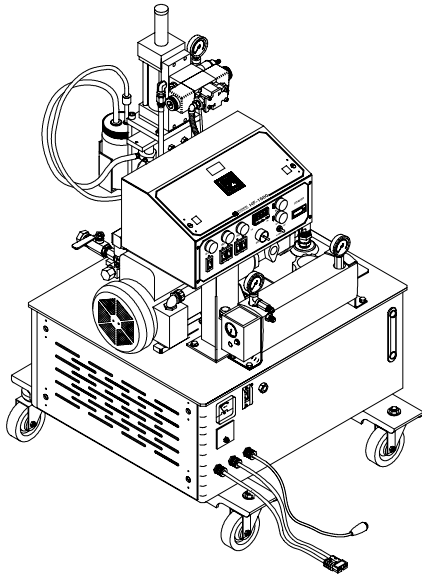


GUSMER[®] CORPORATION

"Success through Unity"



HF-1600/2500 ***Proportioning Unit*** ***Parts Identification Manual*** ***18942-ID***

November 18, 2002

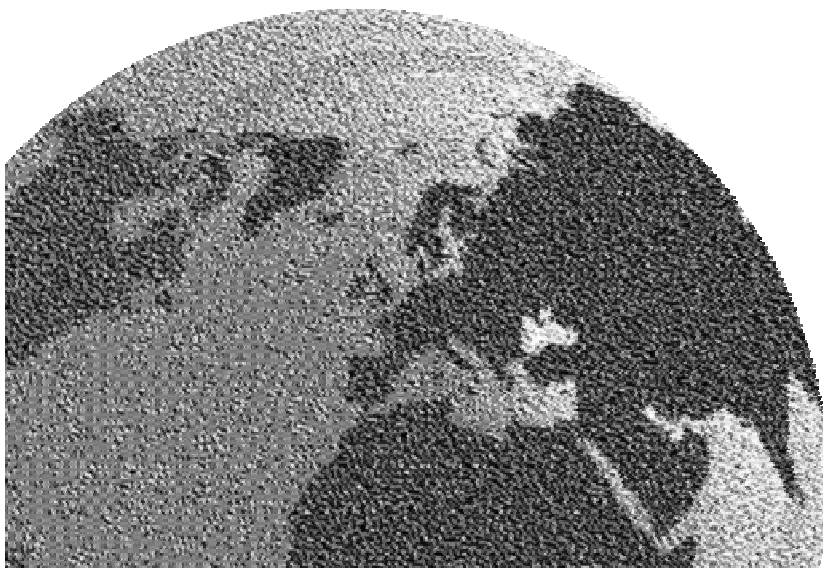
Issue 6

GUSMER CORPORATION[®]

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***NOTICE:** The equipment described in this technical manual must only be operated or serviced by properly trained individuals, thoroughly familiar with the operating instructions and limitations of the equipment. For technical service, call your local distributor. Call: 1-800-FOR-GSMR (1-800-367-4767) for the name and telephone number of your local distributor.*

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CONTENTS

LIST OF FIGURES4

LIST OF TABLES5

WARRANTY.....6

HF-1600/2500 ASSEMBLIES8

 FINAL ASSEMBLY 8

 BASE ASSEMBLY 10

 HYDRAULIC TANK AND ELECTRIC MOTOR ASSEMBLY 12

 HYDRAULIC MOTOR ASSEMBLY 14

 REVERSING SWITCH ASSEMBLY..... 16

 MOTOR LINE ASSEMBLIES 17

Single Phase, 220 Volt..... 17

Three Phase, 230 Volt..... 18

Three Phase, 200 Volt (Available in Asia Only)..... 19

 PRIMARY HEATER ASSEMBLY 20

 HF-1600 PROPORTIONING PUMP ASSEMBLY 22

 HF-2500 PROPORTIONING PUMP ASSEMBLY 24

 HYDRAULIC CYLINDER ASSEMBLY 26

 LUBE PUMP ASSEMBLY 28

ELECTRICAL CONSOLE COMPONENTS29

HF-1600 ELECTRICAL SCHEMATICS.....30

Manual Hose Heat 1 x 230V..... 30

Manual Hose Heat 3 x 230V..... 32

Manual Hose Heat 3 x 200V (Available in Asia Only) 34

Digital Hose Heat 1 x 230V..... 36

Digital Hose Heat 3 x 230V..... 38

HF-2500 ELECTRICAL SCHEMATICS.....40

Digital Hose Heat 1 x 230V..... 40

Digital Hose Heat 3 x 380V..... 42

INSTRUCTION MANUAL DISCREPANCY REPORT49

LIST OF FIGURES

FIGURE 1. FINAL ASSEMBLY, (PART NO. 18000-SIZE/18000-DGT-SIZE/23000-SIZE), EXPLODED VIEW.....	8
FIGURE 2. BASE ASSEMBLY, (PART NO. 18500-SIZE, 23500-SIZE), EXPLODED	10
FIGURE 3. HYDRAULIC TANK AND ELECTRIC MOTOR ASSEMBLY, (PART NO. 18700-SIZE), EXPLODED VIEW	12
FIGURE 4. HYDRAULIC MOTOR ASSEMBLY, (PART NO. 18745, 23745), EXPLODED VIEW.....	14
FIGURE 5. REVERSING SWITCH, (PART NO. 18745-10-1), EXPLODED VIEW	16
FIGURE 6. MOTOR LINE ASSEMBLY, SINGLE PHASE, 220 VOLT, (PART NO. 18703-1), EXPLODED VIEW	17
FIGURE 7. MOTOR LINE ASSEMBLY, THREE PHASE, 230 VOLT, (PART NO. 18703-11), EXPLODED VIEW	18
FIGURE 8. MOTOR LINE ASSEMBLY, THREE PHASE, 200 VOLT, (PART NO. 58503-200), EXPLODED VIEW	19
FIGURE 9. PRIMARY HEATER, (PART NO. 18300, 23300), EXPLODED VIEW	20
FIGURE 10. PROPORTIONING PUMP ASSEMBLY, (PART NO. 18400/18450A-60), EXPLODED VIEW.....	22
FIGURE 11. PROPORTIONING PUMP ASSEMBLY, (PART NO. 36400/36450-52), EXPLODED VIEW.....	24
FIGURE 12. HYDRAULIC CYLINDER ASSEMBLY, (PART NO. 18511-51), EXPLODED VIEW	26
FIGURE 13. LUBE PUMP ASSEMBLY, (PART NO. 17491-52/17491-60), EXPLODED VIEW	28
FIGURE 14. ELECTRICAL CONSOLE COMPONENTS	29
FIGURE 15. HF-1600 MANUAL HOSE HEAT ELECTRICAL SCHEMATIC, (PART NO. SD18000-1), SHEET 1 OF 2	30
FIGURE 16. HF-1600 MANUAL HOSE HEAT ELECTRICAL SCHEMATIC, (PART NO. SD18000-1), SHEET 2 OF 2	31
FIGURE 17. HF-1600 MANUAL HOSE HEAT ELECTRICAL SCHEMATIC, (PART NO. SD18000-11), SHEET 1 OF 2	32
FIGURE 18. HF-1600 MANUAL HOSE HEAT ELECTRICAL SCHEMATIC, (PART NO. SD18000-11), SHEET 2 OF 2	33
FIGURE 19. HF-1600 MANUAL HOSE HEAT ELECTRICAL SCHEMATIC, (PART NO. SD18000-13), SHEET 1 OF 2	34
FIGURE 20. HF-1600 MANUAL HOSE HEAT ELECTRICAL SCHEMATIC, (PART NO. SD18000-13), SHEET 2 OF 2	35
FIGURE 21. HF-1600 DIGITAL HOSE HEAT ELECTRICAL SCHEMATIC, (PART NO. SD18000-20), SHEET 1 OF 2.....	36
FIGURE 22. HF-1600 DIGITAL HOSE HEAT ELECTRICAL SCHEMATIC, (PART NO. SD18000-20), SHEET 2 OF 2.....	37
FIGURE 23. HF-1600 DIGITAL HOSE HEAT ELECTRICAL SCHEMATIC, (PART NO. SD18000-21), SHEET 1 OF 2.....	38
FIGURE 24. HF-1600 DIGITAL HOSE HEAT ELECTRICAL SCHEMATIC, (PART NO. SD18000-21), SHEET 2 OF 2.....	39
FIGURE 25. HF-2500 DIGITAL HOSE HEAT ELECTRICAL SCHEMATIC, (PART NO. SD23000-20), SHEET 1 OF 2.....	40
FIGURE 26. HF-2500 DIGITAL HOSE HEAT ELECTRICAL SCHEMATIC, (PART NO. SD23000-20), SHEET 2 OF 2.....	41
FIGURE 27. HF-2500 DIGITAL HOSE HEAT ELECTRICAL SCHEMATIC, (PART NO. SD23000-22), SHEET 1 OF 2.....	42
FIGURE 28. HF-2500 DIGITAL HOSE HEAT ELECTRICAL SCHEMATIC, (PART NO. SD23000-22), SHEET 2 OF 2.....	43

LIST OF TABLES

TABLE 1. FINAL ASSEMBLY, (PART NO. 18000-SIZE/18000-DGT-SIZE/23000-SIZE), PARTS9

TABLE 2. BASE ASSEMBLY, (PART NO. 18500-SIZE, 23500-SIZE), PARTS11

TABLE 3. HYDRAULIC TANK AND ELECTRIC MOTOR ASSEMBLY, (PART NO. 18700-SIZE), PARTS13

TABLE 4. HYDRAULIC MOTOR ASSEMBLY, (PART NO. 18745, 23745),PARTS15

TABLE 5. REVERSING SWITCH, (PART NO. 18745-10-1), PARTS16

TABLE 6. MOTOR LINE ASSEMBLY, SINGLE PHASE, 220 VOLT, (PART NO. 18703-1), PARTS.....17

TABLE 7. MOTOR LINE ASSEMBLY, THREE PHASE, 230 VOLT, (PART NO. 18703-11), PARTS18

TABLE 8. MOTOR LINE ASSEMBLY, THREE PHASE, 200 VOLT, (PART NO. 58503-200), PARTS19

TABLE 9. PRIMARY HEATER, (PART NO. 18300, 23300), PARTS.....21

TABLE 10. HF-1600 PROPORTIONING PUMP ASSEMBLY, (PART NO. 18400/18450A-60), PARTS.....23

TABLE 11. HF-2500 PROPORTIONING PUMP ASSEMBLY, (PART NO. 36400/36450-52), PARTS.....25

TABLE 12. HYDRAULIC CYLINDER ASSEMBLY, (PART NO. 18511-51), PARTS.....27

TABLE 13. LUBE PUMP ASSEMBLY, (PART NO. 17491-52/17491-60), PARTS.....28

TABLE 14. HF-1600 ELECTRICAL SCHEMATIC, (PART NO. SD18000-SIZE), PARTS44

TABLE 15. HF-2500 ELECTRICAL SCHEMATIC, (PART NO. SD23000-SIZE), PARTS46

WARRANTY

Gusmer Corporation (Gusmer) provides a limited warranty to the original purchaser (Customer) of Gusmer manufactured parts and equipment (Product) against any defects in material or workmanship for a period of one year from the date of shipment from Gusmer facilities.

In the event Product is suspected to be defective in material or workmanship, it must be returned to Gusmer, freight prepaid. If Product is found to be defective in material or workmanship, as determined solely by Gusmer, Gusmer will issue full credit to Customer for the freight charges incurred in returning the defective Product, and either credit will be issued for the replacement cost of the Product or a replacement part will be forwarded no-charge, freight prepaid to Customer.

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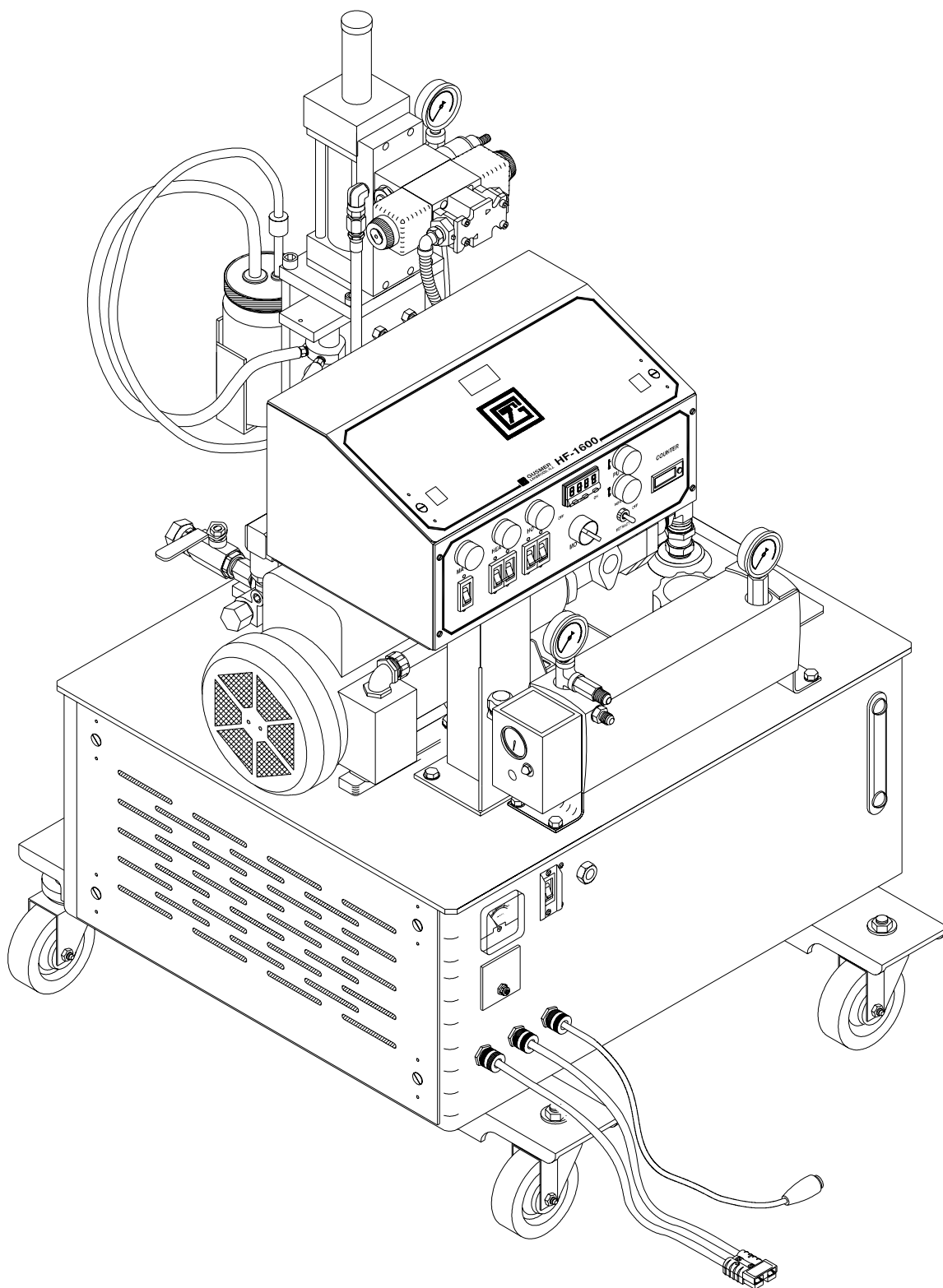
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HF-1600/2500 ASSEMBLIES

FINAL ASSEMBLY

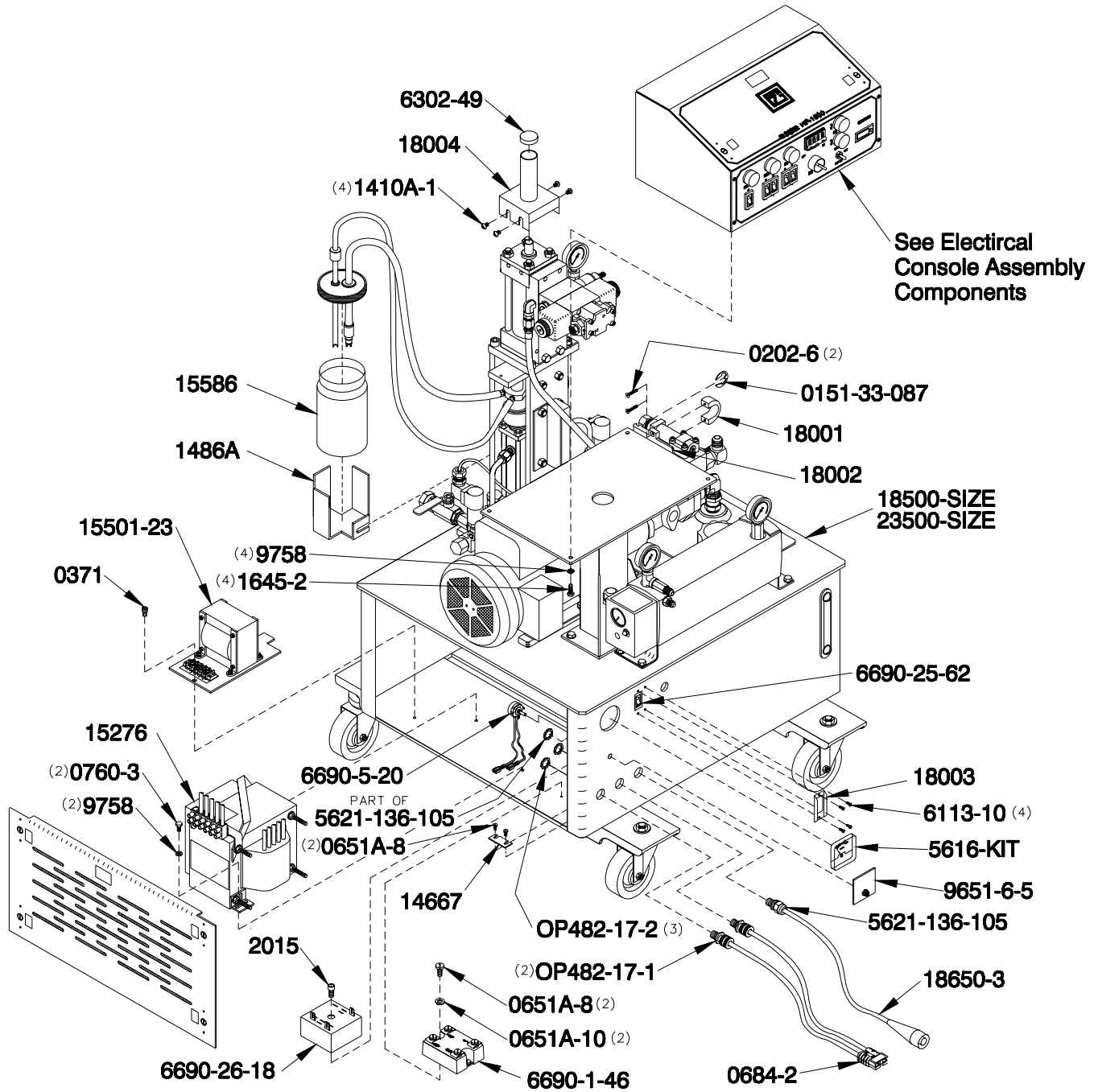


Figure 1. Final Assembly, (Part No. 18000-SIZE/18000-DGT-SIZE/23000-SIZE), Exploded View
18000-DGT- SIZE Shown

NOTE: Consult the Electrical Schematic Section of this Manual for Electrical Components not called out in this Assembly.

