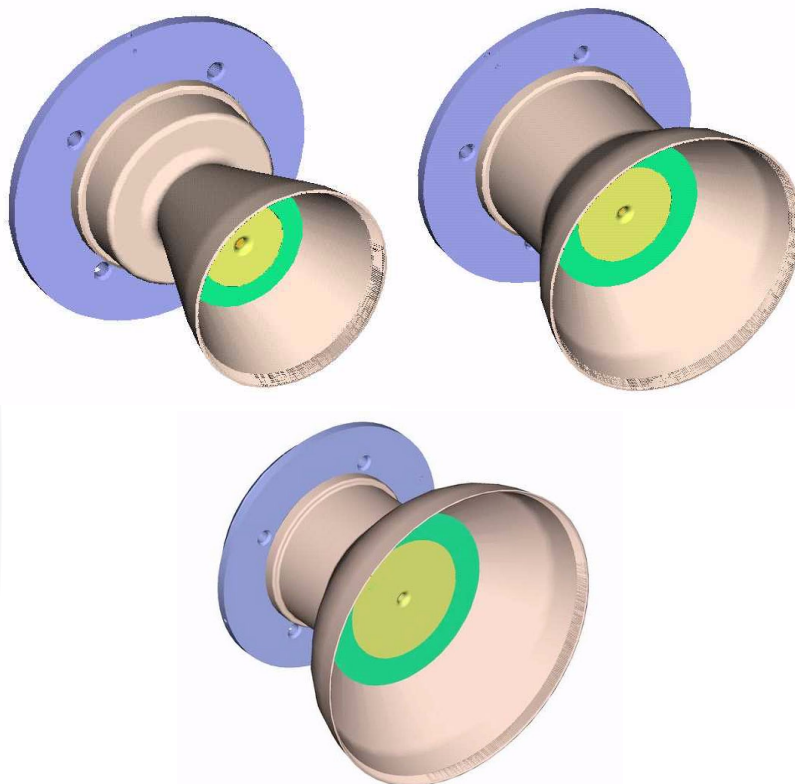


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 **Sames**



User manual

EC 35, 50 and 65 threaded Bellcups + Shaping air Assemblies for PAM-turbine

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EC 35, 50 and 65 threaded Bellcups

+

Shaping air Assemblies for PAM-turbine

1. Recommendations - - - - -	5
2. Description - - - - -	5
3. Characteristics - - - - -	6
4. Tools - - - - -	7
4.1. <i>Used with atomizers, direct charge</i>	7
4.2. <i>Used with PPH 605 atomizer, external charge</i>	9
5. Maintenance- - - - -	11
5.1. <i>EC 35, 50and 65 multiblock shaping air assemblies (outer cover - shaping air shroud)</i>	11
5.1.1. <i>Disassembling</i>	11
5.1.2. <i>Assembling</i>	12
5.2. <i>EC 35, 50 and 65 monoblock shaping air assemblies</i>	14
5.2.1. <i>Disassembling</i>	14
5.2.2. <i>Assembling</i>	14
5.3. <i>EC 65 shaping air assembly on PPH 605 and Aquabell direct charge</i>	15
5.3.1. <i>Disassembling</i>	15
5.3.2. <i>Assembling</i>	16
5.4. <i>EC 35 and 50 threaded bellcup and clip assemblies</i>	17
5.4.1. <i>Disassembling</i>	17
5.4.2. <i>Assembling</i>	18
5.5. <i>Bellcup and clip assembly on PPH 607, Accubell 607, PPH 308, PPH 605 and Aquabell direct charge.</i>	19
5.5.1. <i>Disassembling</i>	19
5.5.2. <i>Assembling</i>	21
5.6. <i>65 EC bellcup and clip assembly on PPH 605 external charge.</i> 23	
5.6.1. <i>Disassembling</i>	23
5.6.2. <i>Assembling</i>	24
5.7. <i>Bellcup distributor</i>	25
5.7.1. <i>Disassembly.</i>	25
5.7.2. <i>Reassembly</i>	26
6. Spare parts- - - - -	27
6.1. <i>EC 35 aluminium threaded bellcup and clip</i>	27
6.2. <i>EC 50 aluminium threaded bellcup and clip</i>	28
6.3. <i>EC 65 aluminium threaded Bellcup</i>	29
6.4. <i>Used with EC 35 Bellcup</i>	30
6.4.1. <i>Shaping air assembly - P/N: 1520632</i>	30
6.4.2. <i>Monoblock shaping air assembly for EC 35 bellcup - P/N: 1526951</i>	31

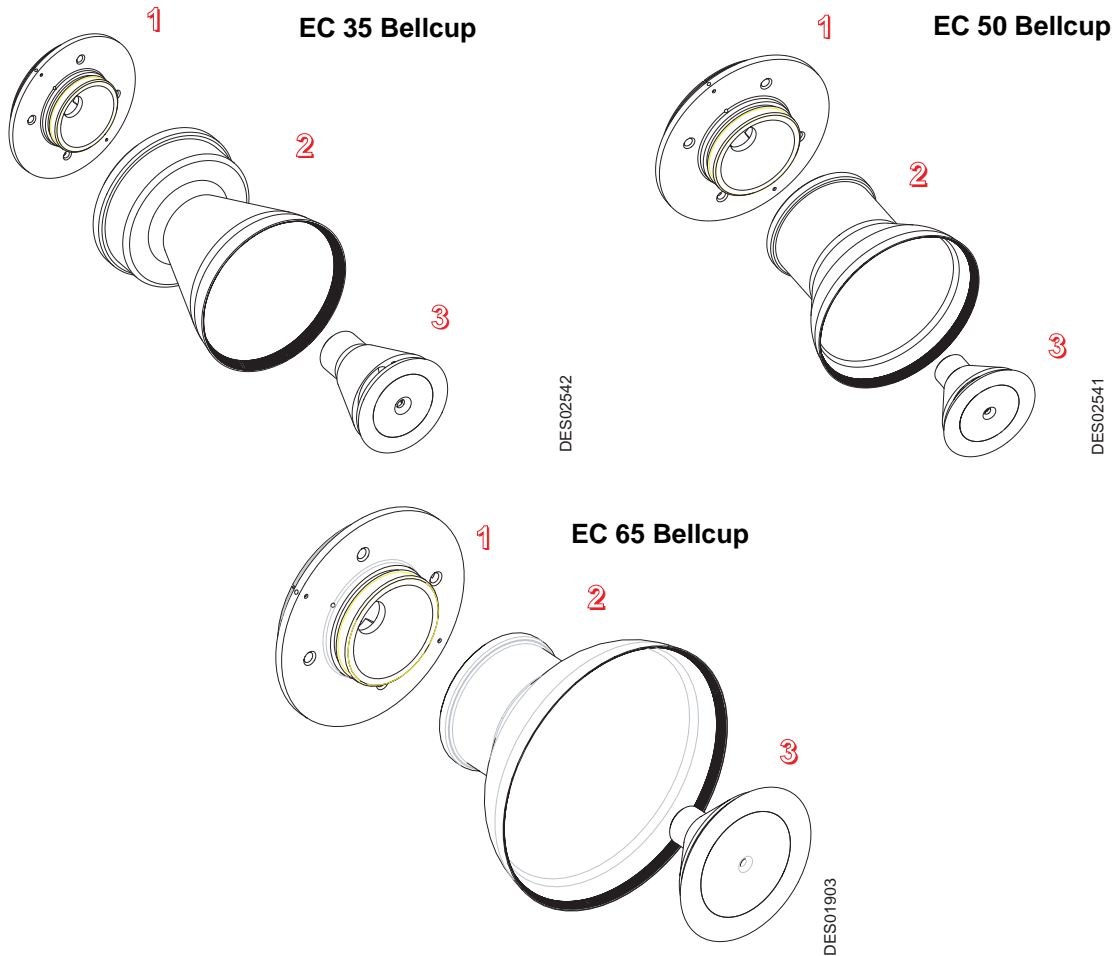
6.5. Used with EC 50 Bellcup	32
6.5.1. Shaping air assembly - P/N: 1520369	32
6.5.2. Monoblock shaping air assembly for EC 50 bellcup - Ref.: 1526952	33
6.6. Used with EC 65 Bellcup	34
6.6.1. Shaping air assembly for PPH 607, Accubell 607 and PPH 308, direct charge.	34
6.6.2. Shaping air assembly for PPH 607, Accubell 607 and PPH 308, direct charge	35
6.6.3. Shaping air assembly for PPH 607, Accubell 607 and PPH 308, direct charge	36
6.6.4. Monoblock shaping air assembly for PPH 607, Accubell 607 and PPH 308 direct charge	37
6.6.5. Shaping air assembly for PPH 605 direct charge	38
6.6.6. Shaping air assembly for Aquabell direct charge.	39
6.6.7. With EC 65 bellcup for PPH 605 external charge	41
6.6.8. With EC 65 bellcup for PPH 308 external charge	41

1. Recommendations

For perfect results, the atomizing bellcup must be cleaned frequently. It is recommended to clean the bellcup external every 8 hours and completely every 120 hours. The bellcup must not be subjected to impacts on its atomizing edge or distorted.

2. Description

The bellcup is a component which allows the atomizing of liquid materials specially high solid primers, basecoats and clearcoats. It is fixed to the turbine rotor with a clip (threaded bellcup side and clipped turbine side). The EC threaded bellcups can be installed on different atomizers (PPH 607, Accubell 607, PPH 308) with the appropriated shaping air assembly.



