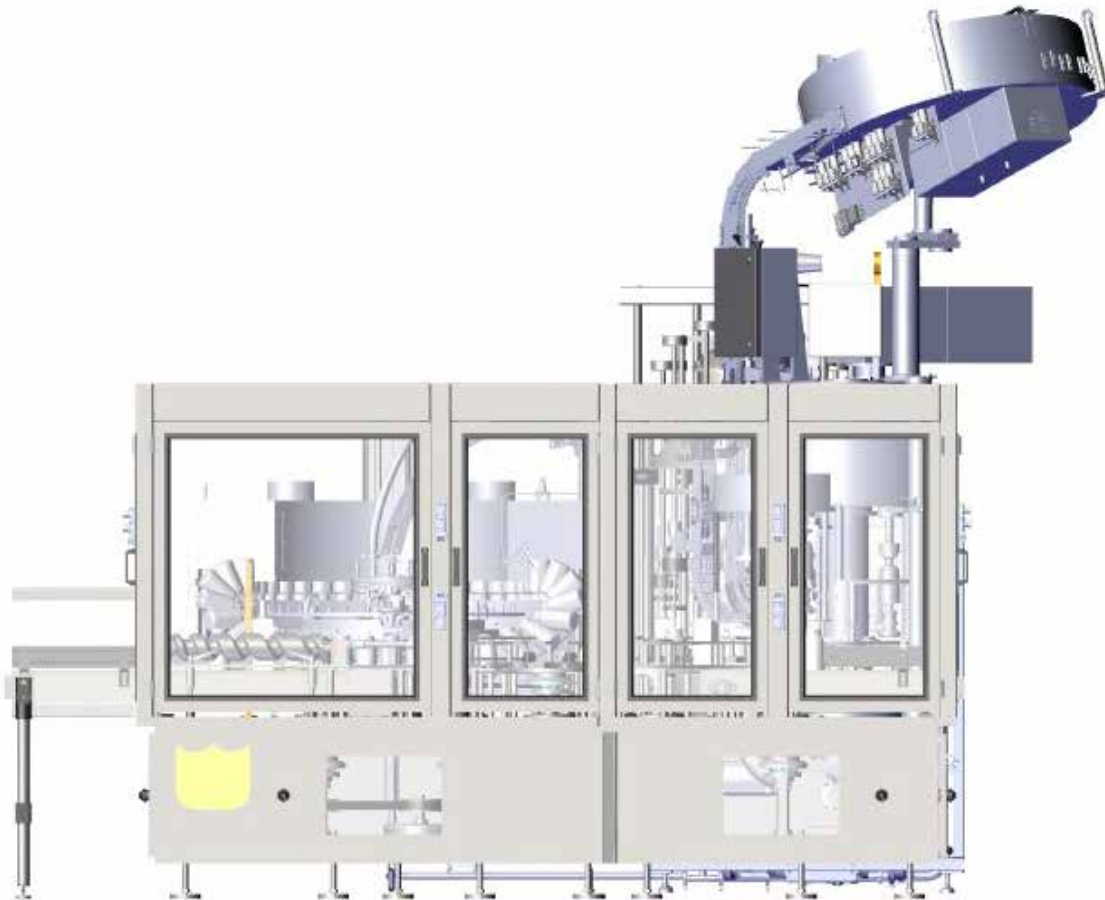


**U. S. BOTTLERS MACHINERY CO.-CHARLOTTE**

**BOTTLING AND PACKAGING ENGINEERS**

Creative Custom Packaging Equipment



## **Rotary Rinser (WAB) / PG Filler (USB) / Rotary Capper (AROL)**

RR-30-58.5in / PG-40-78in / AROL 8-15.6in  
**USB MACHINE NO: 122300**

**Illustrated Parts List  
for  
Luxco**



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### **ATTENTION**

THIS DOCUMENT ONLY IDENTIFIES COMPONENTS AND ASSEMBLIES THAT ARE  
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COMMONLY INVENTORIED ITEMS.

IF YOU REQUIRE A COMPREHENSIVE BILL OF MATERIALS (BOM) FOR THIS MACHINE ORDER,  
CONTACT OUR PARTS DEPARTMENT.

CONTENTS OF THIS DOCUMENT AND PARTS REPRESENTED MAY CHANGE WITHOUT  
NOTICE. COMPONENTS OF COMPARABLE OR GREATER QUALITY MAY BE SUBSTITUTED TO  
PROVIDE ENHANCED FUNCTION AND RELIABILITY.

## Recommended Spare Parts List

| 122300-1 ROTARY RINSER-30-58.5in (WAB) |     |                                   |      |           |          |
|----------------------------------------|-----|-----------------------------------|------|-----------|----------|
| P/N                                    | QTY | DESCRIPTION                       | CODE | UNIT \$\$ | EXTENDED |
| A18468                                 | 1   | U-Joint, 1" x 1", Booted/Keyed    | A    |           |          |
| A21179                                 | 1   | Clutch, Mechanical Overload       | A    |           |          |
| A92790                                 | 1   | Sensor, Prox, XP Pos Output       | A    |           |          |
| A20274                                 | 1   | Single Lobe Knob Assy, Spring     | A    |           |          |
| A18617                                 | 1   | Collar, Brass, Worm Drive         | A    |           |          |
| A23531                                 | 2   | Return Roller, Conveyor Chain     | A    |           |          |
| A19459                                 | 1   | Sprocket, 14mm 48T Polychain      | B    |           |          |
| A18293                                 | 1   | Timing Belt, 14MGT 125T 37mm      | B    |           |          |
| A19452                                 | 1   | Sprocket, 14mm 32T Polychain      | B    |           |          |
| A19613                                 | 1   | Worm Drive Bearing                | B    |           |          |
| A21614                                 | 1   | Worm Idler Bearing                | B    |           |          |
| A18543                                 | 1   | Coupling, Female, Worm Drive      | B    |           |          |
| a19507                                 | 1   | Sprocket, 21T, 815/820            | C    |           |          |
| A18462                                 | 1   | Bearing, 2"Bore, 2 Bolt Flange    | C    |           |          |
| A10515                                 | 1   | Bearing, 1" Bore, 2 Bolt          | C    |           |          |
| X90450                                 | 1   | Crossover Plate, Rinser Infeed    | C    |           |          |
| X90452                                 | 1   | Crossover Plate, Rinser Discharge | C    |           |          |
| X90454                                 | 1   | Crossover Plate Transfer          | C    |           |          |
| A94082                                 | 10  | Wear Strip Profile                | C    |           |          |
| A92604                                 | 1   | Sprocket, SS, 50B13, 1" Bore      | C    |           |          |
| A94686                                 | 1   | Sprocket, SS, 50B14, 1" Bore      | C    |           |          |
| A91111                                 | 1   | Bladder, Replaceable, Bottle Stop | C    |           |          |
| A20287                                 | 1   | Key, Clutch                       | D    |           |          |

**Table 4-1: Recommended Spare Parts List - Rinser**

### CODE DESIGNATIONS

- A** Items critical to machine operation and inventory is imperative.
- B** High wear items that will require replacement within the first year.
- C** Low wear items that will require replacement beyond the first year.
- D** Non-shelf items that require long lead times for delivery.

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**\*\*\*\*See WAB Info for WAB Specific Parts\*\*\*\***

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**RECOMMENDED SPARE PARTS LIST (continued)**

| <b>122300-2 / PG FILLER-40-78in</b> |            |                                            |             |                  |                 |
|-------------------------------------|------------|--------------------------------------------|-------------|------------------|-----------------|
| <b>P/N</b>                          | <b>QTY</b> | <b>DESCRIPTION</b>                         | <b>CODE</b> | <b>UNIT \$\$</b> | <b>EXTENDED</b> |
| A21179                              | 1          | Clutch, USB, 2" Bore                       | A           |                  |                 |
| A92790                              | 1          | Sensor, Proximity                          | A           |                  |                 |
| A18448                              | 6          | Sleeve, Roller Bolt, SS                    | A           |                  |                 |
| X84663                              | 20         | Wheel, Filler Lift                         | A           |                  |                 |
| A15533                              | 20         | Bushing, Filler Slide Rod                  | A           |                  |                 |
| X80501                              | 10         | Spacer, Filler Guide Block Bushing         | A           |                  |                 |
| X87193                              | 10         | Slide Rod                                  | A           |                  |                 |
| A15532                              | 10         | Ring, Retaining, 7/8"                      | A           |                  |                 |
| X88411                              | 10         | Guide Rod, Filler Slide Block, 7/8"        | A           |                  |                 |
| BM9400                              | 1          | Rotary Union Assembly                      | A           |                  |                 |
| X80502                              | 6          | Slide Block for 7/8" Guide Rod             | A           |                  |                 |
| A17600                              | 2          | O-Ring, 20" ID, .275" W                    | A           |                  |                 |
| A21654                              | 1          | O-Ring, 18.455"ID x .275", Viton           | A           |                  |                 |
| A17047                              | 10         | Gasket, 3/4" Tri-Clamp                     | A           |                  |                 |
| A22472                              | 10         | Fitting, 3/4" TC to 3/4" Hose Barb         | A           |                  |                 |
| A22125                              | 50         | Hose, 3/4" Santoprene                      | A           |                  |                 |
| BM9211                              | 10         | Valve Assembly, Complete                   | A           |                  |                 |
| X87684                              | 20         | Tube Bushing, .473" Inner                  | A           |                  |                 |
| A16026                              | 20         | O-Ring, .862" ID, Viton                    | A           |                  |                 |
| X89502                              | 40         | Seal Rubber, 1-1/2"OD, .43" ID, 1/4" Thick | A           |                  |                 |
| A23231                              | 40         | Seal, U-Cup, 666-205, Viton                | A           |                  |                 |
| A21853                              | 10         | Backup Washer, 1-1/2" OD, 5/8" ID          | A           |                  |                 |
| A22973                              | 18         | Tip, 1/2" Inner, 9/16" Outer               | A           |                  |                 |
| X86992                              | 18         | Inner Tube, .47" OD                        | A           |                  |                 |
| X90478                              | 18         | Outer Tube, 9/16" OD                       | A           |                  |                 |
| X49180                              | 20         | Spring, Compression, Valve                 | A           |                  |                 |
| A19562                              | 20         | Clamp, SS, 3/4" Hose                       | A           |                  |                 |
| A20287                              | 1          | Key, Clutch                                | A           |                  |                 |
| X20356                              | 40         | O-Ring, #012, Viton, Valve Tip             | A           |                  |                 |
| A21629                              | 6          | Shoulder Bolt, 5/8" X 1-1/2", SS           | A           |                  |                 |
| X90488                              | 20         | Sealer Rubber, Bell "A"                    | A           |                  |                 |
| X90489                              | 20         | Sealer Rubber, Bell "B/C"                  | A           |                  |                 |
| A21249                              | 1          | Repair Kit, Rotary Union                   | B           |                  |                 |
| A20274                              | 1          | Single Lobe Knob                           | B           |                  |                 |
| A15752                              | 10         | O-Ring, .850" ID                           | B           |                  |                 |
| X90485                              | 5          | Centering Bell, Luxco "A" 33/35MM          | B           |                  |                 |

## RECOMMENDED SPARE PARTS LIST (continued)

|        |   |                                |   |  |  |
|--------|---|--------------------------------|---|--|--|
| X90486 | 5 | Centering Bell, Luxco "B" 30MM | B |  |  |
| X90487 | 5 | Centering Bell, Luxco "C" 28MM | B |  |  |
| A18462 | 1 | Bearing, Flange, 2-Bolt, 2"    | C |  |  |
| X48264 | 1 | Manifold Shoe Set, 90 Degree   | C |  |  |
| X90656 | 1 | Crossover Plate, Filler Infeed | C |  |  |
| A24271 | 2 | Sprocket, Idler, Cam Lift      | C |  |  |

**Table 4-2: Recommended Spare Parts List - Filler**

### CODE DESIGNATIONS

- A** Items critical to machine operation and inventory is imperative.
- B** High wear items that will require replacement within the first year.
- C** Low wear items that will require replacement beyond the first year.
- D** Non-shelf items that require long lead times for delivery.

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**RECOMMENDED SPARE PARTS LIST (continued)**

| 122300-3 / 8-15.6in (AROL) |     |                                   |      |           |          |
|----------------------------|-----|-----------------------------------|------|-----------|----------|
| P/N                        | QTY | DESCRIPTION                       | CODE | UNIT \$\$ | EXTENDED |
| X90664                     | 1   | Crossover Plate, Filler to Capper | B    |           |          |
| X90667                     | 1   | Crossover Plate, Capper Discharge | B    |           |          |
| A19507                     | 1   | Sprocket, 21T, 815/820 Chain      | B    |           |          |
| A20275                     | 1   | "T" Lobe Knob Assembly            | C    |           |          |
| A10515                     | 1   | Bearing, 2-bolt, 1"               | C    |           |          |
| A18628                     | 1   | Tri-Lobe Hub                      | C    |           |          |

**Table 4-3: Recommended Spare Parts List - Capper****NOTE: PLEASE SEE AROL DRAWINGS FOR CAPPER TURRET PARTS****CODE DESIGNATIONS**

- A** Items critical to machine operation and inventory is imperative.
- B** High wear items that will require replacement within the first year.
- C** Low wear items that will require replacement beyond the first year.
- D** Non-shelf items that require long lead times for delivery.

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## RECOMMENDED SPARE PARTS LIST (continued)

| 122300 / Electrical Components |                                                         |     |                             |      |           |          |
|--------------------------------|---------------------------------------------------------|-----|-----------------------------|------|-----------|----------|
| P/N                            | DEVICE ID                                               | QTY | DESCRIPTION                 | CODE | UNIT \$\$ | EXTENDED |
| A91746                         | CB0610                                                  | 1   | 1P, 5A CIRCUIT BREAKER      | C    |           |          |
| A91750                         | CB0507                                                  | 1   | 1P, 20A CIRCUIT BREAKER     | C    |           |          |
| A91748                         | CB0508                                                  | 1   | 1P, 10A CIRCUIT BREAKER     | C    |           |          |
| A91745                         | CB0614                                                  | 1   | 1P, 3A CIRCUIT BREAKER      | C    |           |          |
| A91737                         | CB0501                                                  | 1   | 3P, 5A CIRCUIT BREAKER      | C    |           |          |
| A94036                         | COM1                                                    | 1   | 16 PORT UNMANAGED SWITCH    | D    |           |          |
| A94356                         | DOOR 1-8                                                | 1   | LOCKING DOOR SWITCH         | A,D  |           |          |
| A94091                         | ENCOD-<br>ER RINSER,<br>RINSER STARS,<br>FILLER,CAPPER  | 1   | ENCODER                     | A    |           |          |
| A93743                         | HMI-1                                                   | 1   | PANELVIEW PLUS 7, 10.4"     | A,D  |           |          |
| A94366                         | IB0705,<br>IB2729                                       | 1   | SAFETY BARRIER              | A,D  |           |          |
| A92497                         | IB0919 THRU<br>IB1034                                   | 1   | INPUT BARRIER               | A,D  |           |          |
| A92498                         | IB0612,IB1502<br>THRU IB1535                            | 1   | OUTPUT BARRIER              | A,D  |           |          |
| A92499                         | IB1603.<br>IB1606                                       | 1   | ANALOG IN BARRIER           | A,D  |           |          |
| A92500                         | IB1623,IB1625                                           | 1   | ANALOG OUT BARRIER          | A,D  |           |          |
| A91879                         | K1, K2, K3, K4,<br>K5, K6                               | 1   | SAFETY RELAY                | A,D  |           |          |
| A18697                         | MCB1                                                    | 1   | 3P, 100A CIRCUIT BREAKER    | C    |           |          |
| A22537                         | MCP01,<br>MCP13                                         | 1   | 3P, 6.3-10A CIRCUIT BREAKER | C    |           |          |
| A22538                         | MCP02,<br>MCP03,<br>MCP16                               | 1   | 3P, 10-16A CIRCUIT BREAKER  | C    |           |          |
| A22535                         | MCP05,<br>MCP08,<br>MCP09,<br>MCP10,<br>MCP11,<br>MCP12 | 1   | 3P, 2.5-4A CIRCUIT BREAKER  | C    |           |          |
| A22536                         | MCP04,<br>MCP06,<br>MCP07                               | 1   | 3P, 4-6.3A CIRCUIT BREAKER  | C    |           |          |
| A92913                         | MS-10, MS11,<br>MS-12                                   | 1   | REVERSING STARTER           | A,D  |           |          |
| A19731                         | PB1119                                                  | 1   | RED LIGHTED MAINTAINED PB   |      |           |          |

**RECOMMENDED SPARE PARTS LIST (continued)**

| <b>122300 / Electrical Components</b> |                                                                                                                                                                        |            |                         |             |                  |                 |
|---------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------|-------------------------|-------------|------------------|-----------------|
| <b>P/N</b>                            | <b>DEVICE ID</b>                                                                                                                                                       | <b>QTY</b> | <b>DESCRIPTION</b>      | <b>CODE</b> | <b>UNIT \$\$</b> | <b>EXTENDED</b> |
| A94353                                | PB0705A,<br>PB0705B,<br>PB0705C                                                                                                                                        | 1          | E-STOP STATION          | C           |                  |                 |
| A19728                                | PB0912                                                                                                                                                                 | 1          | GREEN LIGHTED PB        | C           |                  |                 |
| A16558                                | PB0913                                                                                                                                                                 | 1          | RED PB                  | C           |                  |                 |
| A16555                                | PB0914                                                                                                                                                                 | 1          | BLACK PB                | C           |                  |                 |
| A90818                                | PB0915                                                                                                                                                                 | 1          | JOG PENDANT             | A,D         |                  |                 |
| A93037                                | PE11004,<br>PE1005,<br>PR1031                                                                                                                                          | 1          | PHOTOEYE WITH REFLECTOR | A,D         |                  |                 |
| A22357                                | FO1005                                                                                                                                                                 | 1          | FIBER OPTIC PHOTOEYE    | A,D         |                  |                 |
| A92111                                | PS0505                                                                                                                                                                 | 1          | 20A DC POWER SUPPLY     | A,D         |                  |                 |
| A92790                                | PX0919,<br>PX0920,<br>PX1124,<br>PX0921,<br>PX0922,<br>PX0923,<br>PX0924,<br>PX0925,<br>PX1001,<br>PX1003,<br>PX1008,<br>PX1010,<br>PX1011,<br>PX1012,<br>GS201, GS202 | 1          | PROXIMITY SENSOR        | A,D         |                  |                 |
| A93046                                | PX0928,<br>PX0929                                                                                                                                                      | 1          | 30MM PROXIMITY SENSOR   | A,D         |                  |                 |
| A94884                                | RACK 0                                                                                                                                                                 | 1          | SAFETY PROCESSOR        | A,D         |                  |                 |
| A94253                                | RACK 0                                                                                                                                                                 | 1          | 8 PT INPUT              | A,D         |                  |                 |
| A94255                                | RACK 0                                                                                                                                                                 | 1          | 8 PT SAFETY INPUT       | A,D         |                  |                 |
| A94254                                | RACK 0                                                                                                                                                                 | 1          | 8 PT DC OUTPUT          | A,D         |                  |                 |
| A94652                                | RACK 0                                                                                                                                                                 | 1          | 8 PT SAFETY OUTPUT      | A,D         |                  |                 |
| A94814                                | RACK 0                                                                                                                                                                 | 1          | 2CH ANALOG INPUT        | A,D         |                  |                 |
| A94654                                | RACK 0                                                                                                                                                                 | 1          | 4PT ANALOG OUTPUT       | A,D         |                  |                 |
| A94251                                | RACK 0                                                                                                                                                                 | 1          | ETHERNET ADAPTER        | A,D         |                  |                 |
| A91880                                | SR1,SR2                                                                                                                                                                | 1          | SAFETY CONTACTOR        | A,D         |                  |                 |
| A92865                                | SV1502,<br>SV1507,<br>SV0612,<br>SV0613                                                                                                                                | 1          | SOLENOID VALVE          | A,D         |                  |                 |

**RECOMMENDED SPARE PARTS LIST (continued)**

| 122300 / Electrical Components |                     |     |                         |      |           |          |
|--------------------------------|---------------------|-----|-------------------------|------|-----------|----------|
| P/N                            | DEVICE ID           | QTY | DESCRIPTION             | CODE | UNIT \$\$ | EXTENDED |
| A94862                         | VFD4                | 1   | 2 HP POWERFLEX 755      | A,D  |           |          |
| A94863                         | VFD1, VF-D2,VFD3    | 1   | 7.5 HP POWERFLEX 755    | A,D  |           |          |
| A92807                         | VFD05, VFD08, VFD09 | 1   | 1HP POWERFLEX 525 DRIVE | A,D  |           |          |
| A92808                         | VFD06, VFD07        | 1   | 2HP POWERFLEX 525 DRIVE | A,D  |           |          |
|                                |                     |     |                         |      |           |          |

**Table 4-4: Recommended Spare Parts List - Electrical**
**CODE DESIGNATIONS**

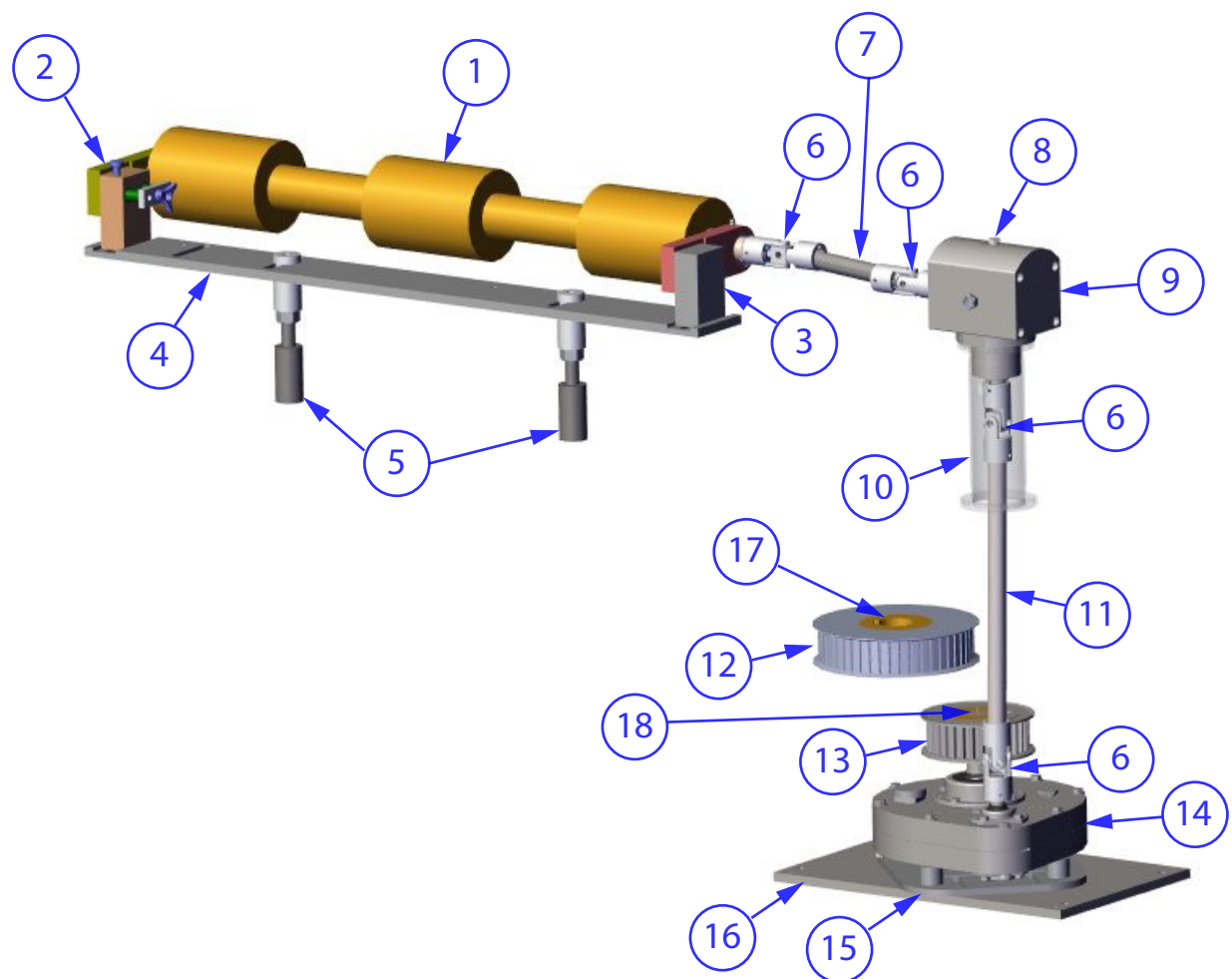
- A** Items critical to machine operation and inventory is imperative.
- B** High wear items that will require replacement within the first year.
- C** Low wear items that will require replacement beyond the first year.
- D** Non-shelf items that require long lead times for delivery.