TABLE 1. FINAL ASSEMBLY, (PART NO. 18000-SIZE/18000-DGT-SIZE/23000-SIZE), PARTS

Part Number	Description	Quantity
0151-33-087	Snap Ring	1
0202-6	Flat Head Cap Screw	2
0371	Socket Head Cap Screw	1
0651A-10	Internal Lockwasher (<i>Digital Hose Heat Only</i>)	2
0651A-8	Pan Head Cap Screw (<i>Digital Hose Heat Only</i>)	4
0684-2	Power Lock Connector	1
0760-3	Hex Head Cap Screw	2
1410A-1	Round Head Machine Screw	4
1486A	Lube Reservoir Bracket	1
1645-2	Hex Head Cap Screw	4
2015	Socket Head Cap Screw	1
5616-KIT	0-80 Ammeter	1
5621-136-105	Straight Connector (<i>Digital Hose Heat Only</i>)	1
6113-10	Button Head Cap Screw	4
6302-49	Poly Cap	1
6690-1-46	Solid State Relay (<i>Digital Hose Heat Only</i>)	1
6690-25-62	Circuit Breaker	1
6690-26-18	Phase Controller	1
6690-5-20	Potentiometer Assembly	1
9651-6-5	Shaft Lock	1
9758	Helical Lockwasher	6
14667	Terminal Jumper (<i>Digital Hose Heat Only</i>)	1
15276	Transformer Assembly	1
15501-23	Transformer Plate Assembly	1
15586	Lube Bottle	1
18001	Compensator Stop Clamp	1
18002	Compensator Stop Plate	1
18003	Switch Guard	1
18004	Guard Weldment	1
18500-SIZE	Base Assembly (<i>HF-1600</i>)	1
18650-3	TSU Wire Assembly (<i>Digital Hose Heat Only</i>)	1
23500-SIZE	Base Assembly (<i>HF-2500</i>)	1
OP482-17-1	Bushing	2
OP482-17-2	Lock Nut	2

BASE ASSEMBLY

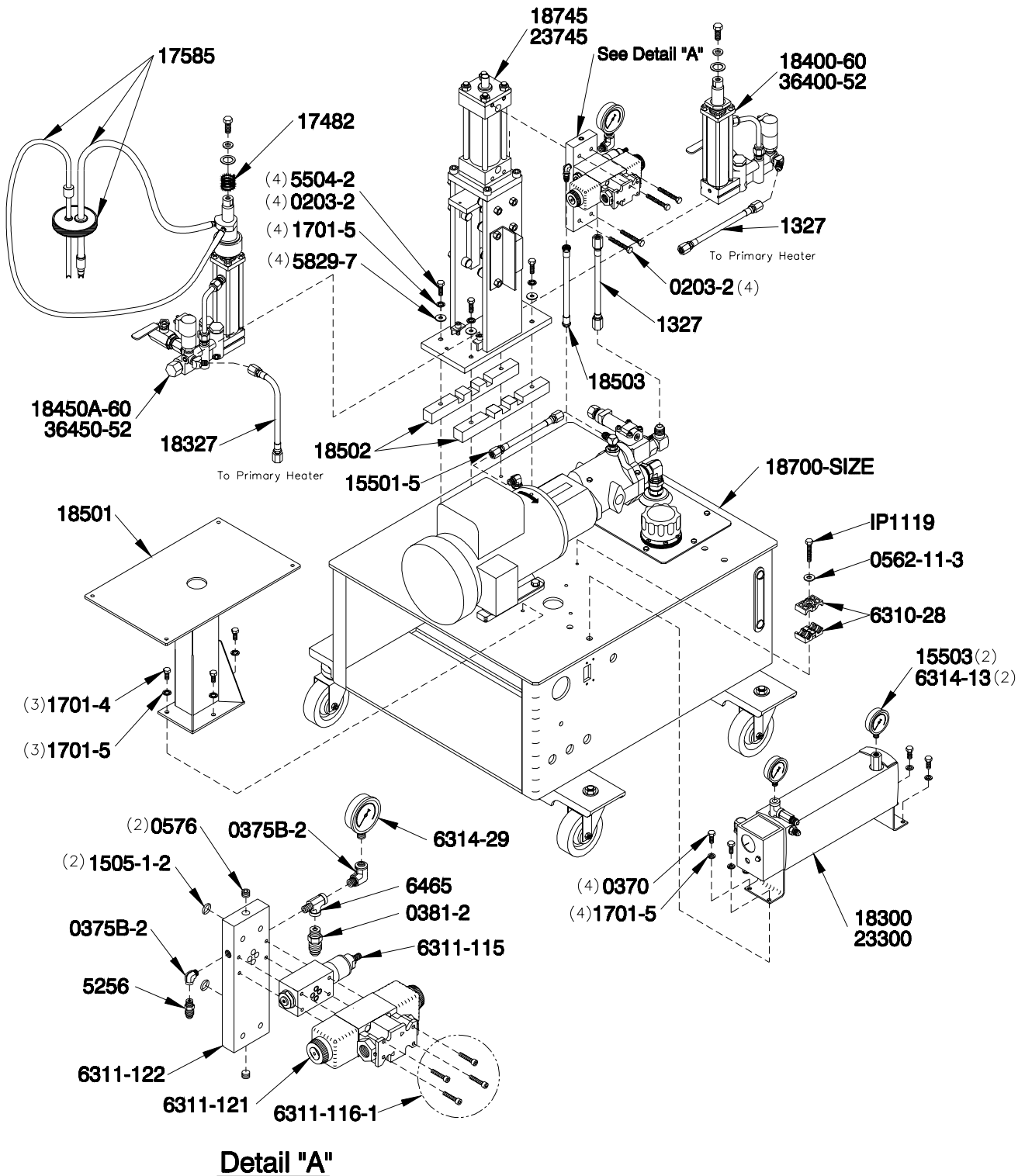


Figure 2. Base Assembly, (Part No. 18500-SIZE, 23500-SIZE), Exploded

TABLE 2. BASE ASSEMBLY, (PART NO. 18500-SIZE, 23500-SIZE), PARTS

Part Number	Description	Quantity
0203-2	Hex Head Cap Screw (HF-1600)	4
	Hex Head Cap Screw (HF-2500)	8
0370	Hex Head Cap Screw	4
0375B-2	Street Elbow	2
0381-2	Hex Nipple	1
0562-11-3	Flat Washer	1
0576	Pipe Plug	2
1327	Interconnect Hose	2
1505-1-2	O-Ring	2
1701-4	Hex Head Cap Screw	3
1701-5	Internal Lockwasher	11
5256	JIC Nipple	1
5504-2	Hex Head Cap Screw (HF-1600)	4
5829-7	Flat Washer	4
6310-28	Hose Clamp	1
6311-115	Pressure Reducing Valve	1
6311-116-1	Bolt Kit	1
6311-121	Directional Valve	1
6311-122	Hydraulic Sub Plate	1
6314-13	0-5000 psi Liquid Filled Gauge (HF-2500)	2
6314-29	0-2000 psi Liquid Filled Gauge	1
6465	Pipe Tee	1
15501-5	Bleed Hose	1
15503	0-3000 psi Liquid Filled Gauge (HF-1600)	2
17482	Spring	1
17585	Lube Reservoir Hose Assembly	1
18300	Primary Heater Assembly (HF-1600)	1
18327	Interconnect Hose	1
18400-60	Resin Proportioning Pump Assembly (HF-1600)	1
18450A-60	Iso Proportioning Pump Assembly (HF-1600)	1
18501	Console Bracket	1
18502	Pump Base Standoff (HF-1600)	2
18503	Return Hose	1
18700-SIZE	Hydraulic Tank And Motor Assembly	1
18745	Hydraulic Motor Assembly (HF-1600)	1
23300	Primary Heater Assembly (HF-2500)	1
23745	Hydraulic Motor Assembly (HF-2500)	1
36400-52	Resin Proportioning Pump Assembly (HF-2500)	1
36450-52	Iso Proportioning Pump Assembly (HF-2500)	1
IP1119	Hex Head Cap Screw	1

HYDRAULIC TANK AND ELECTRIC MOTOR ASSEMBLY

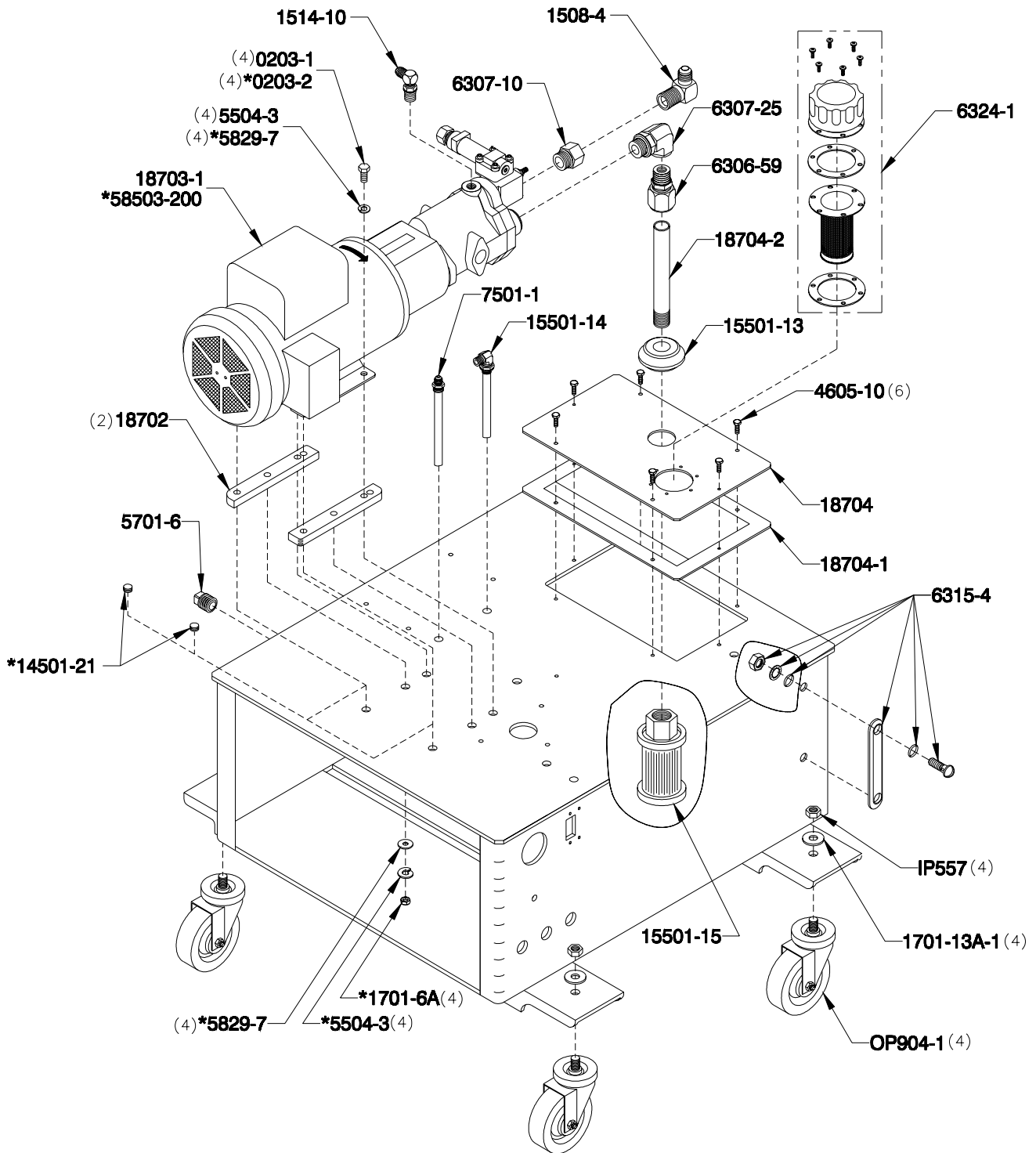


Figure 3. Hydraulic Tank and Electric Motor Assembly, (Part No. 18700-SIZE), Exploded View

* Three-Phase Units Only

TABLE 3. HYDRAULIC TANK AND ELECTRIC MOTOR ASSEMBLY, (PART No. 18700-SIZE), PARTS

Part Number	Description	Quantity
0203-1	Hex Head Cap Screw (<i>Single Phase Only</i>)	4
0203-2	Hex Head Cap Screw (<i>Three Phase Only</i>)	4
1508-4	JIC Elbow	1
1514-3	Lockwasher (<i>Single Phase Only</i>)	4
1514-10	JIC Elbow	1
1701-6A	Locknut (<i>Three Phase Only</i>)	4
1701-13A-1	Internal Lockwasher	4
4605-10	Hex Head Cap Screw	6
5504-3	Helical Lockwasher (<i>Three Phase Only</i>)	4
	(<i>Single Phase Only</i>)	8
5701-6	Drain Plug	1
5829-7	Flat Washer (<i>Three Phase Only</i>)	8
6306-59	Tube Nipple	1
6307-10	O-Ring Bushing	1
6307-25	O-Ring Fitting	1
6315-4	Fluid Level Gauge	1
6324-1	Hydraulic Oil Fill	1
7501-1	Hydraulic Reservoir Return Tube	1
14501-21	Socket Head Set Screw (<i>Three Phase Only</i>)	2
15501-13	Grommet	1
15501-14	Hydraulic Reservoir Return Hose	1
15501-15	Cartridge Strainer	1
18702	Electric Motor Stand-off	2
18703-1	Motor Pump Assembly (1 X 220V)	1
58503-200	Motor Pump Assembly (3 X 200V)	1
18704	Access Cover Plate	1
18704-1	Access Cover Plate Gasket	1
18704-2	Suction Tube	1
IP557	Hex Nut	4
OP904-1	Swivel Castor	4