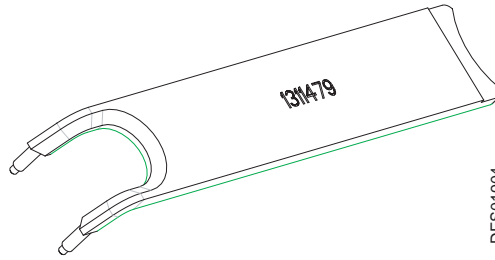
1	Clip
2	Bellcup
3	Distributor

3. Characteristics

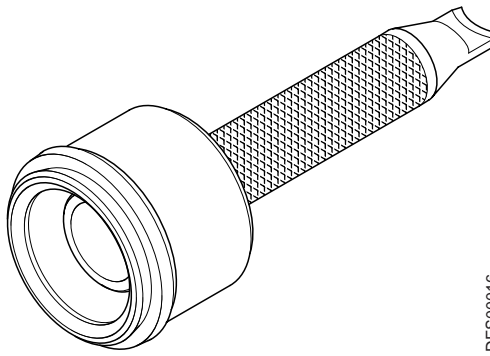
	Diameter	Length	Weight	Weight (with aluminium deflector)
EC 35 aluminium threaded bellcup (without clip)	35 mm	42 mm	16,5 g	21 g
EC 50 aluminium threaded bellcup (without clip)	50 mm	42 mm	23 g	28g
EC 65 aluminium threaded bellcup (without clip)	65 mm	41,7 mm	30,5 g	42,3 g

4. Tools

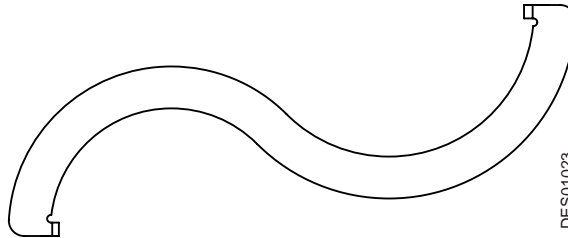
4.1. Used with atomizers, direct charge



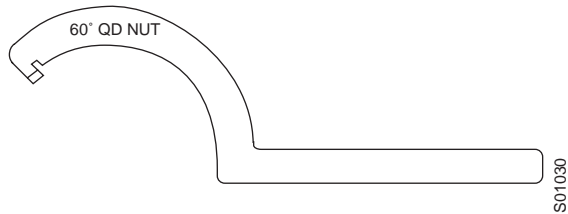
Part Number	Description	Qty	Sale unit
1311479	Tool, EC 50 and 35 bellcup and clip removal	1	1



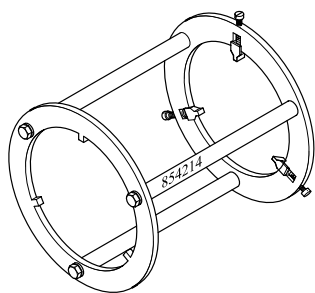
Part Number	Description	Qty	Sale unit
1517728	Tool, EC 65 bellcup and clip removal	1	1



Part Number	Description	Qty	Sale unit
1308689	Assembly /disassembly wrench for outer cover	1	1

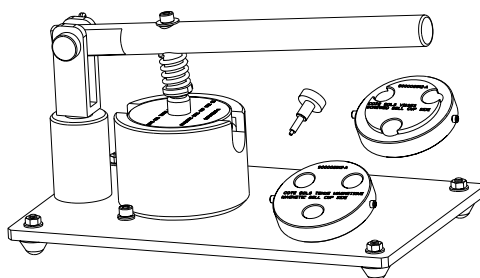


Part Number	Description	Qty	Sale unit
1308678	Assembly /disassembly wrench for outer cover (Aqua-bell)	1	1



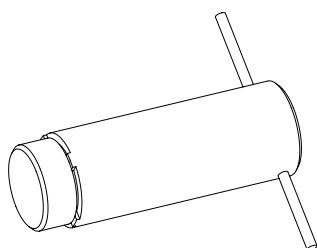
DES00015

Part Number	Description	Qty	Sale unit
854214	Assembly/ Disassembly tool for outer cover (PPH 605)	1	1



DES04373

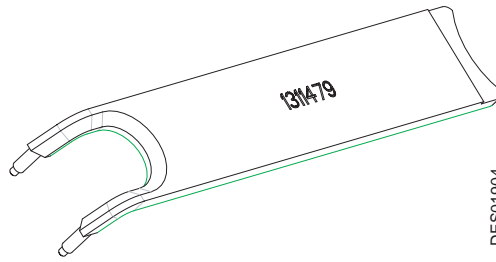
Part Number	Description	Qty	Sale unit
910003737	Assembly/ Disassembly Tool for bell cup distributor	1	1



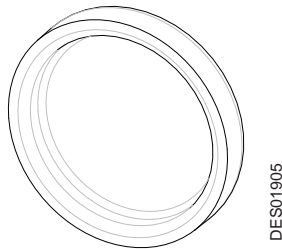
DES02566

Part Number	Description	Qty	Sale unit
1410032	Assembly/ Disassembly tool for EC 35 shaping air nut	1	1
1409735	Assembly/ Disassembly tool for EC 50 shaping air nut	1	1
1408335	Assembly/ Disassembly tool for EC 65 shaping air nut	1	1

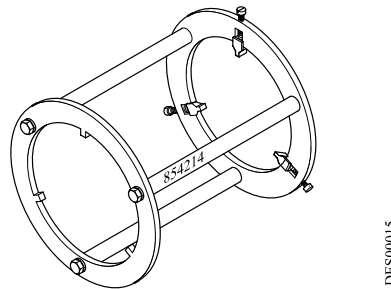
4.2. Used with PPH 605 atomizer, external charge



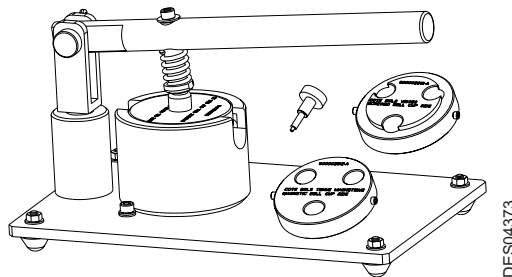
Part Number	Description	Qty	Sale unit
1311479	Tool, EC 50 and 35 bellcup and clip removal	1	1



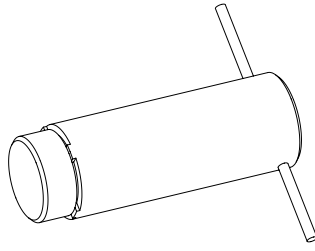
Part Number	Description	Qty	Sale unit
1409133	Protective cover for EC 65 bellcup	1	1



Part Number	Description	Qty	Sale unit
854214	Assembly/ Disassembly tool for outer cover (PPH 605)	1	1



Part Number	Description	Qty	Sale unit
910003737	Assembly/ Disassembly Tool for bell cup distributor	1	1



DES02556

Part Number	Description	Qty	Sale unit
1408335	Assembly/ Disassembly tool for EC 65 shaping air nut	1	1