ALL PRICES ARE HONORED FOR 30 DAYS FROM DATE OF QUOTATION  
ALL PRICES ARE IN US DOLLARS

**US Bottlers Machinery Company, Inc**

11911 Steele Creek Road, Charlotte, NC 28273 <> PO Box 7203, Charlotte, NC 28241  
Phone: 704.587.0231 / 704.587.0232 Fax: 704.588.3808  
parts@usbottlers.com  
www.usbottlers.com

## Worm Drive Assembly

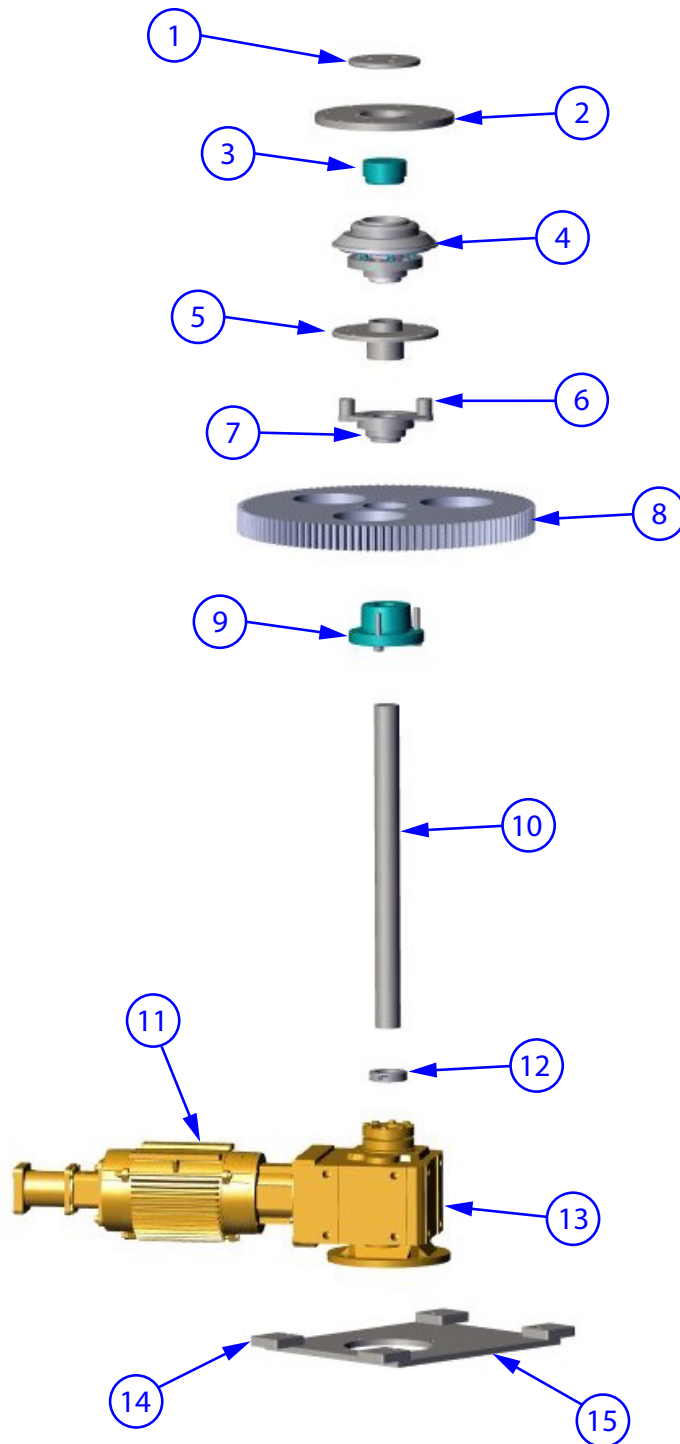


**Figure 4-5: *Worm Drive Assembly***

## Worm Drive Assembly (continued)

| Item Number | Part Number | Detail                                                                               | Quantity |
|-------------|-------------|--------------------------------------------------------------------------------------|----------|
| 1           | A18540      | WORM ASSEMBLY, BOTTLE SPECIFIC                                                       | 1        |
| 2           | A19615      | BRACKET ASS'Y COMPLETE- 3/4" BRG-WORM IDL                                            | 1        |
| 3           | A19616      | BRACKET ASSY COMPLETE- 1" DRIVE COUPLING-                                            | 1        |
| 4           | B12213      | PLATE- WORM MOUNT- FIXED HT                                                          | 1        |
| 5           | A20307      | POST ASSY- ADJUSTABLE WORM SUPPORT                                                   | 2        |
| 6           | A18468      | U-JOINT- SS- 1 X 1- BOOTED- KEYED                                                    | 3        |
| 7           | X72458      | SHAFT- 1" DIA SS X 12" LONG- FEEDWORM                                                | 1        |
| 8           | A93534      | BREATHER - VENT - 1/4" NPT SS                                                        | 1        |
| 9           | B13471      | 90 DEGREE GEARBOX - BACK GEAR DRIVE - WORM DRIVE<br>[SHIPPED WITHOUT OIL IN GEARBOX] | 1        |
| 10          | X85460      | SUPPORT STAND, WORM DRIVE                                                            | 1        |
| 11          | A18487      | SHAFT-1" DIA-SS- GBOX/GBOX- 17"                                                      | 1        |
| 12          | A19459      | SPROCKET- 14MM PITCH- 48 T 37 MM WIDE                                                | 1        |
| 13          | A19452      | SPROCKET- 14MM PITCH- 32 T 37 MM WIDE                                                | 1        |
| 14          | B13533      | GEARBOX - PARALLEL SHAFT - 8:1                                                       | 1        |
| 15          | C11123      | REDUCER BASE- PARALLEL SHAFT "E" & "F"                                               | 1        |
| 16          | X85578      | PLATE - GEARBOX MOUNT - WORM DRIVE                                                   | 1        |
| 17          | A19889      | BUSHING- TL- 3020 X 2                                                                | 1        |
| 18          | A19884      | BUSHING- TL- 2517 X 1-1/4                                                            | 1        |

## Motor Drive Train Assembly

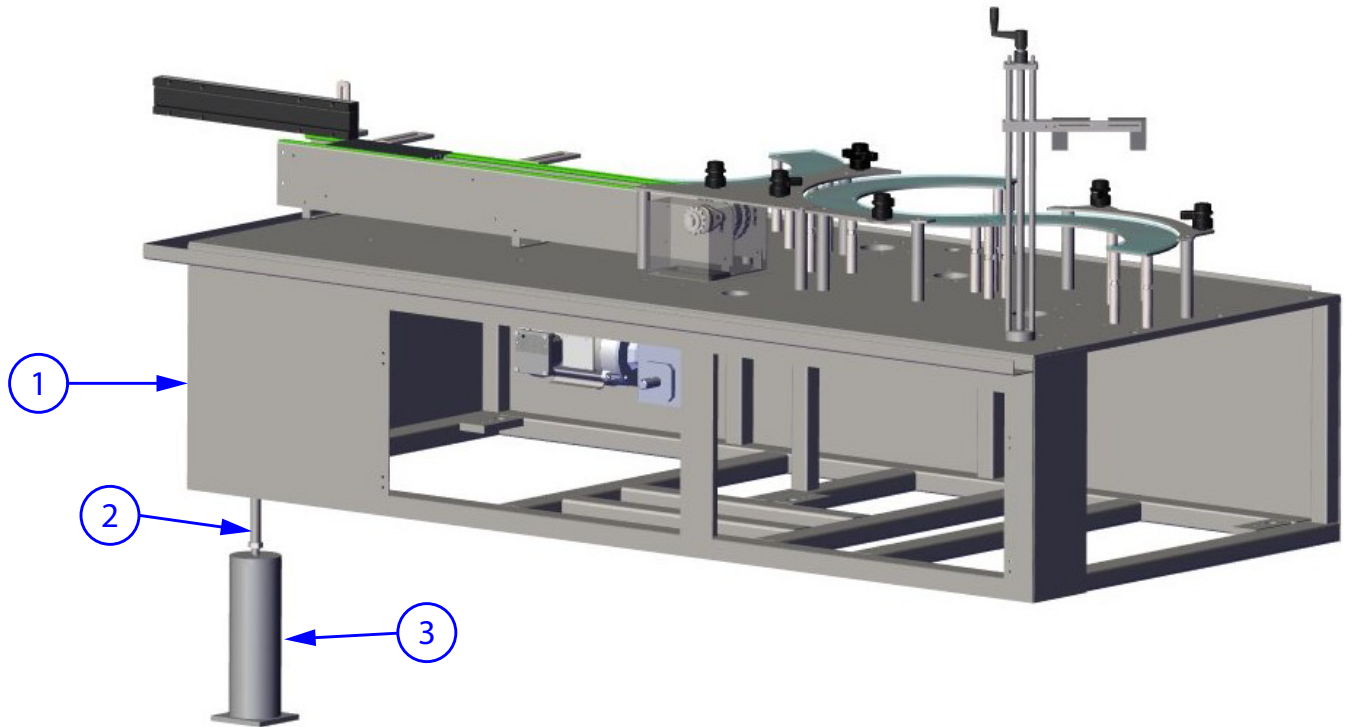


**Figure 4-6: Motor Drive Train Assembly**

## Motor Drive Train Assembly (continued)

| Item Number | Part Number | Detail                                      | Quantity |
|-------------|-------------|---------------------------------------------|----------|
| 1           | A22021      | COVER - STAR CORE PLATE W/BUSHING HOLES     | 1        |
| 2           | C11900      | PLATE- CORE- STAR TO CLUTCH MOUNT           | 1        |
| 3           | A22020      | HUB - CLUTCH CENTERING- USB CLUTCH          | 1        |
| 4           | A21179      | CLUTCH-MECH O'LOAD-SS- 2"BORE-USB MFG       | 1        |
| 5           | A19402      | HUB- BUSHING-2in-SS- NO BEARING- NO LUBE    | 1        |
| 6           | X89953      | SPACER - STAR BEARING REVERSE               | 2        |
| 7           | A18462      | BEARING- 2" BORE- 2-BOLT FLANGE- SS         | 1        |
| 8           | X90440      | BULL GEAR -- 23..4" PD - 5DP - 117T         | 1        |
| 9           | A19439      | BUSHING- QD STYLE- DODGE- E 2"              | 1        |
| 10          | A24231      | SHAFT - FILLER DRIVE - 2" - STOBBER GEARBOX | 1        |
| 11          | A93682      | MOTOR-2HP XP-VECTOR W/ENCODER see specs     | 1        |
| 12          | A18178      | SET COLLAR- SPLIT- 2" I.D.- SS              | 2        |
| 13          | A94784      | GEARBOX - STOBBER - K513_0780 - 145TC       | 1        |
| 14          | A24068      | EDGE - GEARBOX SUPPORT MOUNT                | 4        |
| 15          | X90611      | GEARBOX MOUNT PLATE - K513                  | 1        |

## Rinser Component Parts



**Figure 4-7: Rinser Component Parts Assembly**



## Rinser Component Parts (continued)

| Item Number | Part Number | Detail                                 | Quantity |
|-------------|-------------|----------------------------------------|----------|
| 1           | X90439      | CABINET - 58.5" RINSER FRONT - L-R     | 1        |
| 2           | A10505      | FOOT JACK SCREW ASSY- S.S CONSTRUCTION | 6        |
| 3           | X70856      | FOOT- 51" CONV. HEIGHT- SS EXTENSIONS  | 6        |

## Rinser Component Parts (continued)

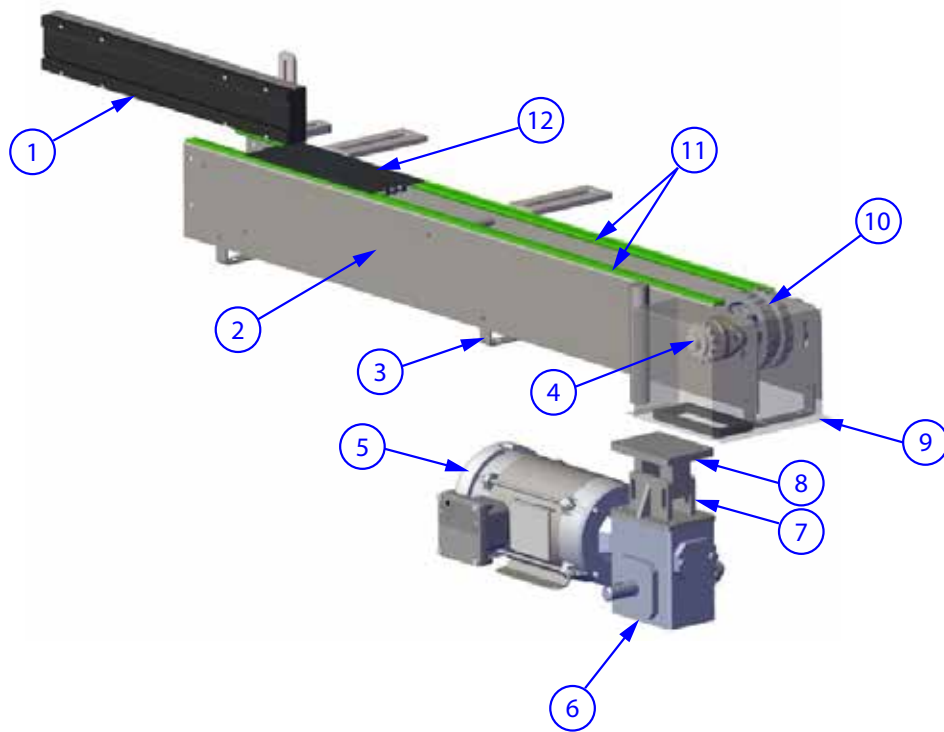


Figure 4-8: *Conveyor Assembly (a)*

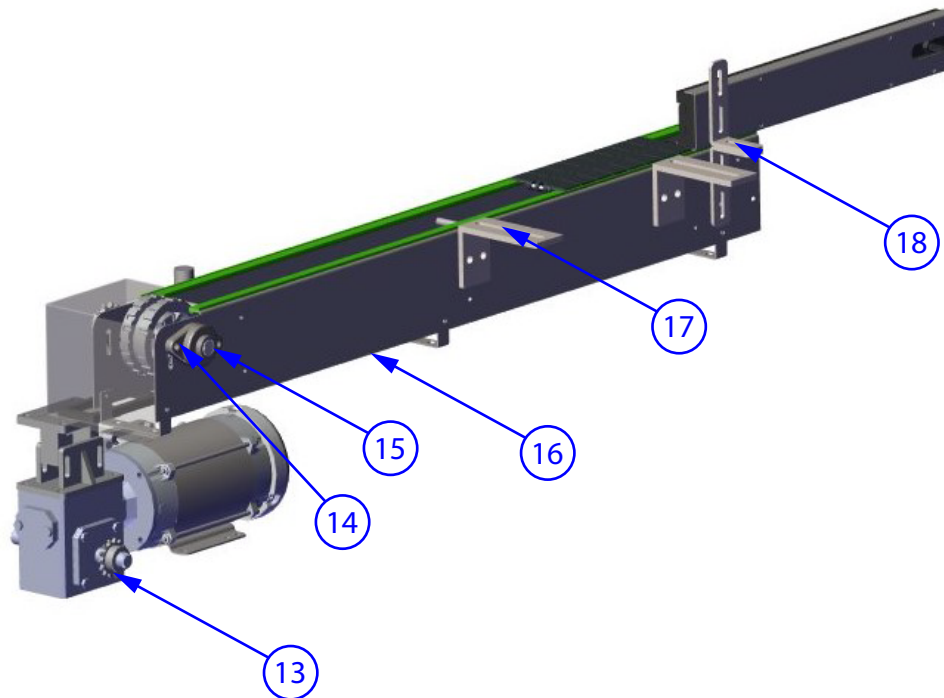
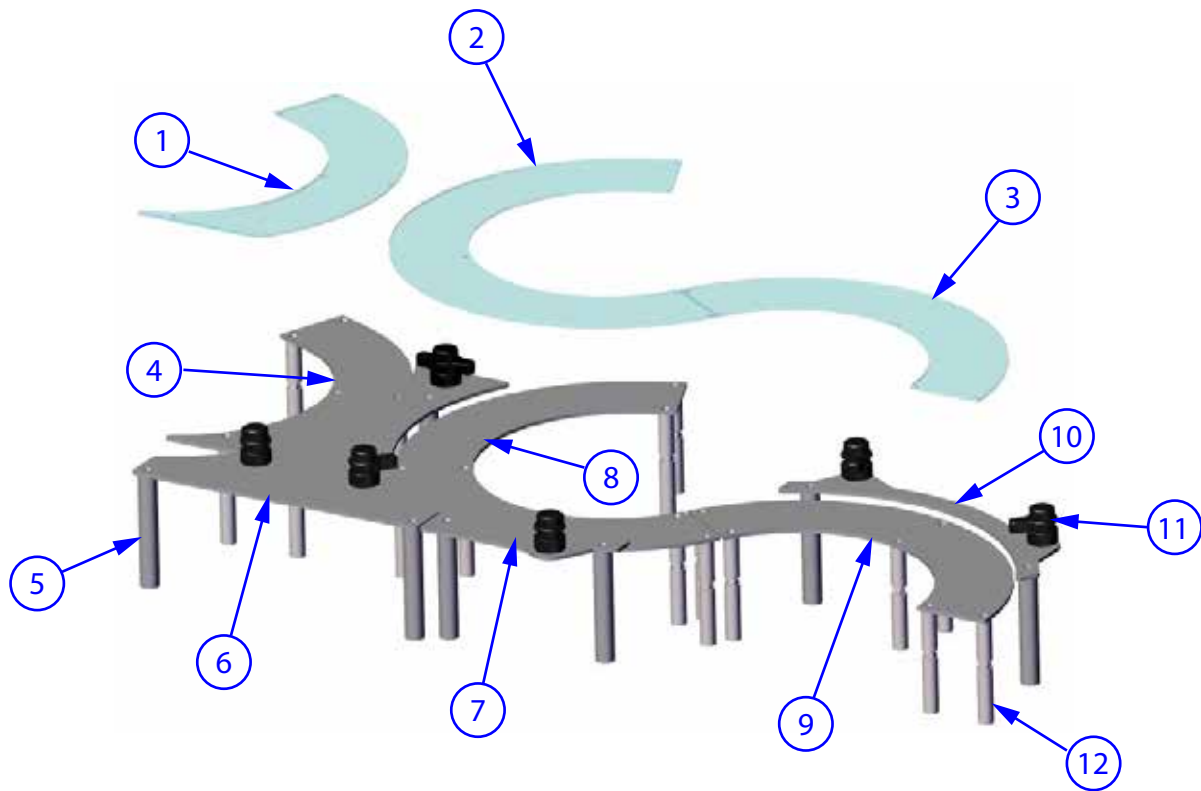


