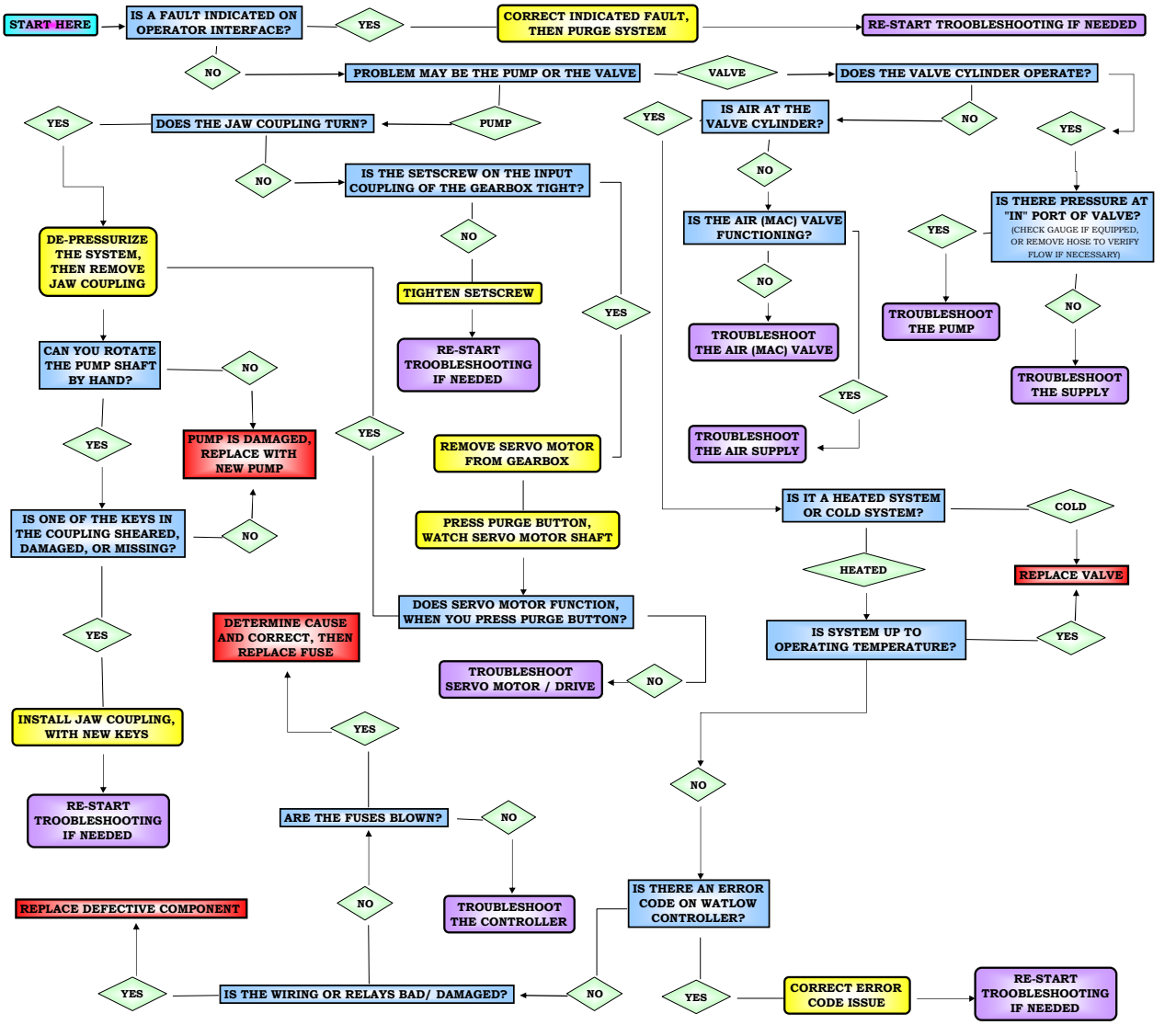