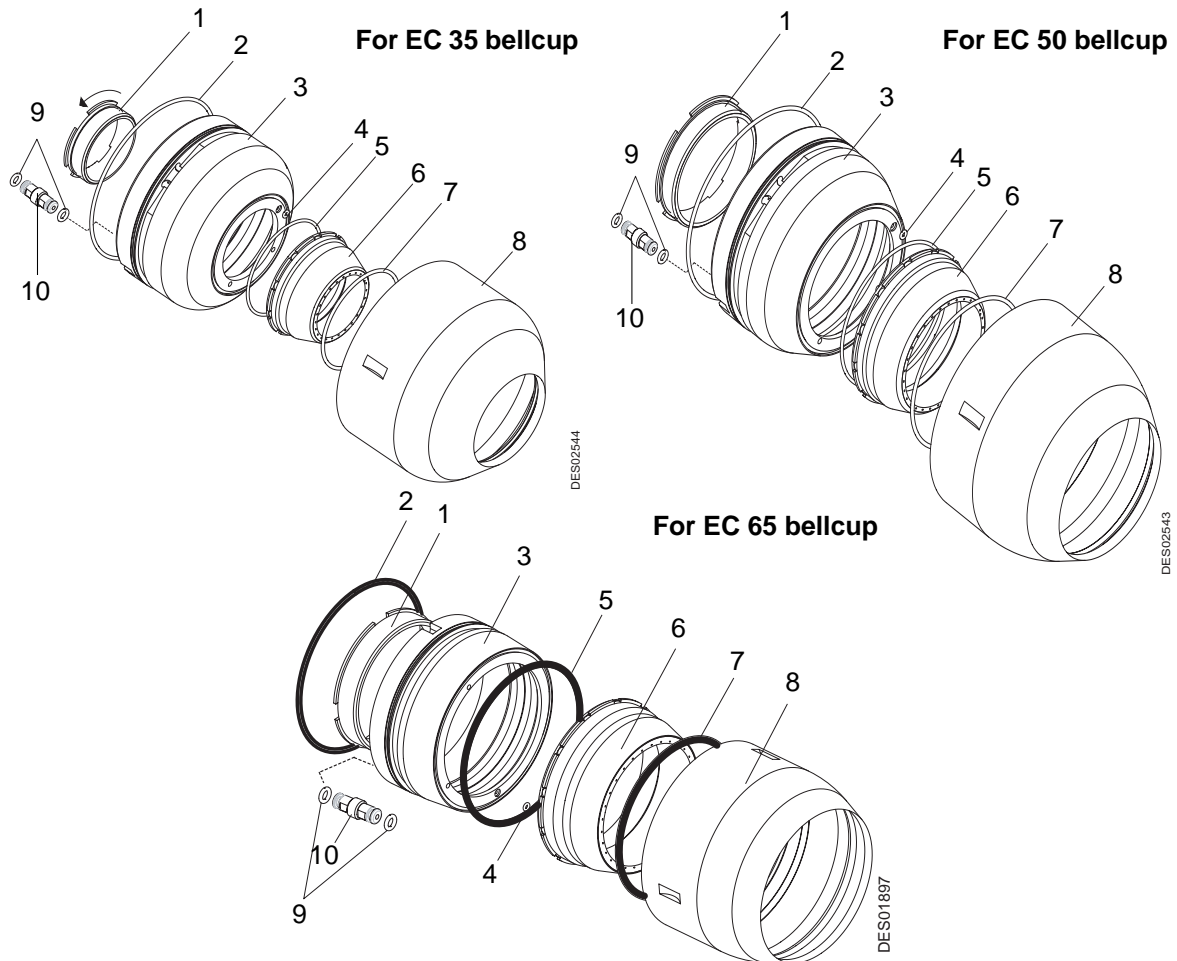
5. Maintenance

5.1. EC 35, 50 and 65 multiblock shaping air assemblies (outer cover - shaping air shroud)

5.1.1. Disassembling

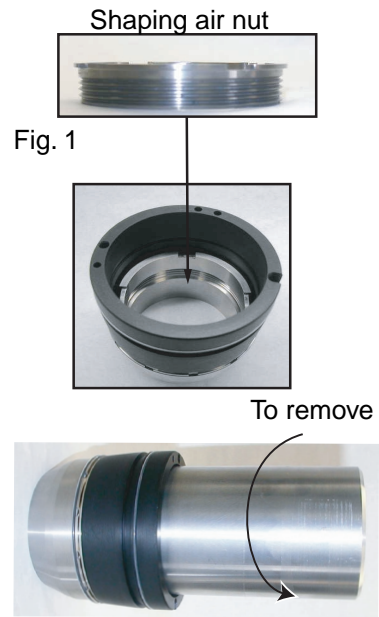
- **Step 1:** Make sure that the high voltage is OFF.
- **Step 2:** Remove the outer cover (item. 8) using the tool P/N # 1308689 by placing the wrench notches into the aluminium cover slots, turn clockwise and continue removing by hand.

Note: After one turn, push backward the insert (item 6) with your thumbs. That will ease the outer cover (item 8) rotation.



Item	Description	Qty
1	Shaping air nut	1
2	O-ring	1
3	Vortex Shaping air shroud	1
4	O-ring - chemically inert	1
5	O-ring	1
6	Vortex Shaping air insert - 45°	1
7	O-ring	1
8	Vortex outer cover	1
9	O-ring	2
10	Solvent pipette, stainless steel	1

- **Step 3:** The shaping air shroud and shaping air insert are fastened together (see fig.1) with the shaping air nut. Remove using the appropriate tool ([see § 4 page 7](#)) as illustrated.
- **Step 4:** Remove the three o-rings (Item 2, 4 et 5) from the shaping air shroud (Item 3).

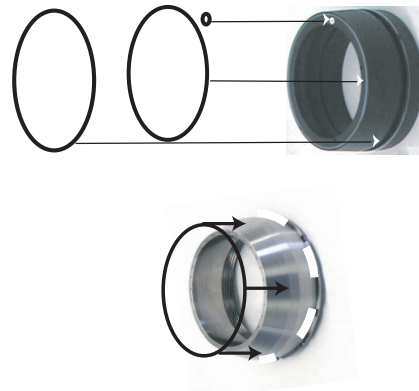


5.1.2. Assembling

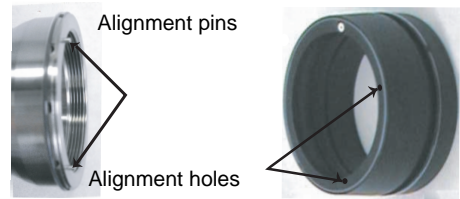


WARNING : Clean all components and inspect for damage, replace if necessary [see § 6 page 27](#).

- **Step 1:** Place the three o-rings (Item 2, 4 and 5) onto the shaping air shroud (Item 3).
- **Step 2:** Slide o-ring (Item 7) over the aluminium cover. Insert until it sits on stainless steel shoulder.



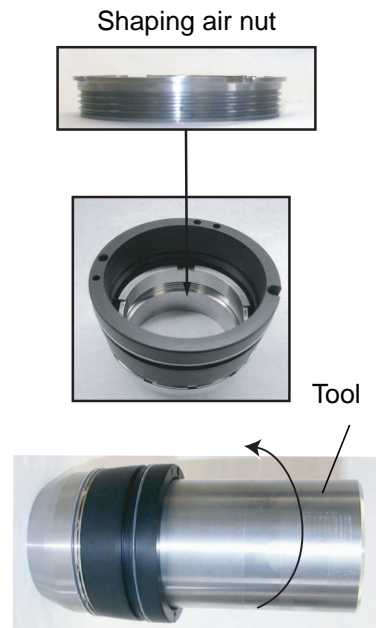
- **Step 3:** Align the shaping air insert (Item 6) to the shaping air shroud, be careful not to damage the o-rings.



- **Step 4:** Secure the shaping air insert to the shaping air shroud by placing the shaping air shroud as illustrated and tighten lightly the nut with fingers.



- **Step 5:** Secure in place with the appropriate tool (see § 4 page 7).



- **Step 6:** Place the outer cover (Item. 8) over the assembly, secure it by hand then tighten it with the tool P/N: 1308689.

5.2. EC 35, 50 and 65 monoblock shaping air assemblies

5.2.1. Disassembling

- **Step 1:** Make sure that the high voltage is OFF.
- **Step 2:** Remove the aluminium cover using the tool P/N # 1308689, by placing the wrench notches into the aluminium cover slots, turn clockwise and continue removing by hand. Remove the shaping air shroud from the atomizer.

5.2.2. Assembling



WARNING : Clean all components and inspect for damage, replace if necessary [see § 6 page 27](#).

- **Step 1:** Put in place the shaping air shroud on the atomizer.
- **Step 2:** Install the o-ring in the outer cover.
- **Step 3:** Place the outer cover on the atomizer, secure it by hand then tighten it with the tool P/N: 1308689.

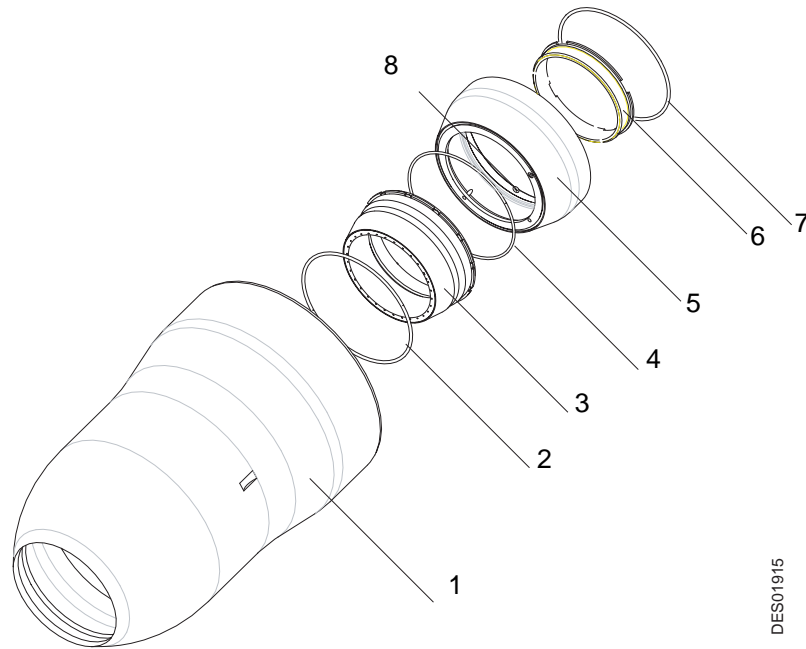
5.3. EC 65 shaping air assembly on PPH 605 and Aquabell direct charge

5.3.1. Disassembling

The disassembling procedure is the same as PPH 607, Accubell 607 and PPH 308, except use tool # 854214 for plastic cover removal for PPH 605 direct charge and tool # 1308678 for Aquabell.