Figure 4-9: *Conveyor Assembly (b)*

## Rinser Component Parts (continued)

| Item Number | Part Number | Detail                                               | Quantity |
|-------------|-------------|------------------------------------------------------|----------|
| -----       | -----       | <b>CONVEYOR ASSEMBLY PARTS</b>                       | --       |
| 1           | A90988      | BOTTLE STOP- 2' BLADDER DEVICE                       | 1        |
| 2           | X90444      | INFEED CONV FRONT FRAME - 58.5" RINSER               | 1        |
| 3           | A23924      | CONVEYOR BKT - 7-1/2" CONV. HEIGHT - 4-1/2" CHAIN    | 3        |
| 4           | A92604      | SPROCKET - SS - 50B13 1" BORE                        | 1        |
| 5           | A93764      | MOTOR- 1HP- 143TC- XP-INVERTER DUTY                  | 1        |
| 6           | A94666      | GEARBOX 15:1 WORM - WASHDOWN - DOUBLE OUTPUT - 140TC | 1        |
| 7           | B13514      | GR821 GEARBOX BASE - ADJUSTABLE - CONV DRIVE         | 1        |
| 8           | B13513      | MOUNT - INFEED CONVEYOR DRIVE BASE                   | 1        |
| 9           | X90604      | CONVEYOR DRIVE COVER                                 | 1        |
| 10          | A19507      | SPROCKET- 21 TEETH 815/820 CHAIN- 1"ID               | 1        |
| 11          | A94082      | WEAR STRIP PROFILE                                   | 12       |
| 12          | A93132      | CONVEYOR CHAIN                                       | A/R      |
| 13          | A94686      | SPROCKET - 14T - #50 - SS - 1" BORE W/ KEYWAY        | 1        |
| 14          | A10515      | BEARING- 2 BLT FLNG- 1" SHAFT                        | 2        |
| 15          | A21180      | SHAFT- CONVEYOR DRIVE - 9-1/4" LONG                  | 1        |
| 16          | X90443      | INFEED CONV BACK FRAME - 58.5" RINSER                | 1        |
| 17          | A18316      | BRACKET- WORM IDLER LOWER SUPPORT                    | 2        |
| 18          | A90990      | BRACKET- BOTTLE STOP MOUNTING- SS                    | 2        |
| 19          | A23530      | CONVEYOR SIDE SPACER - 4-1/2" CHAIN (not shown)      | 10       |
| 20          | A23531      | CONVEYOR CHAIN ROLLER - 4-1/2" CHAIN (not shown)     | 5        |
| 21          | X90605      | CONVEYOR DRIVE DAM (not shown)                       | 1        |

## Rinser Component Parts (continued)

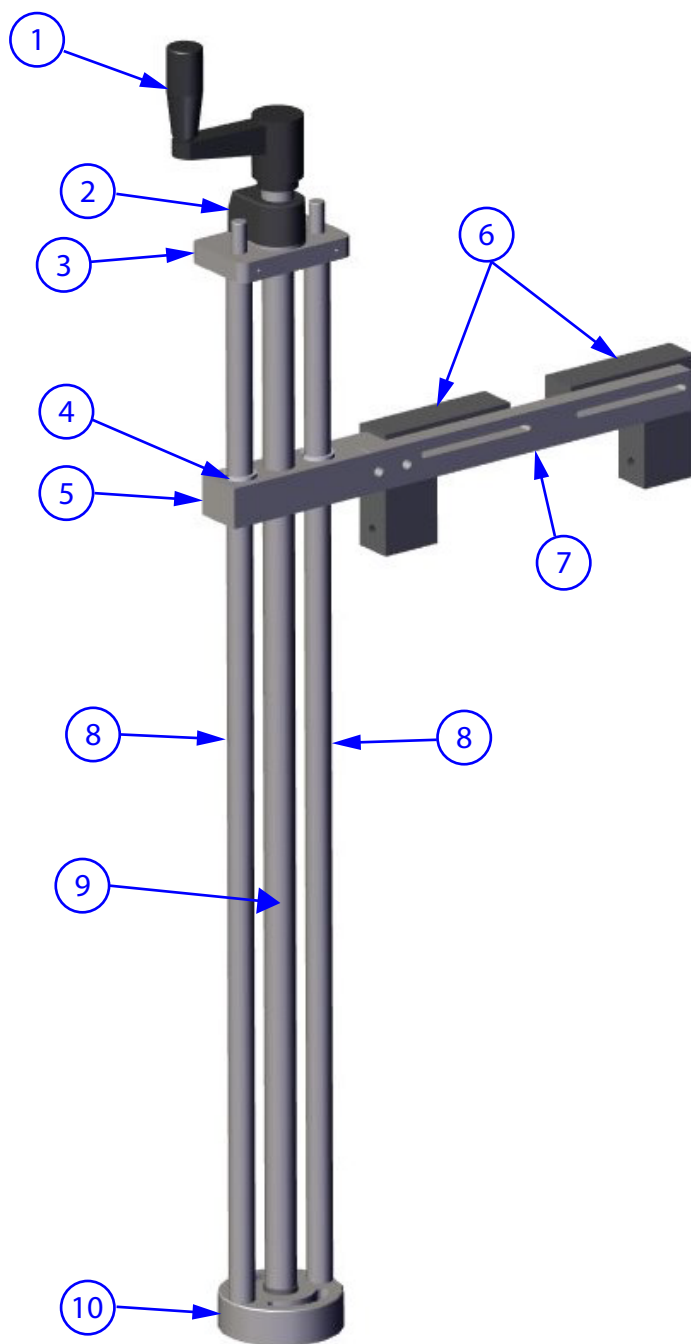


**Figure 4-10: *Rinser Plates***

## Rinser Component Parts (continued)

| Item | Part Number | Description                                      | Qty |
|------|-------------|--------------------------------------------------|-----|
| --   | -----       | <b>RINSER PLATES</b>                             | --  |
| 1    | X90450      | CROSSOVER PLATE- RINSER INFEED - 23.4" STAR      | 1   |
| 2    | X90452      | CROSSOVER PLATE - RINSER DISCH - 23.4" STAR      | 1   |
| 3    | X90454      | CROSSOVER PLATE - 23.4" TRANSFER - RINSER-FILLER | 1   |
| 4    | X90449      | SUPPORT PLATE - RINSER INFEED - 23.4" STAR       | 1   |
| 5    | X75612      | POST - 1-1/4"DIA - CORE PLT MOUNT - SS           | 8   |
| 6    | X90455      | CORE PLATE - RINSER INFEED - 23.4" STAR          | 1   |
| 7    | X90456      | CORE PLATE - RINSER DISCH- 23.4" STAR            | 1   |
| 8    | X90451      | SUPPORT PLATE - RINSER DISCH - 23.4" STAR        | 1   |
| 9    | X90453      | SUPPORT PLATE - 23.4" TRANSFER - RINSER-FILLER   | 1   |
| 10   | X90457      | CORE PLATE - 23.4" TRANSFER - RINSER-FILLER      | 1   |
| 11   | A20274      | SINGLE LOBE KNOB ASSY- SPRING HOLD DOWN          | 6   |
| 12   | A17136      | POST- CROSSOVER SUPPORT- MODEL A-C-E             | 20  |

## Rinser Component Parts (continued)

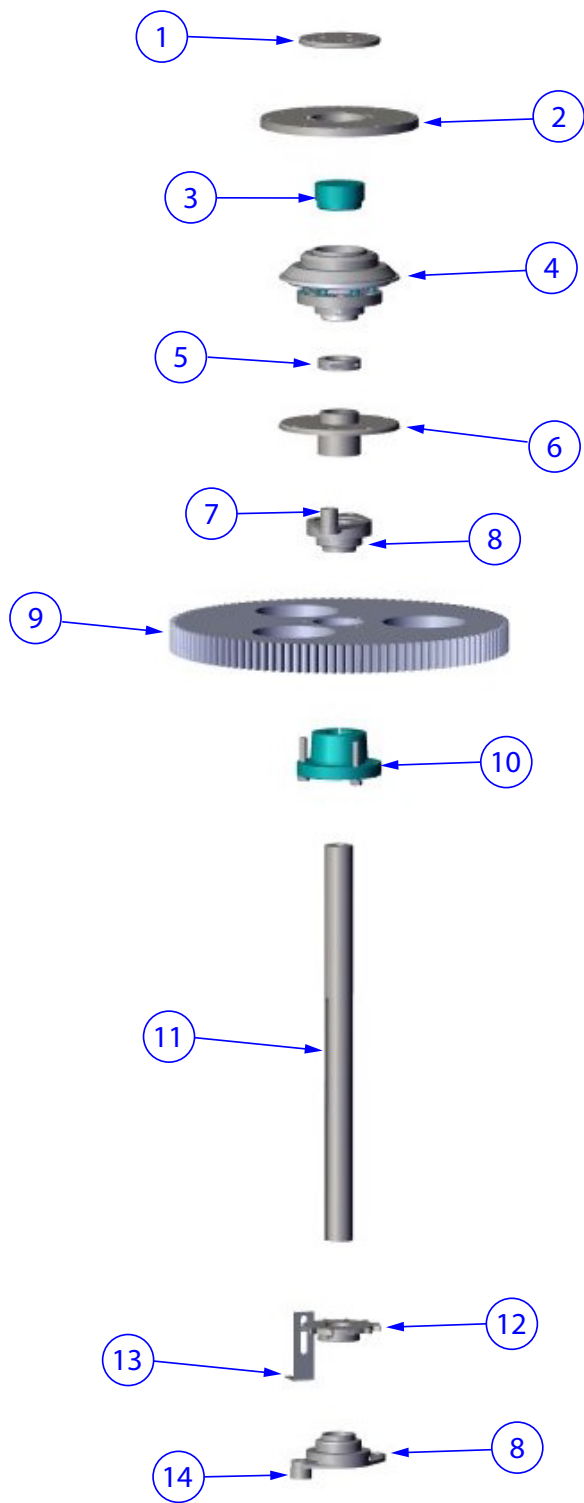


**Figure 4-11: *Bottle Present Sensor Bracket***

## Rinser Component Parts (continued)

| Item | Part Number   | Description                                          | Qty |
|------|---------------|------------------------------------------------------|-----|
| --   | <b>X90807</b> | <b>BOTTLE PRESENT SENSOR BRACKET ASSEMBLY</b>        | --  |
|      |               |                                                      |     |
| 1    | X84917        | HANDLE- ADJ. CRANK- GLASS FILLED NYLON               | 1   |
| 2    | X84912        | POSITION INDICATOR                                   | 1   |
| 3    | X90804        | PLATE - TOP MTG BTL PRESENT SENSOR BKT 2 GUIDE ROD   | 1   |
| 4    | A15702        | BUSHING- FILLER GUIDE ROD BLOCK                      | 2   |
| 5    | X90806        | MTG ARM - BTL PRESENT SENSOR BKT 2 GUIDE ROD         | 1   |
| 6    | A22357        | BRACKET - PASS-THROUGH FIBER OPTIC                   | 2   |
| 7    | X84927        | BRACKET - BOTTLE PRESENT EYE                         | 1   |
| 8    | X84914        | ROD - GUIDE - ACTUATOR                               | 2   |
| 9    | X84913        | ROD - THREADED- 3/4-8 ACME - RH                      | 1   |
| 10   | X90805        | BASE - ADJUSTER BTL PRESENT SENSOR BRKT 2 GUIDE ROD  | 1   |
| 11   | A93188        | WASHER - ADJUSTER (not shown)                        | 1   |
| 12   | A22163        | FITTING-GREASE-STRAIGHT-1/8" NPT 304SS (not shown)   | 1   |
| 13   | A20338        | SNAP RING- 1/2" EXTERNAL- SS (not shown)             | 1   |
| 14   | X84918        | BUSHING - ADJUSTABLE BASE (not shown)                | 1   |
| 15   | X84919        | BUSHING - ADJUSTABLE UPPER (not shown)               | 1   |
| 16   | A22608        | PIN- SPRING- 1/8" OD X 1-1/4" LG 18-8 SS (not shown) | 2   |

## Rinser Infeed Star Shaft



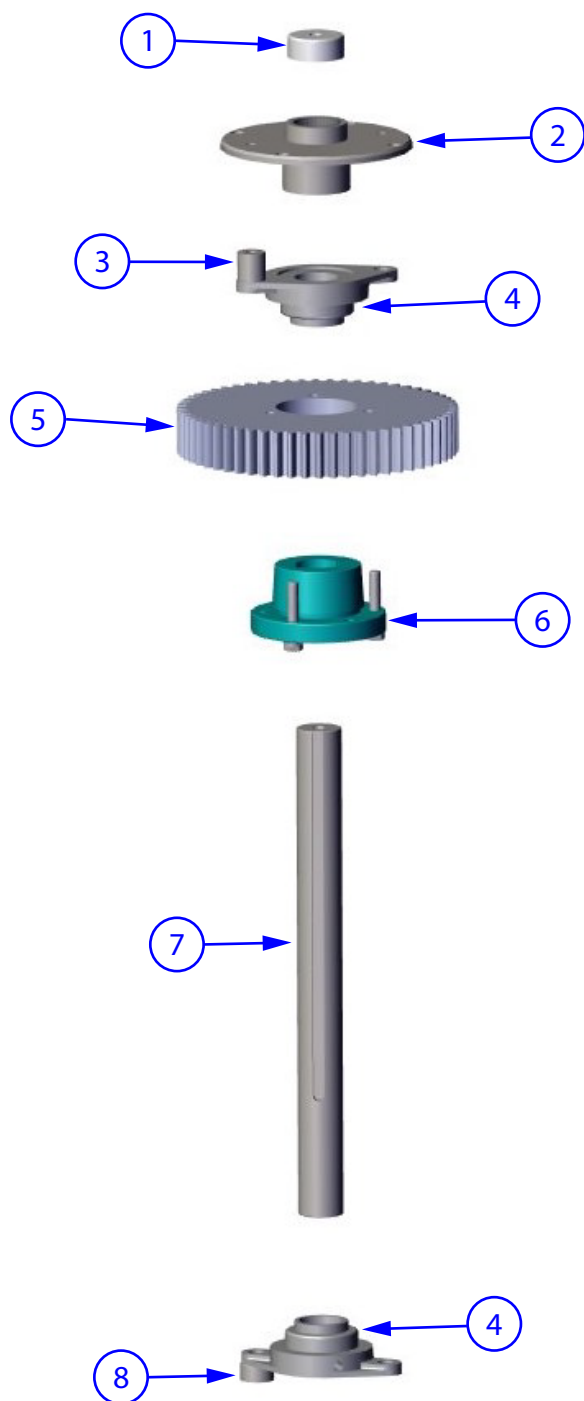
**Figure 4-12: Rinser Infeed Star Shaft Assembly**



## Rinser Infeed Star Shaft (continued)

| Item Number | Part Number | Detail                                   | Quantity |
|-------------|-------------|------------------------------------------|----------|
| 1           | A22021      | COVER - STAR CORE PLATE W/BUSHING HOLES  | 1        |
| 2           | C11900      | PLATE- CORE- STAR TO CLUTCH MOUNT        | 1        |
| 3           | A22020      | HUB - CLUTCH CENTERING- USB CLUTCH       | 1        |
| 4           | A21179      | CLUTCH-MECH O'LOAD-SS- 2"BORE-USB MFG    | 1        |
| 5           | A18178      | SET COLLAR- SPLIT- 2" I.D.- SS           | 1        |
| 6           | A19402      | HUB- BUSHING-2in-SS- NO BEARING- NO LUBE | 1        |
| 7           | X89953      | SPACER - STAR BEARING REVERSE            | 2        |
| 8           | A18462      | BEARING- 2" BORE- 2-BOLT FLANGE- SS      | 2        |
| 9           | X90440      | BULL GEAR -- 23.4" PD - 5DP - 117T       | 1        |
| 10          | A19439      | BUSHING- QD STYLE- DODGE- E 2"           | 1        |
| 11          | A24198      | SHAFT - STAR - 2" 5" TOP KEYWAY          | 1        |
| 12          | X74264      | TIMING STAR- 2" BORE- 12 TEETH- SS       | 1        |
| 13          | A16629      | BRACKET- STAR SHAFT- PROX SENSOR MOUNTIN | 1        |
| 14          | A23191      | SPACER, WELD ON, STAR SHAFT BEARING      | 2        |

## Rinser Transfer Star Shaft



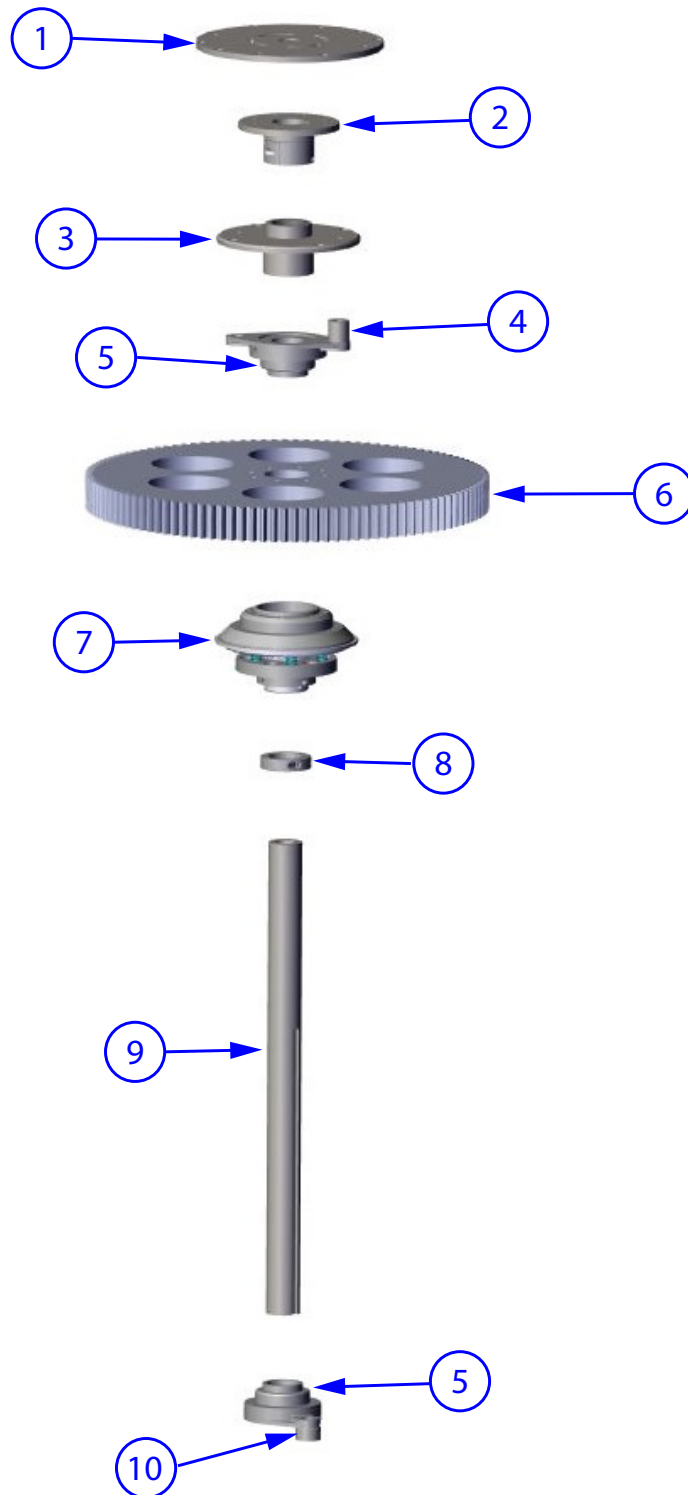
**Figure 4-13: Rinser Transfer Star Shaft Assembly**



## Rinser Transfer Star Shaft (continued)

| Item Number | Part Number | Detail                                   | Quantity |
|-------------|-------------|------------------------------------------|----------|
| 1           | A23824      | SHAFT CAP - 2" SHAFT - NYLON             | 1        |
| 2           | A19402      | HUB- BUSHING-2in-SS- NO BEARING- NO LUBE | 1        |
| 3           | X89953      | SPACER - STAR BEARING REVERSE            | 2        |
| 4           | A18462      | BEARING- 2" BORE- 2-BOLT FLANGE- SS      | 2        |
| 5           | X90442      | BULL GEAR - 12" PD - 5DP - 60T           | 1        |
| 6           | A19439      | BUSHING- QD STYLE- DODGE- E 2"           | 1        |
| 7           | A24198      | SHAFT - STAR - 2" 5" TOP KEYWAY          | 1        |
| 8           | A23191      | SPACER, WELD ON, STAR SHAFT BEARING      | 2        |