* *Three-Phase Unit (Part No. 18700-13) available in Asia Only.*

HYDRAULIC MOTOR ASSEMBLY

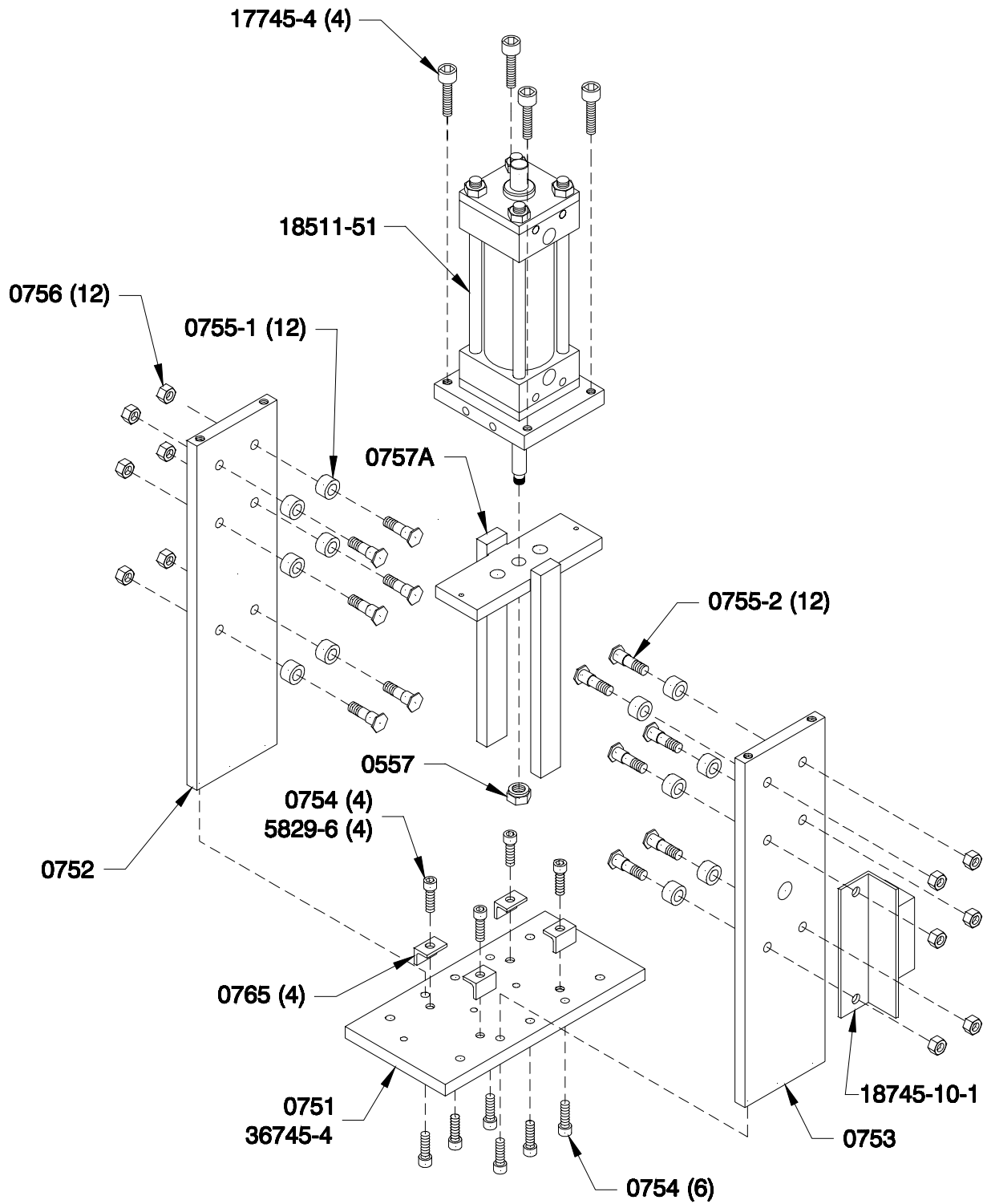


Figure 4. Hydraulic Motor Assembly, (Part No. 18745, 23745), Exploded View

TABLE 4. HYDRAULIC MOTOR ASSEMBLY, (PART NO. 18745, 23745),PARTS

Part Number	Description	Quantity
0557	Piston Rod Nut	1
0751	Proportioning Base (<i>HF-1600 only</i>)	1
0752	Air Cylinder Upright	1
0753	Air Cylinder Upright-Sw Side	1
0754	Socket Head Cap Screw	10
	Socket Head Cap Screw (<i>HF-2500 only</i>)	6
0755-1	Bearings	12
0755-2	Cam Roller Stud	12
0756	Hex Nut	12
0757A	Pump Yoke	1
0765	Pump Mounting Bracket (<i>HF-1600 only</i>)	4
5829-6	Socket Head Cap Screw (<i>HF-2500 only</i>)	4
17745-4	Socket Head Cap Screw	4
18511-51	Hydraulic Cylinder	1
36745-4	Proportioning Base (<i>HF-2500 only</i>)	1
18745-10-1	Reversing Switch Assembly	1

REVERSING SWITCH ASSEMBLY

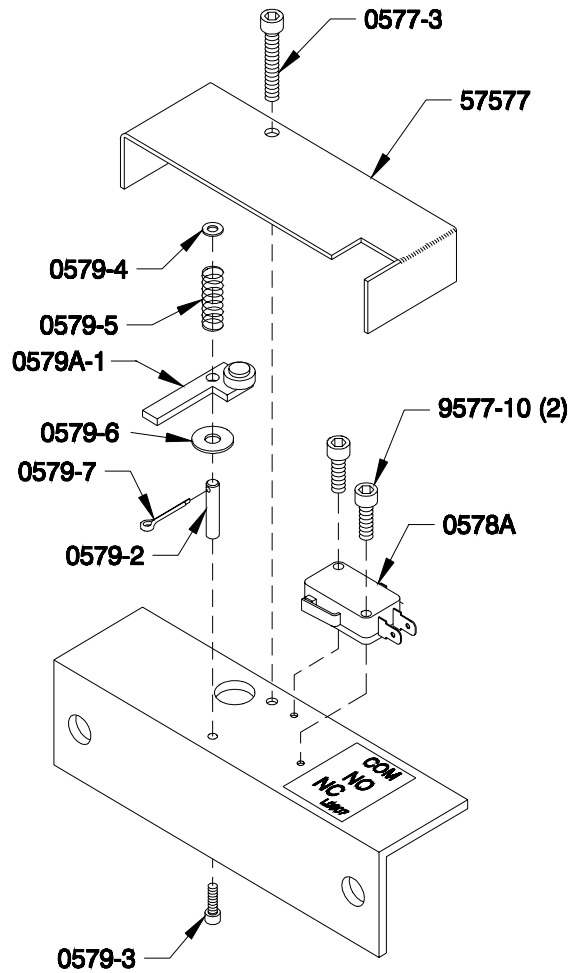


Figure 5. Reversing Switch, (Part No. 18745-10-1), Exploded View

TABLE 5. REVERSING SWITCH, (PART NO. 18745-10-1), PARTS

Part Number	Description	Quantity
0577-3	Socket Head Cap Screw	1
0578A	Reversing Switch	1
0579-2	Pivot Arm	1
0579-3	Socket Head Cap Screw	1
0579-4	Flat Washer	1
0579-5	Spring	1
0579-6	Fiber Washer	1
0579-7	Cotter Pin	1
0579A-1	Reversing Switch Lever	1
57577	Reversing Switch Cover Box	1
9577-10	Socket Head Cap Screw	2

MOTOR LINE ASSEMBLIES

Single Phase, 220 Volt

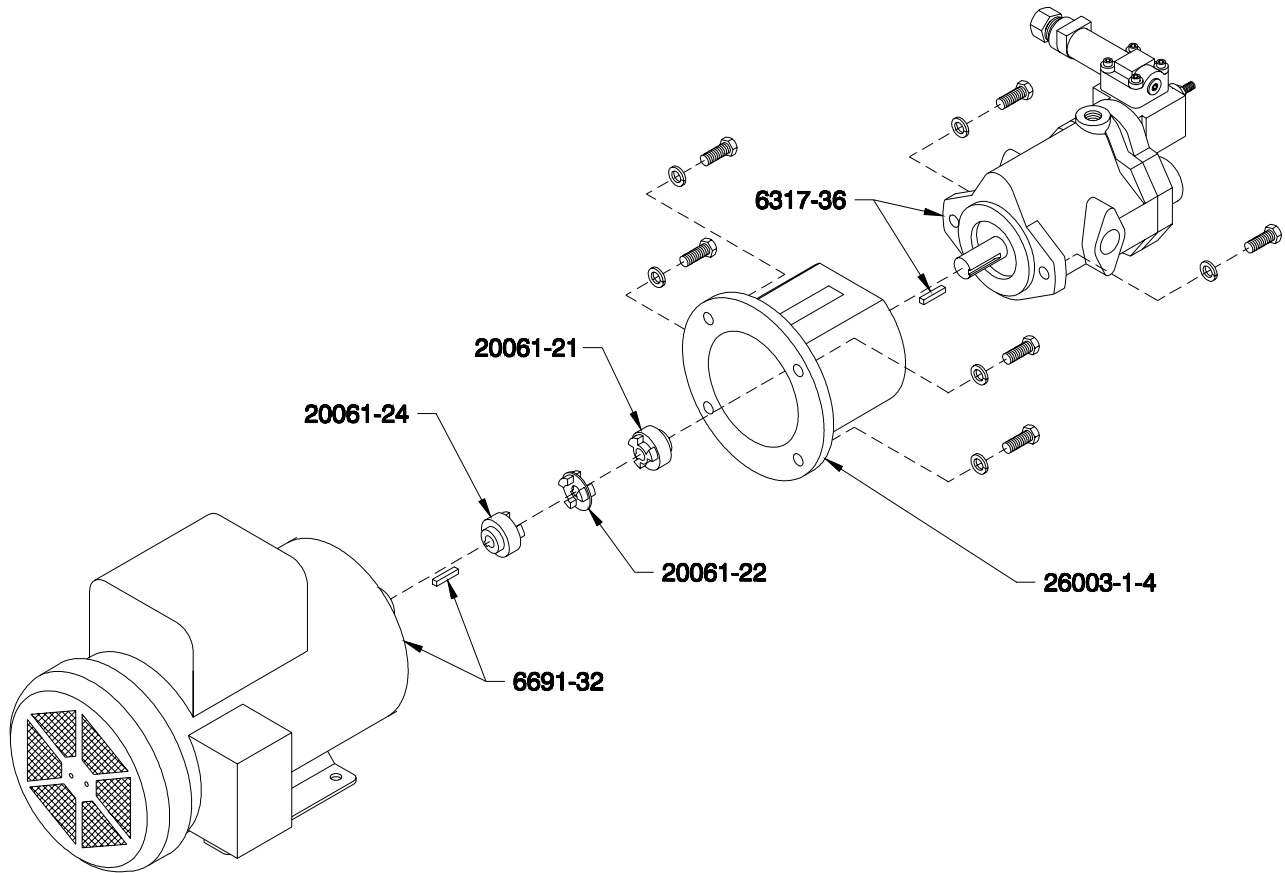


Figure 6. Motor Line Assembly, Single Phase, 220 Volt, (Part No. 18703-1), Exploded View

TABLE 6. MOTOR LINE ASSEMBLY, SINGLE PHASE, 220 VOLT, (PART NO. 18703-1), PARTS

Part Number	Description	Quantity
6317-36	Hydraulic Pump	1
6691-32	2HP/220V Motor	1
20061-21	Shaft Coupler	1
20061-22	Coupling Alignment Spider	1
20061-24	Shaft Coupler	1
26003-1-4	Bell Housing	1

Three Phase, 230 Volt

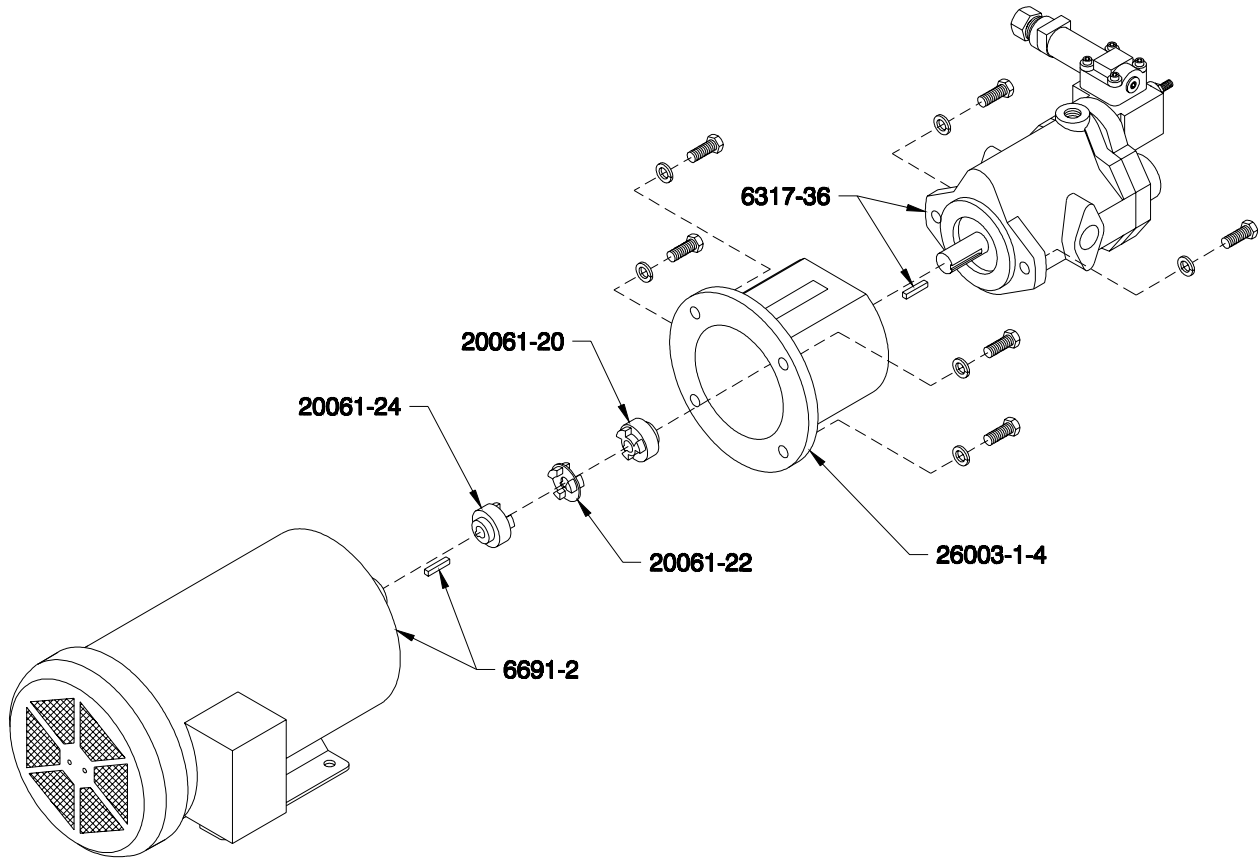


Figure 7. Motor Line Assembly, Three Phase, 230 Volt, (Part No. 18703-11), Exploded View

TABLE 7. MOTOR LINE ASSEMBLY, THREE PHASE, 230 VOLT, (PART NO. 18703-11), PARTS

Part Number	Description	Quantity
6317-36	Hydraulic Pump	1
6691-2	2HP Motor	1
20061-21	Shaft Coupler	1
20061-22	Coupling Alignment Spider	1
20061-24	Shaft Coupler	1
26003-1-4	Bell Housing	1

**Three Phase, 200 Volt
(Available in Asia Only)**

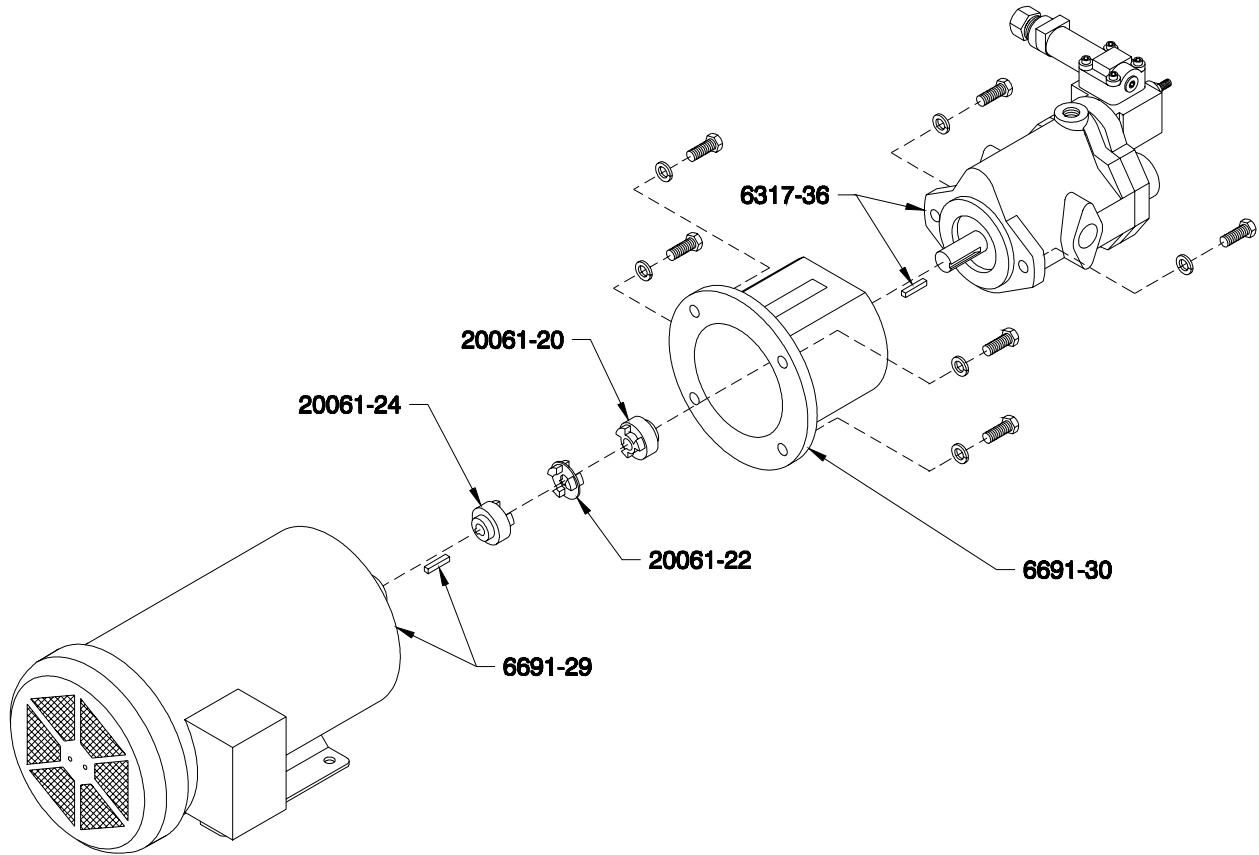


Figure 8. Motor Line Assembly, Three Phase, 200 Volt, (Part No. 58503-200), Exploded View