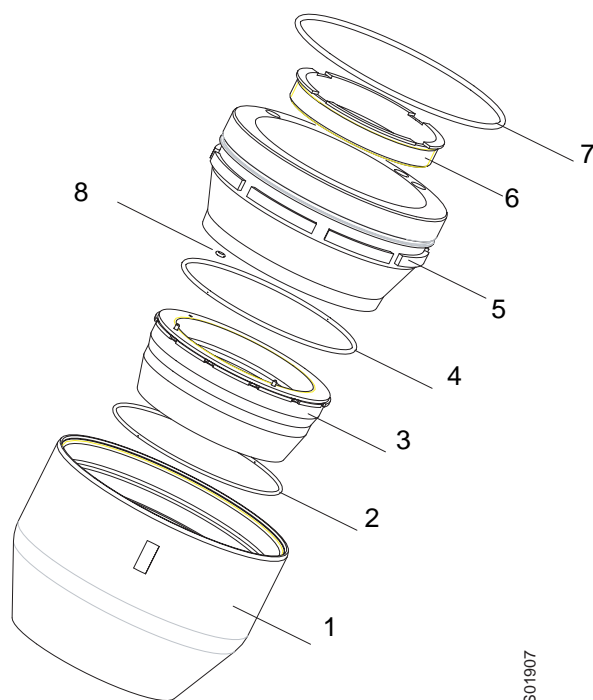
[see § 5.1.1 page 11](#)

PPH 605



Item	Description	Qty
	EC 65 shaping air assembly of PPH 605	1
1	Plastic cover	1
2	O-ring	1
3	Shaping air insert OD: 65 mm	1
4	O-ring	1
5	Shaping air shroud	1
6	Shaping air nut OD: 65 mm	1
7	O-ring	1
8	O-ring - chemically inert	1

Aquabell



DES01907

Item	Description	Qty
	EC 65 shaping air assembly	1
1	Aluminium cover	1
2	O-ring	1
3	Shaping air insert OD: 65 mm	1
4	O-ring	1
5	Shaping air shroud	1
6	Shaping air nut OD: 65 mm	1
7	O-ring	1
8	O-ring - chemically inert	1

5.3.2. Assembling

[see § 5.1.2 page 12](#)

5.4. EC 35 and 50 threaded bellcup and clip assemblies

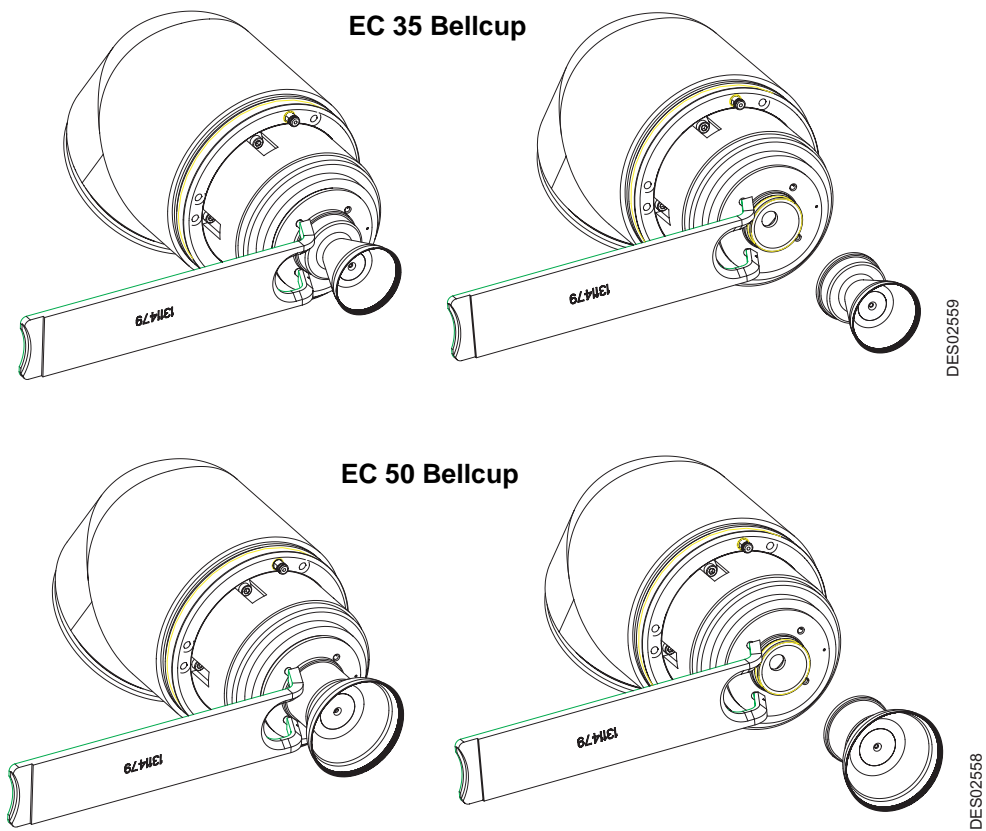
5.4.1. Disassembling

Note : The EC 50 and 35 bellcup disassembling with shaping air shroud removed.



WARNING : Before any operation on the different bellcup assemblies, it is recommended to wear rubber gloves to protect your hands from the sharp edges of the bellcup. Bellcup should have neither shock or deformation on the atomizing edge.

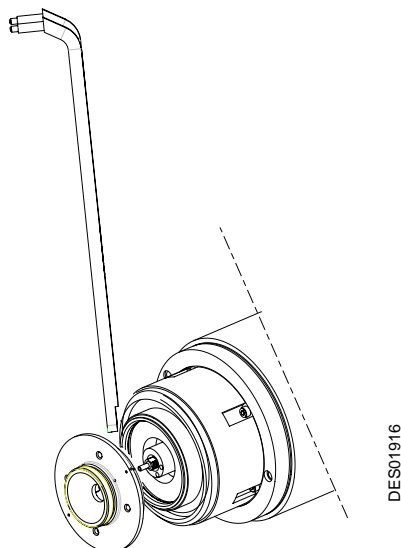
- **Step 1:** Position the wrench notches P/N: 1311479 into two clip holes as illustrated.
- **Step 2:** Keep bellcup and loosen it.



WARNING : The clip stays in place.

Clip disassembling

- **Step 1:** Insert the other end of the tool P/N: 1311479 between the clip and the turbine.
- **Step 2:** Use the turbine as a bearing point. Release the clip from the turbine by turning the tool at right angle, taking care to hold the clip with the other hand.



5.4.2. Assembling



WARNING : Check the clip for damage, replace if necessary. The clip functional areas must be clean, without trace of paint.

Clip reinstallation:

- **Step 1:** Place new or clean clip on the rotor, carefully centred.
- **Step 2:** Press strongly with fingers. A slight click should be heard.

Outer cover reinstallation, [see § 5.1.2 page 12](#) .

Bellcup reinstallation: [see § 5.5.2 page 21](#)

5.5. Bellcup and clip assembly on PPH 607, Accubell 607, PPH 308, PPH 605 and Aquabell direct charge.

5.5.1. Disassembling



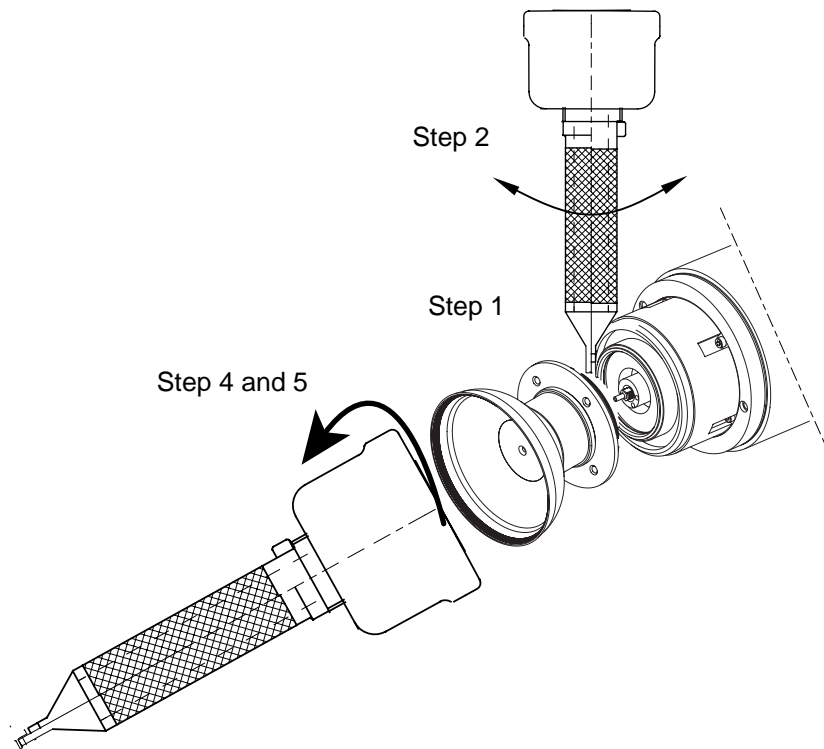
WARNING : Before starting any operation, bearing air and high voltage supply must be turned OFF .



WARNING : Wear rubber gloves to protect your hands from the sharp edges of the bellcup.

Bellcup clip assembly disassembling with tool P/N # 1517728, shaping air assembly removed .