## Rinser Discharge Star Shaft



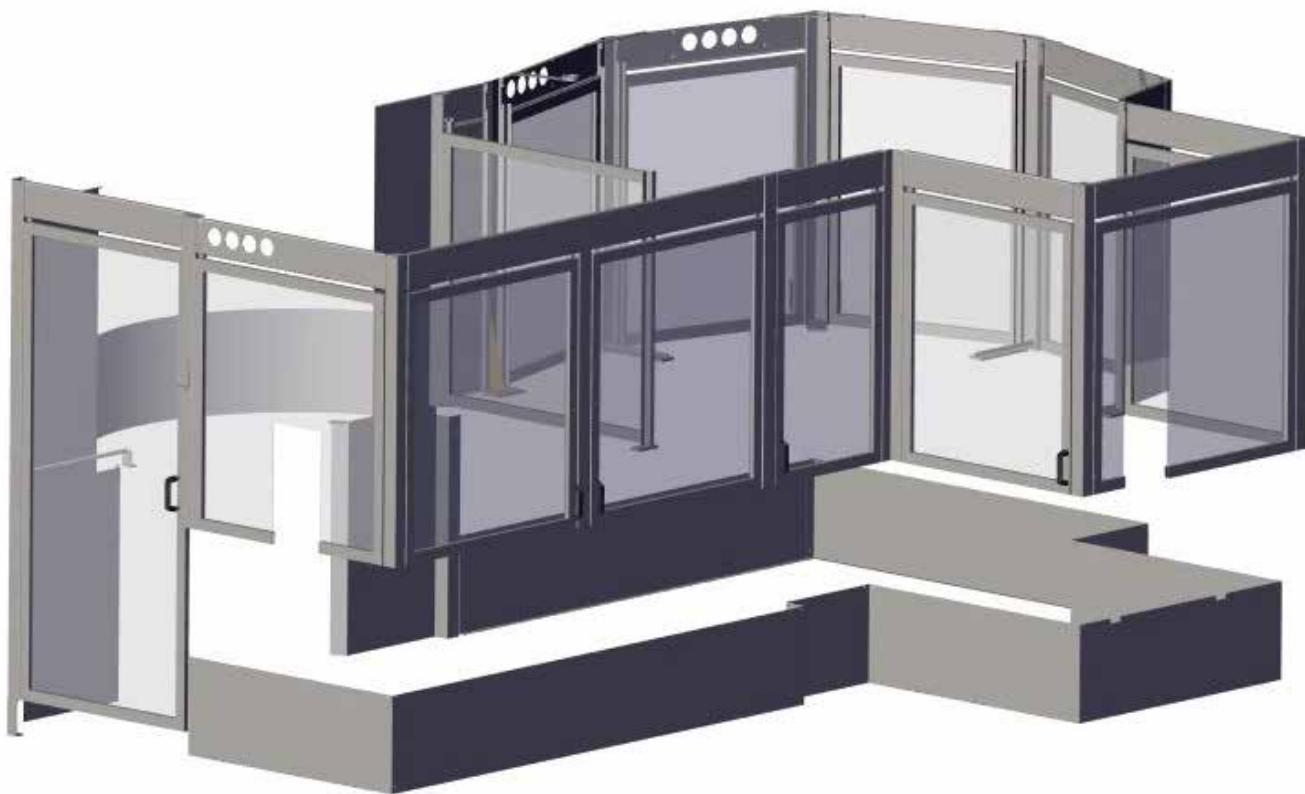
**Figure 4-14: Rinser Discharge Star Shaft Assembly**



## Rinser Discharge Star Shaft (continued)

| Item Number | Part Number | Detail                                      | Quantity |
|-------------|-------------|---------------------------------------------|----------|
| 1           | A19366      | CORE- 20"/22"/26"/31" STAR- Q-CHANGE- SS    | 1        |
| 2           | A18980      | HUB W/COLLAR- 2" STAR SHAFT- SS             | 1        |
| 3           | A19402      | HUB- BUSHING-2in-SS- NO BEARING- NO LUBE    | 1        |
| 4           | X89953      | SPACER - STAR BEARING REVERSE               | 2        |
| 5           | A18462      | BEARING- 2" BORE- 2-BOLT FLANGE- SS         | 2        |
| 6           | X90441      | GEAR - CLUTCH MOUNT - 23.4" PD - 5DP - 117T | 1        |
| 7           | A21179      | CLUTCH-MECH O'LOAD-SS- 2"BORE-USB MFG       | 1        |
| 8           | A18178      | SET COLLAR- SPLIT- 2" I.D.- SS              | 1        |
| 9           | A24198      | SHAFT - STAR - 2" 5" TOP KEYWAY             | 1        |
| 10          | A23191      | SPACER, WELD ON, STAR SHAFT BEARING         | 2        |

## Guard Door Assembly (continued)

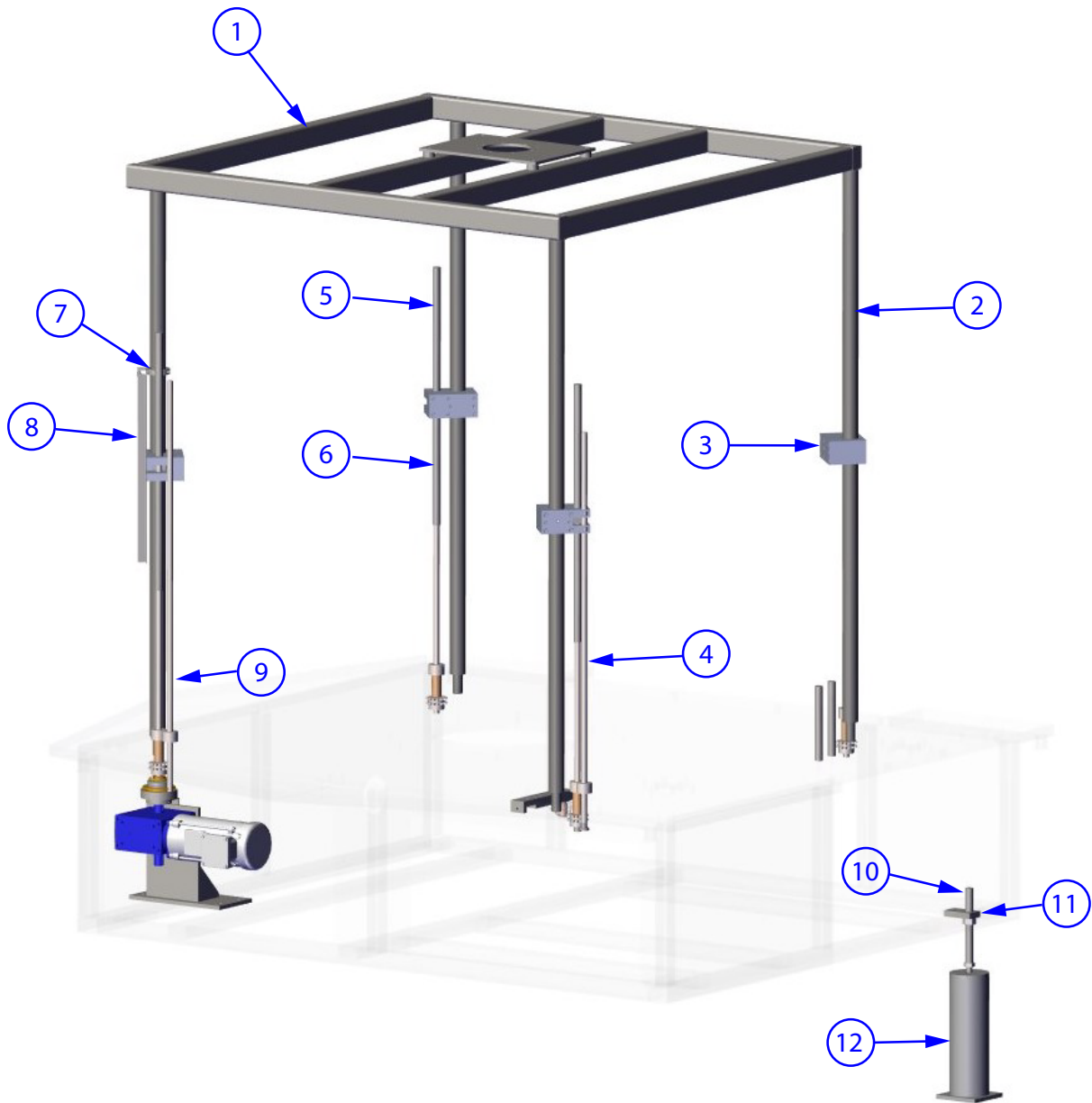


**Figure 4-15: *Guard Door Assembly***

## Guard Door Assembly (continued)

| Item | Part Number   | Description                                   | Qty |
|------|---------------|-----------------------------------------------|-----|
| --   | <b>BM9307</b> | <b>GUARD DOOR ASSEMBLY</b>                    | --  |
|      |               |                                               |     |
| 1    | A92801        | PLATE - DOOR CATCH - PLASTIC COVERED          | 11  |
| 2    | A18324        | HANDLE- PULL- BLACK PLASTIC                   | 11  |
| 3    | A94086        | DOOR HINGE RIGHT - LIFTOFF SS                 | 12  |
| 4    | A94087        | DOOR HINGE LEFT - LIFTOFF SS                  | 10  |
| 5    | A92800        | CATCH - MAGNETIC - CHEMICAL RESISTANT         | 11  |
| 6    | X90459        | ASSEMBLY - GUARDING - DOORS & PANELS - 122300 | 1   |
| 7    | X90460        | ASSEMBLY - GUARDING - TOP RAILS - 122300      | 1   |
| 8    | A94356        | SCHMERSAL LOCKING DOOR SAFETY SWTCH C1D2      | 11  |
| 9    | A23978        | DOOR SWITCH BRACKET FOR A94356                | 11  |
| 10   | X90207        | E-STOP MOUNTING BRACKET                       | 3   |
| 11   | X90458        | SKIRT - LUXCO TRI-BLOCK - 122300              | 1   |

## Main Chassis Assembly



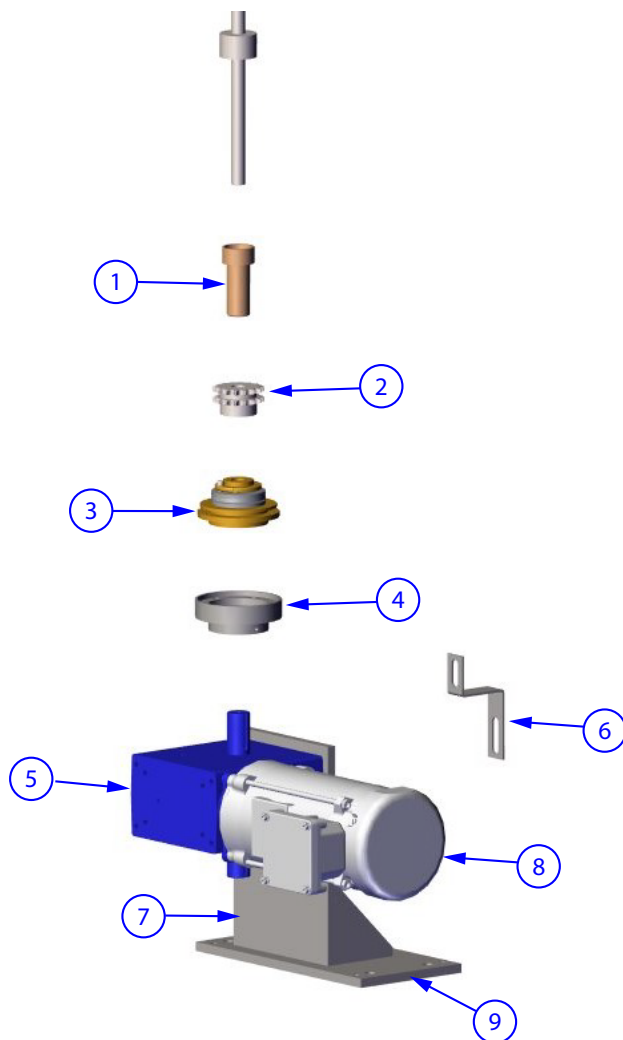
**Figure 4-16: Main Chassis Assembly**



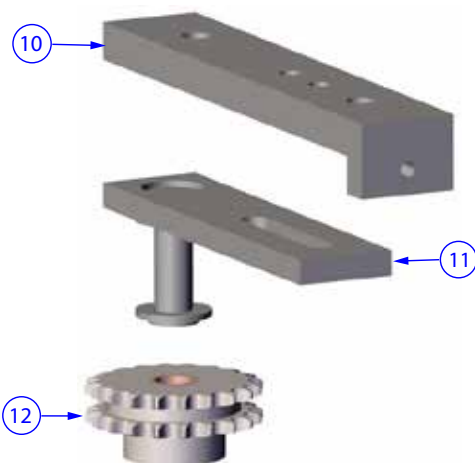
## Main Chassis Assembly (continued)

| Item Number | Part Number | Detail                                     | Quantity |
|-------------|-------------|--------------------------------------------|----------|
| 1           | X90585      | ROOF - 78" FILLER                          | 1        |
| 2           | A17235      | CAM RAISING STUD- WE & F 304SS             | 4        |
| 3           | X89944      | CAM STUD BEARING BLOCK - SPLIT - MODEL "E" | 4        |
| 4           | B13461      | CAM ADJUST SCREW - SHORT - 3/4-10 CUSTOM   | 3        |
| 5           | X90131      | CAM RAISING SCREW TOP COVER                | 4        |
| 6           | X90132      | CAM RAISING SCREW BOTTOM COVER             | 4        |
| 7           | A19968      | BRACKET- SENSOR                            | 2        |
| 8           | A24415      | BRACKET - FILLER CAM HEIGHT LIMIT SENSOR   | 1        |
| 9           | B13462      | CAM ADJUST SCREW, LONG - 3/4-10, CUSTOM    | 3        |
| 10          | A10505      | FOOT JACK SCREW ASSY- S.S CONSTRUCTION     | 1        |
| 11          | A18906      | NUT PLATE- FOOT- 1"-14 THREAD              | 8        |
| 12          | X70856      | FOOT- 51" CONV. HEIGHT- SS EXTENSIONS      | 8        |

## Main Chassis Assembly (continued)



**Figure 4-17: Filler Lift Assembly**



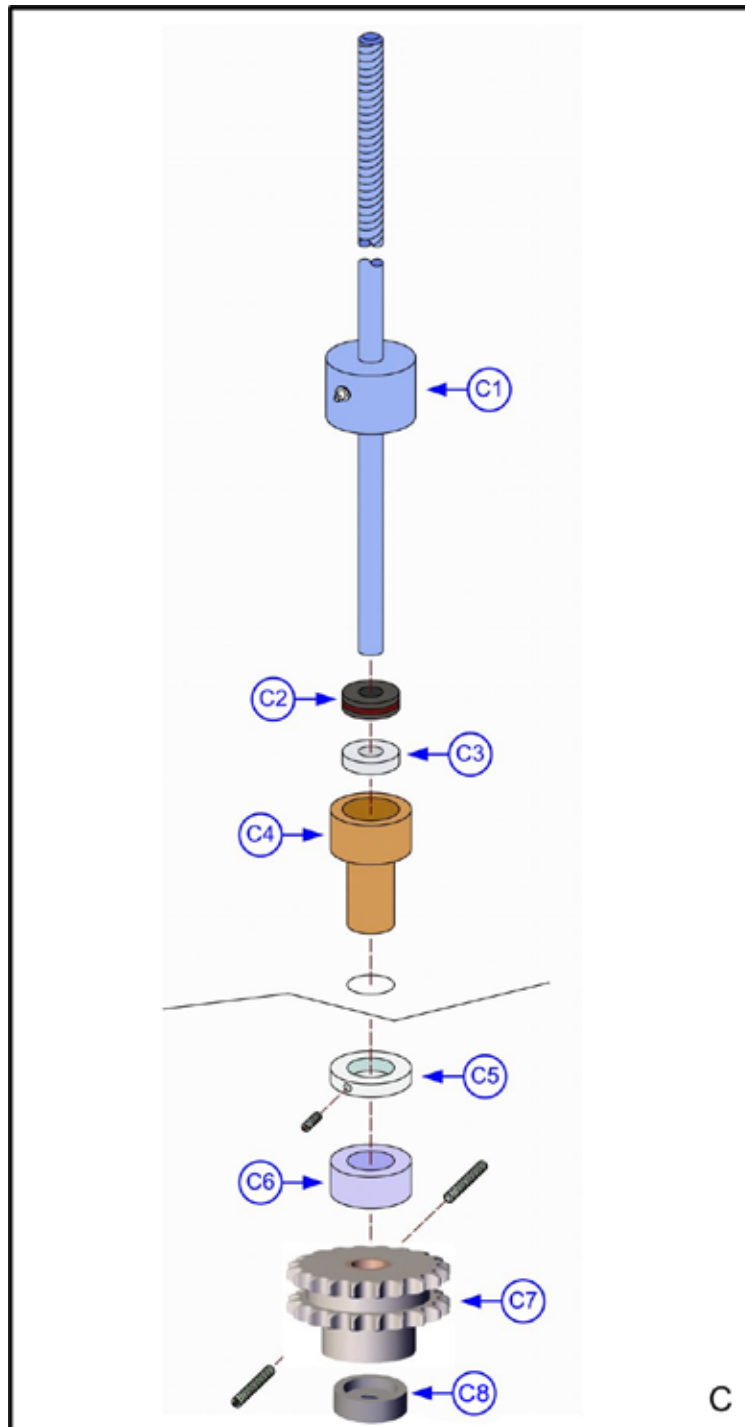
**Figure 4-18: Idler Bracket Assembly**



## Main Chassis Assembly (continued)

| Item Number | Part Number | Detail                                                | Quantity |
|-------------|-------------|-------------------------------------------------------|----------|
| 1           | A18771      | BUSHING- CAM ADJUST- W/DAM- BRASS                     | 1        |
| 2           | A94688      | SPROCKET -DOUBLE - 16T SS #40-2, 3/4" BORE, KEYED     | 1        |
| 3           | A94159      | CLUTCH -FRICTION -3/4" BORE -CAM SCREW                | 1        |
| 4           | B13226      | HUB - CLUTCH CAM SCREW - 1-1/4" BORE                  | 1        |
| 5           | A92354      | GEARBOX - HUB CITY - 264 STYLE A - 60:1               | 1        |
| 6           | A23802      | PROX. MOUNT BRACKET                                   | 1        |
| 7           | X88030      | BRACKET - GEARBOX                                     | 1        |
| 8           | A92854      | MOTOR- 1 HP 3PH 56C, XPFC                             |          |
| 9           | X91024      | PLATE - CAM RAISE GEARBOX MOUNT                       | 1        |
| 10          | A21800      | SPACER- IDLER BRACKET - ADJUSTABLE                    | 2        |
| 11          | A24340      | IDLER BRACKET ASSEMBLY - 3/4" PIN ANTI-ROTATE         | 2        |
| 12          | A24271      | SPROCKET - DOUBLE - 16T SS - #40-2, W/ OILITE BUSHING | 2        |

## Main Chassis Assembly (continued)



**Figure 4-19: CAM Screw and Sprocket Assembly**

## Main Chassis Assembly (continued)

| Item | Part Number | Detail                                            | Qty |
|------|-------------|---------------------------------------------------|-----|
| C1   | B13461      | CAM ADJUST SCREW - SHORT - 3/4-10 CUSTOM          | 3   |
|      | B13462      | CAM ADJUST SCREW, LONG - 3/4-10, CUSTOM           | 1   |
| C2   | A19269      | BEARING, 3/4' THRUST, SS                          | 4   |
| C3   | A19328      | WASHER, THRUST BEARING SPACER, 3/4", SS           | 4   |
| C4   | A18771      | BUSHING, CAM ADJUST, W/DAM, BRASS                 | 4   |
| C5   | A10088      | SET COLLAR- SS- SINGLE PIECE- 1 1/4"              | 4   |
| C6   | -----       | N/A                                               | --  |
| C7   | A94688      | SPROCKET -DOUBLE - 16T SS #40-2, 3/4" BORE, KEYED | 4   |
| C8   | A24503      | SHAFT CAP, CAM SCREW - DOUBLE CHAIN - KEYED       | 3   |