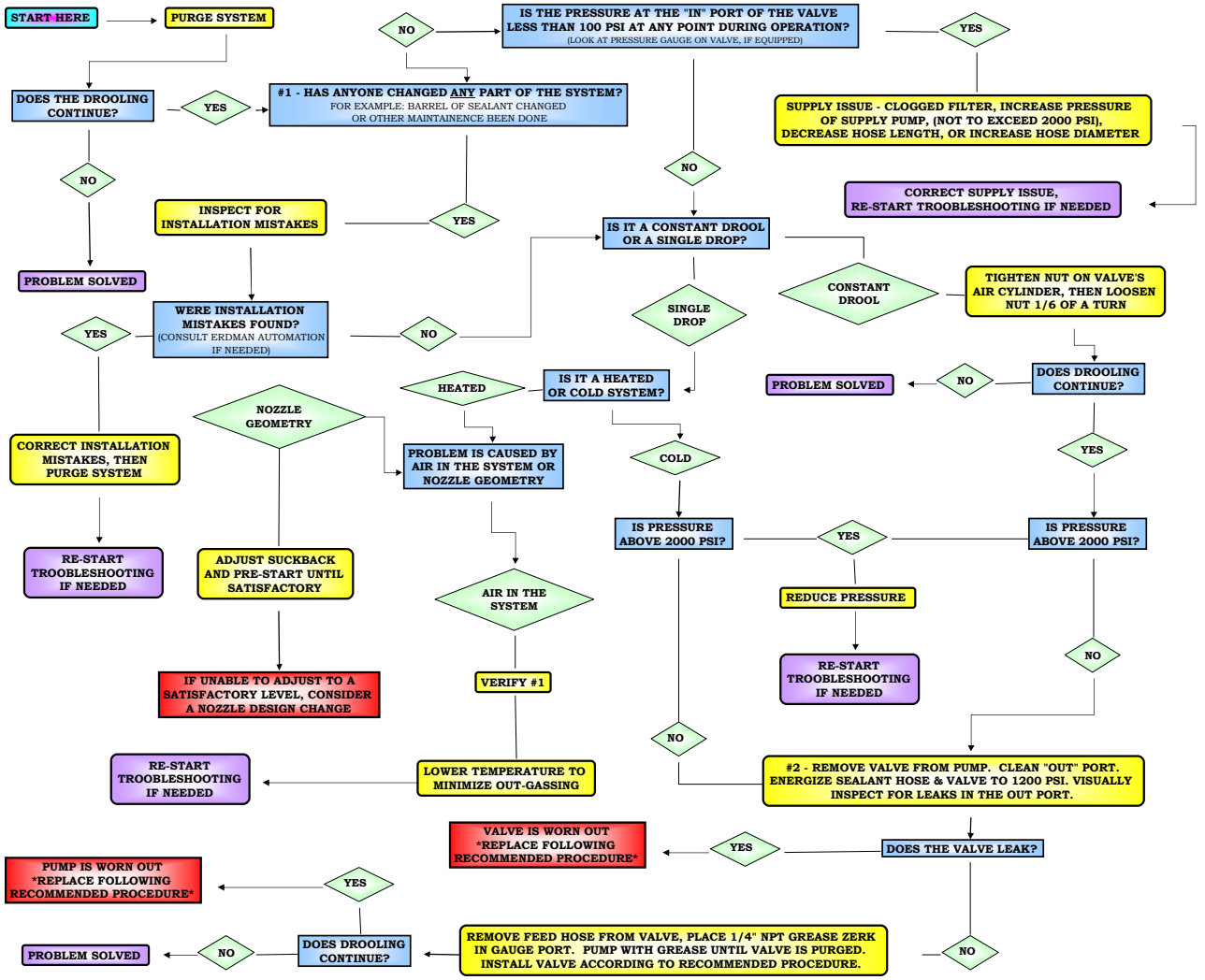
TROUBLESHOOTING: NO SEALANT