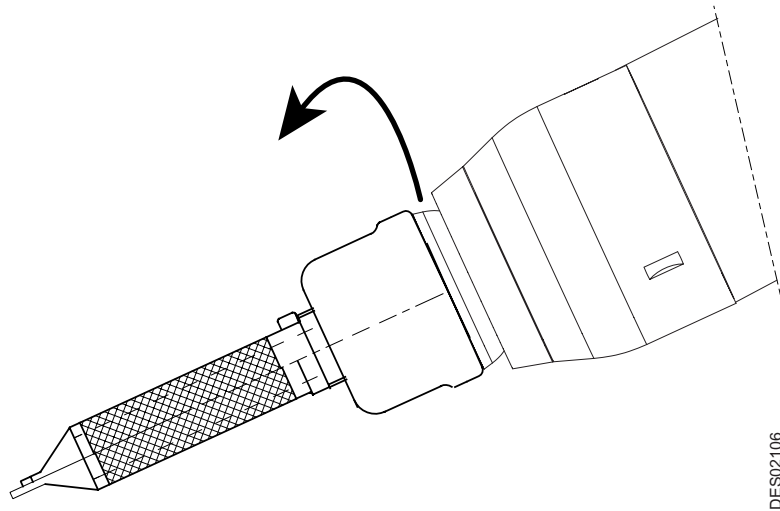
- **Step 1:** Place the tool between turbine and clip, the shoulder must be placed on the turbine side.
- **Step 2:** Turn the tool using its shoulder as a bearing point.
- **Step 3:** Free the clip from the turbine by turning the tool at right angle, taking special care to hold the clip with the other hand.
- **Step 4:** Place the opened clamp around the bellcup and clip assembly. Turn handle clockwise. Tighten the clamp around it.
- **Step 5:** Turn counterclock-wise to separate the bellcup from the clip.



DES01894

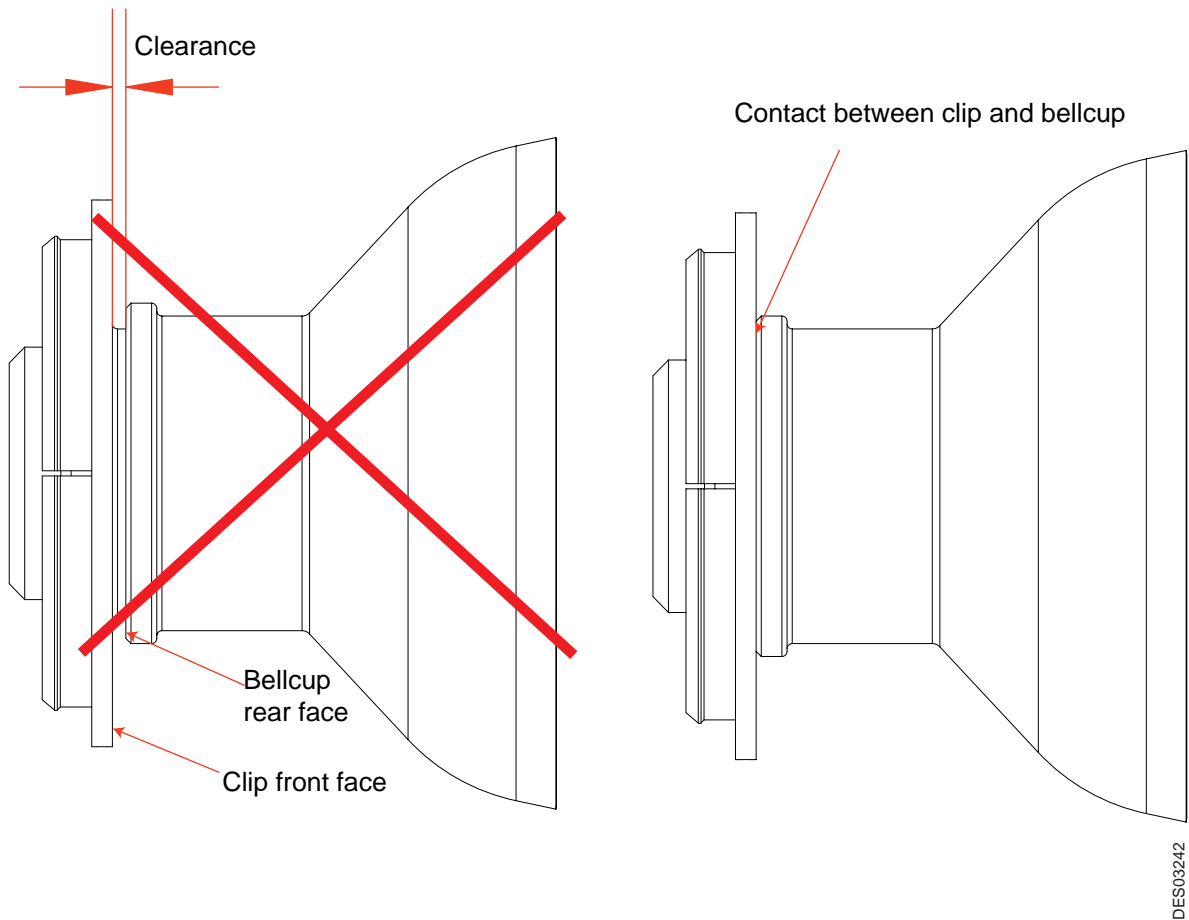
Bellcup disassembling, shaping air assembly installed.

- **Step 1:** Place the opened clamp close on the bellcup and rotate to lock the bellcup in the clamps.
- **Step 2:** Tighten the bellcup from the clip.



5.5.2. Assembling

5.5.2.1. Assembling the bellcup on the clip



WARNING : Screw and tight the bellcup until the rear face stops against the front face of the clip. If there is no contact, it creates an unbalanced situation and the bellcup might fly off and damage the atomizer (turbine, shaping air assembly...).



WARNING : Never use the equipment if there is no contact between the bellcup rear face and the clip front face.

5.5.2.2. Assembling the bellcup / clip assembly



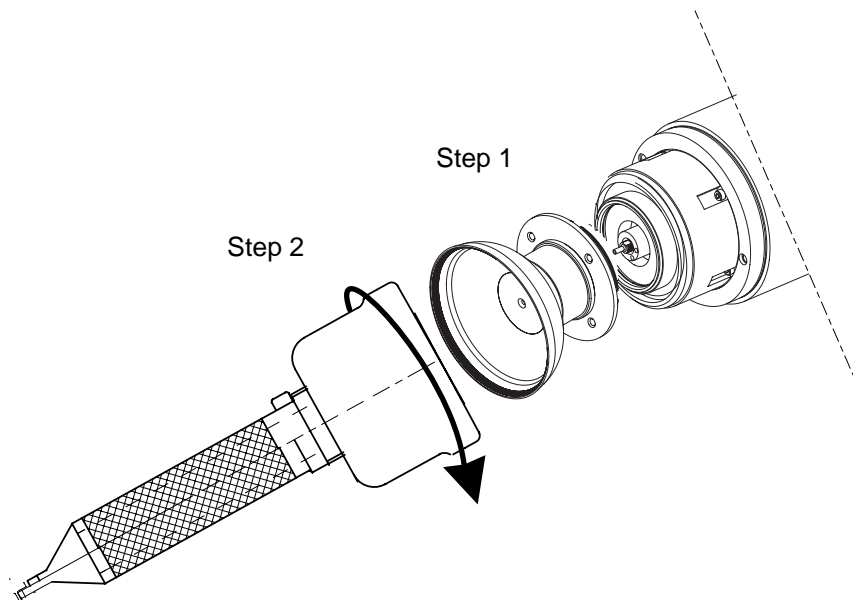
WARNING : Before reinstallation, clean off all traces of paint from the bellcup and its surfaces.

Remarks : Assembling is the same shaping air assembly removed or installed.



WARNING : To avoid injury, it is recommended to wear rubber gloves to install the bellcup and clip.

- **Step 1:** Secure the clip to the bellcup by turning the tool clockwise by hand.
- **Step 2:** Place the opened clamp close the grip around and tighten the bellcup onto the clip. Remove the tool.
- **Step 3:** Press the bellcup and clip assembly to the turbine motor making sure it is well secured.



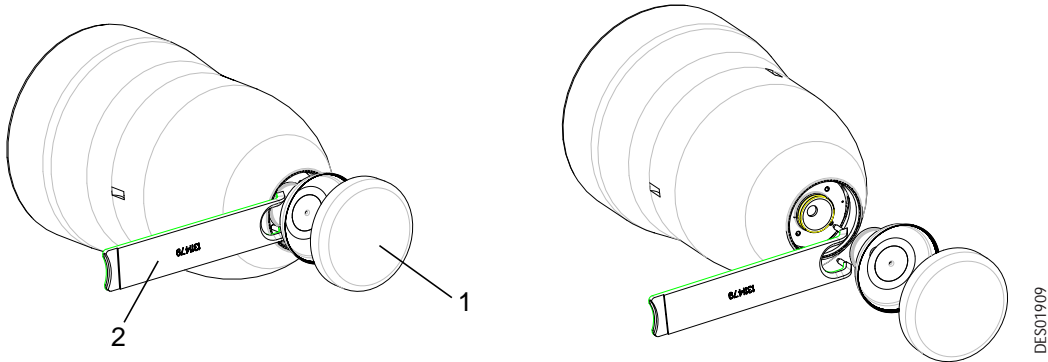
DES01893

5.6. 65 EC bellcup and clip assembly on PPH 605 external charge.

5.6.1. Disassembling

Note : The 65 EC bellcup disassembling with plastic cover in place.