TABLE 8. MOTOR LINE ASSEMBLY, THREE PHASE, 200 VOLT, (PART NO. 58503-200), PARTS

Part Number	Description	Quantity
6317-36	Hydraulic Pump	1
6691-29	2HP/200V Motor	1
6691-30	Bell Housing	1
20061-20	Shaft Coupler	1
20061-22	Coupling Alignment Spider	1
20061-24	Shaft Coupler	1

PRIMARY HEATER ASSEMBLY

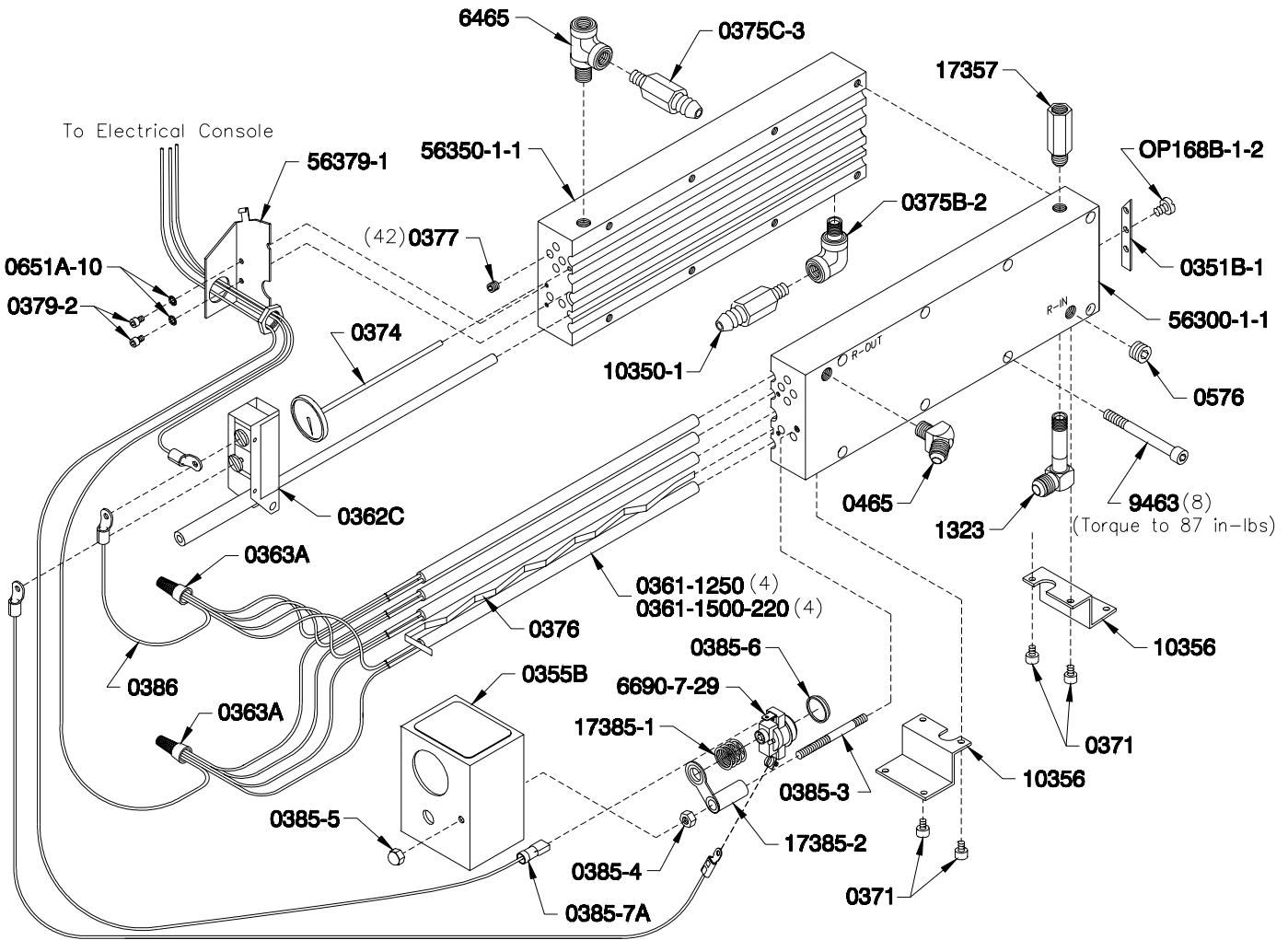


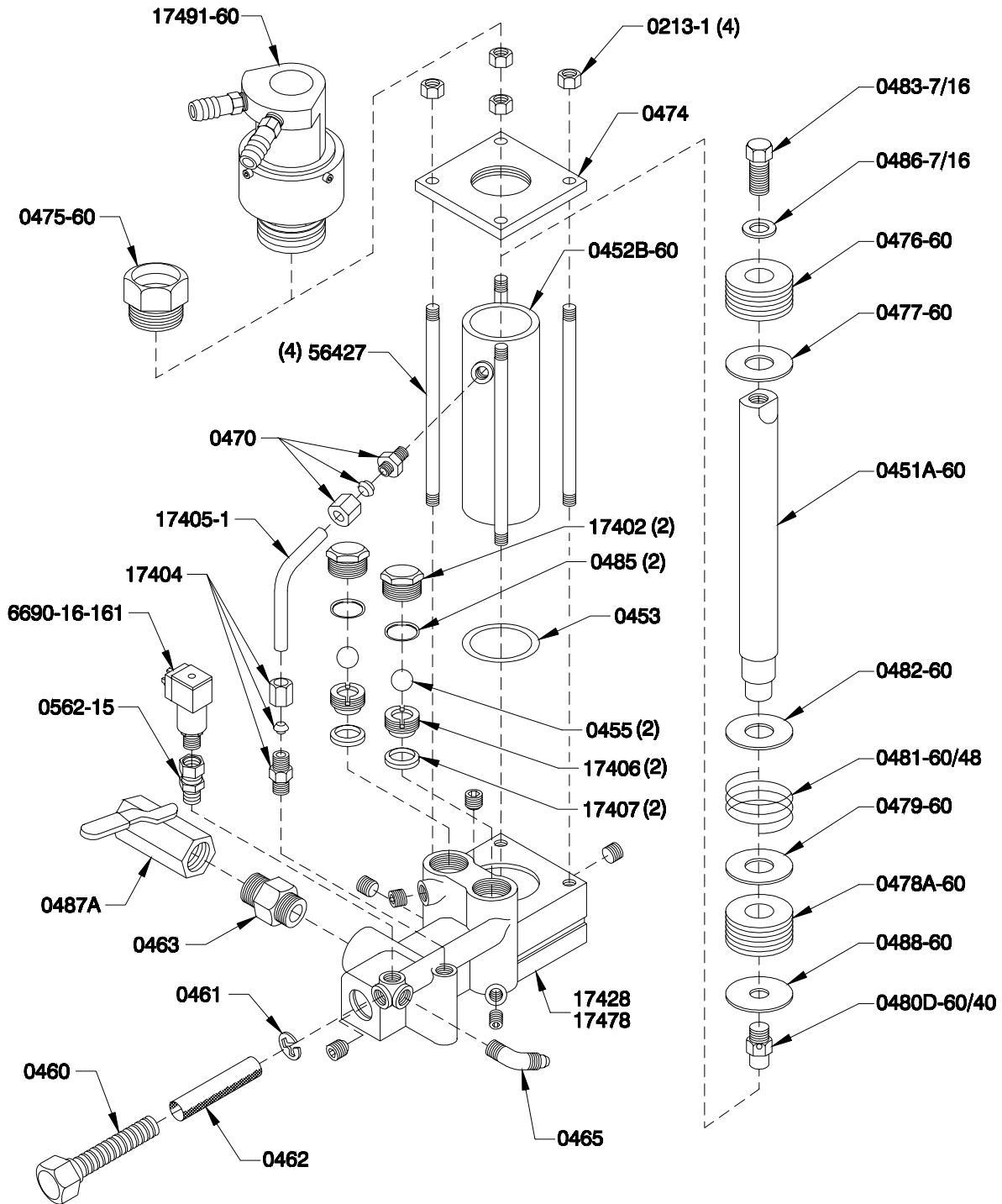
Figure 9. Primary Heater, (Part No. 18300, 23300), Exploded View

TABLE 9. PRIMARY HEATER, (PART NO. 18300, 23300), PARTS

Part Number	Description	Quantity
0351B-1	Stop	1
0355B	Thermostat Cover Box	1
0361-1250	Heating Element (<i>HF-1600 only</i>)	4
0361-1500-220	Heating Element 1500 Watt (<i>HF-2500 only</i>)	4
0362C	Thermostat	1
0363A	Insulating Wire Nut	2
0371	Socket Head Cap Screw	4
0374	Dial Thermometer	1
0375B-2	Street Elbow	1
0375C-3	Hose Nipple	1
0376	Leaf Spring	1
0377	Pipe Plug	42
0379-2	Socket Head Cap Screw	2
0385-3	Threaded Stud	1
0385-4	Hex Nut	1
0385-5	Acorn Nut	1
0385-6	Heat Transfer Plate	1
0385-7A	Wire Harness	1
0386	Firerod Harness	1
0465	Hose Elbow	1
0576	Pipe Plug	1
0651A-10	Lockwasher	2
1323	Long Male Elbow	1
6465	Pipe Tee	1
6690-7-29	Thermal Limit Switch	1
*9463	Socket Head Cap Screw	8
10350-1	Extended Hose Nipple	1
10356	Bracket	2
17357	Bushing	1
17385-1	Wave Spring	1
17385-2	Mounting Bracket	1
56300-1-1	R-Primary Heater Half	1
56350-1-1	A-Primary Heater Half	1
56379-1	Thermostat Mounting Bracket	1
OP168B-1-2	Pan Head Machine Screw	1

*Torque Specifications: 87 Inch Pounds

HF-1600 PROPORTIONING PUMP ASSEMBLY



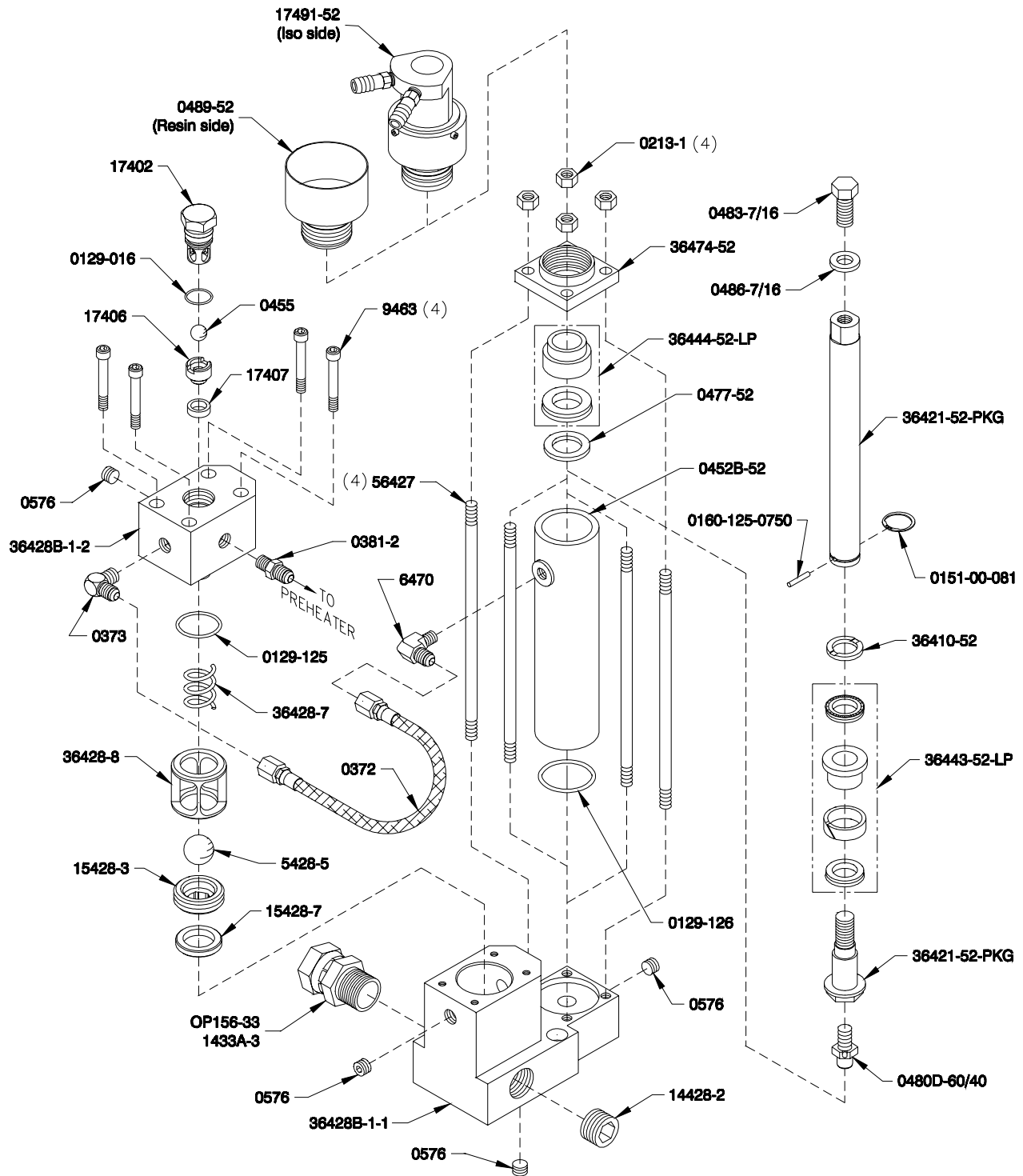
**Figure 10. Proportioning Pump Assembly, (Part No. 18400/18450A-60), Exploded View
(18450A-60 Shown)**

NOTE: Consult your distributor for information concerning the availability of non-standard pump sizes.

TABLE 10. HF-1600 PROPORTIONING PUMP ASSEMBLY, (PART NO. 18400/18450A-60), PARTS

Part Number	Description	Quantity
0213-1	Hex Nut	4
0451A-60	Piston Rod	1
0452B-60	Cylinder	1
0453	O-Ring	1
0455	Valve Ball	2
0460	Screen Screw	1
0461	Snap Ring	1
0462	Pump Screen	1
0463	Hex Nipple	1
0465	Hose Elbow	1
0470	Tube Nipple	1
0474	Cylinder Top	1
0475-60	Packing Nut (Resin Pump only)	1
0476-60	Packing	1
0477-60	Packing Support Washer	1
0478A-60	Packing	1
0479-60	Packing Support Washer	1
0480D-60/40	Packing Retainer Bolt	1
0481-60/48	Conical Spring	1
0482-60	Spring Retainer Washer	1
0483-7/16	Hex Head Cap Screw	1
0485	O-Ring	2
0486-7/16	Washer	1
0487A	Ball Valve	1
0488-60	Packing Retainer Washer	1
0562-15	Swivel Union	1
6690-16-161	Pressure Switch	1
17402	Check Valve Retainer	2
17404	Tube Fitting	1
17405-1	Connecting Tube	1
17406	Check Valve Seat	2
17407	Check Valve Seal	2
17428	Resin Pump Base	1
17478	Iso Pump Base	1
17491-60	Lube Pump Assembly (Iso Pump only)	1
56427	Tie Rod	4

HF-2500 PROPORTIONING PUMP ASSEMBLY



**Figure 11. Proportioning Pump Assembly, (Part No. 36400/36450-52), Exploded View
(36450-52 Shown)**

NOTE: Consult your distributor for information concerning the availability of non-standard pump sizes.

