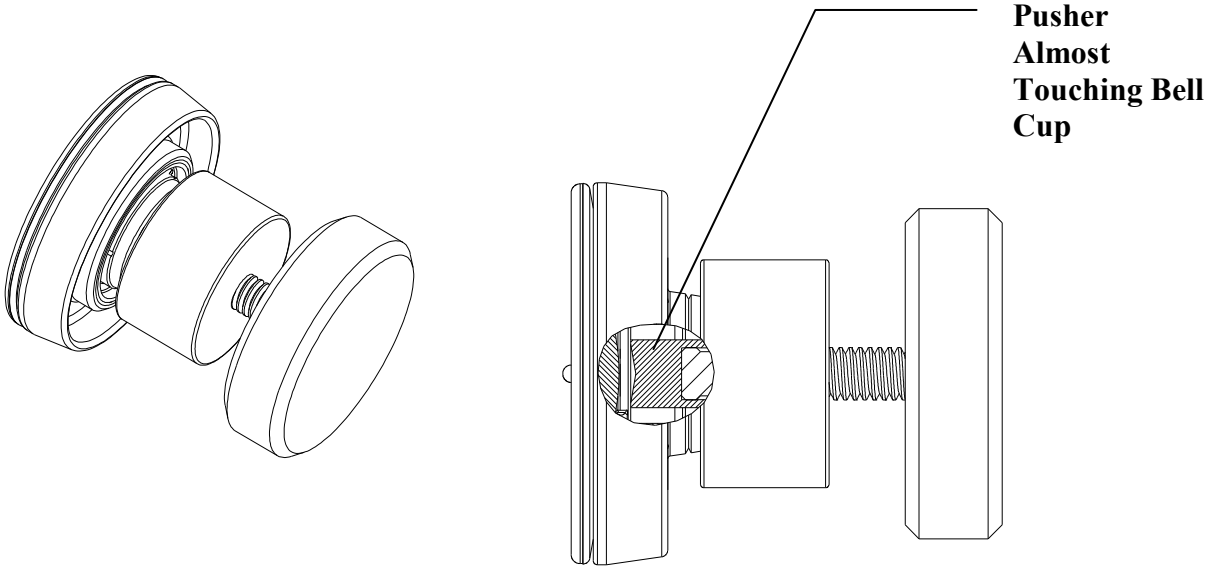
1. **Unscrew the NUT, counterclockwise, on the disassembly tool (EFC PN: TL-6A26B) until the white PUSHER is protruding approximately ½" beyond the NUT.**



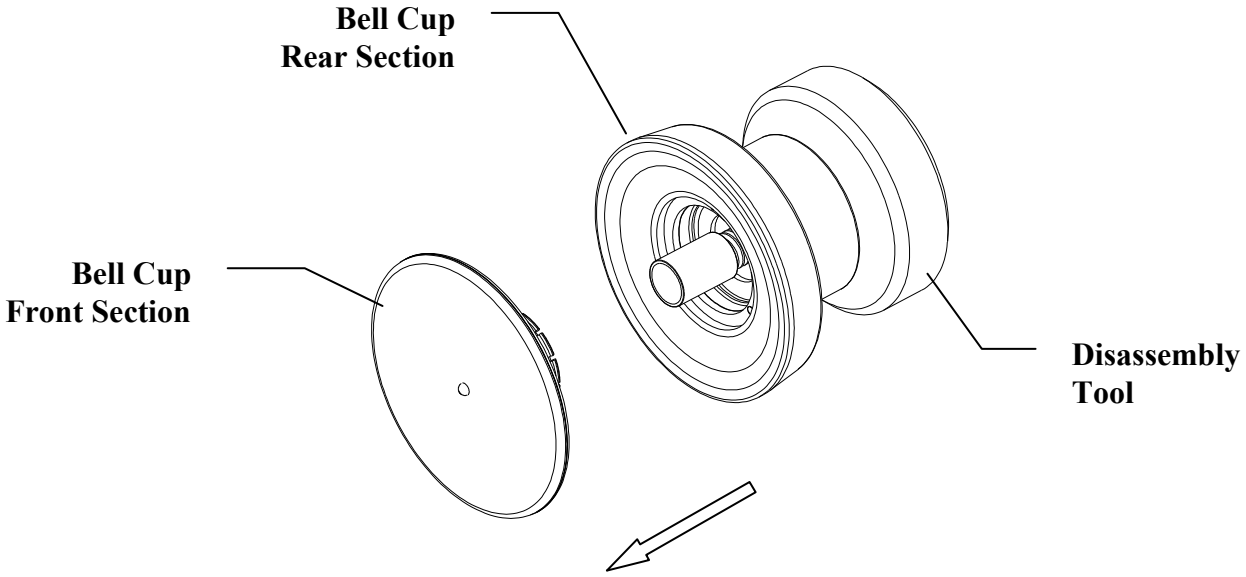

2. **Insert the disassembly tool (EFC PN: TL-9A26) into the back of the bell cup.**