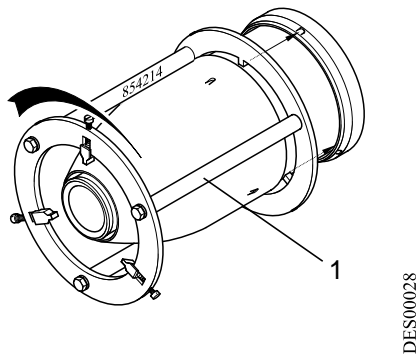
- **Step 1:** Install the protective cover P/N # 1409133 (Item 1) on the bellcup.
- **Step 2:** Position the wrench notches P/N # 1311479 (Item 2) into two clip holes.
- **Step 3:** Keep bellcup and loosen it.



WARNING : The clip stays in place. To remove it, the plastic cover must be previously removed.

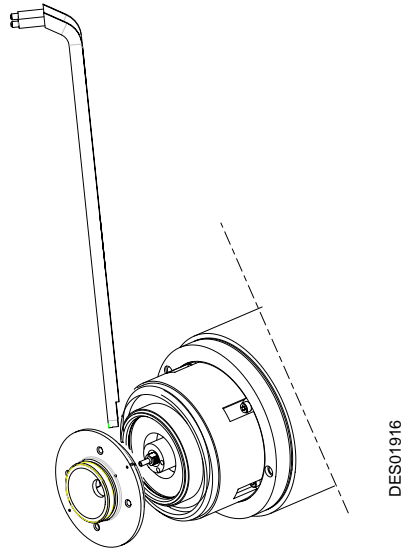
Plastic cover disassembling

- **Step 1:** Install the white plastic cover disassembling tool P/N # 854214 (item 1) on the atomizer.
- **Step 2:** Release the white plastic cover.
- **Step 3:** Loosen handly and remove the plastic cover.



Clip disassembling

- **Step 1:** Insert the other end of the tool P/N # 1311479 between the clip and the turbine.
- **Step 2:** Use the turbine as a bearing point. Release the clip from the turbine by turning the tool at right angle, taking care to hold the clip with the other hand.



5.6.2. Assembling

Clip reinstallation:

- **Step 1:** Place new or clean clip on the rotor, carefully centred.
- **Step 2:** Press strongly with fingers. A slight click should be heard.

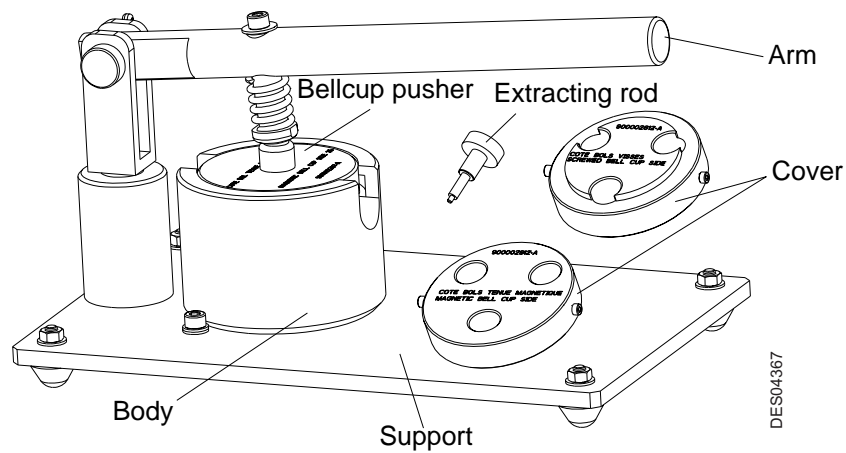
Aluminium cover reinstallation:

- **Step 1:** Install the plastic cover on the PPH 605.
- **Step 2:** Screw it on by hand.
- **Step 3:** Lock it using the appropriate tool.

Bellcup reinstallation:

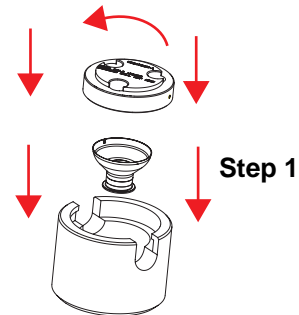
- **Step 1:** Place the protective cover on the bellcup.
- **Step 2:** Place the bellcup on the clip and tighten it.

5.7. Bellcup distributor



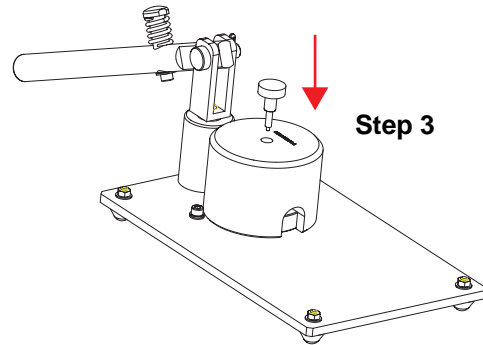
5.7.1. Disassembly

- **Step 1:** Put in place the bellcup in the body. Choose the cover according to the type of the bellcup (screwed or with magnetic fixing). **Remark:** the position of the cover is given by the marking which must be side bellcup.

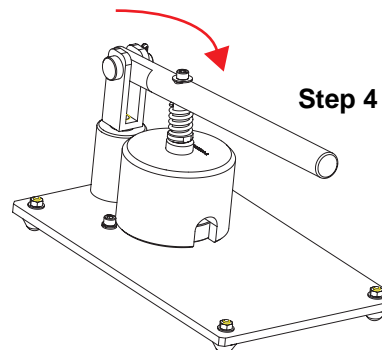


- **Step 2:** Place the cover on the body and turn it to secure the bellcup.

- **Step 3:** Place the body on the support in stop against the screws, (cover side support). Put in place the extracting rod.



- **Step 4:** Bring the arm on the extracting rod and press until it stops. A "Clac" must be heard, distributor is separated from bellcup.

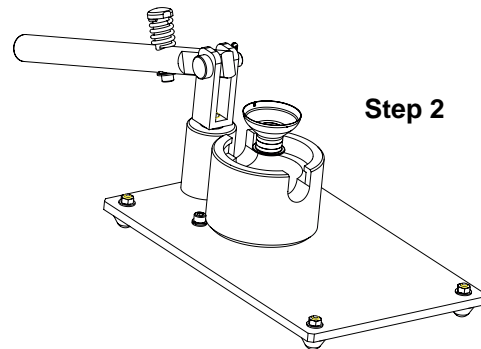


DES04369

5.7.2. Reassembly

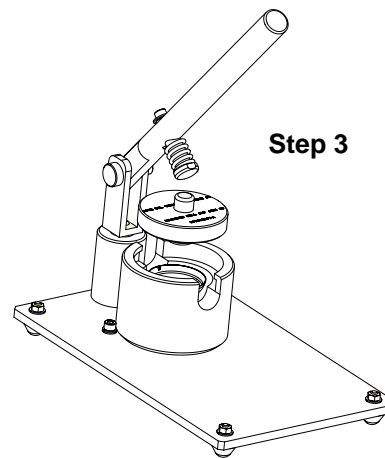
- **Step 1:** Manually position the distributor in bellcup.

- **Step 2:** Place bellcup in the tool body.

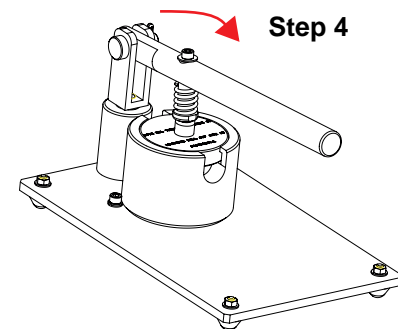


- **Step 3:** Select according to the bellcup diameter, the side of the bellcup pusher. Install the bellcup pusher in the body.

Remark: the position of the cover is given by the marking which must be side bellcup.



- **Step 4:** Bring the arm on the bellcup pusher and press until complete crushing of the spring. Distributor is then assembled.



DES04370

6. Spare parts

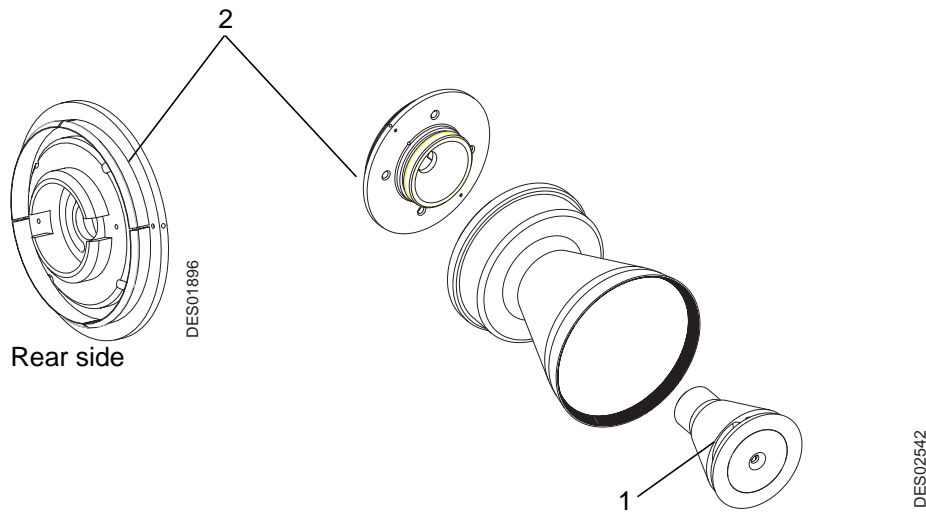


WARNING : Average lifetime of a bellcup and a deflector.