TABLE 11. HF-2500 PROPORTIONING PUMP ASSEMBLY, (PART NO. 36400/36450-52), PARTS

Part Number	Description	Quantity
0129-016	O-Ring	1
0129-125	O-Ring	1
0129-126	O-Ring	1
0151-00-081	Tru Arc	1
0160-125-0750	Dowel Pin	1
0213-1	Hex Nut	4
0372	Interconnect Hose	1
0373	Elbow	1
0381-2	Hex Nipple	1
0452B-52	Cylinder	1
0455	Valve Ball	1
0477-52	Packing Support Washer	1
0480D-60/40	Packing Retainer Bolt	1
0483-7/16	Hex Head Cap Screw	1
0486-7/16	Washer	1
0489-52	Lube Cup (Resin Pump only)	1
0576	Flush Seal Pipe Plug	4
1433A-3	Swivel Union (Resin Side)	1
5428-5	Stainless Steel Ball	1
6470	Elbow	1
9463	Socket Head Cap Screw	4
14428-2	Flush Seal Pipe Plug	1
15428-3	Valve Ball Seat	1
15428-7	Seat Seal	2
17402	Check Valve Retainer	1
17406	Check Valve Seat	1
17407	Check Valve Seal	1
17491-52	Lube Pump Assembly (Iso Pump only)	1
36410-52	Piston Support Washer	1
36421-52-PKG	Piston Rod W/ Head (Includes D & E)	1
36428-7	Spring	1
36428-8	Ball Check Sleeve	1
36428B-1-1	Lower Pump Base	1
36428B-1-2	Upper Pump Base	1
36443-52-LP	Piston Lip Seal Set	1
36444-52-LP	Cylinder Lip Seal Set	1
36474-52	Cylinder Top	1
56427	Tie Rod	4
OP156-33	Swivel Union (Iso Side)	1

HYDRAULIC CYLINDER ASSEMBLY

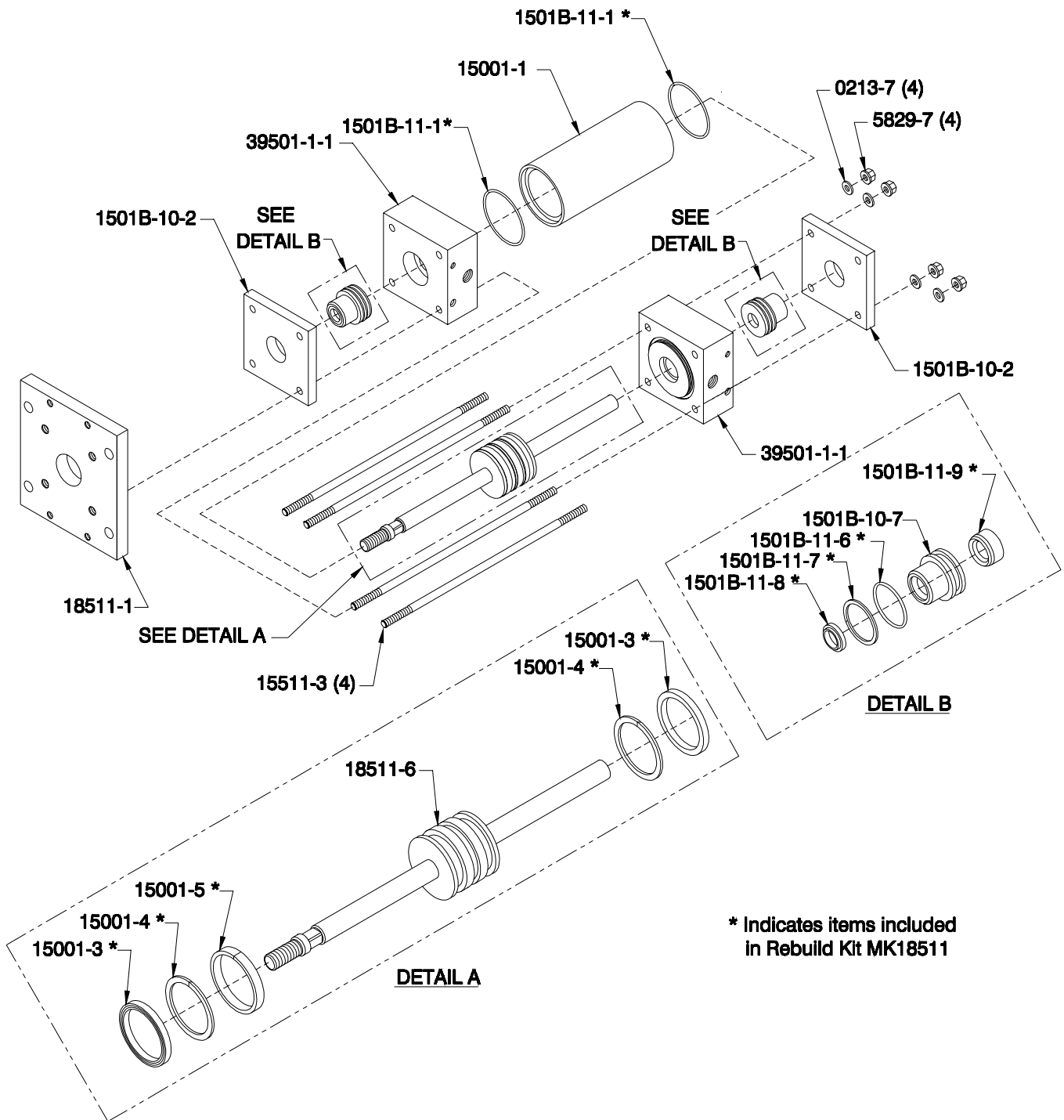


Figure 12. Hydraulic Cylinder Assembly, (Part No. 18511-51), Exploded View

TABLE 12. HYDRAULIC CYLINDER ASSEMBLY, (PART NO. 18511-51), PARTS

Part Number.	Description	Quantity
0213-7	Flange Nut	4
1501B-10-2	Retainer Plate	2
1501B-10-7	Rod Bushing	1
1501B-11-1	O-Ring	2
1501B-11-9	Shaft Seal	1
1501B-11-6	O-Ring	1
1501B-11-7	Back up Ring	1
1501B-11-8	Rod Wiper	1
5829-7	Flat Washer	4
15001-1	Cylinder Body	1
15001-3	U-Cup	2
15001-4	Back up Ring	2
15001-5	Wear Ring	1
15511-3	Tie Rod	4
18511-1	Hydraulic Cylinder Bottom Plate	1
18511-6	Piston Assembly	1
39501-1-1	Port Block	2

LUBE PUMP ASSEMBLY

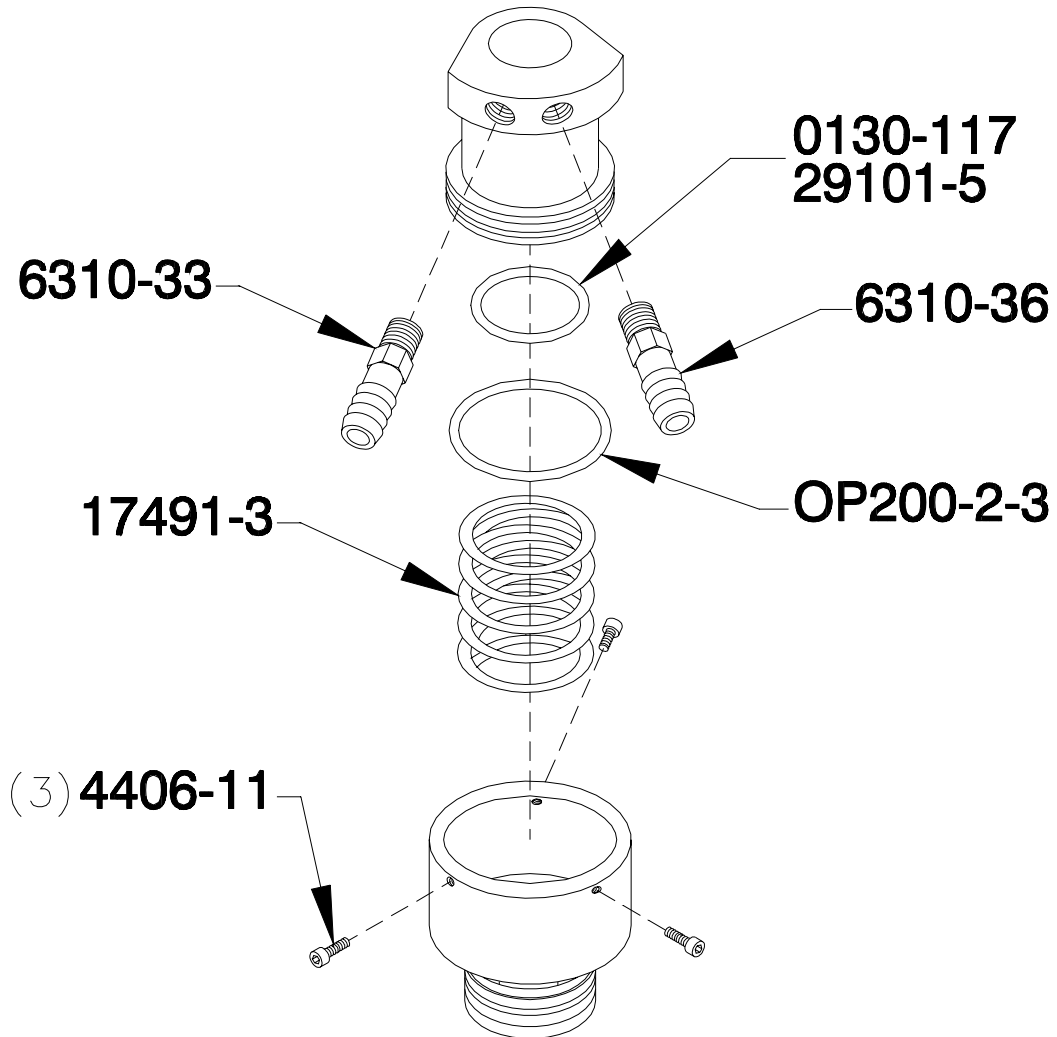


Figure 13. Lube Pump Assembly, (Part No. 17491-52/17491-60), Exploded View

TABLE 13. LUBE PUMP ASSEMBLY, (PART NO. 17491-52/17491-60), PARTS

Part No.	Description	Quantity
0130-117	O-Ring (HF-2500 only)	1
4406-11	Socket Head Cap Screw	3
6310-33	Hose Barb	1
6310-36	Hose Barb	1
17491-3	Spring	1
29101-5	O-Ring (HF-1600 only)	1
OP200-2-3	O-Ring	1

ELECTRICAL CONSOLE COMPONENTS

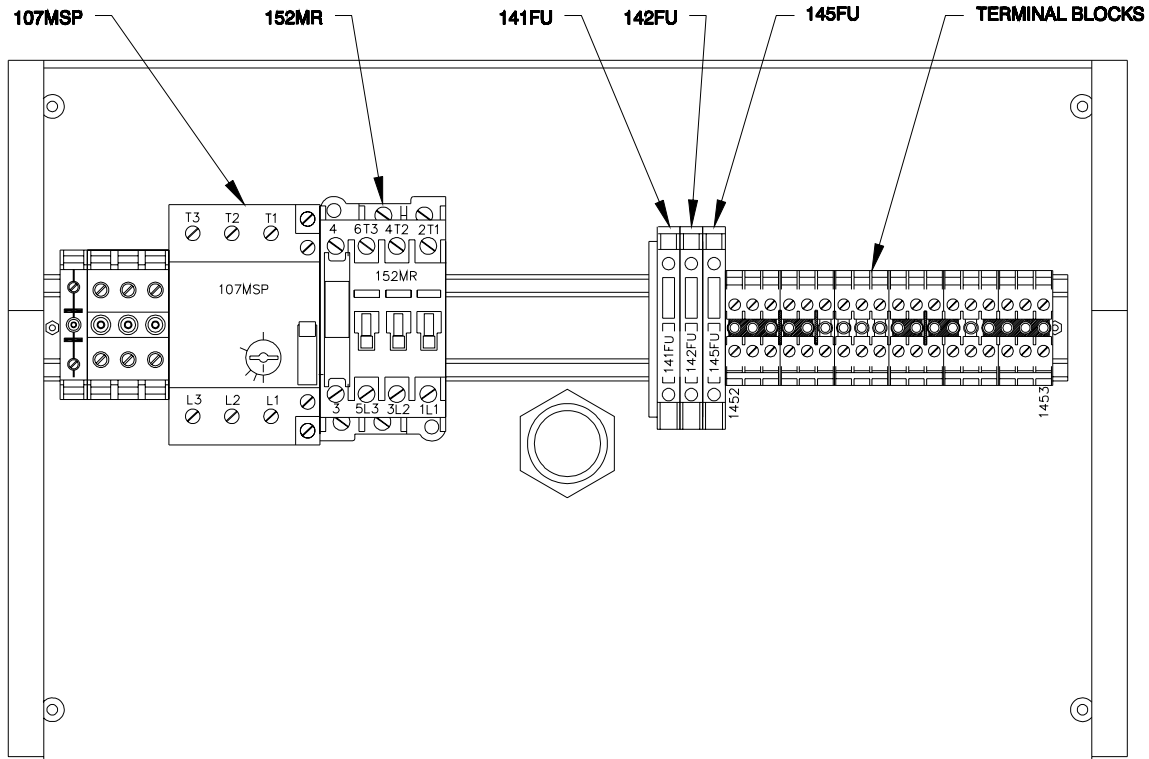
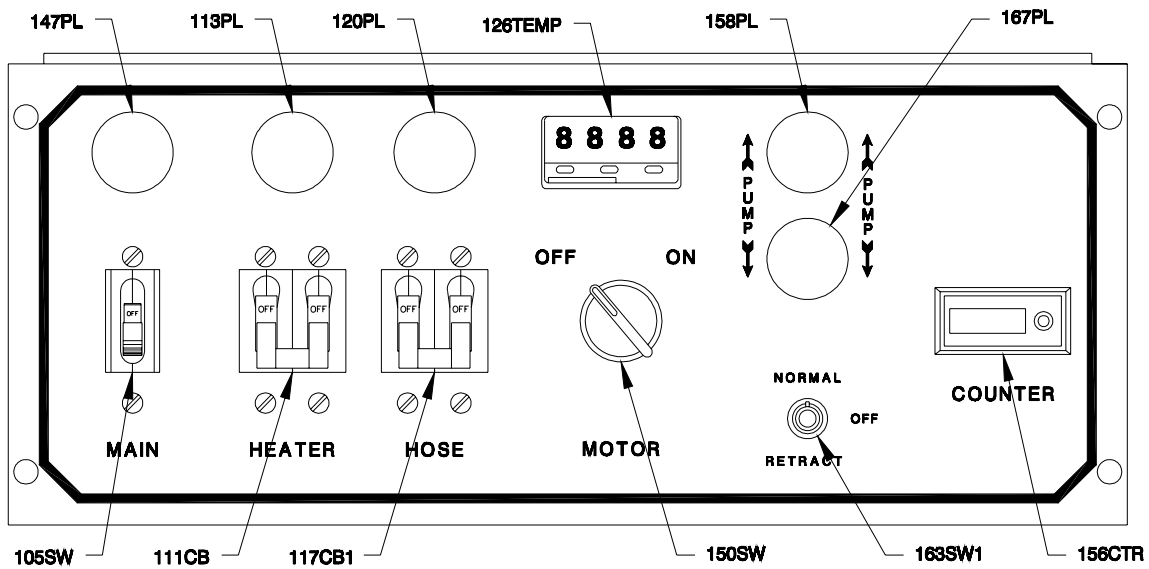


Figure 14. Electrical Console Components
(Digital Hose Heat Console Shown)

Note: For schematic symbol part numbers and descriptions see Electrical Schematics.

HF-1600 ELECTRICAL SCHEMATICS

Manual Hose Heat 1 x 230V

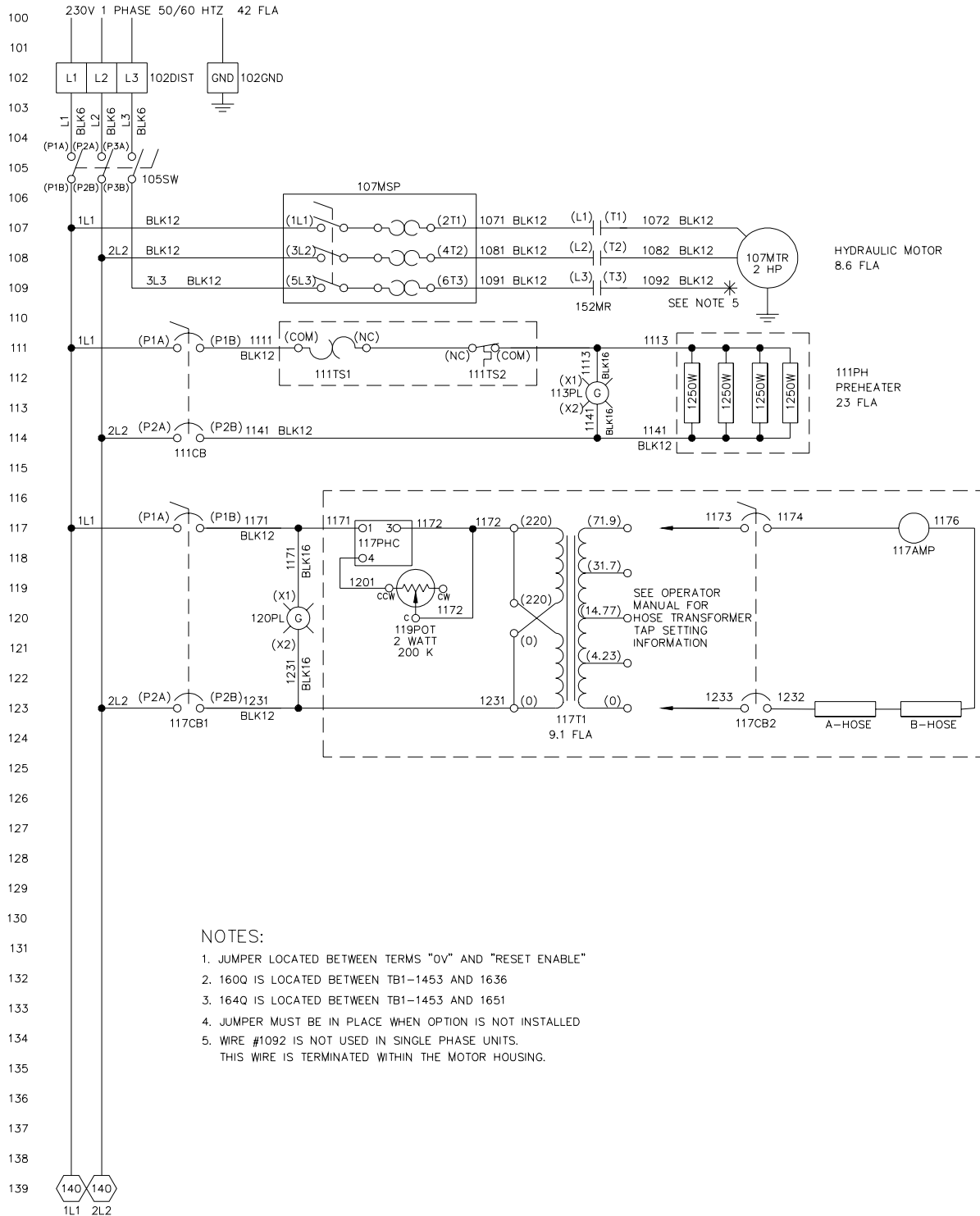


Figure 15. HF-1600 Manual Hose Heat Electrical Schematic, (Part No. SD18000-1), Sheet 1 of 2