## Component Parts Assembly

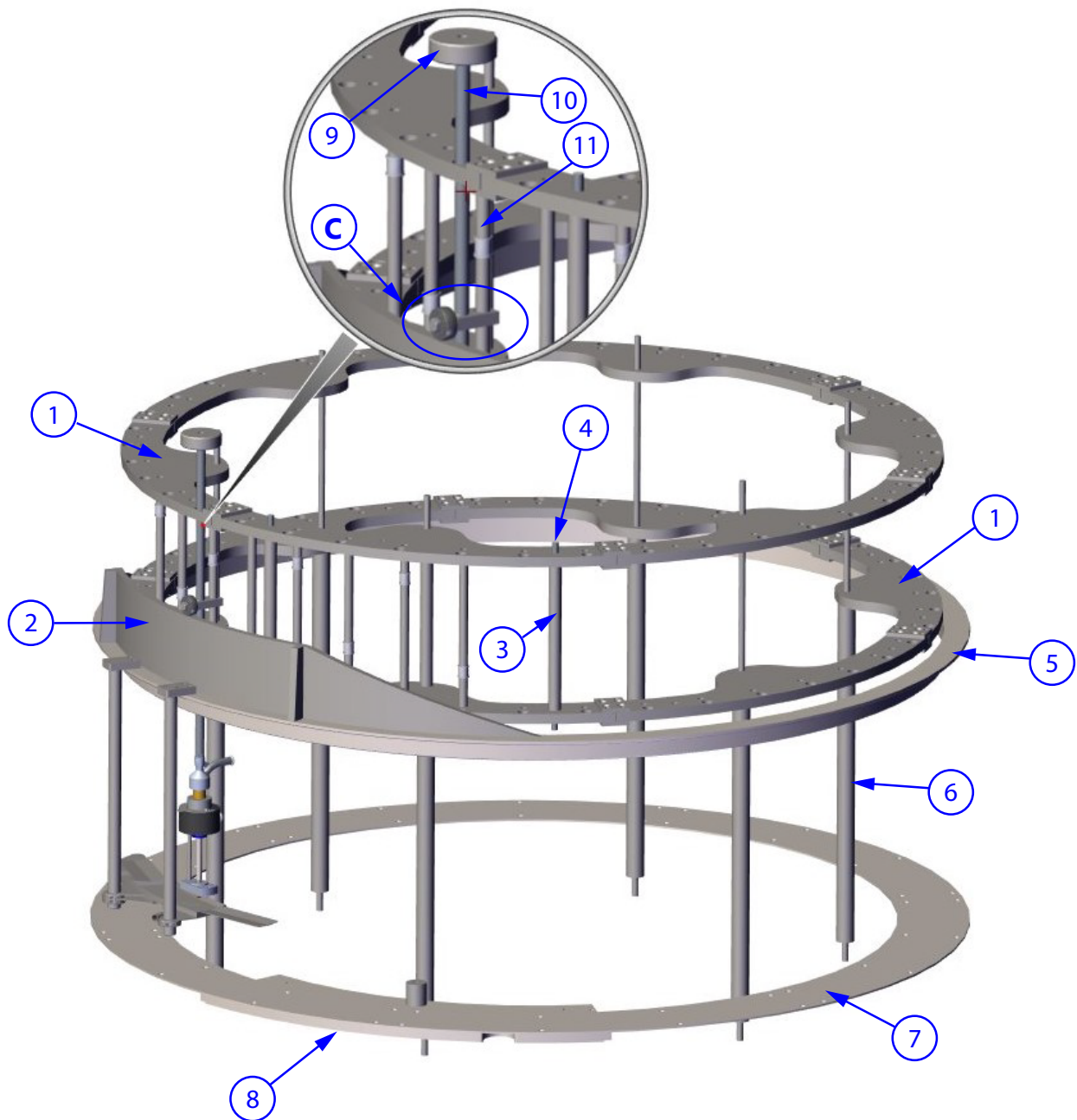
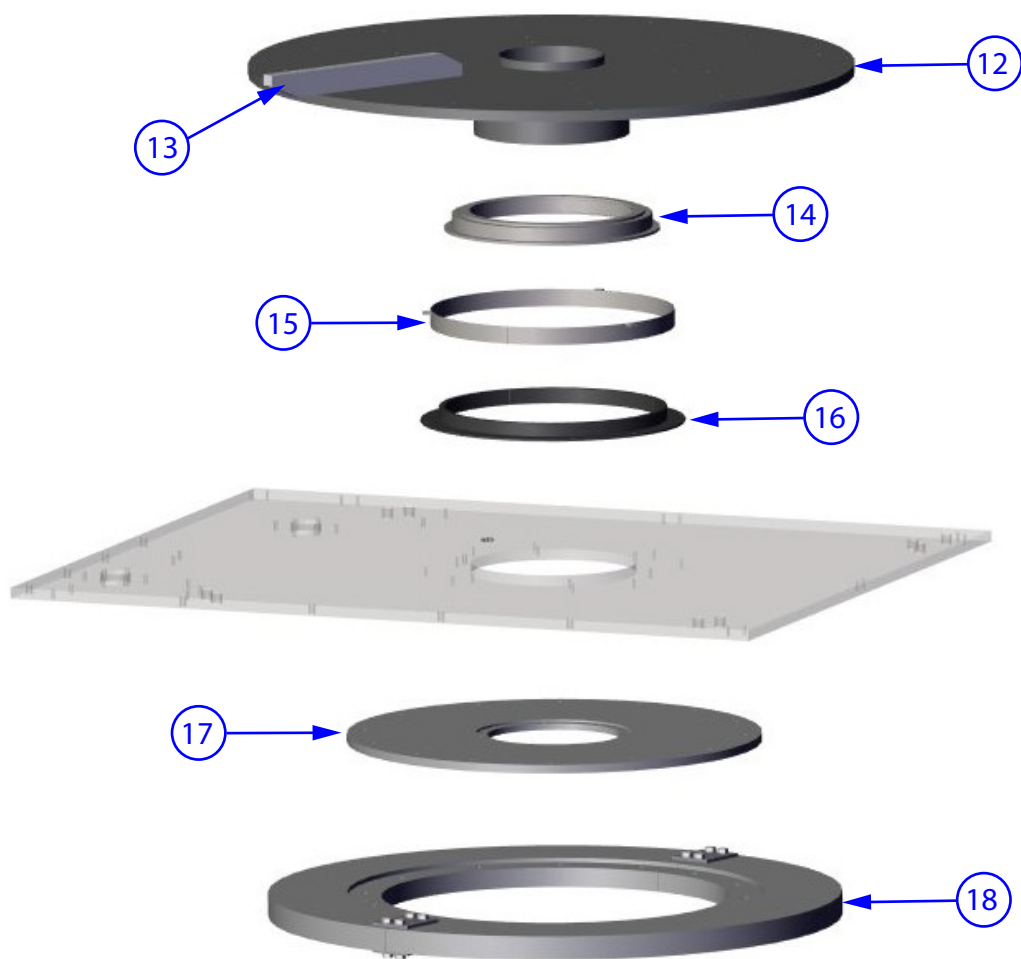


Figure 4-20: *Component Parts\_a*

**Component Parts Assembly (continued)**



**Figure 4-21: *Component Parts\_b***

## Component Parts Assembly (continued)

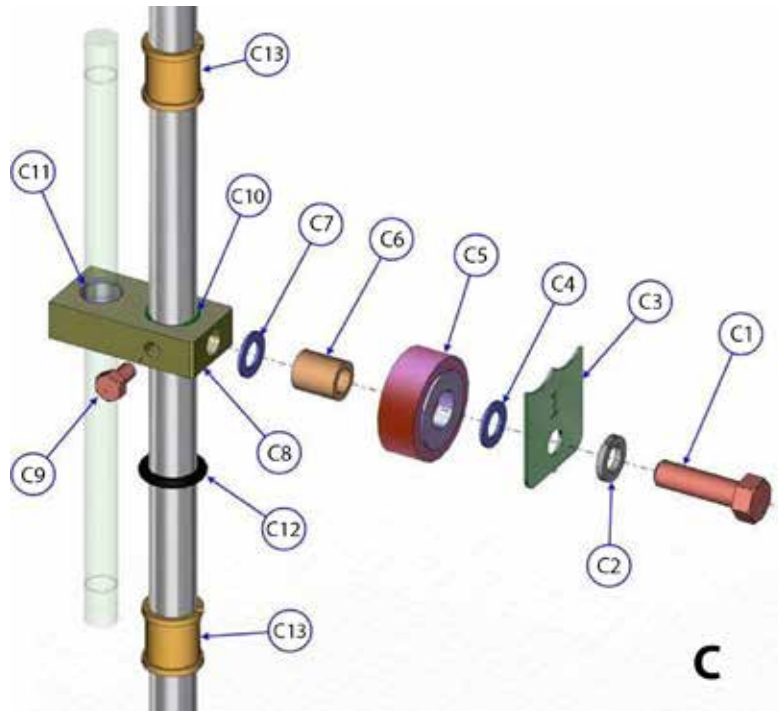


Figure 4-22: *Filler Lift Roller Assembly*

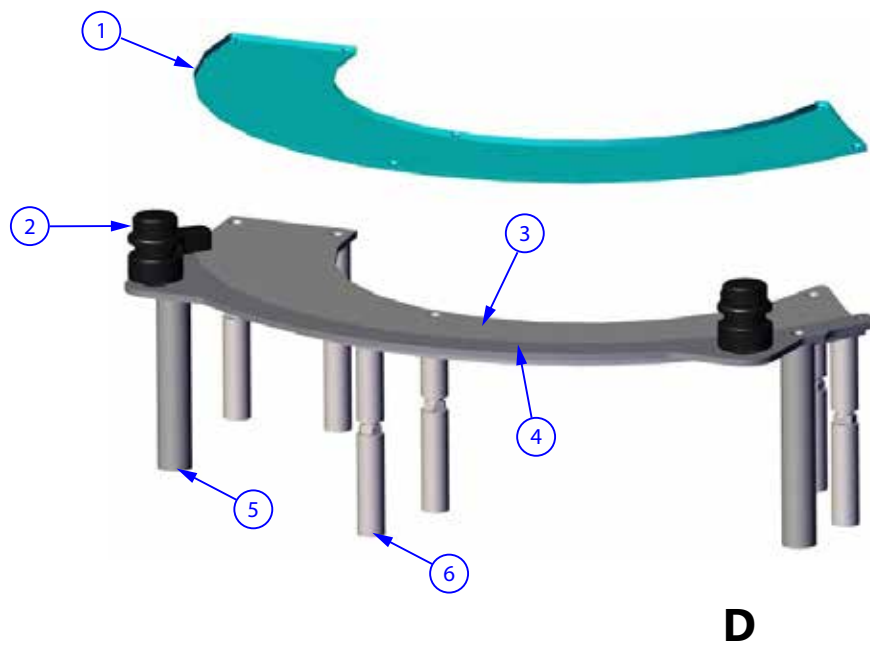
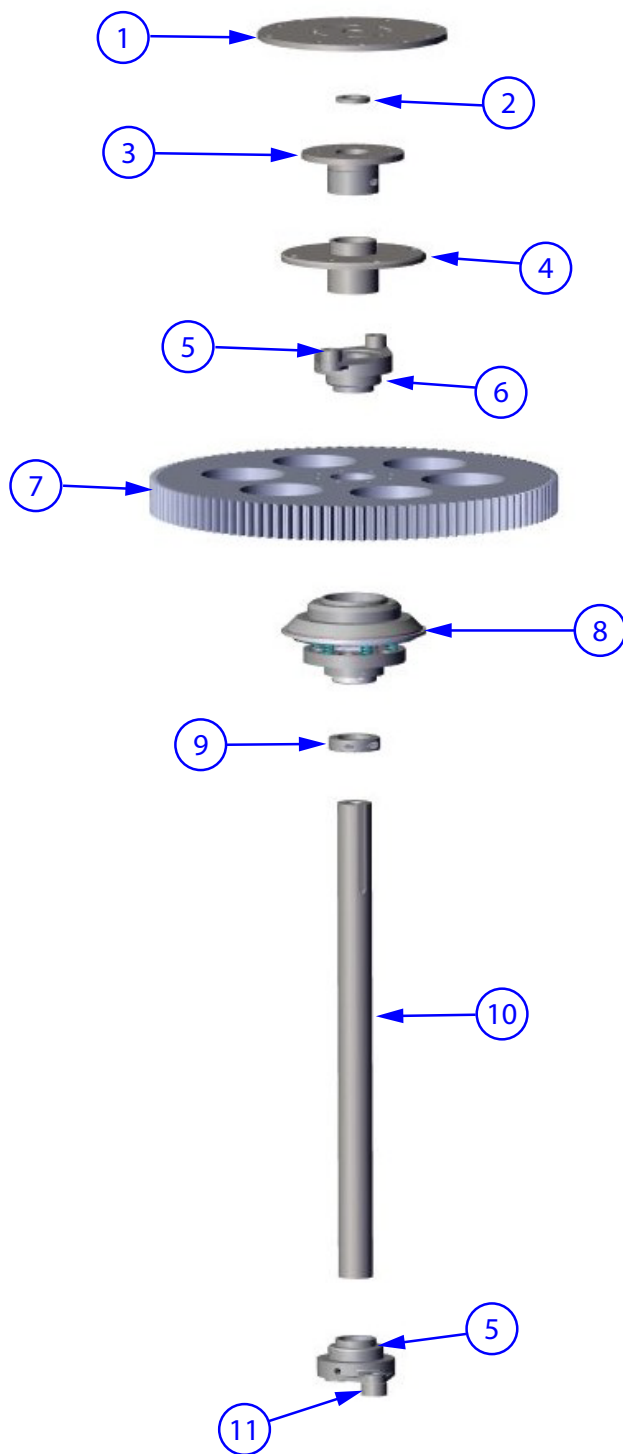


Figure 4-23: *Filler Plates Assembly*

## Component Parts Assembly (continued)

| Item Number | Part Number | Detail                                           | Quantity |
|-------------|-------------|--------------------------------------------------|----------|
| --          | BM9212      | COMPONENT PARTS                                  | --       |
| 1           | X90647      | SLIDE RING 40 HD 78" PD - SS - SEGMENTED         | 2        |
| 2           | B13594      | VALVE LIFT CAM - CUSTOM LIFT - 3/4"              | 1        |
| 3           | X87187      | SLIDE RING SPACER - 14.688"                      | 18       |
| 4           | X87196      | SLIDE RING TIE BOLT                              | 12       |
| 5           | X73917      | CAM RING- 78"PD FILLER- SS- LESS LIFT            | 1        |
| 6           | X79419      | TIE ROD - CUSTOM                                 | 6        |
| 7           | X73913      | BEDPLATE SET- 78" P.D.- 7 GAUGE SS               | 1        |
| 8           | X77125      | SUPPORT SEGMENT - 78"PD W/ CENTER STAR           | 6        |
| 9           | A15739      | WEIGHT- RND SLIDE- 4 1/2 # 304 S.S.              | 40       |
| 10          | X87193      | SLIDE ROD - EXTENDED                             | 40       |
| 11          | X88411      | GUIDE ROD - 7/8" DIA X 14.688" L                 | 40       |
| 12          | X73924      | TANKBASE- 78"PD SS BEDPLATE SUPT- W/DAM          | 1        |
| 13          | X73925      | ARM-SUPPORT FOR CANTILEVERED BEDPLTS-78"         | 6        |
| 14          | B11520      | BEARING- 21 3/8" PD X 2.218" TALL-CORR           | 1        |
| 15          | X89818      | RING - ROLLED - SHROUD                           | 1        |
| 16          | B13380      | CLADDING - FILLER MAIN BEARING 44" PD (SET OF 4) | 4        |
| 17          | X72181      | PLATE-GEAR MOUNT- SS- 66"PD- UNDER CABIN         | 1        |
| 18          | C12031      | GEAR- PLASTIC- 66"PD - "E" FILLER                | 1        |
| C1          | -----       | HEX BOLT                                         | 40       |
| C2          | A15532      | RING, RETAINING FOR 7/8" ROD                     | 40       |
| C3          | A19001      | STATION # -SS- FILLER X QUANTITY                 | 40       |
| C4          | A11815      | WASHER- 33/64 X 7/8 X 1/16 THKTUBE SHANK         | 40       |
| C5          | X84663      | WHEEL - FILLER - TYVAR                           | 40       |
| C6          | A18448      | SLEEVE, ROLLER BOLT, SS                          | 40       |
| C7          | A11815      | WASHER, 33/64" X 7/8" X 1/16" THK TUBE SHANK     | 40       |
| C8          | X80502      | SLIDE BLOCK - FOR 7/8" DIA GUIDE ROD             | 40       |
| C9          | -----       | HEX BOLT                                         | 40       |
| C10         | A15532      | RING, RETAINING FOR 7/8" ROD                     | 40       |
| C11         | A15533      | BUSHING- FILLER SLIDE ROD 7/8" ID NYLATR         | 40       |
| C12         | A15752      | O RING .850ID X .210W 70-80D VITON               | 40       |
| C13         | A15533      | BUSHING- FILLER SLIDE ROD 7/8" ID NYLATR         | 80       |
| D1          | X90656      | CROSSOVER PLATE - FILLER INFEED - 23.4" STAR     | 1        |
| D2          | A20274      | SINGLE LOBE KNOB ASSY- SPRING HOLD DOWN          | 2        |
| D3          | X90655      | SUPPORT PLATE - FILLER INFEED - 23.4" STAR       | 1        |
| D4          | X90657      | CORE PLATE - FILLER INFEED - 23.4" STAR          | 1        |
| D5          | X75612      | POST - 1-1/4"DIA - CORE PLT MOUNT - SS           | 3        |
| D6          | A17136      | POST- CROSSOVER SUPPORT- MODEL A-C-E             | 6        |

## Filler Infeed Star Drive Assembly



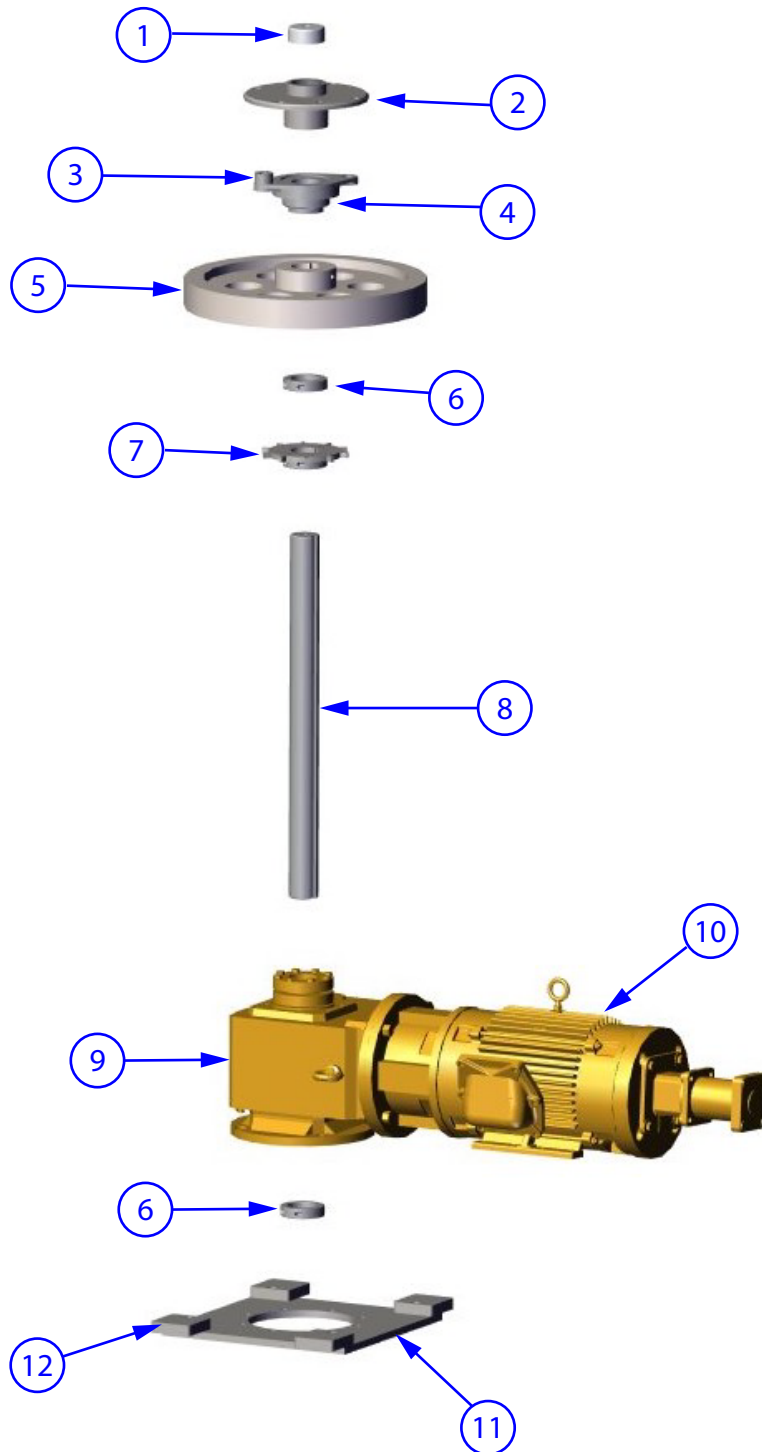
**Figure 4-24: Filler Infeed Star Drive Assembly**



**Filler Infeed Star Drive (continued)**

| Item Number | Part Number | Detail                                      | Quantity |
|-------------|-------------|---------------------------------------------|----------|
| 1           | A19366      | CORE- 20"/22"/26"/31" STAR- Q-CHANGE- SS    | 1        |
| 2           | A19233      | WASHER- 2" COLLAR TO CORE PLATE- SS         | 1        |
| 3           | A18980      | HUB W/COLLAR- 2" STAR SHAFT- SS             | 1        |
| 4           | A19402      | HUB- BUSHING-2in-SS- NO BEARING- NO LUBE    | 1        |
| 5           | A19611      | SPACER- 1-1/4"OD X 17/32"ID X 11/16"L-SS    | 2        |
| 6           | A18462      | BEARING- 2" BORE- 2-BOLT FLANGE- SS         | 2        |
| 7           | X90441      | GEAR - CLUTCH MOUNT - 23.4" PD - 5DP - 117T | 1        |
| 8           | A21179      | CLUTCH-MECH O'LOAD-SS- 2"BORE-USB MFG       | 1        |
| 9           | A18178      | SET COLLAR- SPLIT- 2" I.D.- SS              | 2        |
| 10          | A24198      | SHAFT - STAR - 2" 5" TOP KEYWAY             | 1        |
| 11          | A23191      | SPACER, WELD ON, STAR SHAFT BEARING         | 2        |

## Filler Motor Drive Assembly



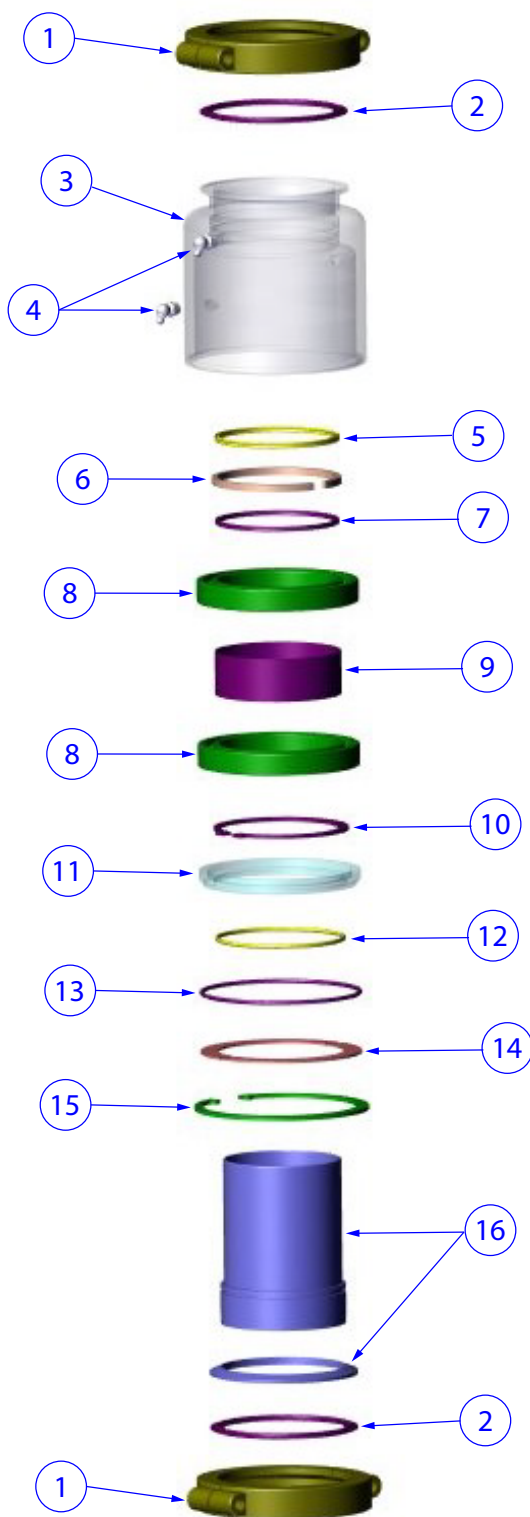
**Figure 4-25: Filler Motor Drive Assembly**