3. **Screw, clockwise, the body of the disassembly tool onto the threads of the powder bell cup. The tool will seat against the bell cup shaft.**



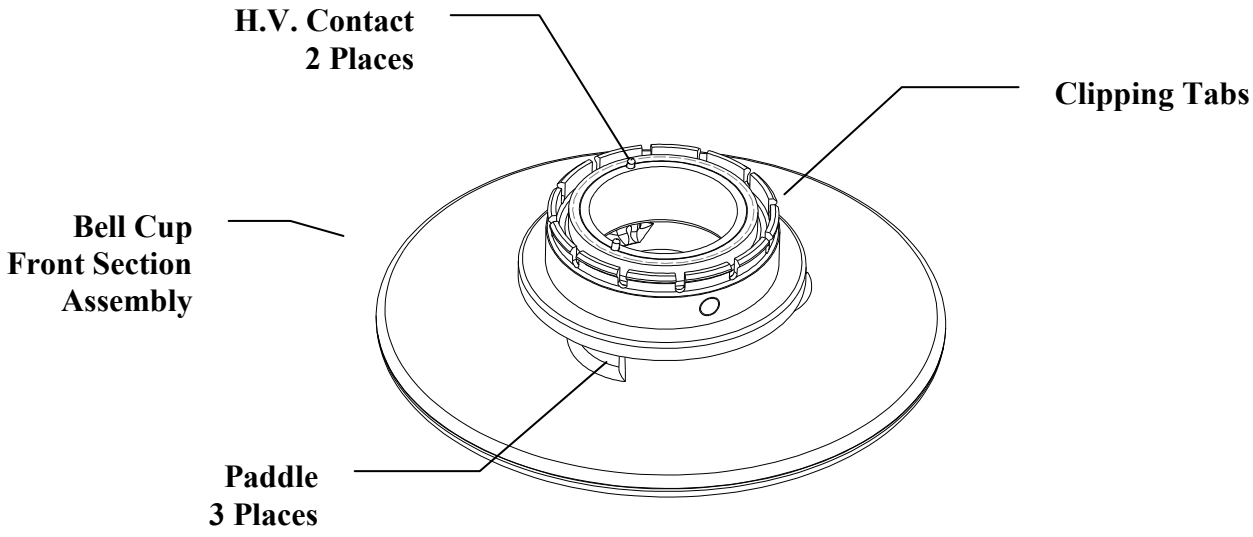

4. **Turn the handle clockwise until the bell cup separates into two pieces.**



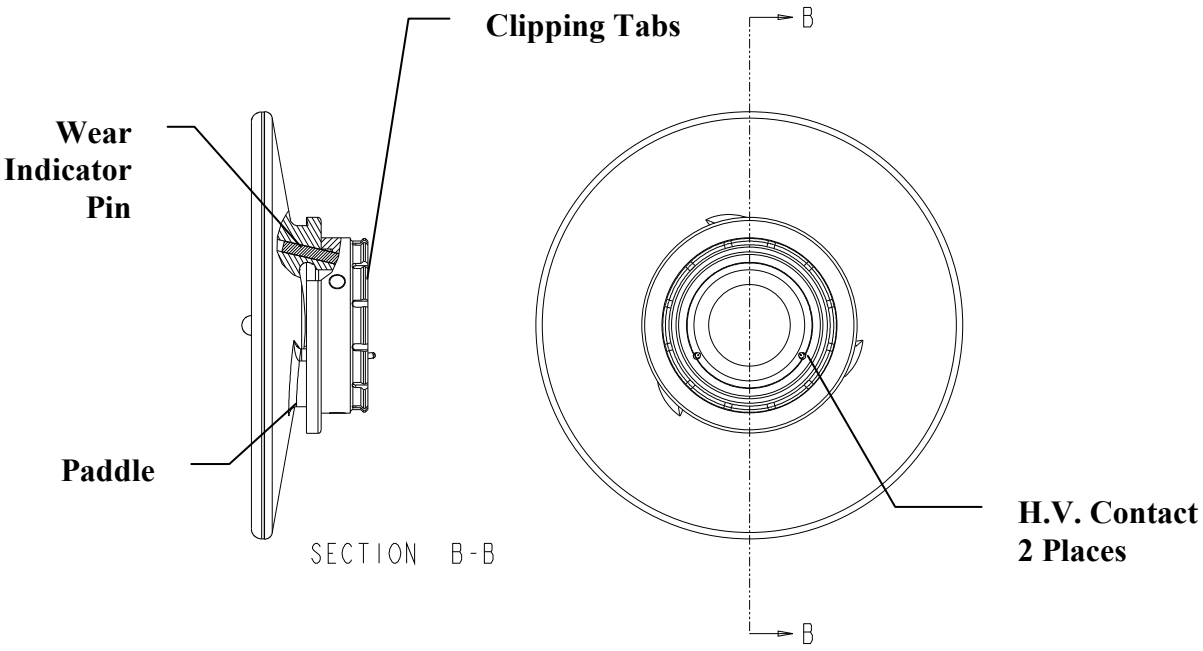
*Cleaning / Inspection*

1. **Using compressed air, carefully blow out any powder within or on the outside of the cup's two halves.**

2. **Check the internal paddles of the front section for signs of excessive powder wear and powder impact fusion. Make sure the clipping tabs are free of powder.**