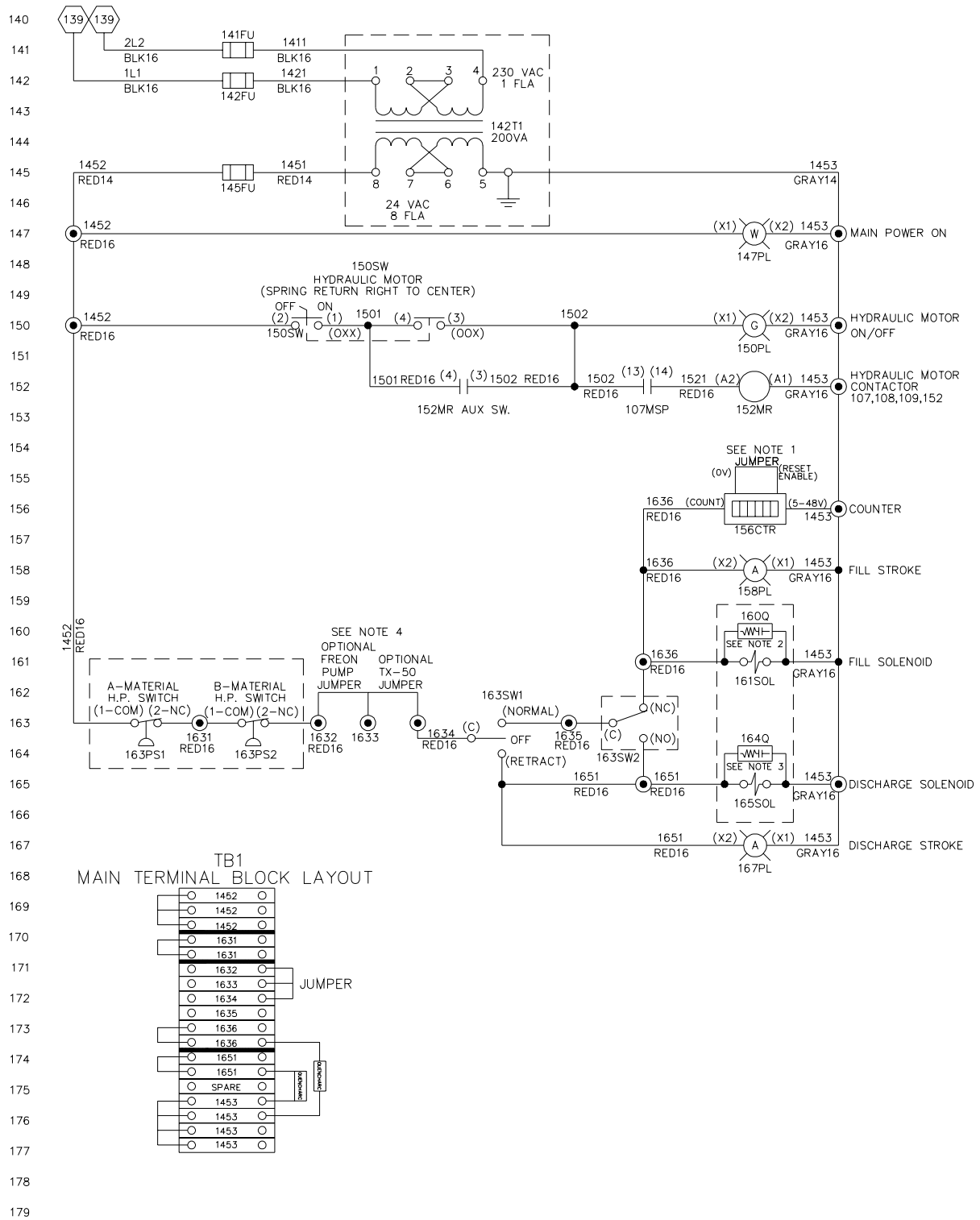


Figure 16. HF-1600 Manual Hose Heat Electrical Schematic, (Part No. SD18000-1), Sheet 2 of 2

Manual Hose Heat 3 x 230V

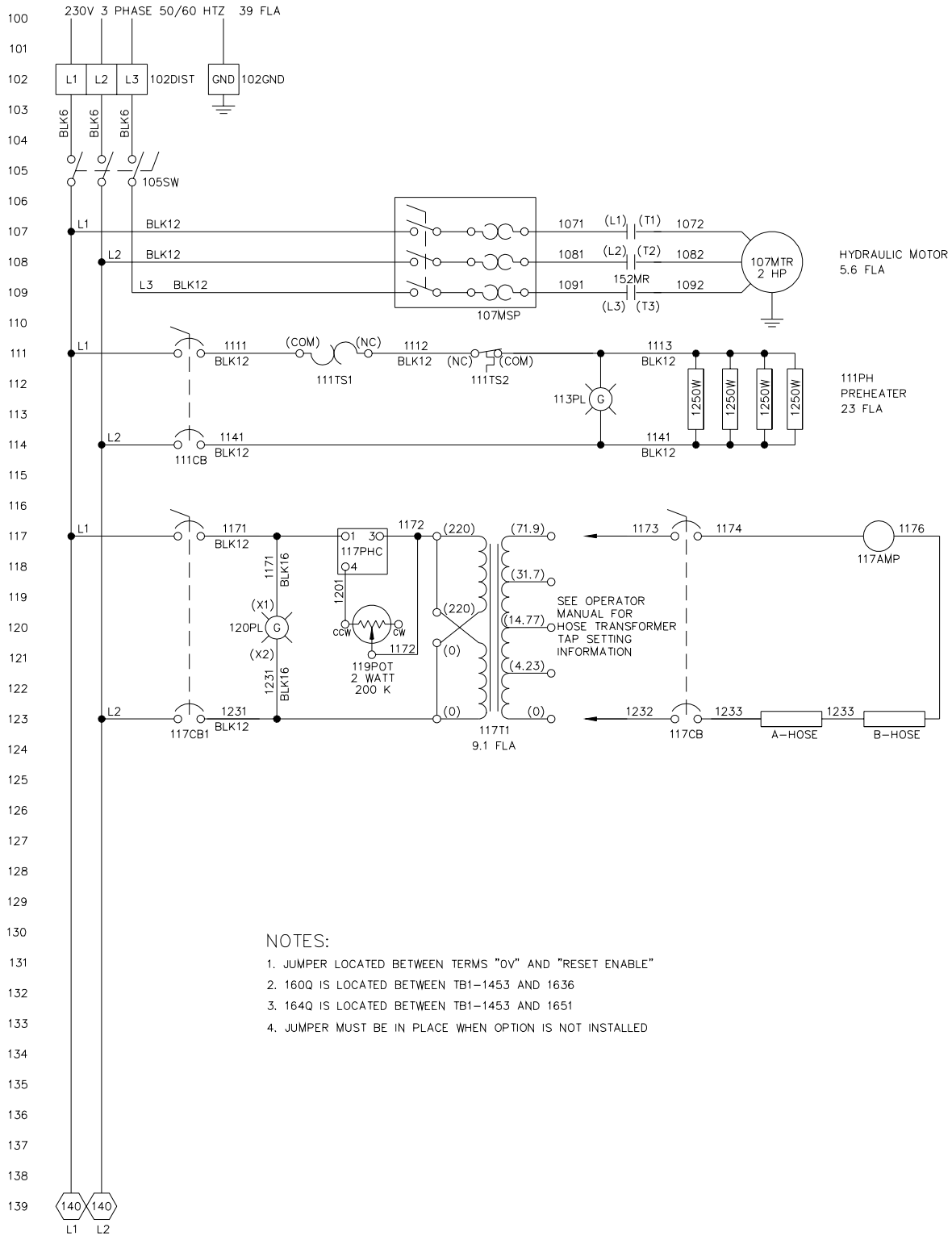


Figure 17. HF-1600 Manual Hose Heat Electrical Schematic, (Part No. SD18000-11), Sheet 1 of 2

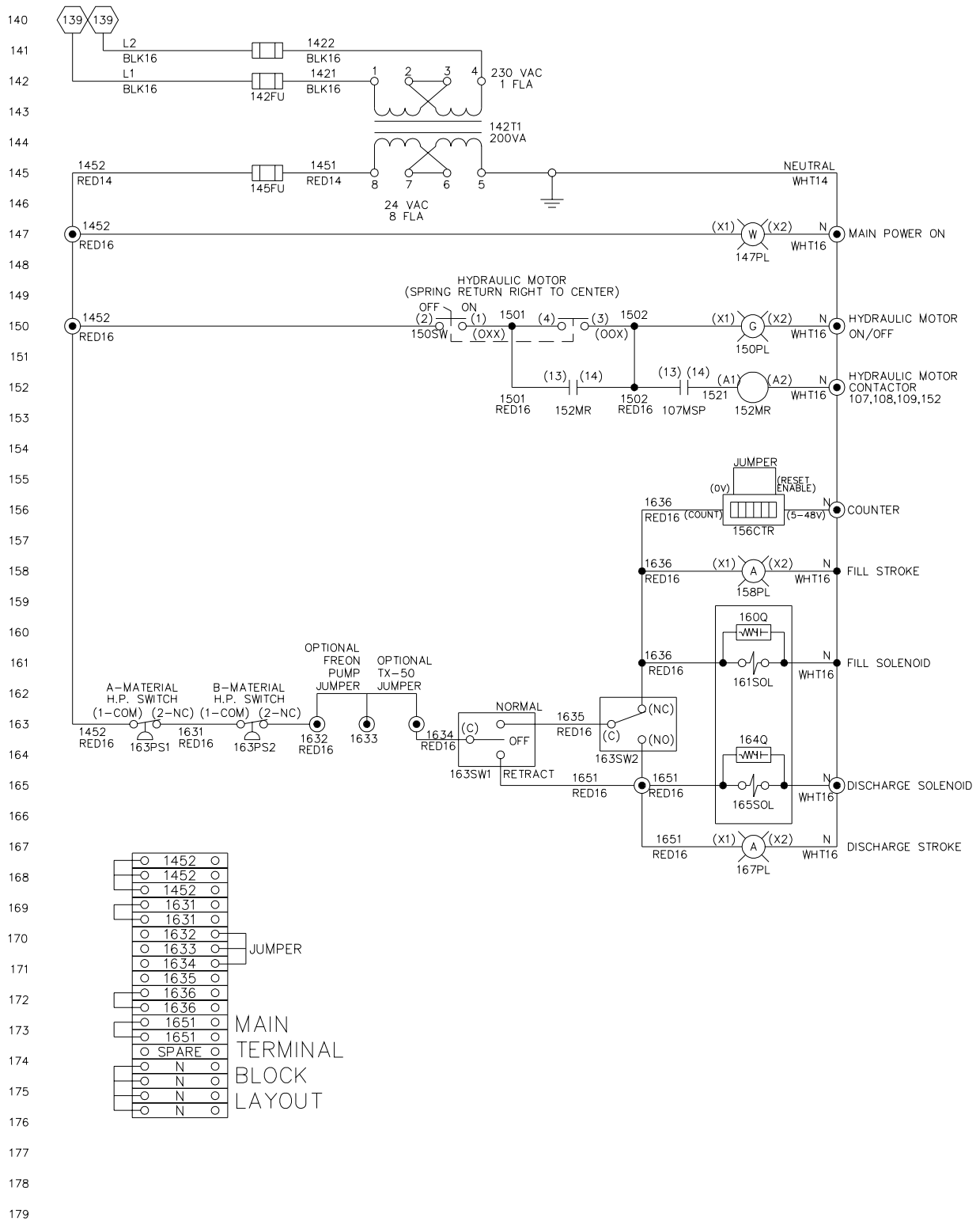


Figure 18. HF-1600 Manual Hose Heat Electrical Schematic, (Part No. SD18000-11), Sheet 2 of 2

**Manual Hose Heat 3 x 200V
(Available in Asia Only)**

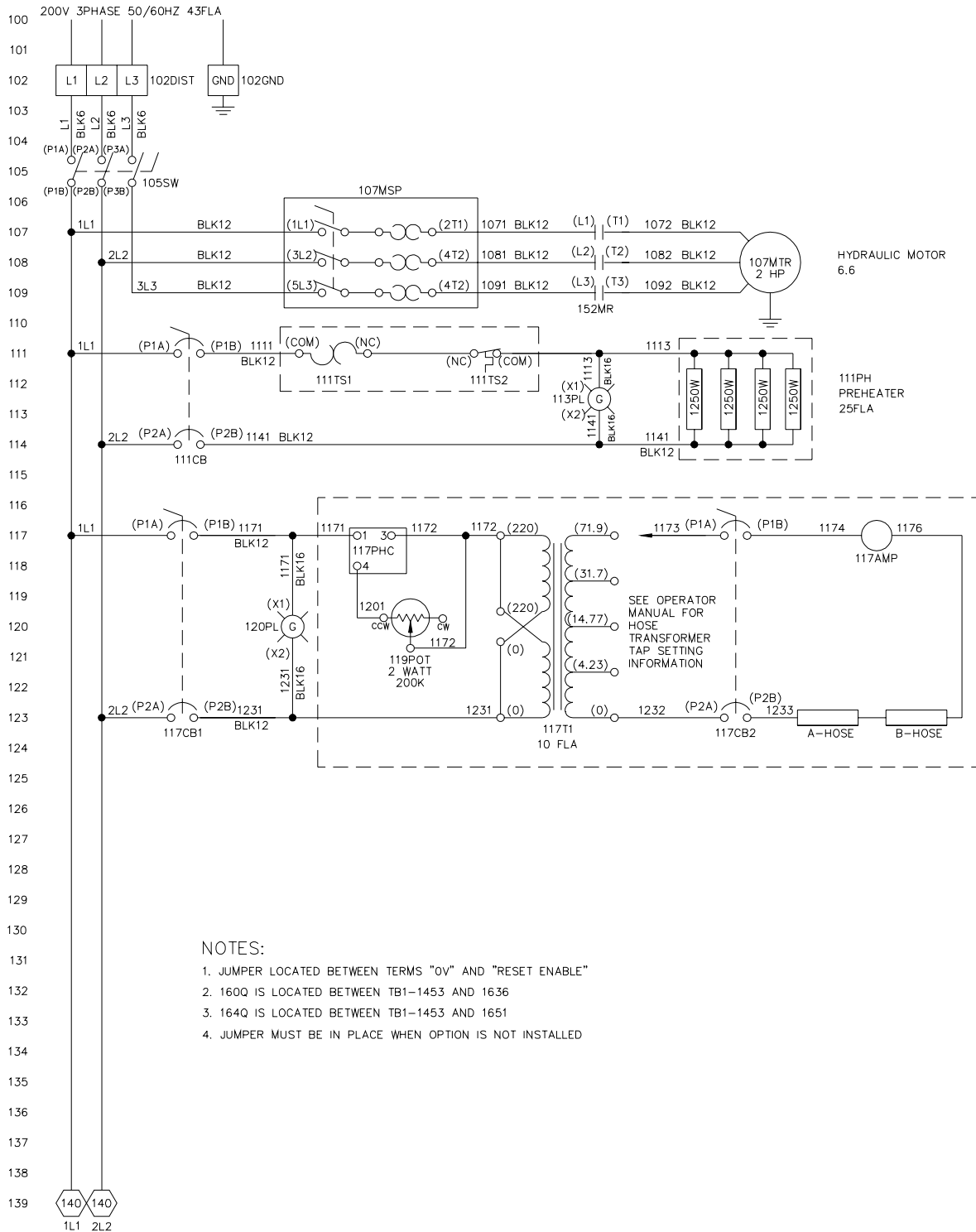


Figure 19. HF-1600 Manual Hose Heat Electrical Schematic, (Part No. SD18000-13), Sheet 1 of 2