TROUBLESHOOTING: DROOLING SEALANT SYSTEM



Erdman Automation Corp.

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EACypump Fluid Meter and EACyflo Valve:
Instruction for removal and installation

1. Shut off the air to the extrusion pump and purge the remaining air pressure in the sealant hose by using the Purge Button on the controls cabinet of the machine.

2. When all the pressure has been depleted from the sealant supply hose, shut off and disconnect the air to the machine and extrusion pump. Turn off the power and disconnect the supply cord to the machine controls cabinet.

3. Have a supply of rags or paper towels handy to clean up any excess adhesive.

4. Disconnect and cap the main sealant supply hose from the existing fluid meter or valve. *Note: Parts and/or fittings that are disconnected and exposed to air for more than 15 minutes should be sealed to prevent curing that can cause malfunction or damage to sensitive components*.

5. Mark the placement of air supply lines to the cylinder on the existing valve and disconnect. (On heated units, mark placement of thermal couples and heater elements on both fluid meter and valve to assure proper installation on new unit.)

6. When replacing both fluid meter and valve, complete initial fluid meter and valve assembly as it appears on your machine before removing old unit. When only replacing fluid meter or valve, take note of assembly orientation before removing old unit and assembly accordingly.

7. Fluid meter and valve assembles are mounted to the gearbox using a variety of mounting plates. It may be easier to remove a portion of the mounting assembly with the fluid meter so take a moment to find the best method of removal. Pull the fluid meter away from the gearbox, making sure to note the placement of the spider gear for installation on the new fluid meter. Transfer any portion of the mounting assembly to the new fluid meter if needed.

8. Remove the Coupling on the old fluid meter shaft by loosening the setscrew and place it on the new fluid meter shaft. (Repeat this step for nozzle coupling on long body style fluid meters.) Do not tighten the setscrew(s) at this time. Hold the spider gear in place on the gearbox coupling, while positioning the new fluid meter. When the fluid meter is in position, tighten the setscrew on the fluid meter side coupling. Replace the socket head bolts on the mounting assembly and tighten.

9. Reconnect the air supply lines to the cylinder on the new valve and install thermal couples/heater elements to fluid meter/valve, if applicable.

10. Make sure the valve fitting on the main sealant supply hose is free and clear of any debris. If not, wipe clean and attach to the new valve. Check all bolts and fittings for tightness.

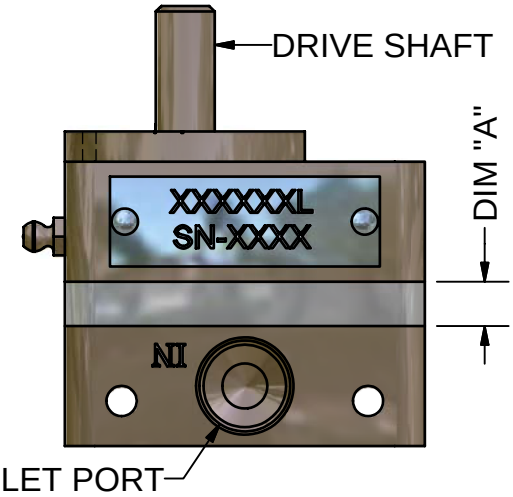
11. Plug in the power cord and apply power to the machine, this will allow the machine to come up to operating parameters. Plug in the air supply lines to the machine and to the extrusion pump. Apply air pressure to both.