## Filler Motor Drive (continued)

| Item Number | Part Number | Detail                                     | Quantity |
|-------------|-------------|--------------------------------------------|----------|
| 1           | A23824      | SHAFT CAP - 2" SHAFT - NYLON               | 1        |
| 2           | A19402      | HUB- BUSHING-2in-SS- NO BEARING- NO LUBE   | 1        |
| 3           | A19611      | SPACER- 1-1/4"OD X 17/32"ID X 11/16"L-SS   | 2        |
| 4           | A18462      | BEARING- 2" BORE- 2-BOLT FLANGE- SS        | 1        |
| 5           | X70449      | STAR GEAR- SS- MODEL "F"- 2" BORE          | 1        |
| 6           | A18178      | SET COLLAR- SPLIT- 2" I.D.- SS             | 2        |
| 7           | A21508      | TIMING SPROCKET- 10T SPLIT S.S.            | 1        |
| 8           | A24035      | SHAFT - 2" D - 25" L                       | 1        |
| 9           | A94791      | 4718.54GEARBOX - STOBBER - K513_0650 - 180 | 1        |
| 10          | A93752      | MOTOR-3HP XP-VECTOR W/ ENCODER see specs   | 1        |
| 11          | X90577      | PLATE - GEARBOX MOUNT                      | 1        |
| 12          | A24068      | EDGE - GEARBOX SUPPORT MOUNT               | 4        |

## Filler Rotary Union Assembly

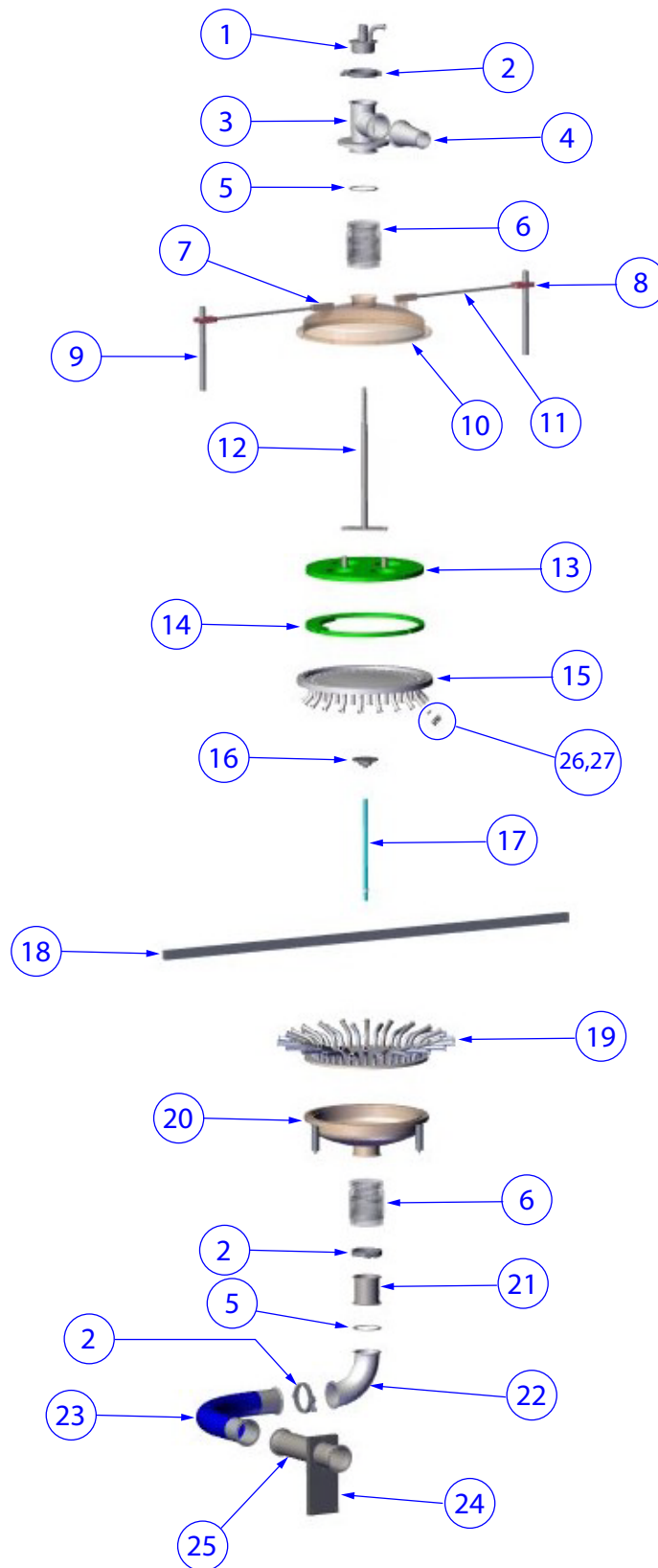


**Figure 4-26: Filler Rotary Union Assembly**

## Filler Rotary Union Assembly (continued)

| Item Number | Part Number   | Detail                                    | Quantity |
|-------------|---------------|-------------------------------------------|----------|
| --          | <b>BM9400</b> | <b>ROTARY UNION ASSEMBLY</b>              | <b>2</b> |
| --          | A21419        | 4" DIA ROTARY UNION                       | 2        |
| 1           | A17062        | CLAMP 4" TRI-CLOVER SANITARY ROTARY UNION | 2        |
| 2           | A19191        | GASKET- 4" TEFLON- WHITE- TRI-CLOVER      | 2        |
| 3           | C11919        | HOUSING- ROTARY UNION- DUAL GREASE PTS    | 1        |
| 4           | A10118        | FITTING- 65 DEG ALEMITE- GREASE           | 2        |
| 5           | A18318        | TRI-LOBE QUAD O DYNE SEAL- BUNA-N         | 1        |
| 6           | A21317        | BUSHING- SPLIT- ALIGNMENT RING FOR UNION  | 1        |
| 7           | A18100        | QUAD RING- 3-5/8" ID X 3/16" CS VITON     |          |
| 8           | A17935        | BEARING- 3.74 ID X 5.12 OD X .71 WIDE     | 2        |
| 9           | A17940        | SPACER- BEARING SPACER- ROTARY UNION      | 1        |
| 10          | A17938        | SNAP RING- EXTERNAL 4" SS                 | 1        |
| 11          | A17936        | SEAL SUPPORT- ROTARY UNION                | 1        |
| 12          | A17939        | O-RING- 3.859 ID X .139 W FOR 3.875 OD    | 1        |
| 13          | A17906        | O RING- 4.859 ID X .139 W VITON #249      | 1        |
| 14          | A17986        | SPACER SET- SEAL RETAINER- ROTARY UNION   | 1        |
| 15          | A17937        | SNAP RING- INTERNAL 5" SS                 | 1        |
| 16          | C11266        | FERRULE- INLET SECTION- 4" ROTARY UNION   | 1        |

## Filler Liquid System Assembly

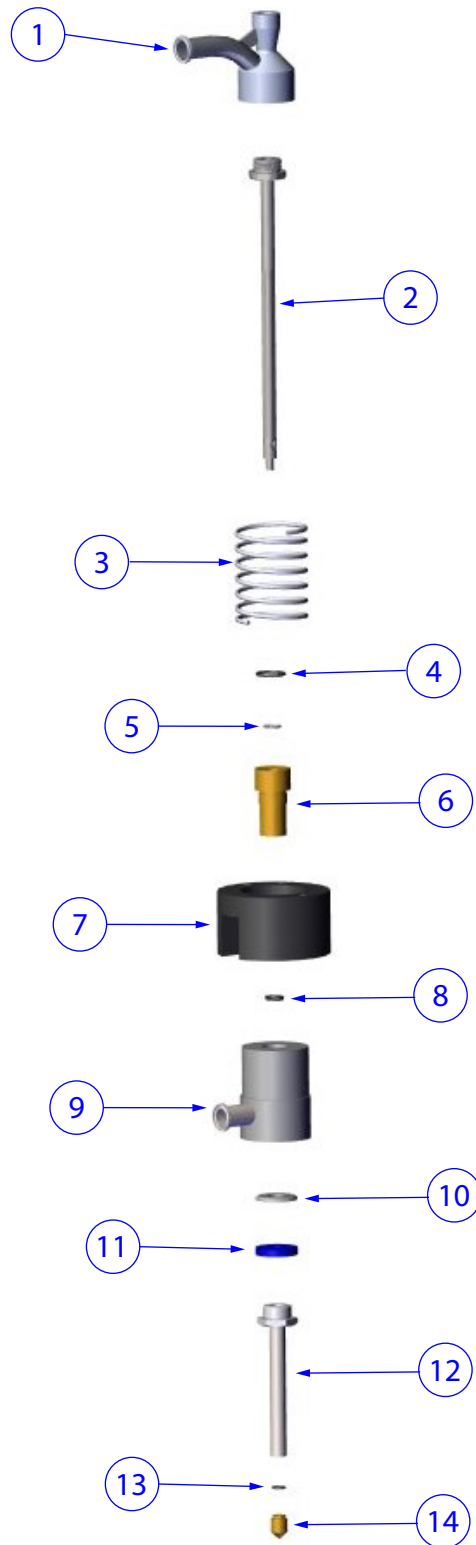


**Figure 4-27: Filler Liquid System Assembly**

## Filler Liquid System Assembly (continued)

| Item Number | Part Number      | Detail                                                         | Qty        |
|-------------|------------------|----------------------------------------------------------------|------------|
| --          | <b>BM9405</b>    | <b>CLOSED MAN. LIQUID SYSTEM- PG FILLER</b>                    | --         |
| 1           | X86479           | CAP - 4" TEE - DOUBLE SHAFT COLLAR                             | 1          |
| 2           | A17053           | CLAMP- 4" HEAVY DUTY TRI-CLAMP 304SS                           | 5          |
| 3           | C11161           | PIPE INLET- 4" FLANGED                                         | 1          |
| 4           | A90856           | REDUCER- 4 TO 2 1/2" WITH FERRULES 316 S                       | 1          |
| 5           | A91974           | GASKET - 4" TRI-CLAMP - VITON                                  | 5          |
| 6           | BM9400           | ROTARY UNION                                                   | 2          |
| 7           | A10414           | HUB- TIE BAR GRAVITY FILLER                                    | 2          |
| 8           | A15670           | TIE BAR FORK- GRAVITY MANIFOLD                                 | 2          |
| 9           | X89144           | STOP NUT - 1" D - 14" LONG                                     | 2          |
| 10          | D10494           | TOP- SUPPLY MANIFOLD - 4" INLET X LARGE                        | 1          |
| 11          | A24504           | TIE BAR- MANIFOLD- 78" PD PG-60                                | 2          |
| 12          | X86480           | SHOE DRIVE HUB - GRAVITY FILLER                                | 1          |
| 13          | A19556           | PLATE- SHOE SUPPORT W/ PINS WELDED ON                          | 1          |
| 14          | X48264           | MANIFOLD SHOE SET 90 DEGREE                                    | 1          |
| 15          | D11001           | SUPPLY MANIFOLD - 40 HD 3/4" TC                                | 1          |
| 16          | A16995           | SWIVEL-DISTRIBUTING VALVE MOUNTING                             | 1          |
| 17          | A20873           | SUPPORT BRACKET - DISTRIBUTOR                                  | 1          |
| 18          | X73921           | BAR- SUPPORT- 78" PD FILLER- SS                                | 1          |
| 19          | D10768           | OVERFLOW MANIFOLD CVR - PG-40 - TRI-CLMP                       | 1          |
| 20          | D10384           | DIST VALVE BOTTOM- 4" TRI-CLAMP                                | 1          |
| 21          | A21823           | MANIFOLD EXT- 4-1/2" LONG SS 4" PIPE                           | 1          |
| 22          | A17041           | ELBOW- 4" 90 DEGREE TRI-CLAMP - CIP 316S                       | 1          |
| 23          | A93832           | HOSE ASSY- 4" RFSV SILICONE - 48" OAL                          | 1          |
| 24          | A17225           | SUPPORT- 4" INLET PIPE CABINET                                 | 1          |
| 25          | B11575           | PIPE- OVERFLOW- 4"X34" LONG- C FRAME                           | 1          |
| 26          | A17047<br>A17048 | GASKET- 3/4 TRI-CLAMP- VITON<br>CLAMP- 3/4" TRI-CLAMP HVY DUTY | 204<br>204 |
| 27          | A22125           | HOSE 3/4"ID OPAQUE RUBBER UNREINFORCED (not shown)             | 250        |
| 28          | A21654           | O-RING - 18.455 ID X .275 - #466 VITON (not shown)             | 1          |
| 29          | A17600           | O-RING- 20"ID .275 W VITON #469 FDA APP (not shown)            | 2          |
| 30          | A92163           | BUTTERFLY VALVE- 2-1/2" - ASSY, THROTTLING (not shown)         | 1          |

## Mechanical Filler Valve Assembly

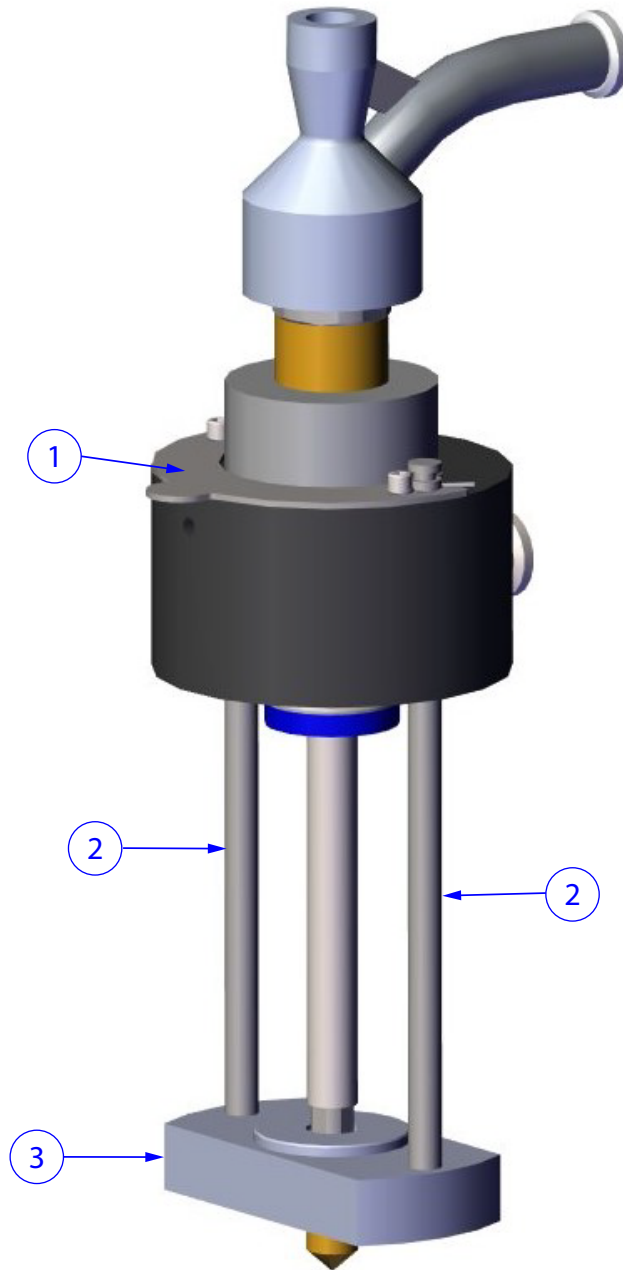


**Figure 4-28: Filler Valve Assembly**

## Mechanical Filler Valve Assembly (continued)

| Item Number | Part Number   | Detail                                                     | Quantity |
|-------------|---------------|------------------------------------------------------------|----------|
| --          | <b>BM9211</b> | <b>VALVE ASSEMBLY- PRESSURE /GRAVITY FILLER</b>            | --       |
|             |               |                                                            |          |
| 1           | A20792        | TUBE HEAD ASSEMBLY - 1" - 20 THREAD                        | 1        |
| 2           | X86992        | INNER TUBE - .47" OD - LIDESTRI                            | 1        |
| 3           | X49180        | SPRING-COMP- 1-11/32 ID 3" FL .093"WIRE                    | 1        |
| 4           | A16026        | O RING-.862 ID X .103 W VITON #118                         | 2        |
| 5           | -----         | N/A                                                        | --       |
| 6           | X87684        | BUSHING-.473 INNER W/PRUVA TYPE U-CUP                      | 1        |
| 7           | X76467        | BELL HEAD - PLASTIC- W/ALIGNMENT HOLE                      | 1        |
| 8           | A23231        | SEAL - U-CUP - 666-205 - VITON                             | 1        |
| 9           | X72293        | TUBE BODY- 2-1/2"OD- 3/4" MINI CLAMP                       | 1        |
| 10          | A21853        | WASHER- BACKUP - 41/64" ID - 1-1/2" OD                     | 1        |
| 11          | X89502        | SLR RUBBER- 1-1/2"OD .43"ID 1/4"TH SIL 25-30               | 1        |
| 12          | X90478        | OUTER TUBE - 9/16" OD - 5-3/8" OAL - LUXCO                 | 1        |
| 13          | X20356        | O-RING- VITON- #012                                        | 1        |
| 14          | A22973        | TIP - 1/2" INNER 9/16" OUTER - KYNAR                       | 1        |
| 15          | A21659        | SPACER SET FOR 9/16" TUBE- COLORED PLSTC (not shown)       | 1        |
| 16          | A19680        | SPACER- 5/8" SNAP-ON- CUSTOM LENGTH (not shown)            | 1        |
| 17          | X90484        | CIP CUP ASSY - 9/16" OUTER - PG VALVE (see pgs. IPL-52,53) | 1        |

## Mechanical Filler Valve Assembly



**Figure 4-29: Centering Bell Assembly**

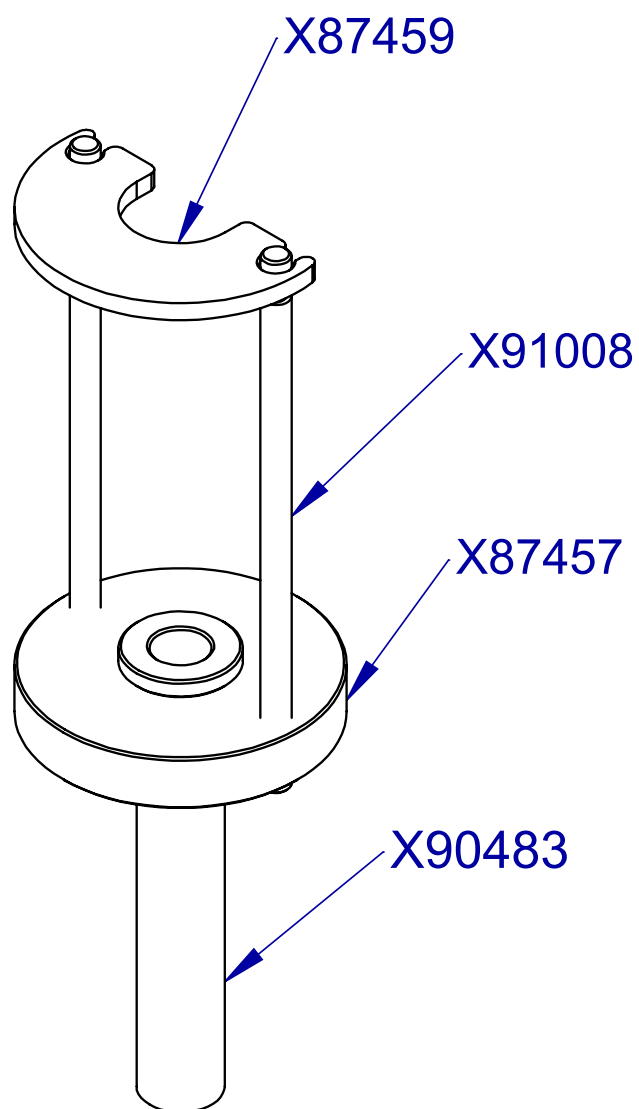


## Mechanical Filler Valve Assembly (continued)

| Item Number | Part Number | Detail                                                                                                                   | Quantity |
|-------------|-------------|--------------------------------------------------------------------------------------------------------------------------|----------|
| 1           | X90482      | CAPTURE PLATE ASSY - CENTERING BELL - 3-1/4" BC                                                                          | 1        |
| 2           | X90479      | ROD - CENTERING BELL - LUXCO 122300                                                                                      | 2        |
| 3           | X90485      | CENTERING BELL - LUXCO "A" 33/35 MM                                                                                      | 1        |
|             | X90486      | CENTERING BELL - LUXCO "B" 30 MM                                                                                         | 1        |
|             | X90487      | CENTERING BELL - LUXCO "C" 28 MM                                                                                         | 1        |
| 4           | X90488      | SEALER RUBBER - BELL "A" - LUXCO (not shown)                                                                             | 1        |
|             | X90489      | SEALER RUBBER - BELL "B/C" - LUXCO (not shown)                                                                           | 2        |
| 5           | A93580      | SPRING- COMPRESSION- .625"OD .565"ID, (slide onto centering bell rods between centering bell and tube body), (not shown) | 4        |