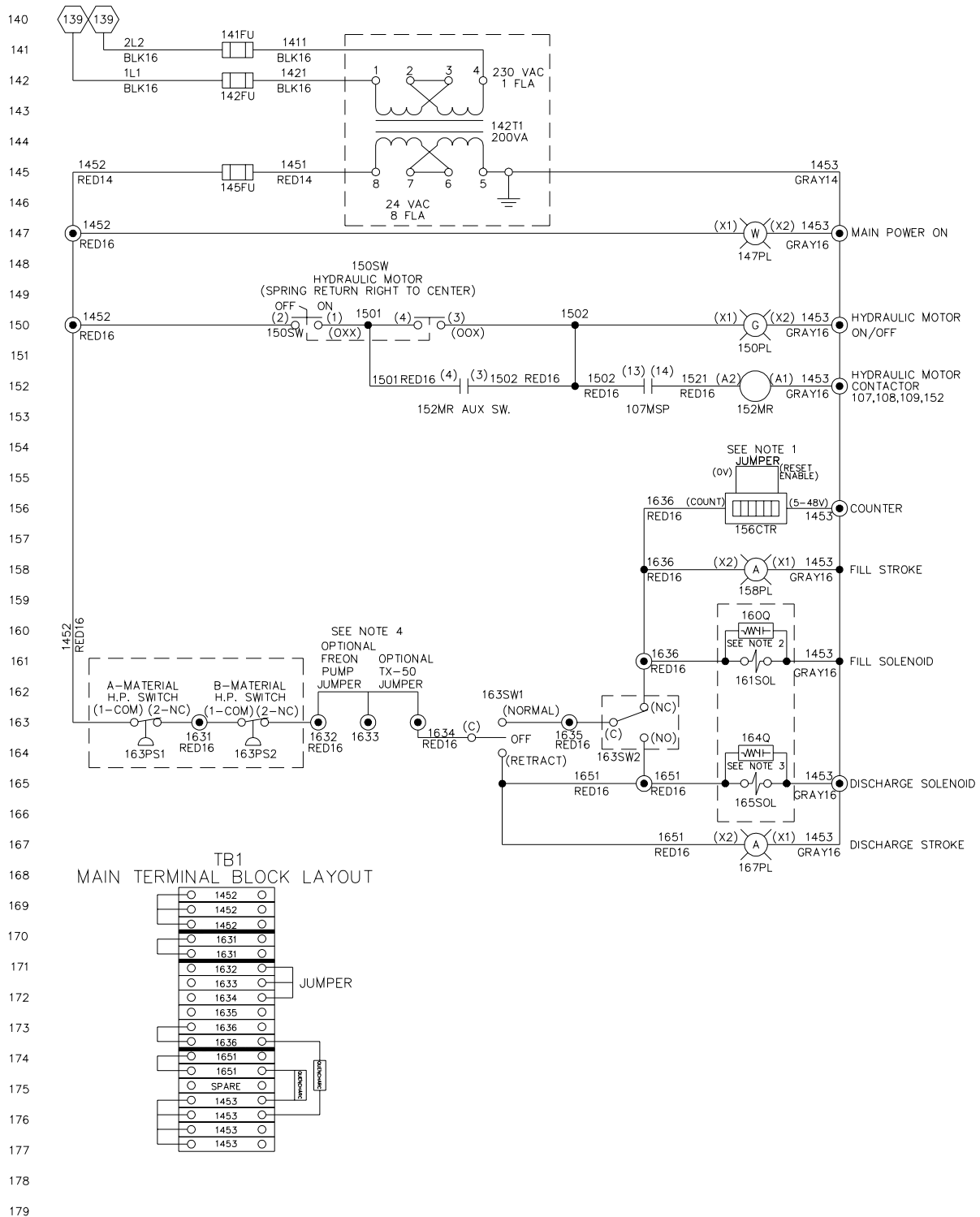


Figure 20. HF-1600 Manual Hose Heat Electrical Schematic, (Part No. SD18000-13), Sheet 2 of 2

Digital Hose Heat 1 x 230V

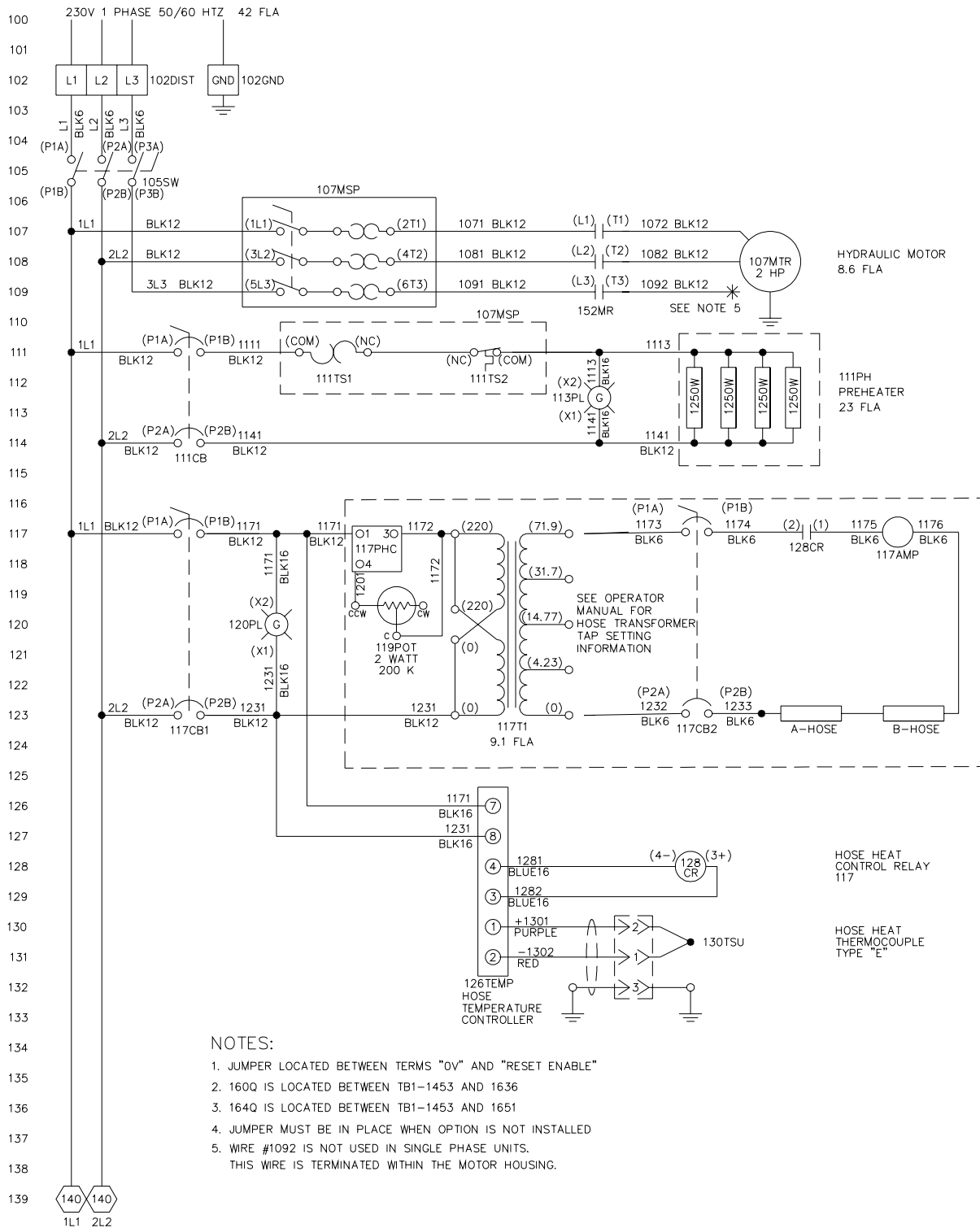


Figure 21. HF-1600 Digital Hose Heat Electrical Schematic, (Part No. SD18000-20), Sheet 1 of 2

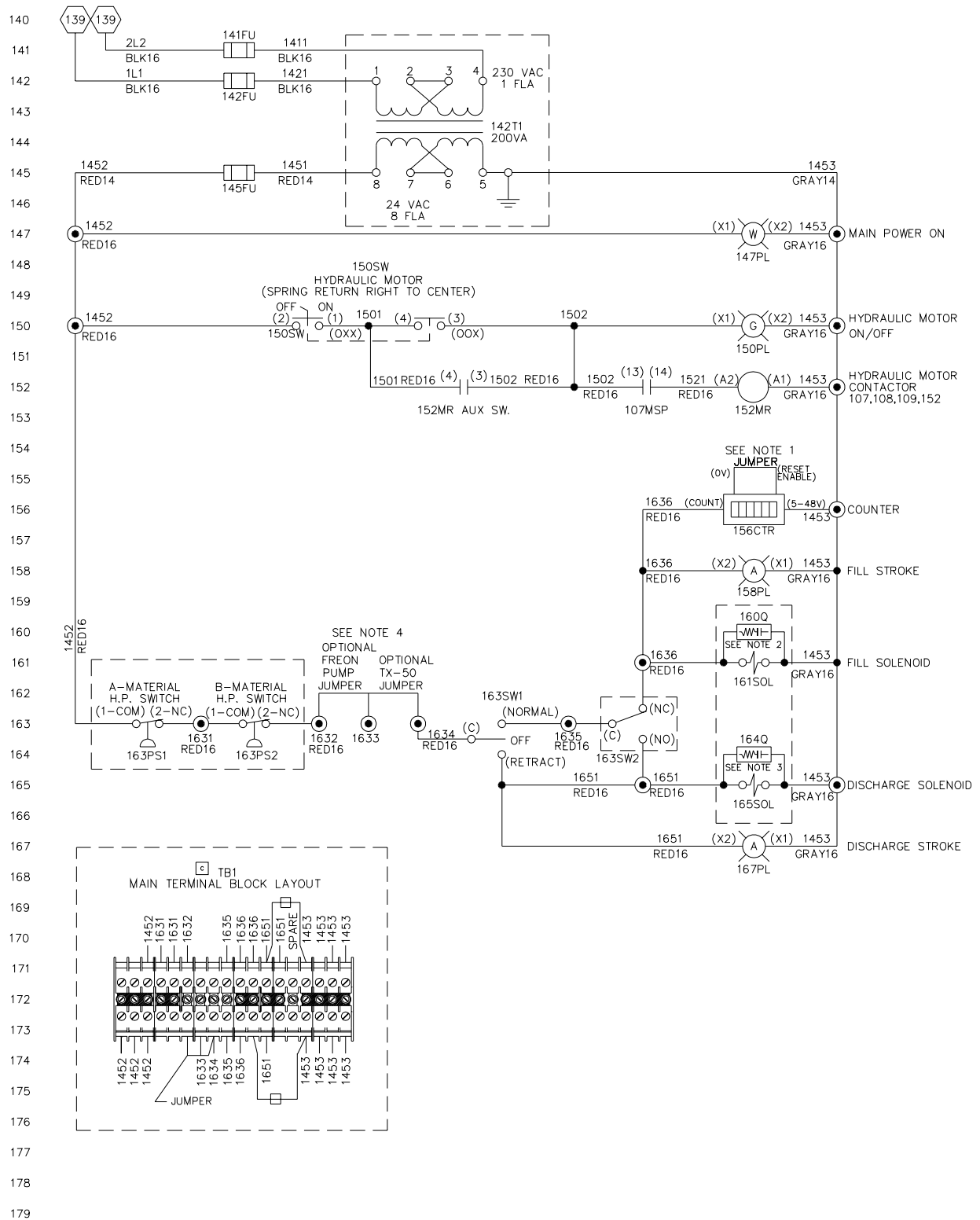


Figure 22. HF-1600 Digital Hose Heat Electrical Schematic, (Part No. SD18000-20), Sheet 2 of 2

Digital Hose Heat 3 x 230V

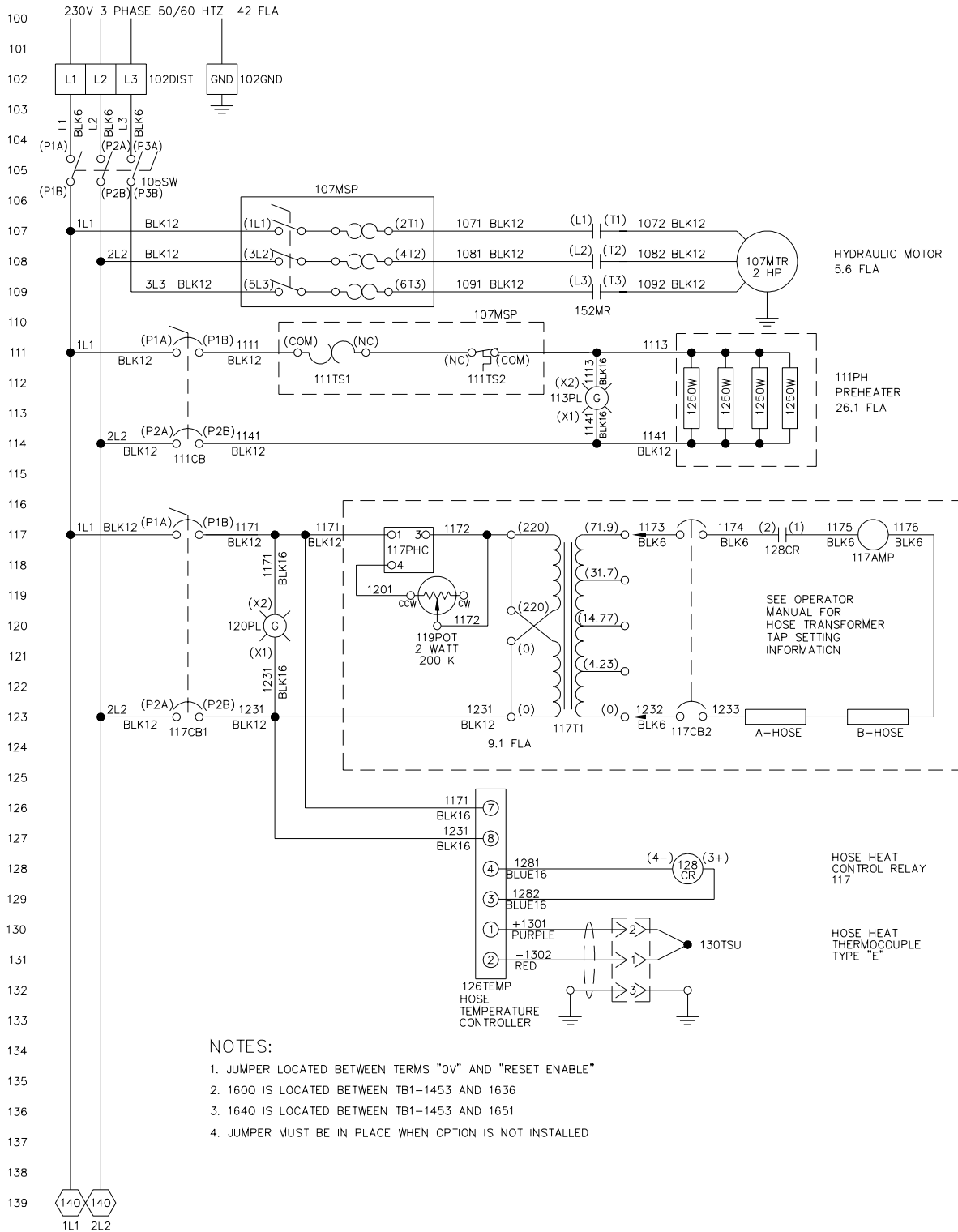


Figure 23. HF-1600 Digital Hose Heat Electrical Schematic, (Part No. SD18000-21), Sheet 1 of 2

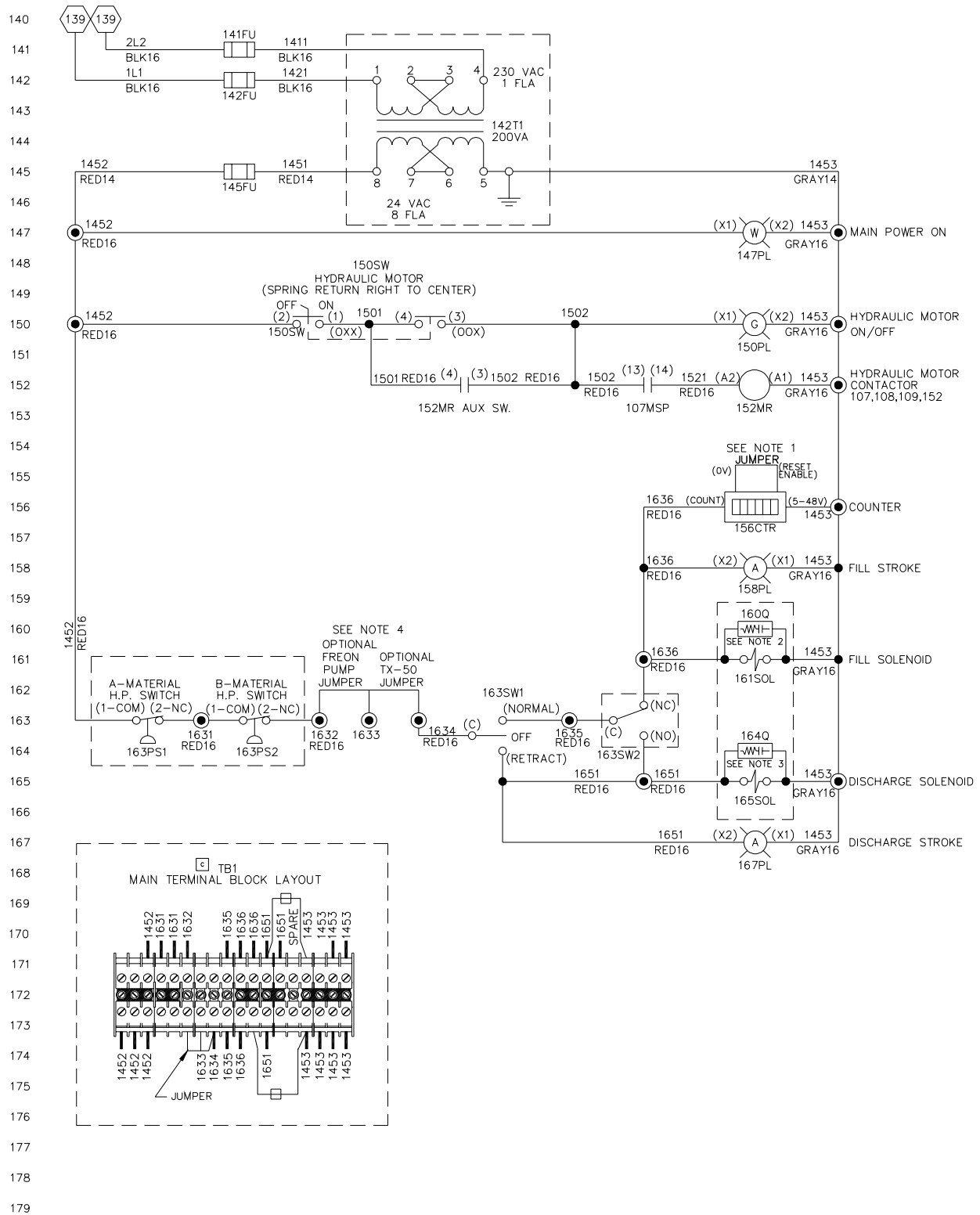


Figure 24. HF-1600 Digital Hose Heat Electrical Schematic, (Part No. SD18000-21), Sheet 2 of 2