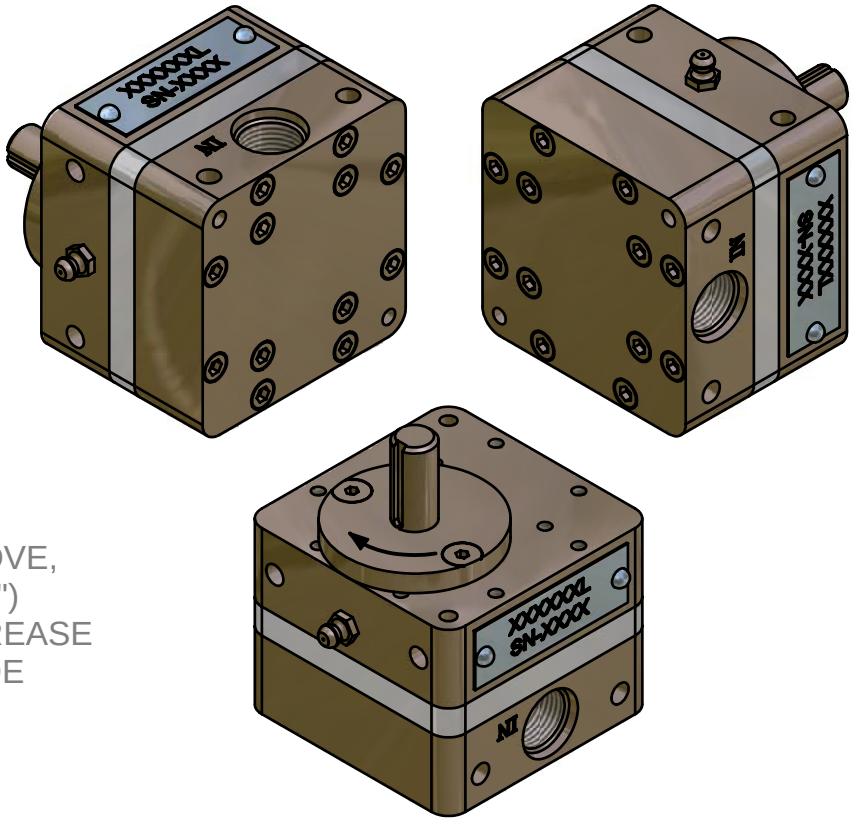
12. Purge the system, using the Purge Button on the control cabinet. Repeat the purging process until all the oil and air is out of the new fluid meter and valve assembly.

13. If the fluid meter is being returned to EAC as a core return, tape over the ports or use the plugs. Packing slip should include Return Goods Authorization # to assure core return credit to your account. (If the replacement fluid meter was not assigned an RGA#, or was a spare from your inventory, please call EAC at (763) 389-9475 to be assigned an RGA#.

FLUID METER IDENTIFICATION GUIDE

LEFT HAND FLUID METER COMMONLY CALLED A "PUMP"