## CIP CUP Assembly



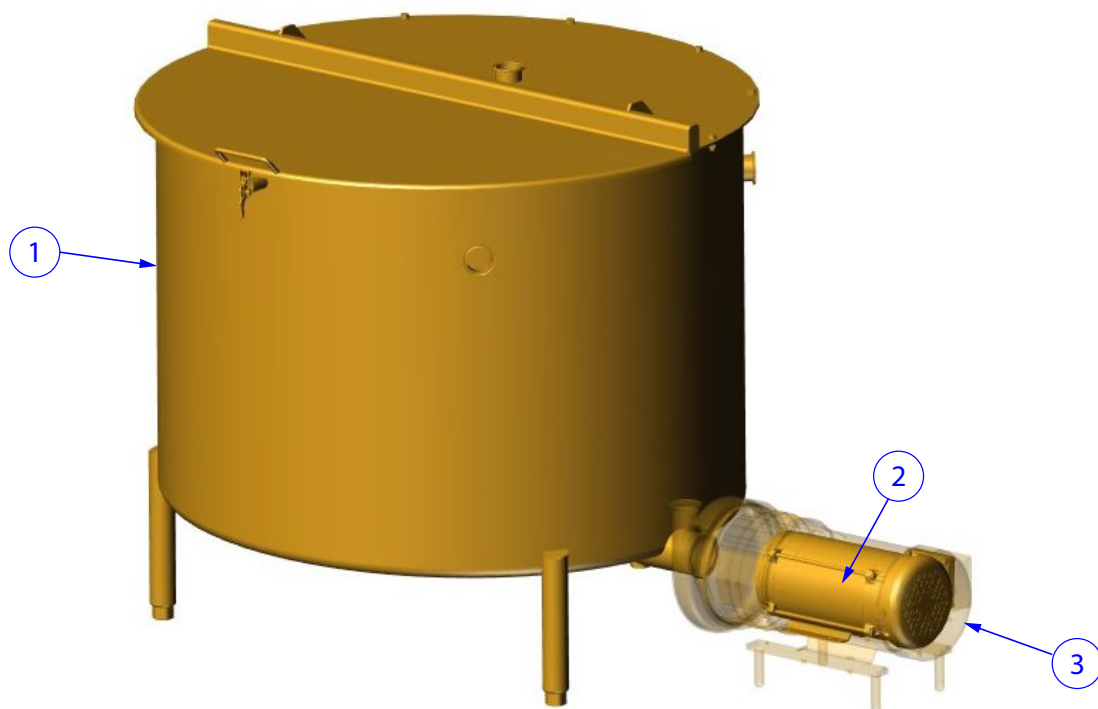
**Figure 4-30: CIP CUP Assembly**



## Mechanical Filler Valve Assembly (continued)

| Item Number | Part Number   | Detail                                       | Quantity |
|-------------|---------------|----------------------------------------------|----------|
| --          | <b>X90484</b> | <b>CIP CUP ASSY - 9/16" OUTER - PG VALVE</b> | --       |
| 1           | X87459        | TOP CLIP - CIP                               | 1        |
| 2           | X91008        | ROD, CIP CUP                                 | 2        |
| 3           | X87457        | RING - CIP                                   | 1        |
| 4           | X90483        | CIP CUP - 9/16" OUTER - 6-1/2" DEPTH         | 1        |

## Production Tank



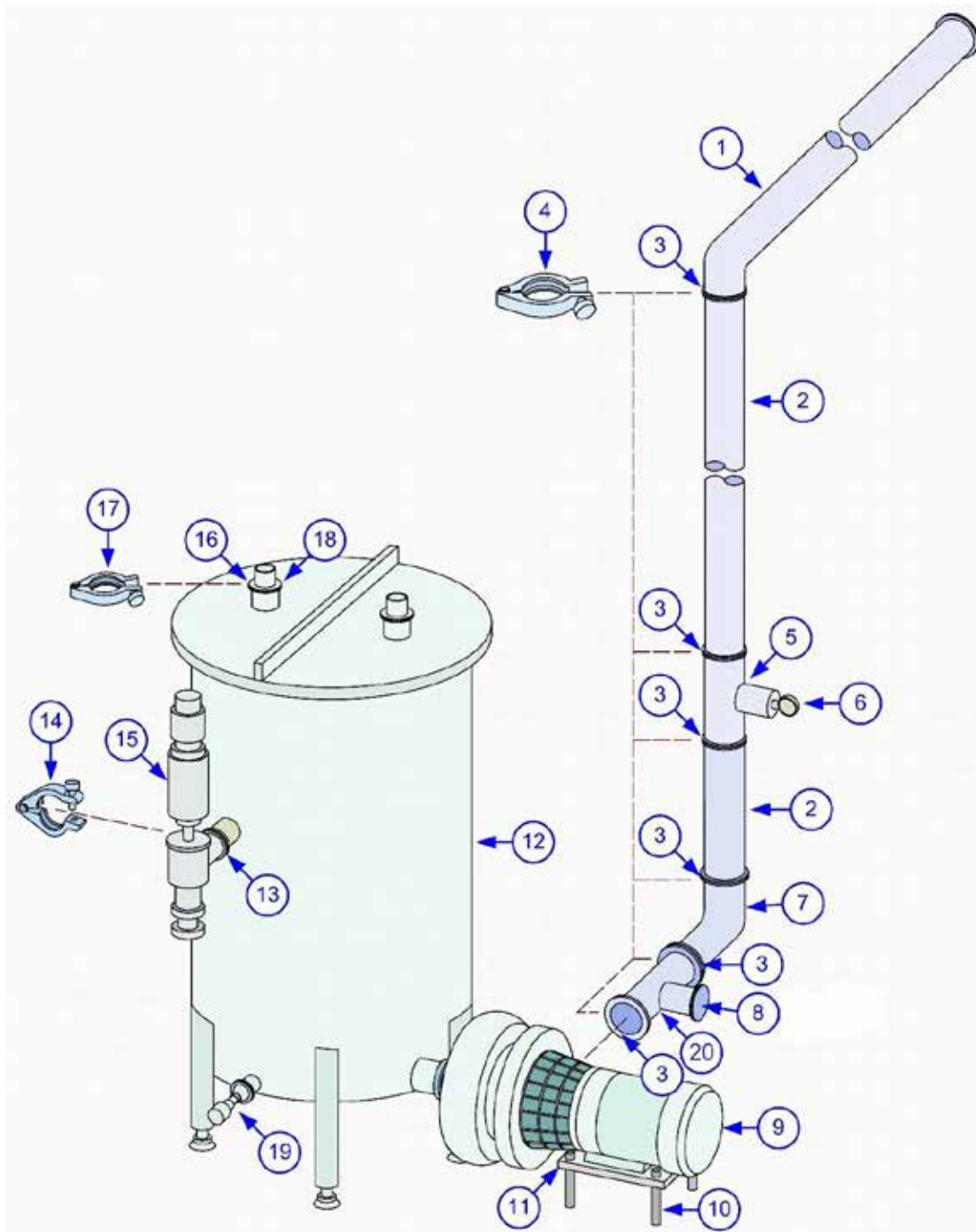
**Figure 4-31: *Production Tank-Pump/Motor Pressure System***



**Production Tank (continued)**

| Item Number | Part Number   | Detail                               | Quantity |
|-------------|---------------|--------------------------------------|----------|
| --          | <b>BM8626</b> | <b>PRODUCTION TANK</b>               | --       |
| 1           | A91045        | PRODUCTION TANK (reference 122300-2) | 1        |
| 2           | A93700        | MOTOR- 2HP - XP INVERTER DUTY 145TC  | 1        |
| 3           | A18363        | PUMP ONLY - LESS MOTOR               | 1        |

## Production Tank (continued)

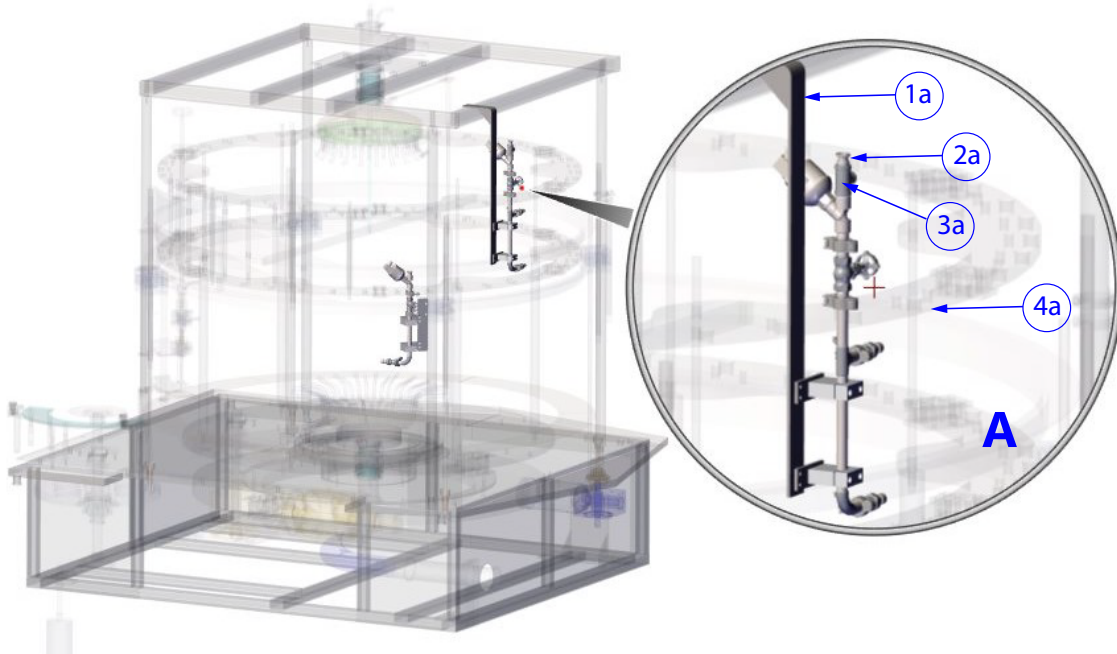


**Figure 4-32: Supply Tank / Liquid Assembly**

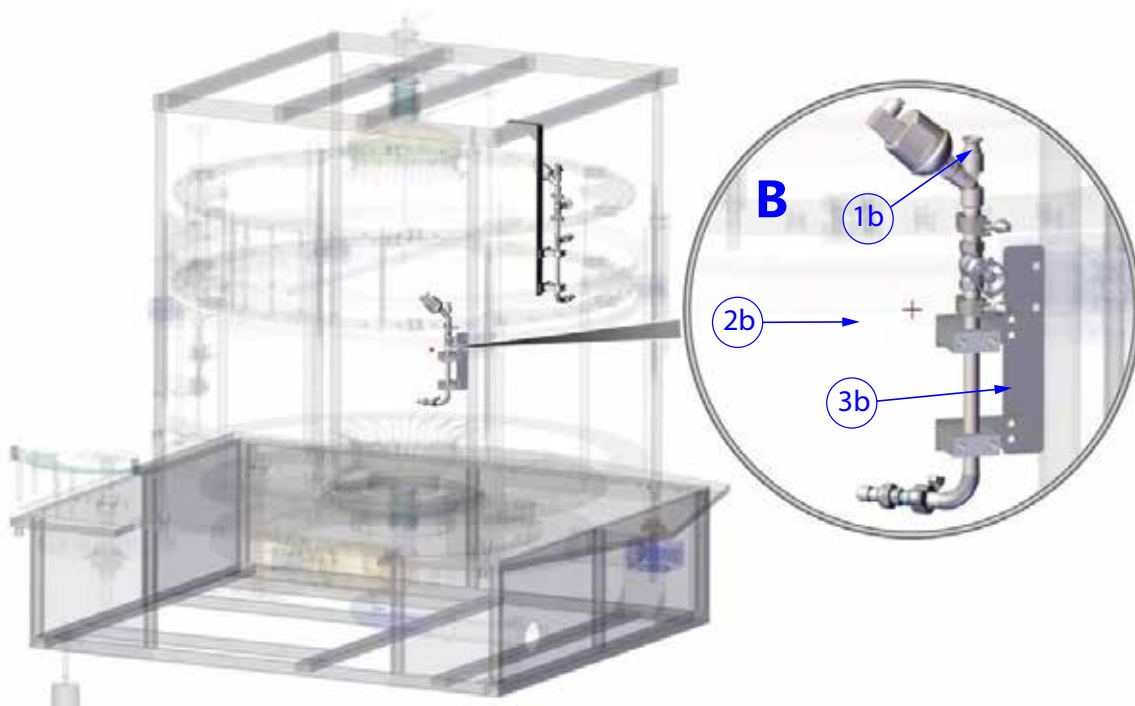
## Production Tank (continued)

| Item Number | Part Number | Detail                                          | Quantity |
|-------------|-------------|-------------------------------------------------|----------|
| --          |             |                                                 |          |
| 1           | -----       | TUBING w/ELBOW, SANITARY, FLANGED, 2-1/2"       | 1        |
| 2           | -----       | TUBING, SANITARY, FLANGED, 2-1/2"               | 2        |
| 3           | A13998      | GASKET, CIP SILICON, 2-1/2"                     | 8        |
| 4           | A17051      | CLAMP, 2-1/2", HEAVY DUTY, TRI-CLAMP            | 8        |
| 5           | A17657      | TEE- REDUCING 2 1/2" TO 2" 316SS WITH FE        | 2        |
| 6           | A13271      | GAUGE, 0-15 PSI, 2", CIP SANITARY, 316 SS       | 1        |
| 7           | A17039      | ELBOW, 90 DEGREE, TRI-CLAMP CIP                 | 4        |
| 8           | A92567      | BUTTERFLY VALVE- 2" AIR TO OPEN SPRING TO CLOSE | 1        |
| 9a          | A18363      | PUMP ONLY - LESS MOTOR                          | 1        |
| 9b          | A93700      | MOTOR- 2HP - XP INVERTER DUTY 145TC             | 1        |
| 10          | A20281      | PUMP SUPPORT FEET                               | 4        |
| 11          | A20280      | SUPPORT BRACKET, PUMP MOTOR                     | 2        |
| 12          | A91045      | TANK- (Reference 122300-2)                      | 1        |
| 13          | A13999      | GASKET, CIP SILICON, 3"                         | 1        |
| 14          | A17052      | CLAMP, HEAVY DUTY, TRI-CLAMP 3"                 | 1        |
| 15          | A90831      | VALVE- THROTTLING W/SPECIAL ACTUATOR - 2        | 1        |
| 16          | A13996      | GASKET, CIP SILICON, 1-1/2"                     | 2        |
| 17          | A17049      | CLAMP, 1-1/2", HEAVY DUTY TRI-CLAMP             | 2        |
| 18          | A18155      | SPRAY BALL, 1-1/2", TRI-CLAMP                   | 2        |
| 19          | A21371      | LEVEL SENSOR - 2" TRI-CLAMP - 4-20 MA SS        | 1        |
| 20          | A18179      | TEE- REDUCING- 2" X 1-1/2"- W/FITTINGS          | 1        |

## R.O. Wash System Assembly



**Figure 4-33: R.O. Wash System\_a**



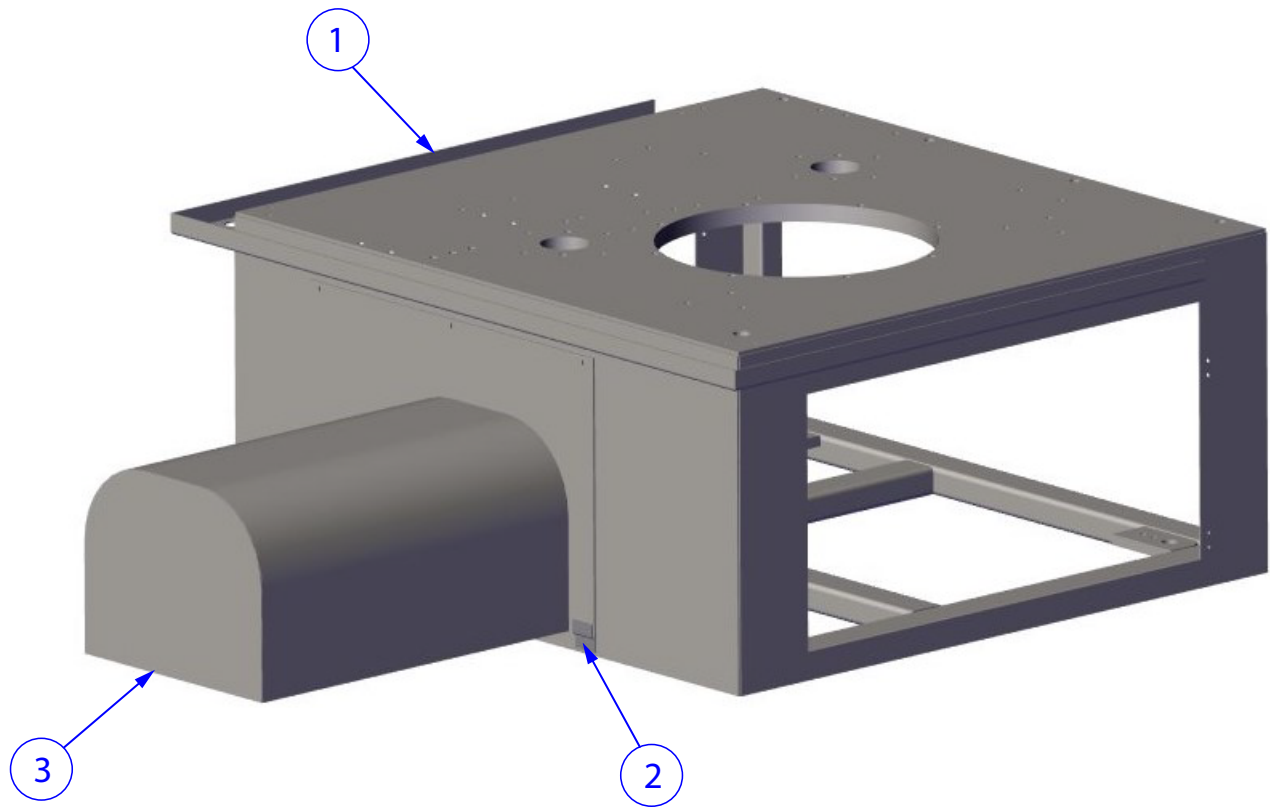
**Figure 4-34: R.O. Wash System\_b**



## R.O. Wash System Assembly (continued)

| Item Number | Part Number     | Detail                                   | Quantity |
|-------------|-----------------|------------------------------------------|----------|
| -----       | <b>BM202004</b> | <b>R.O. WASH SYSTEM</b>                  | --       |
| 1a          | X90447          | BUSHING WASH BRACKET - TOP FRAME MOUNT   | 1        |
| 2a          | X86760          | ADAPTER - 3/4" TRI-CLAMP TO 1/2"NPT MALE | 1        |
| 3a          | A17019          | TEE-PIPE RED.1/2IPS X 1/2IPS X 3/8 304SS | 1        |
| 4a          | B13347          | SHOWER - SLIDE ROD BUSHING WASH          | 1        |
| 1b          | X86760          | ADAPTER - 3/4" TRI-CLAMP TO 1/2"NPT MALE | 1        |
| 2b          | B13170          | SHOWER - VALVE BUSHING LUBE              | 1        |
| 3b          | X89444          | VALVE WASH BRACKET                       | 1        |

## Capper Main Chassis Assembly



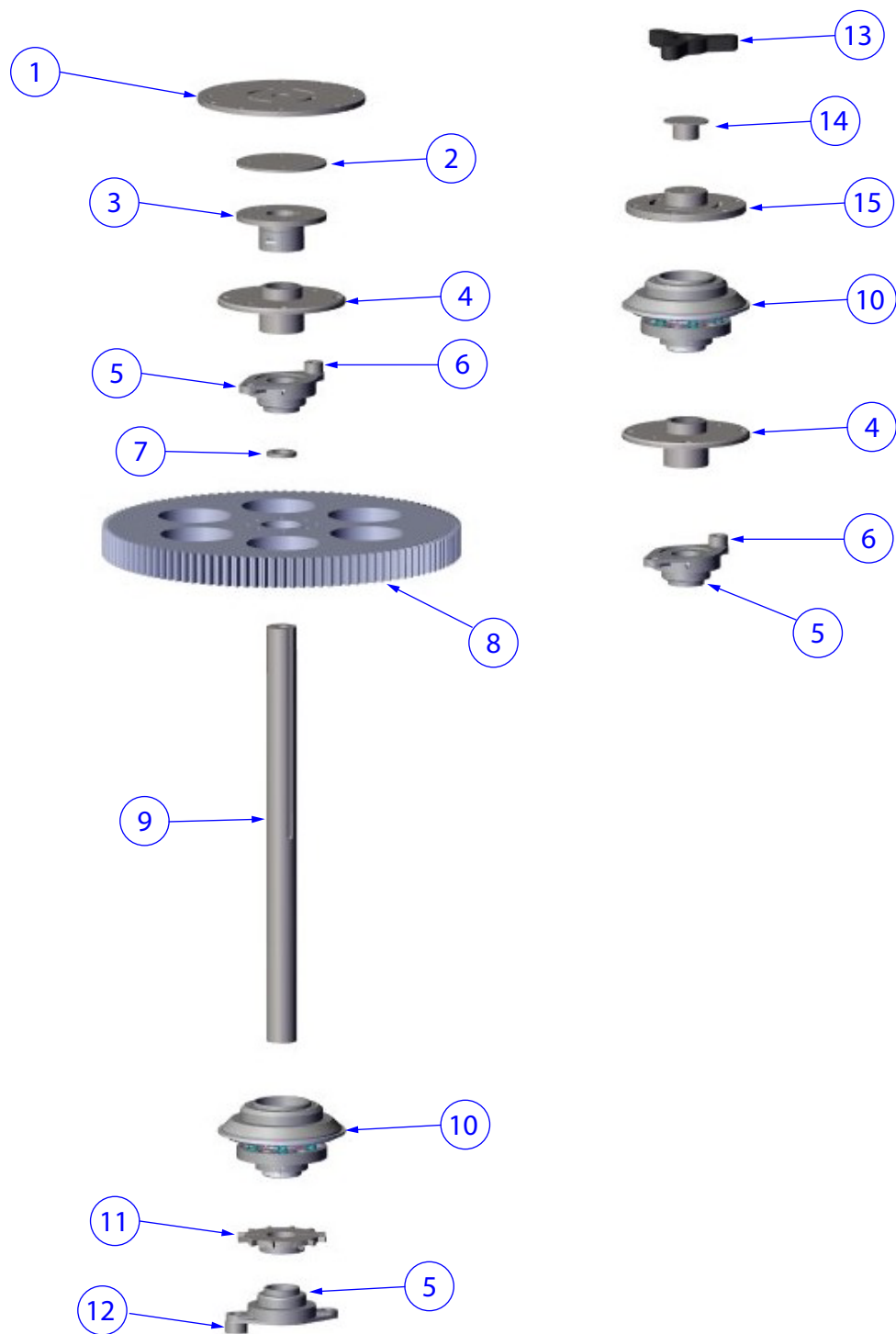
**Figure 4-35: *Capper Main Chassis Assembly***