	Clearcoats	Basecoats
Bellcup	5000 hours	5000 hours
Deflector	3000 hours	1500 hours

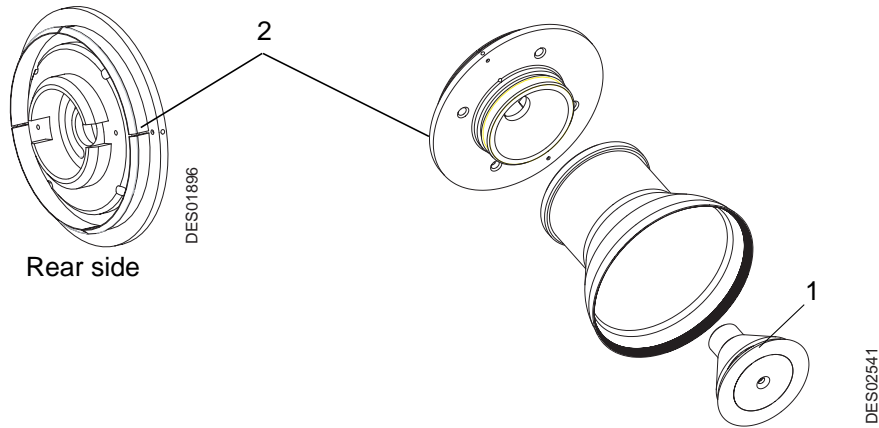
Note: These average values depend of the paint type, of the paint flow and of the bellcup rotation speed.

6.1. EC 35 aluminium threaded bellcup and clip



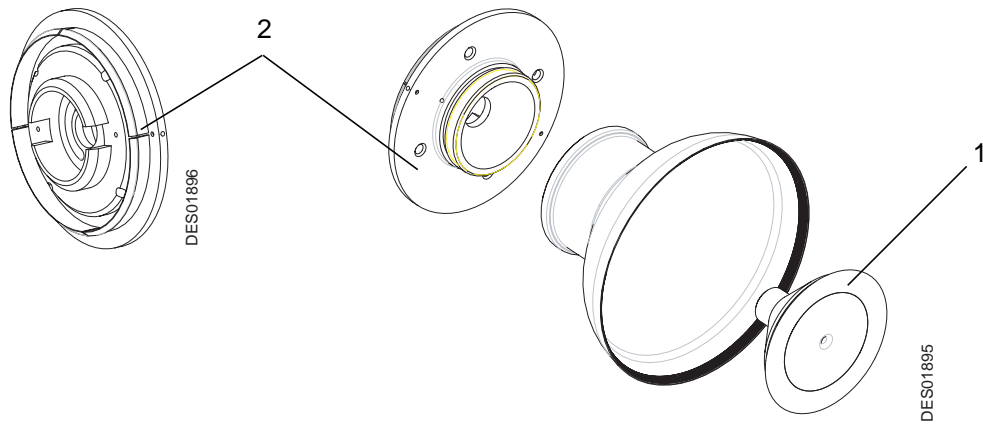
Item	Part number	Description	Qty	Sale unit
	1525410	EC 35 Bellcup assembly with clip	1	1
	1520633	EC 35 Bellcup and Distributor	1	1
1	1312181	Distributor	1	1
2	1308547	Clip	1	1

6.2. EC 50 aluminium threaded bellcup and clip



Item	Part number	Description	Qty	Sale unit
	1521170	EC 50 Bellcup assembly with clip	1	1
	1520370	EC 50 Bellcup and Distributor	1	1
1	1312135	Distributor	1	1
2	1308547	Clip	1	1

6.3. EC 65 aluminium threaded Bellcup



Item	Part number	Description	Qty	Sale unit
	1516661	EC 65 bellcup with clip	1	1
	1516662	EC 65 bellcup and distributor without clip	1	1
1	1309562	Distributor	1	1
2	1308547	Clip	1	1

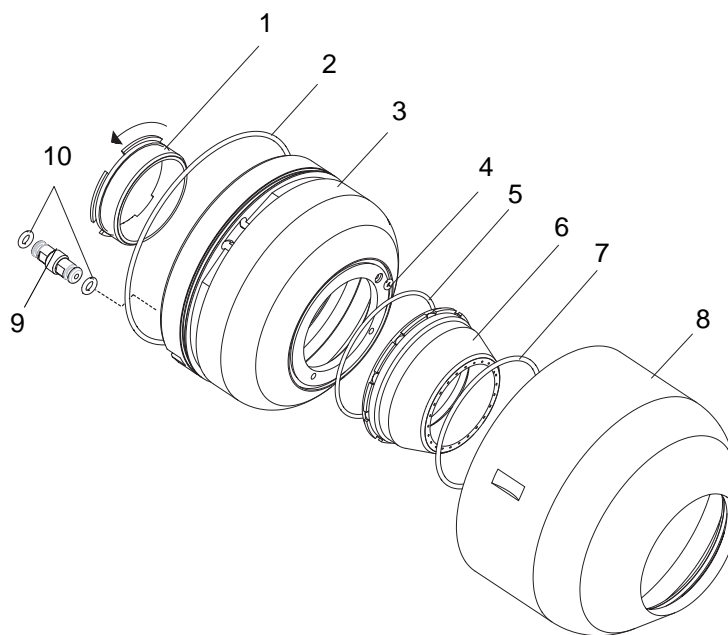
Item	Part number	Description	Qty	Sale unit
	1527572	OAC EC 65 bellcup with clip	1	1
	1527182	OAC EC 65 bellcup and distributor without clip	1	1
1	1315758	Distributor	1	1
2	1308547	Clip	1	1

Item	Part number	Description	Qty	Sale unit
	910000319	EC 65 bellcup and distributor without clip	1	1
1	1314247	Distributor	1	1
2	1308547	Clip	1	1

6.4. Used with EC 35 Bellcup

6.4.1. Shaping air assembly - P/N: 1520632

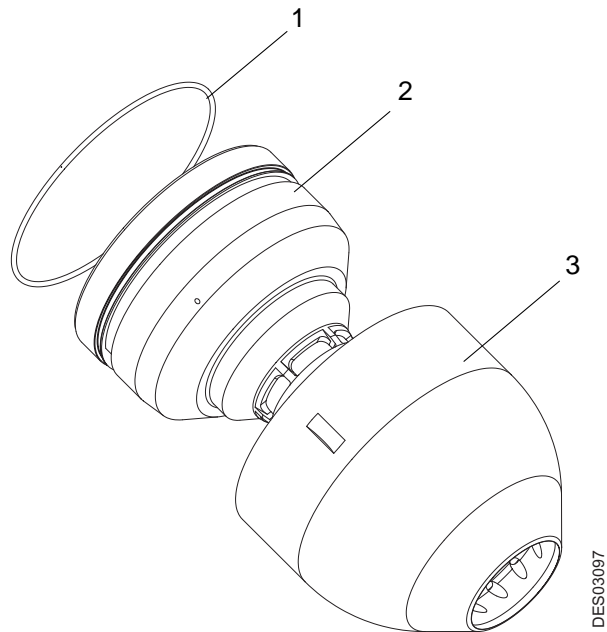
Vortex 45° - Holes in the metallic vortex insert



DES02544

Item	Part number	Description	Qty	Sale unit
	1520632	EC 35 Shaping air assembly	1	1
1	1312182	Vortex Shaping air nut - D: 35 mm	1	1
2	J2FENV622	O-ring	1	1
3	1203491	Vortex shaping air shroud - D: 35 mm	1	1
4	J3STKL014	O-ring - chemically inert	1	1
5	J2FENV396	O-ring	1	1
6	1203484	Vortex Shaping air insert D: 35 mm - 45°	1	1
7	J2FENV488	O-ring	1	1
8	1203492	Vortex outer cover - D: 35 mm	1	1
9	1519555	Equipped solvent pipette - stainless steel	1	1
10	J3STKL027	O-ring - chemically inert (included in item 9)	2	1

6.4.2. Monoblock shaping air assembly for EC 35 bellcup - P/N: 1526951
Vortex 45° - Holes in the plastic shaping air shroud

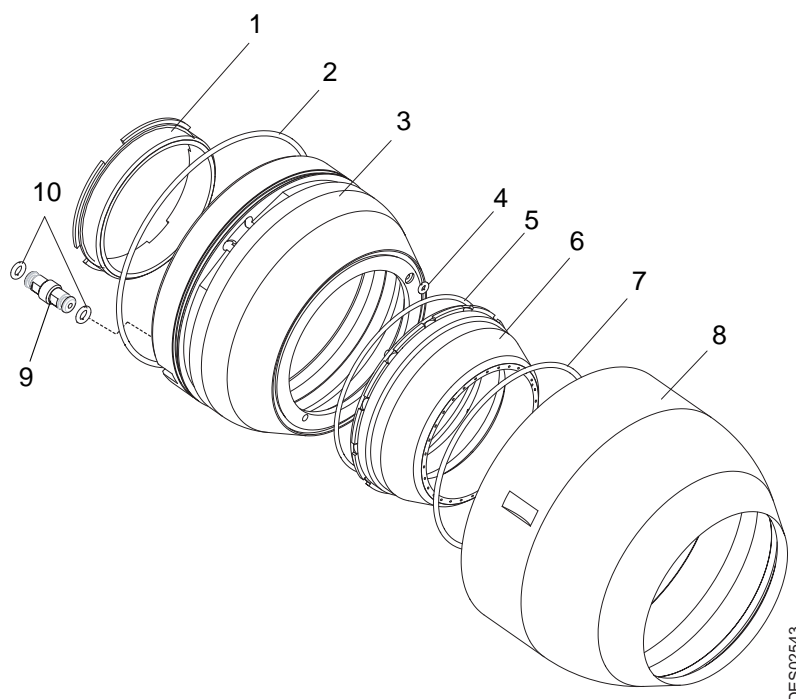


Item	Part number	Description	Qty	Sale unit
	1526951	Monoblock shaping air assembly for EC 35 bellcup	1	1
1	J2FENV622	O-ring	1	1
2	1105730	Vortex shaping air shroud - D: 35 mm	1	1
3	1105731	Vortex outer cover - D: 35 mm	1	1