3. **The front section of the powder bell cup has a wear indicator pin embedded into the one paddle that does not have an h. v. contact pressed into it.**
   **Once the black wear indicator pin is exposed, it is time to change the bell cup's front section.**

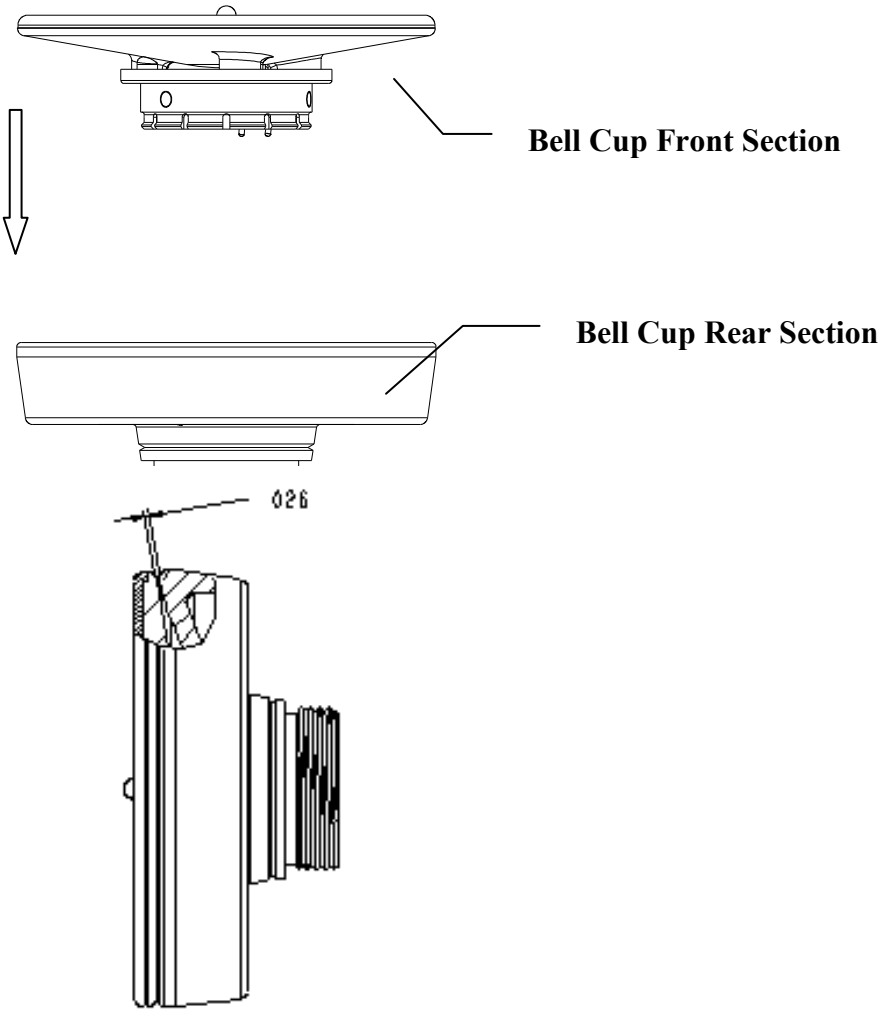


*Assembly*

1. **Place the bell cup rear section onto a stable flat surface, such as a table top.**

2. **Line up the front section with the rear section and carefully start the front section clipping tabs into the rear section.**

3. **Carefully push the Front Section into the Rear Section. The two pieces will "snap" together, leaving approximately a .026" gap.**




4. **The bell cup is now ready for use.**