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ENGINEERING NOTICE

Date: 1/23/13

Subject: Inspection/Cleaning Procedures for 25-2A24, 25-2A24K, 25-2A07 and 25-2A07K Bell Cup Assemblies





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Disassembly:

Carefully remove the bell cup from the air bearing motor by holding the motor shaft stationary with EFC Bell Cup Wrench #TL-1A31 and unscrewing the cup counterclockwise.

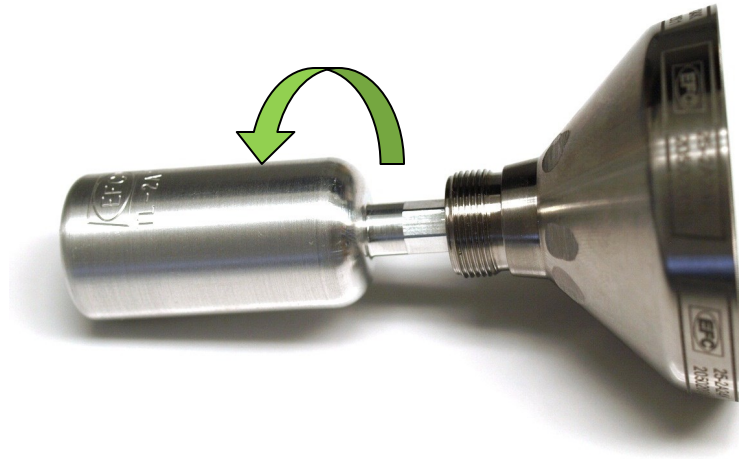




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Insert Removal:

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.

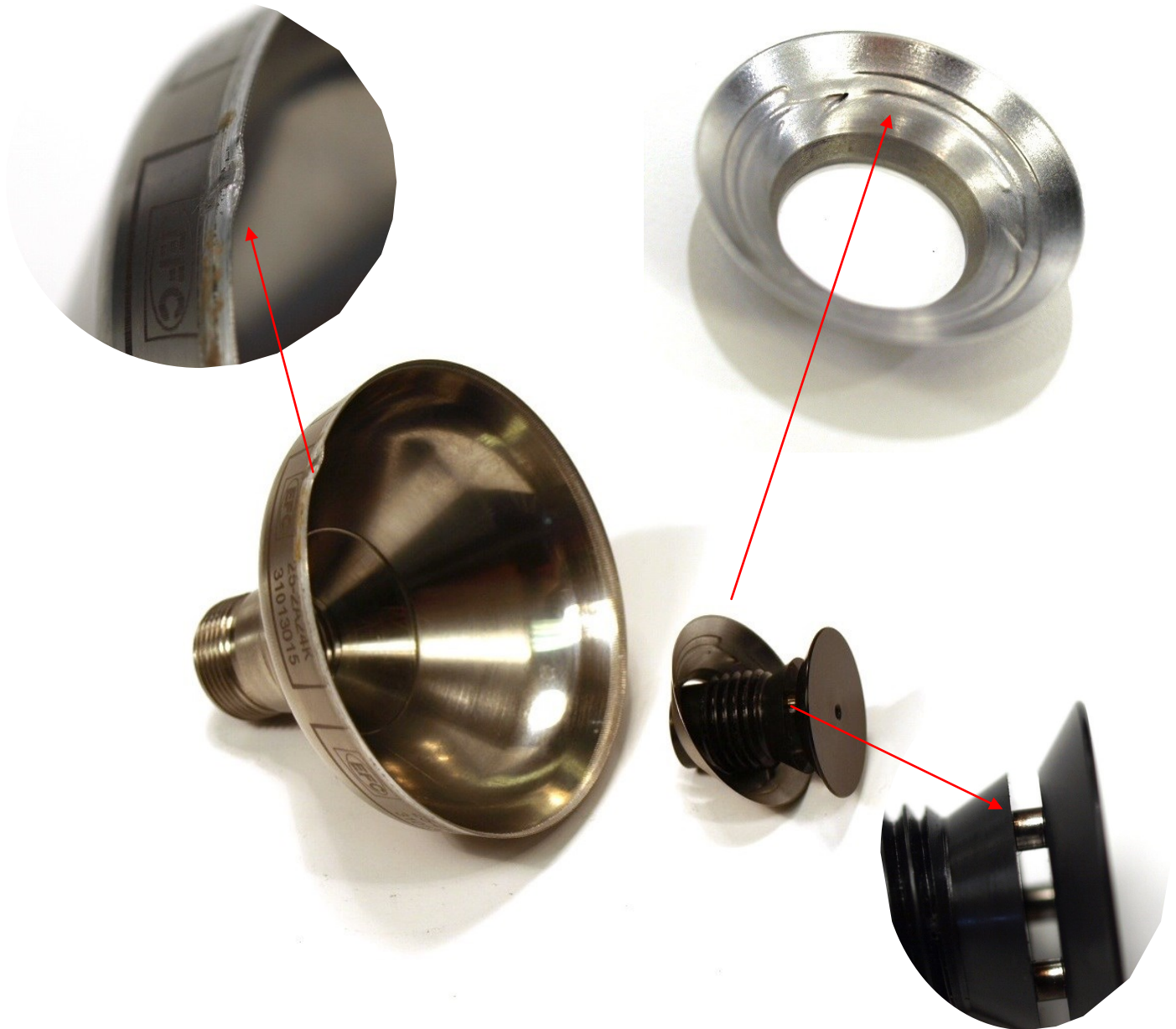




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Visual Wear & Damage:

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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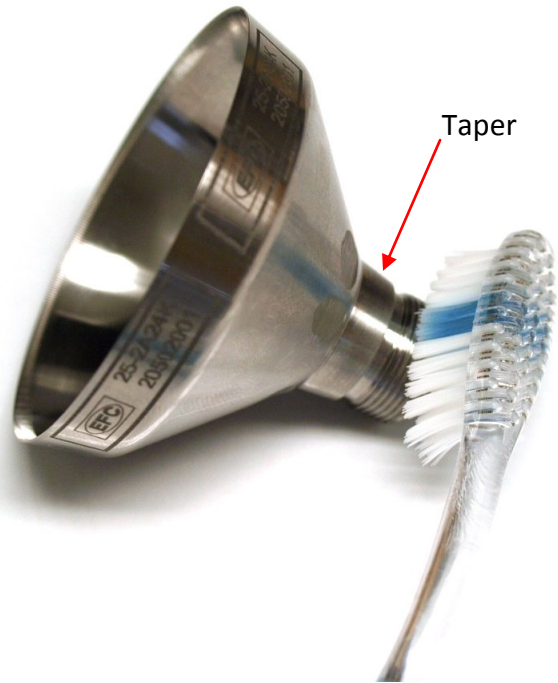
Cleaning:

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.





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Reassembly:

Carefully reassemble the cup using the proper tooling. **Set torque wrench to 25 in/lbs.** Attach torque wrench to insert tool. Slide insert tool through hole on 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.

Notes:

1. 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.
2. Recommended torque setting for bell cup to atomizer shaft connection is **5 Newton Meters / 44 inch pounds**