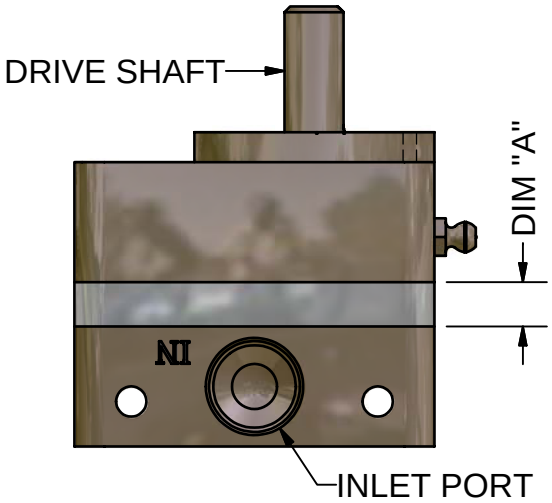


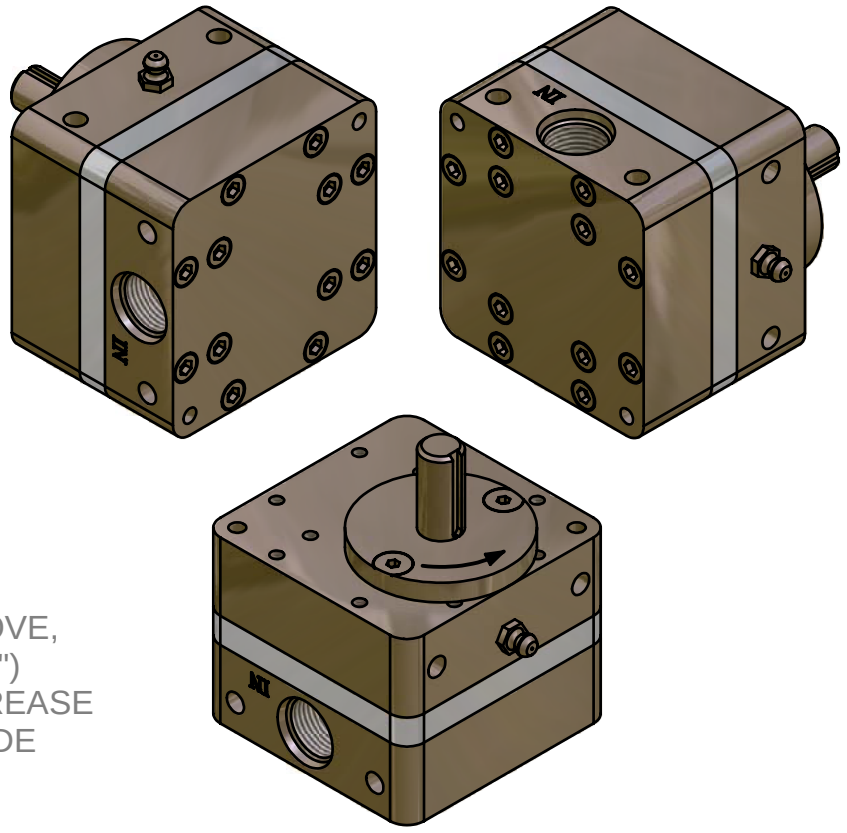


WHEN ORIENTED AS SHOWN ABOVE,
WITH INLET PORT (MARKED "IN")
AS SHOWN, THE DRIVE SHAFT & GREASE
ZERK IS TOWARD THE LEFT SIDE
OF THE FLUID METER

DETERMINING SIZE

SIZE	DIM "A"
1 GALLON	1/4" (.25)
1 1/2 GALLON	3/8" (.38)
3 GALLON	3/4" (.75)