## Capper Main Chassis Assembly (continued)

| Item Number | Part Number | Detail                                             | Quantity |
|-------------|-------------|----------------------------------------------------|----------|
| 1           | X90659      | CABINET - AROL - 15.6" CAPPER - TRI-BLOCK          | 1        |
| 2           | X90870      | TAB - DOGHOUSE MOUNT                               | 2        |
| 3           | X90869      | DOGHOUSE MOTOR COVER                               | 1        |
| 4           | X86349      | TAMPER PROOF DOOR LATCH ASSEMBLY (not shown)       | 2        |
| 5           | X70856      | FOOT- 51" CONV. HEIGHT- SS EXTENSIONS (not shown)  | 5        |
| 6           | A10505      | FOOT JACK SCREW ASSY- S.S CONSTRUCTION (not shown) | 5        |

## Capper Star Drive Assembly



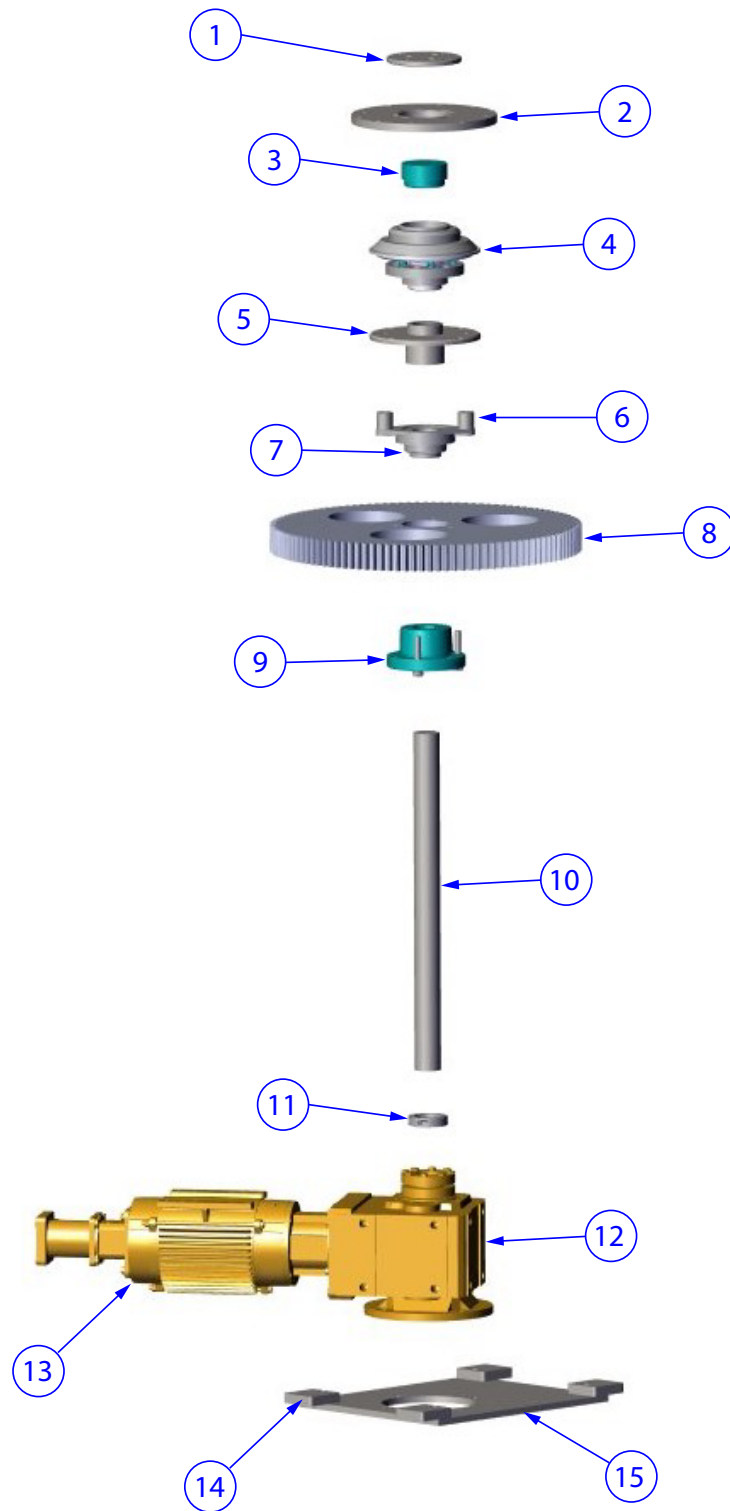
**Figure 4-36: Capper Star Drive Assembly**



## Capper Star Drive Assembly (continued)

| Item Number | Part Number | Detail                                      | Quantity |
|-------------|-------------|---------------------------------------------|----------|
| 1           | A19366      | CORE- 20"/22"/26"/31" STAR- Q-CHANGE- SS    | 1        |
| 2           | A23281      | COVER, STAR CORE PLATE 4 1/2" B.C.          | 1        |
| 3           | A18980      | HUB W/COLLAR- 2" STAR SHAFT- SS             | 1        |
| 4           | A19402      | HUB- BUSHING-2in-SS- NO BEARING- NO LUBE    | 1        |
| 5           | A18462      | BEARING- 2" BORE- 2-BOLT FLANGE- SS         | 3        |
| 6           | A19611      | SPACER- 1-1/4"OD X 17/32"ID X 11/16"L-SS    | 4        |
| 7           | A19233      | WASHER- 2" COLLAR TO CORE PLATE- SS         | 1        |
| 8           | X90441      | GEAR - CLUTCH MOUNT - 23.4" PD - 5DP - 117T | 1        |
| 9           | A19138      | STAR SHAFT- 2"- CAPPER- SS                  | 1        |
| 10          | A21179      | CLUTCH-MECH O'LOAD-SS- 2"BORE-USB MFG       | 2        |
| 11          | X74264      | TIMING STAR- 2" BORE- 12 TEETH- SS          | 1        |
| 12          | A23191      | SPACER, WELD ON, STAR SHAFT BEARING         | 2        |
| 13          | A18628      | TRI-LOBE HUB- STAR HOLD DOWN- BLACK PLAS    | 1        |
| 14          | A20991      | HUB - DETENT - STAR CORE                    | 1        |
| 15          | A23948      | STAR CORE-CLUTCH MT-SM STAR W/TRI-LOBE      | 1        |

## Capper Motor Drive Train Assembly



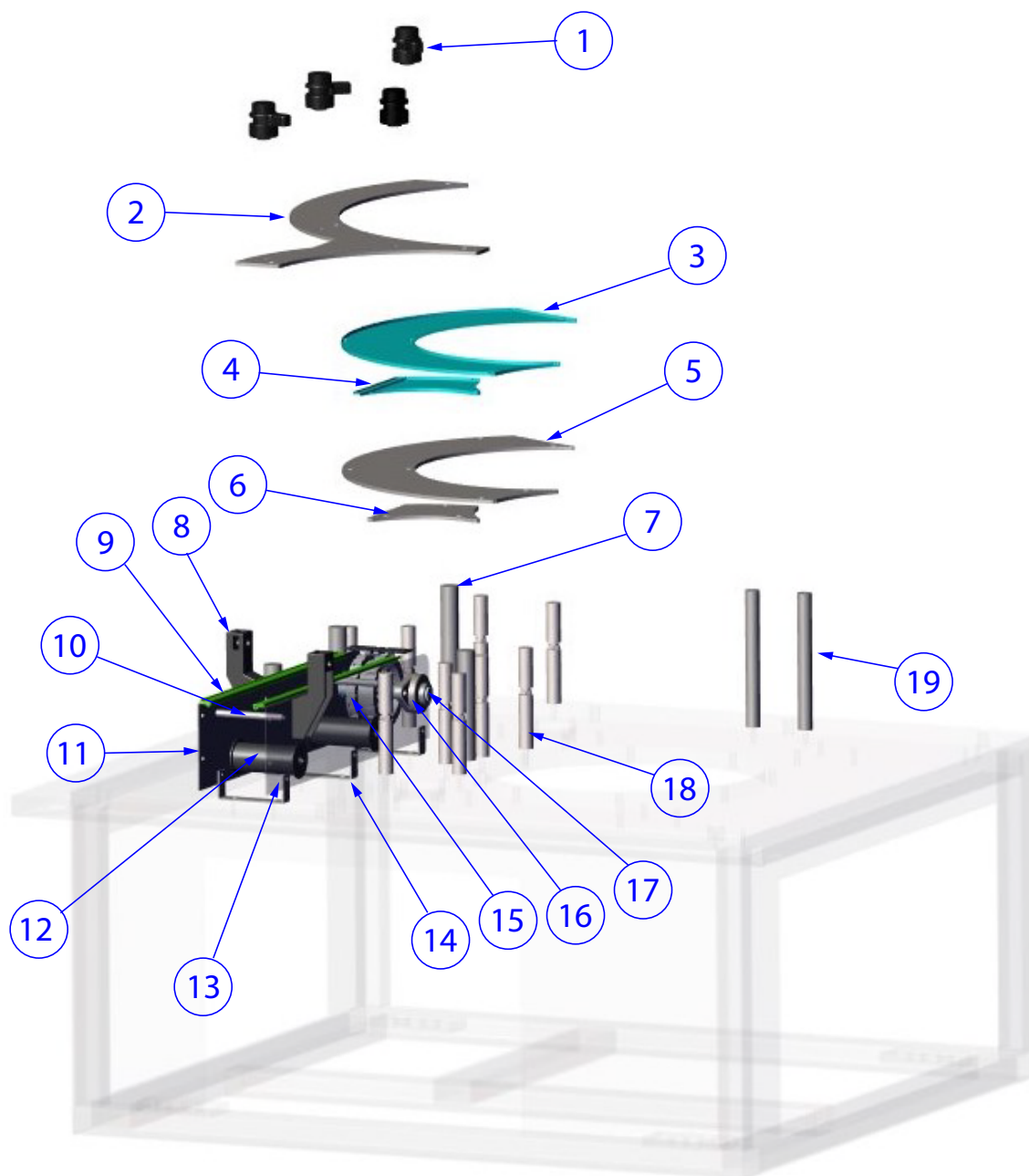
**Figure 4-37: Capper Motor Drive Train Assembly**



## Capper Motor Drive Train Assembly (continued)

| Item Number | Part Number | Detail                                   | Quantity |
|-------------|-------------|------------------------------------------|----------|
| 1           | A22021      | COVER - STAR CORE PLATE W/BUSHING HOLES  | 1        |
| 2           | C11900      | PLATE- CORE- STAR TO CLUTCH MOUNT        | 1        |
| 3           | A22020      | HUB - CLUTCH CENTERING- USB CLUTCH       | 1        |
| 4           | A21179      | CLUTCH-MECH O'LOAD-SS- 2"BORE-USB MFG    | 1        |
| 5           | A19402      | HUB- BUSHING-2in-SS- NO BEARING- NO LUBE | 1        |
| 6           | X89953      | SPACER - STAR BEARING REVERSE            | 2        |
| 7           | A18462      | BEARING- 2" BORE- 2-BOLT FLANGE- SS      | 1        |
| 8           | X90662      | BULL GEAR - 15.6" PD - 5DP - 78T         | 1        |
| 9           | A19439      | BUSHING- QD STYLE- DODGE- E 2"           | 1        |
| 10          | A24351      | DRIVE SHAFT - 2" - 29" L                 | 1        |
| 11          | A18178      | SET COLLAR- SPLIT- 2" I.D.- SS           | 1        |
| 12          | A94795      | GEARBOX - STOBBER -K713_0790, 210        | 1        |
| 13          | A93277      | MOTOR-5 HP XP-VECTOR W/ENCODER-see specs | 1        |
| 14          | A24068      | EDGE - GEARBOX SUPPORT MOUNT             | 4        |
| 15          | X90616      | GEARBOX MOUNT PLATE                      | 1        |

## Capper Bridgeplate Assembly



**Figure 4-38: Capper Bridgeplate Assembly**

## Capper Bridgeplate Assembly (continued)

| Item Number | Part Number | Detail                                               | Quantity |
|-------------|-------------|------------------------------------------------------|----------|
| 1           | A20274      | SINGLE LOBE KNOB ASSY- SPRING HOLD DOWN              | 6        |
| 2           | X90668      | CORE PLATE - CAPPER DISCH - 51.6" CAPPER/STAR        | 1        |
| 3           | X90664      | CROSSOVER PLATE - FILLER TO CAPPER - 23.4" STAR      | 1        |
| 4           | X90667      | CROSSOVER PLATE - CAPPER DISCH - 15.6" CAPPER/STAR   | 1        |
| 5           | X90663      | CROSSOVER SUPPORT - FILLER TO CAPPER - 23.4" STAR    | 1        |
| 6           | X90666      | CROSSOVER SUPPORT - CAPPER DISCH - 15.6" CAPPER/STAR | 1        |
| 7           | X75612      | POST - 1-1/4"DIA - CORE PLT MOUNT - SS               | 6        |
| 8           | A17454      | BRACKET- STANDARD GUID RAIL VALUGUIDE                | 5        |
| 9           | A94082      | WEAR STRIP PROFILE                                   | 2        |
| 10          | A23530      | CONVEYOR SIDE SPACER - 4-1/2" CHAIN                  | 6        |
| 11          | X90669      | CONVEYOR FRAME FRONT - DISCH - 15.6" CAPPER/STAR     | 1        |
| 12          | A23531      | CONVEYOR CHAIN ROLLER - 4-1/2" CHAIN                 | 3        |
| 13          | X90670      | CONVEYOR FRAME BACK - DISCH - 15.6" CAPPER/STAR      | 1        |
| 14          | A23924      | CONVEYOR BKT - 7-1/2" CONV. HEIGHT - 4-1/2" CHAIN    | 3        |
| 15          | A19507      | SPROCKET- 21 TEETH 815/820 CHAIN- 1"ID               | 1        |
| 16          | A10515      | BEARING- 2 BLT FLNG- 1" SHAFT                        | 2        |
| 17          | A17969      | SHAFT- IDLER- 1" DIA X 8 3/8" LNG                    | 1        |
| 18          | A17136      | POST- CROSSOVER SUPPORT- MODEL A-C-E                 | 12       |
| 19          | X70579      | POSTS- FINGER- SS- 1" DIA.- 3/8" TAP                 | 2        |

## Air Prep Manifold Assembly

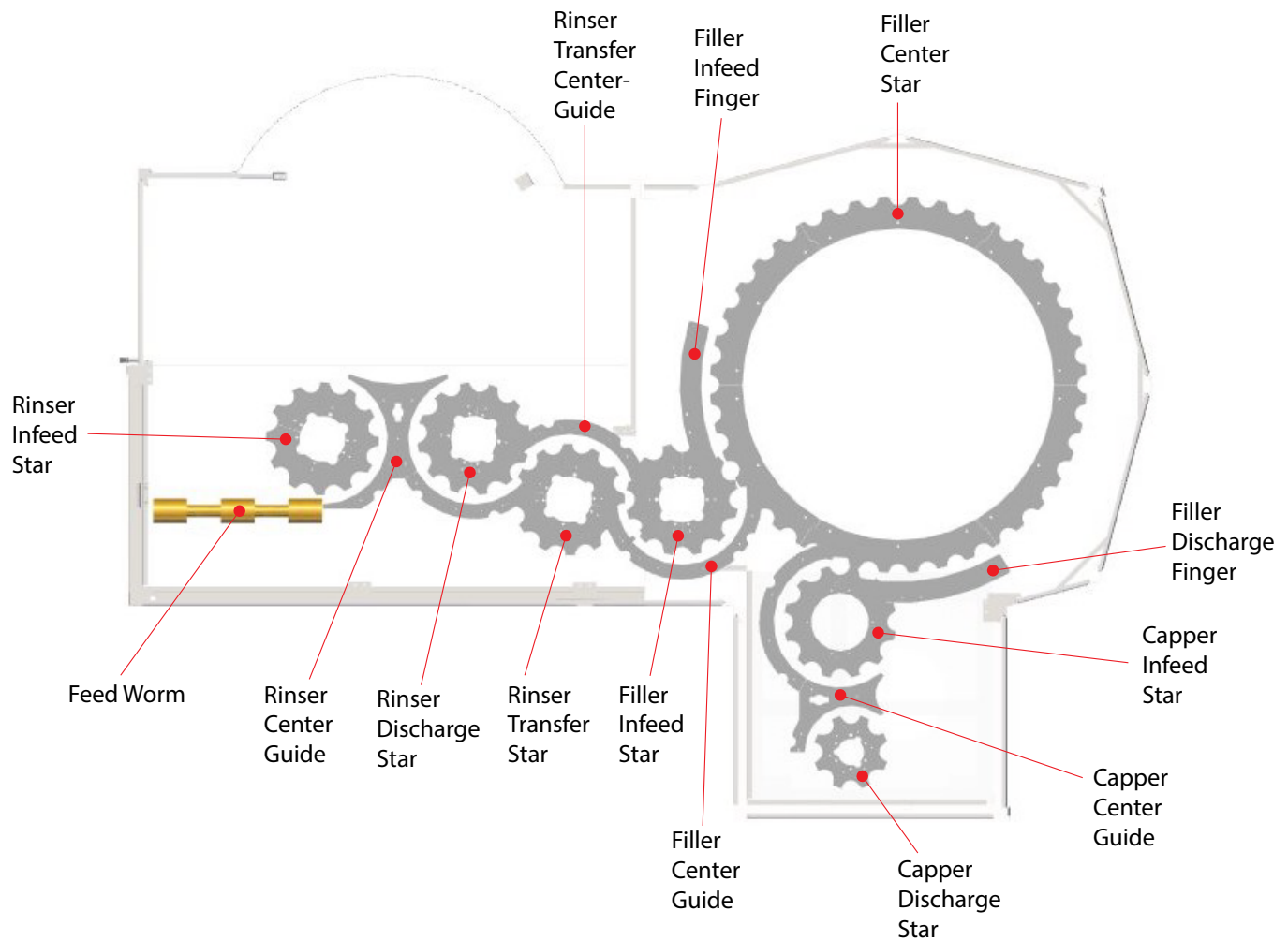


**Figure 4-39: *Air Prep Manifold Assembly***

## Air Prep Manifold Assembly (continued)

| Item Number | Part Number   | Detail                                   | Quantity |
|-------------|---------------|------------------------------------------|----------|
| --          | <b>BM8513</b> | <b>PNEUMATIC PANEL BOX</b>               | --       |
| 1           | A92865        | INTRINSICALLY SAFE SOLENOID, 4-WAY       | 5        |
| 2           | A94247        | ENCLOSURE - 20X20X8 - SLOPED W/CUTOUTS   | 1        |
| 3           | A94276        | SUBPANEL - 20X20                         | 1        |
| 4           | A94391        | PARKER 1/2 MANUAL VALVE - XP             | 1        |
| 5           | A94392        | PARKER 1/2 FILTER REGULATOR - XP         | 1        |
| 6           | A94393        | PARKER 1/2 SUPPLY BLOCK - XP             | 5        |
| 7           | A94394        | PARKER 1/2 AIR PILOTED DUMP VALVE - XP   | 2        |
| 8           | A94395        | PARKER 1/2 T BRACKET - XP                | 2        |
| 9           | A94396        | PARKER 1/2 MODULE CONNECTOR - XP         | 9        |
| 10          | A94398        | PARKER 1/2 PRESSURE SWITCH - XP          | 3        |
| 11          | A94211        | BRACKET - SUPPLY AIR MANIFOLD            | 2        |
| 12          | A94375        | FESTO MANIFOLD KIT CPV10-EX              | 1        |
| 13          | A23804        | SPACER FOR AIR MANIFOLDS C-RAIL          | 8        |
| 14          | A94703        | VALVE - 1/2" 3-WAY AIR OPERATED          | 2        |
| 15          | A94704        | ADAPTER G1/2M - 1/2NPTF                  | 1        |
| 16          | A90590        | NIPPLE CLOSE 1/2 IPS 304 S.S.            | 3        |
| 17          | A16773        | NIPPLE- 1/2 X 3" LG- NPT 316 SS          | 2        |
| 18          | A18149        | GAUGE- 0-15 PSI- PANEL MOUNT             | 1        |
| 19          | A17991        | AIR MANIFOLD- 8 OUTLETS 1/4" IPS Q-CONNE | 1        |
| 20          | A20659        | PLUG - 1/4" AIR LINE                     | 10       |
| 21          | A13723        | PLUG- PIPE- ALLEN HEAD- 3/8" SS          | 10       |
| 22          | A20646        | SILENCER - SS - 1/8"NPT                  | 20       |

## Attachments Assembly



**Figure 4-40: Attachments Assembly**



**Attachments Assembly (continued)**

| Item Number | Part Number | Detail                          | Quantity |
|-------------|-------------|---------------------------------|----------|
| --          | A18540      | RINSER FEED WORM ASSEMBLY       | --       |
| --          | X90977      | RINSER CENTER GUIDE ASSEMBLY    | --       |
| --          | X90981      | RINSER INFEED & DISCHARGE STARS | --       |
| --          | X90978      | RINSER TRANSFER CENTER GUIDE    | --       |
| --          | X90981      | RINSER TRANSFER STAR            | --       |
| --          | X90981      | FILLER INFEED STAR              | --       |
| --          | X90979      | FILLER CENTER GUIDE             | --       |
| --          | X90970      | FILLER CENTER STAR              | --       |
| --          | X90971      | FILLER INFEED FINGER            | --       |
| --          | X90972      | FILLER DISCHARGE FINGER         | --       |
| --          | X90980      | CAPPER CENTER GUIDE             | --       |
| --          | X90981      | CAPPER INFEED STAR              | --       |
| --          | X90982      | CAPPER DISCHARGE STAR           | --       |



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