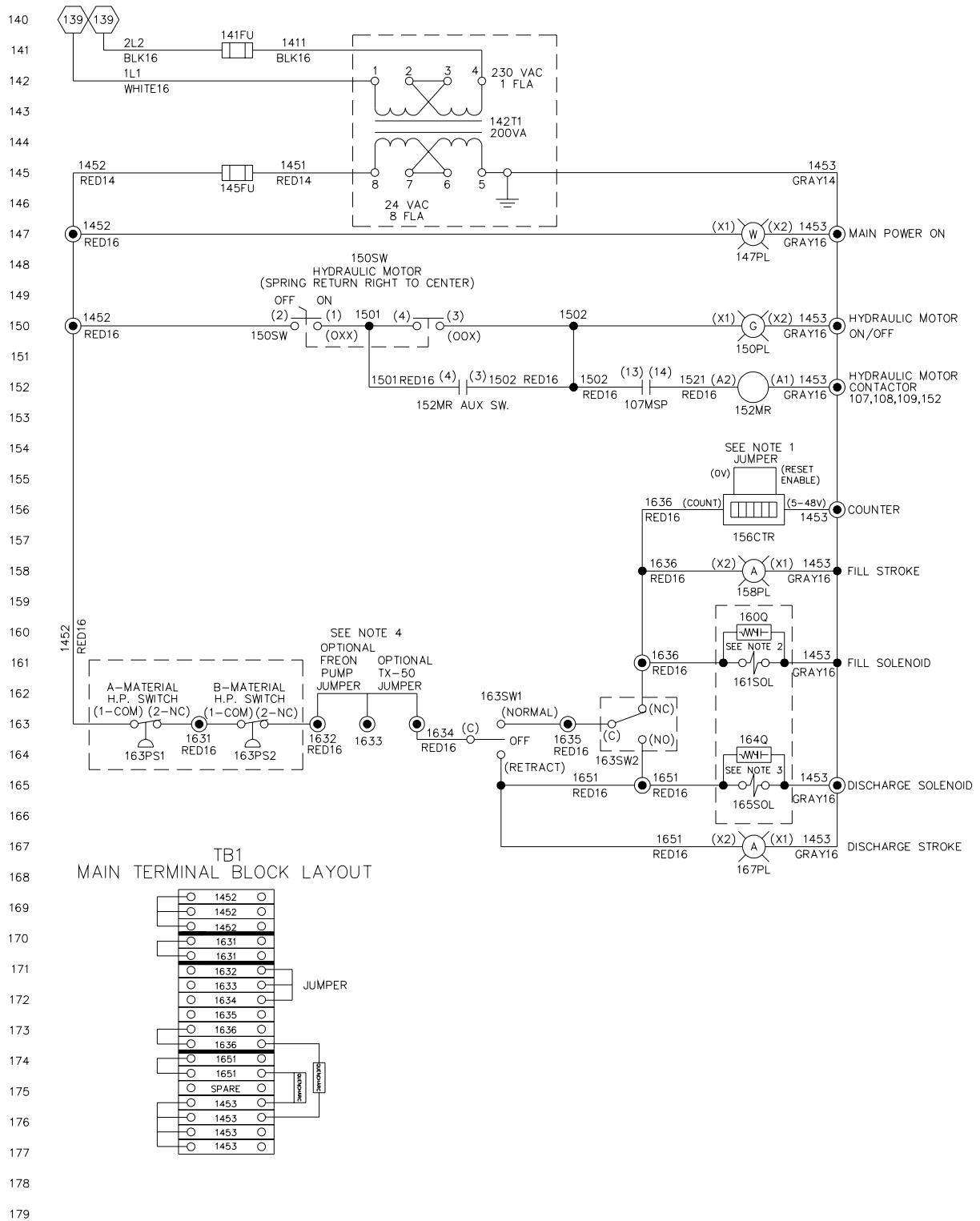


Figure 26. HF-2500 Digital Hose Heat Electrical Schematic, (Part No. SD23000-20), Sheet 2 of 2

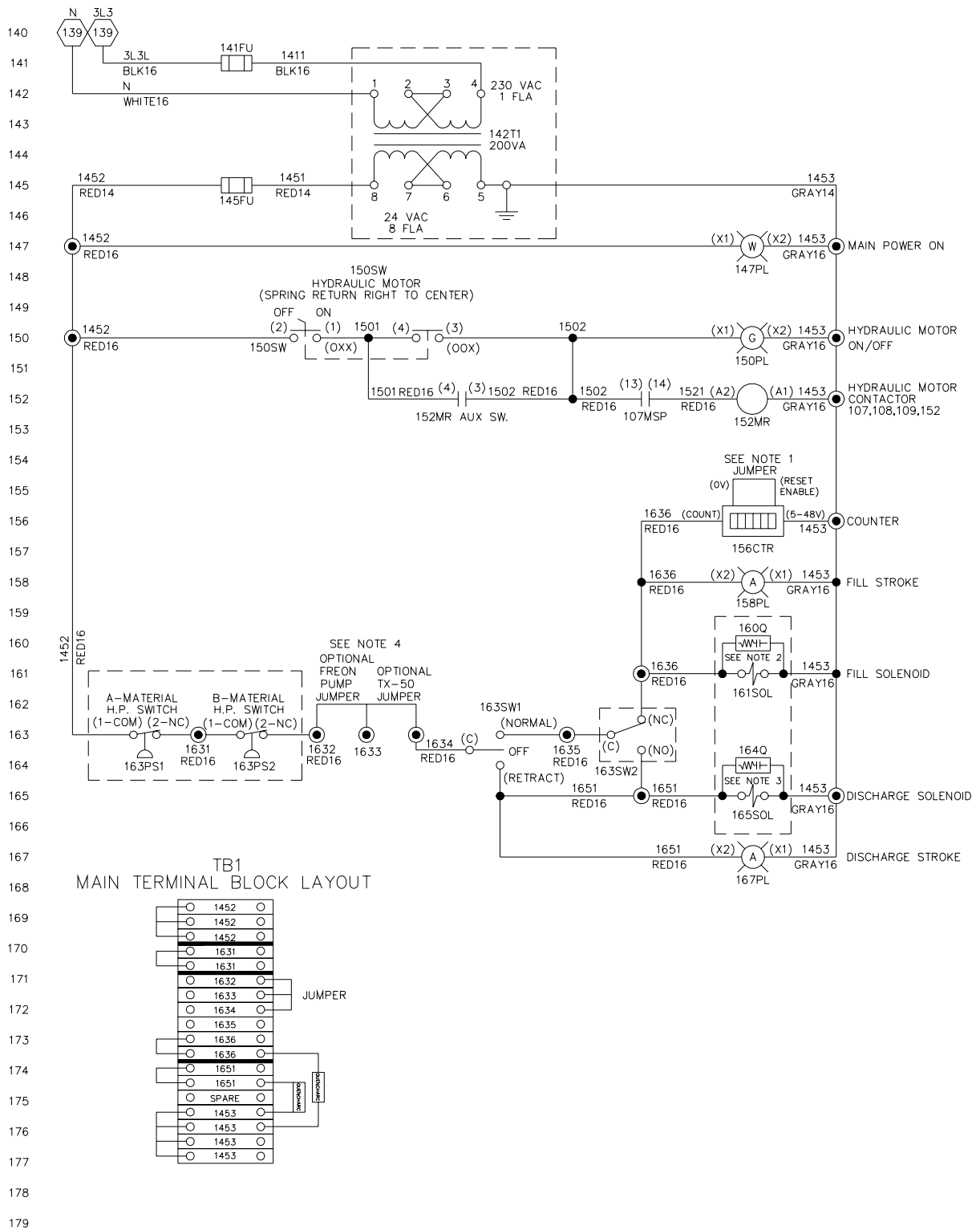


Figure 28. HF-2500 Digital Hose Heat Electrical Schematic, (Part No. SD23000-22), Sheet 2 of 2

TABLE 14. HF-1600 ELECTRICAL SCHEMATIC, (PART No. SD18000-SIZE), PARTS

Reference Letter	Part No.	Description	Quantity
102DIST	6690-20-28-33	Terminal Block	1
102GND	6690-20-28-7	Ground Block	1
105SW	6690-16-10	Switch	1
107MSP	6690-27-82	Motor Protect	1
107MTR	6691-2	2 HP Motor (3 x 230V)	1
	6691-32	2 HP Motor (1 x 230V)	1
	6691-29*	2 HP Motor (3 x 200V) (<i>Available in Asia only</i>)	1
111CB	0692-1-25	25 Amp Circuit Breaker	1
111TS1	0362C	Thermostat	1
111TS2	0385-1	Thermal Limit Switch	1
113PL	6690-19-15-25	240V Resistor Module	1
	6690-19-15-19	Pilot Light w/o Lens	1
	6690-19-15-11	Mounting Latch	1
	6690-19-15-20	130V Incandescent Bulb	1
	6690-19-15-12	Green lens	1
	111PH	0361-1250	Heating Element - 1250 Watt
117CB1	0692-1-25	25 Amp Circuit Breaker	1
117PHC	6690-26-18	Phase Control	1
117T1	15276	Transformer Assembly	1
117CB2	6690-25-62	Circuit Breaker	1
117AMP	5616	Ammeter	1
119POT	6690-5-17	Potentiometer	1
120PL	6690-19-15-25	240V Resistor Module	1
	6690-19-15-19	Pilot Light w/o Lens	1
	6690-19-15-11	Mounting Latch	1
	6690-19-15-20	130V Incandescent Bulb	1
	6690-19-15-12	Green lens	1
126TEMP	6690-26-17S-KIT	CAL 3200 (<i>Digital Hose Heat only</i>)	1
128CR	6690-1-46	Solid State Relay (<i>Digital Hose Heat only</i>)	1
130TSU		TSU (<i>Digital Hose Heat only</i>)	REF
	18650-3	TSU Wire Assembly (<i>Digital Hose Heat only</i>)	1
141FU	6690-24-112	Din Rail Fuse Holder	1
	6690-24-113	Din Rail Fuse Holder End Plate	1
	6690-24-116	Buss Mdl-2.5 Fuse	1
142FU	6690-24-112	Din Rail Fuse Holder	1
	6690-24-116	Buss Mdl-2.5 Fuse	1
142T1	15501-23	Transformer Plate Assembly	1
145FU	6690-24-112	Fuse Holder	1
	6690-24-113	Fuse Holder End Plate	1
	6690-24-3	8 Amp Fuse	1
	147PL	6690-19-15-17	Light Base
	6690-19-15-19	Pilot Light w/o Lens	1
	6690-19-15-11	Mounting Latch	1
	0662A	Incandescent Bulb	1
	6690-19-15-14	Clear Lens	1
150SW	6690-16-146	Selector Switch	1
	6690-19-15-11	Mounting Latch	1
	6690-16-59-1	Switch Block	1

Reference Letter	Part No.	Description	Quantity
	6690-16-60-1	Switch Block	1
150PL	6690-19-15-17	Light Base	1
	0662A	Clear Lens	1
152MR	6690-27-80	Contacto	1
156CTR	6690-29-27	Counter	1
158PL	6690-19-15-17	Light Base	1
	6690-19-15-19	Pilot Light w/o Lens	1
	6690-19-15-11	Mounting Latch	1
	0662A	Incandescent Bulb	1
	6690-19-15-15	Amber Lens	1
160Q	6690-21-1	Quencharc	1
161SOL	6311-116-24	24V Solenoid Coil	1
163PS1	6690-16-161	Pressure Switch	1
	6690-16-76-1	Din Connector	1
163PS2	6690-16-161	Pressure Switch	1
	6690-16-76-1	Din Connector	1
163SW1	6690-16-6	Toggle Switch	1
163SW2	0578A	Reversing Switch	1
164Q	6690-21-1	Quencharc	1
165SOL	6311-116-24	24V Solenoid Coil	1
167PL	6690-19-15-17	Light Base	1
	6690-19-15-19	Pilot Light w/o Lens	1
	6690-19-15-11	Mounting Latch	1
	0662A	Incandescent Bulb	1
	6690-19-15-15	Amber Lens	1

TABLE 15. HF-2500 ELECTRICAL SCHEMATIC, (PART No. SD23000-SIZE), PARTS

Reference Letter	Part No.	Description	Quantity
102DIST	6690-20-28-33	Terminal Block	1
102GND	6690-20-28-7	Ground Block	1
105SW	6690-16-10	Switch	1
107MSP	6690-27-82	Motor Protect	1
107MTR	6691-2	2 HP Motor (3 x 230V)	1
	6691-32	2 HP Motor (1 x 230V)	1
	6691-29*	2 HP Motor (3 x 200V) (<i>Available in Asia only</i>)	1
111CB	0693-1	30 Amp Circuit Breaker	1
111TS1	0362C	Thermostat	1
111TS2	0385-1	Thermal Limit Switch	1
113PL	6690-19-15-25	240V Resistor Module	1
	6690-19-15-19	Pilot Light w/o Lens	1
	6690-19-15-11	Mounting Latch	1
	6690-19-15-20	130V Incandescent Bulb	1
	6690-19-15-12	Green lens	1
	0361-1500-220	Heating Element - 1500 Watt	4
117CB1	0692-1-25	25 Amp Circuit Breaker	1
117PHC	6690-26-18	Phase Control	1
117T1	15276	Transformer Assembly	1
117CB2	6690-25-62	Circuit Breaker	1
117AMP	5616	Ammeter	1
119POT	6690-5-17	Potentiometer	1
120PL	6690-19-15-25	240V Resistor Module	1
	6690-19-15-19	Pilot Light w/o Lens	1
	6690-19-15-11	Mounting Latch	1
	6690-19-15-20	130V Incandescent Bulb	1
	6690-19-15-12	Green lens	1
126TEMP	6690-26-17S-KIT	CAL 3200	1
128CR	6690-1-46	Solid State Relay	1
130TSU		TSU	REF
	18650-3	TSU Wire Assembly	1
141FU	6690-24-112	Din Rail Fuse Holder	1
	6690-24-113	Din Rail Fuse Holder End Plate	1
	6690-24-116	Buss Mdl-2.5 Fuse	1
142FU	6690-24-112	Din Rail Fuse Holder	1
	6690-24-116	Buss Mdl-2.5 Fuse	1
142T1	15501-23	Transformer Plate Assembly	1
145FU	6690-24-112	Fuse Holder	1
	6690-24-113	Fuse Holder End Plate	1
	6690-24-3	8 Amp Fuse	1
	6690-19-15-17	Light Base	1
147PL	6690-19-15-19	Pilot Light w/o Lens	1
	6690-19-15-11	Mounting Latch	1
	0662A	Incandescent Bulb	1
	6690-19-15-14	Clear Lens	1
	6690-16-146	Selector Switch	1
	6690-19-15-11	Mounting Latch	1

Reference Letter	Part No.	Description	Quantity
	6690-16-59-1	Switch Block	1
	6690-16-60-1	Switch Block	1
150PL	6690-19-15-17	Light Base	1
	0662A	Clear Lens	1
152MR	6690-27-80	Contacto	1
156CTR	6690-29-27	Counter	1
158PL	6690-19-15-17	Light Base	1
	6690-19-15-19	Pilot Light w/o Lens	1
	6690-19-15-11	Mounting Latch	1
	0662A	Incandescent Bulb	1
	6690-19-15-15	Amber Lens	1
160Q	6690-21-1	Quencharc	1
161SOL	6311-116-24	24V Solenoid Coil	1
163PS1	6690-16-161	Pressure Switch	1
	6690-16-76-1	Din Connector	1
163PS2	6690-16-161	Pressure Switch	1
	6690-16-76-1	Din Connector	1
163SW1	6690-16-6	Toggle Switch	1
163SW2	0578A	Reversing Switch	1
164Q	6690-21-1	Quencharc	1
165SOL	6311-116-24	24V Solenoid Coil	1
167PL	6690-19-15-17	Light Base	1
	6690-19-15-19	Pilot Light w/o Lens	1
	6690-19-15-11	Mounting Latch	1
	0662A	Incandescent Bulb	1
	6690-19-15-15	Amber Lens	1

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1	Date	Enter date report is submitted.
2	Name	Enter name of person making report.
3	IM Number	Enter the Part Number of the Instruction Manual from the title page.
4	Issue Number	Enter the Issue number of the Instruction Manual from the title page. If there is no issue number, enter NONE .
5	Date of Issue	Enter the date of Issue of the Instruction Manual from the title page. If there is no issue date, enter NONE .
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