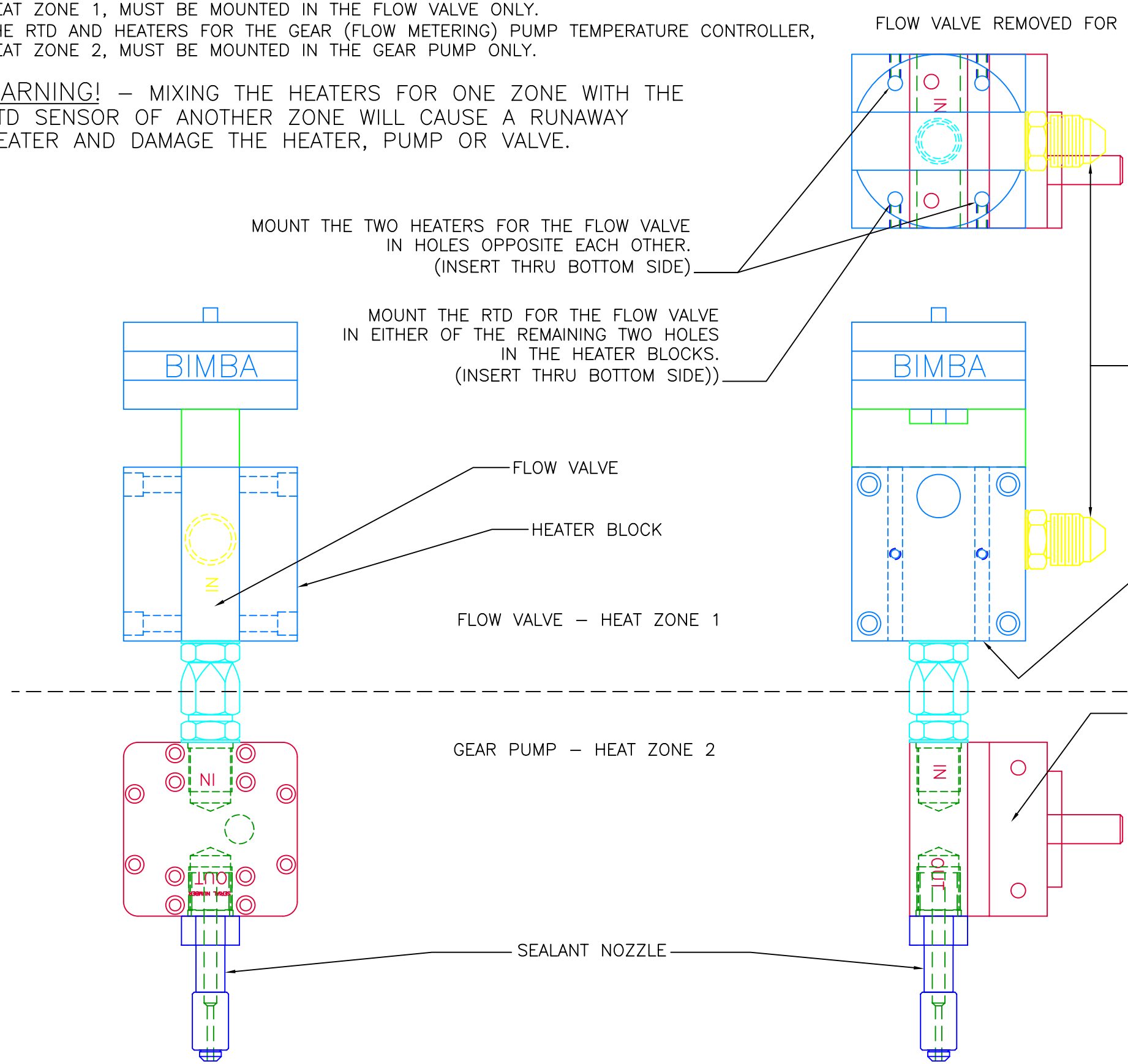


WHEN ORIENTED AS SHOWN ABOVE,
WITH INLET PORT (MARKED "IN")
AS SHOWN, THE DRIVE SHAFT & GREASE
ZERK IS TOWARD THE RIGHT SIDE
OF THE FLUID METER

RIGHT HAND FLUID METER COMMONLY CALLED A "PUMP"

NOTE: THE RTD AND HEATERS FOR THE FLOW VALVE TEMPERATURE CONTROLLER, HEAT ZONE 1, MUST BE MOUNTED IN THE FLOW VALVE ONLY.
THE RTD AND HEATERS FOR THE GEAR (FLOW METERING) PUMP TEMPERATURE CONTROLLER, HEAT ZONE 2, MUST BE MOUNTED IN THE GEAR PUMP ONLY.

WARNING! – MIXING THE HEATERS FOR ONE ZONE WITH THE RTD SENSOR OF ANOTHER ZONE WILL CAUSE A RUNAWAY HEATER AND DAMAGE THE HEATER, PUMP OR VALVE.



WARNING! – BEFORE INSERTION OF A HEATER INTO ITS MOUNTING HOLE, IT MUST BE COATED WITH INDUSTRIAL BORON NITRIDE MOLD RELEASE, CRC #03310 OR EQUIVALENT. FAILURE TO DO SO MAY MAKE IT IMPOSSIBLE TO REPLACE THE COMPONENT IN THE FUTURE BECAUSE IT WILL NOT BE REMOVABLE.

ERDMAN Automation Corp.
1603 S 14TH ST, Princeton, MN 55371

Description: HEATED PUMP ASSEMBLY CONTROLS' LOCATIONS	
Drawn By: SES	Dwg: INFO–1
Date: 11 / 2006	Sheet 1 of 1

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EACypump and EACyflo Valve:
ENGINEERING UPDATE NOTICE

Recent advancements in the EacyFlo Valve have brought a need for technical memo Illustrating proper adjustments of Erdman Standard Packing Gland Valves.
The reason for the design change to a Packing Gland Nut style is to ensure longer life and cleaner – leak free operation. This memo will explain proper maintenance of Packing Gland valves. Failure to follow procedure may result in valve failure/damage.

1. Clean all seepage or migrated sealant from Poppet Rod & Gland Nut.
2. Actuate valve to check proper operation before adjustments are made.
3. Make a single 60 deg turn to gland nut to compress Teflon o-rings.
4. Monitor adjustments made after 24 hours. If migration has not stopped, repeat step 3 – check again in 24 hours.