6.5. Used with EC 50 Bellcup

6.5.1. Shaping air assembly - P/N: 1520369

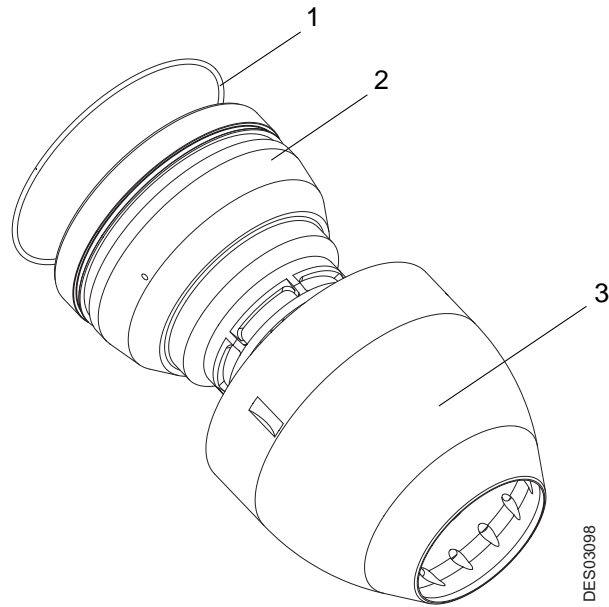
Vortex 45° - Holes in the metallic vortex insert



Item	Part number	Description	Qty	Sale unit
	1520369	EC 50 Shaping air assembly	1	1
1	1312136	Vortex Shaping air nut - D: 50 mm	1	1
2	J2FENV622	O-ring	1	1
3	1203474	Vortex shaping air shroud - D: 50 mm	1	1
4	J3STKL014	O-ring - chemically inert	1	1
5	J2FENV395	O-ring	1	1
6	1203473	Vortex shaping air insert, D: 50 mm - 45°	1	1
7	J2FENV561	O-ring	1	1
8	1203475	Vortex outer cover - D: 50 mm	1	1
9	1519555	Equipped solvent pipette - stainless steel	1	1
10	J3STKL027	O-ring - chemically inert (included in item 9)	2	1

6.5.2. Monoblock shaping air assembly for EC 50 bellcup - Ref.: 1526952

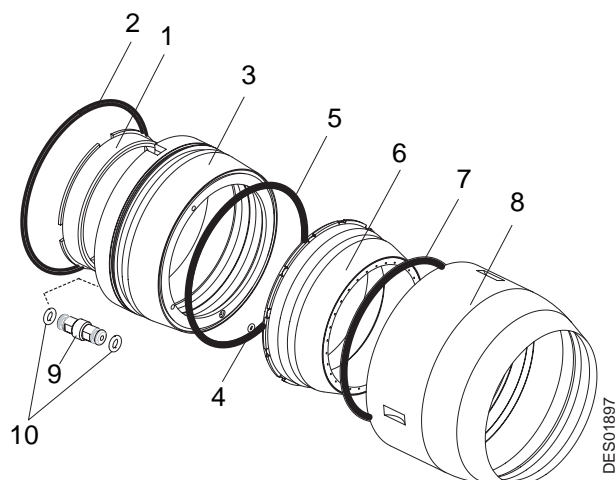
Vortex 45° - Holes in the plastic shaping air shroud



Item	Part number	Description	Qty	Sale unit
	1526952	Monoblock shaping air assembly for EC 50 bellcup	1	1
1	J2FENV622	O-ring	1	1
2	1105723	Vortex shaping air shroud - D: 50 mm	1	1
3	1105724	Vortex outer cover - D: 50 mm	1	1

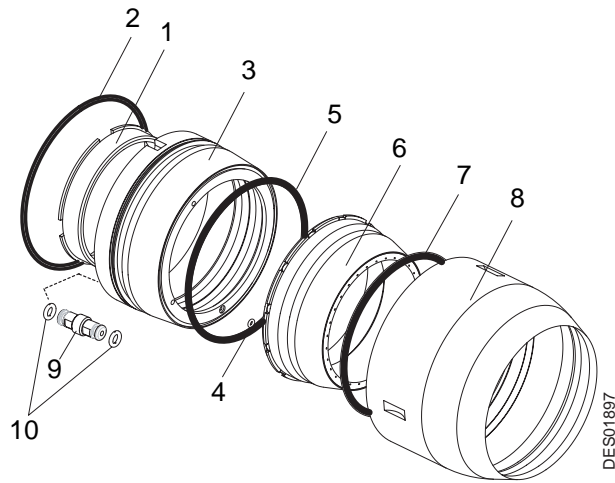
6.6. Used with EC 65 Bellcup

6.6.1. Shaping air assembly for PPH 607, Accubell 607 and PPH 308, direct charge Vortex 45° - Holes in the metallic vortex insert - Single rinsing



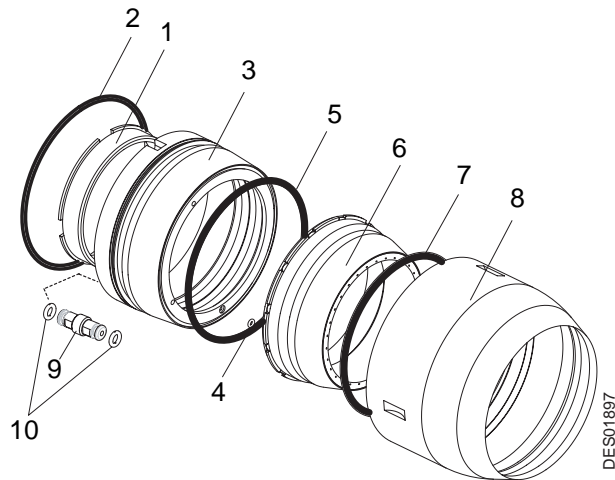
Item	Part number	Description	Qty	Sale unit
	1514409	EC 65 Shaping air assembly - 45°	1	1
1	1310370	Vortex Shaping air nut - D: 65 mm	1	1
2	J2FENV622	O-ring	1	1
3	1202995	Vortex shaping air shroud - D: 65 mm	1	1
4	J3STKL014	O-ring - chemically inert	1	1
5	J2FENV385	O-ring	1	1
6	1202570	Vortex shaping air insert, D: 65 mm - 45°	1	1
7	J2FENV386	O-ring	1	1
8	1202996	Vortex outer cover - D: 50 mm	1	1
			1	1
9	1519555	Equipped solvent pipette - stainless steel	1	1
10	J3STKL027	O-ring - chemically inert (included in item 9)	2	1

6.6.2. Shaping air assembly for PPH 607, Accubell 607 and PPH 308, direct charge
Vortex 45° - Holes in the metallic vortex insert - Dual rinsing



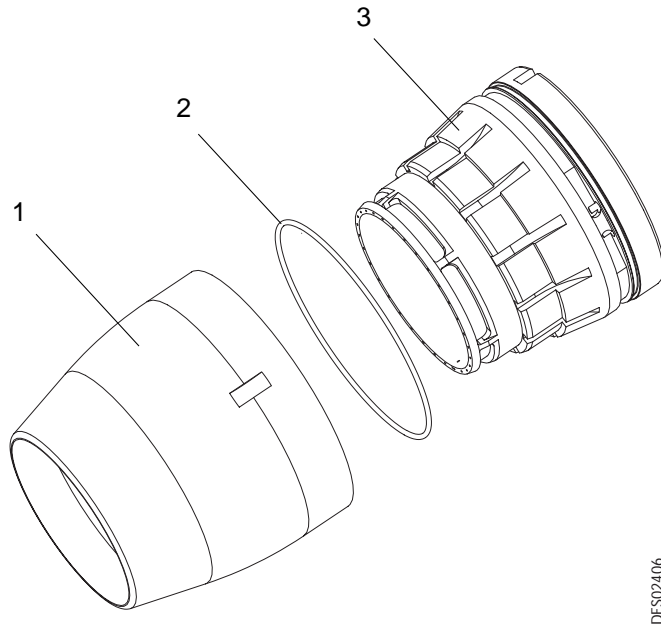
Item	Part number	Description	Qty	Sale unit
	1527425	EC 65 Shaping air assembly - 45°	1	1
1	1310370	Vortex Shaping air nut - D: 65 mm	1	1
2	J2FENV622	O-ring	1	1
3	1202995	Vortex shaping air shroud - D: 65 mm	1	1
4	J3STKL014	O-ring - chemically inert	1	1
5	J2FENV385	O-ring	1	1
6	1204012	Vortex shaping air insert, D: 65 mm - 45°	1	1
7	J2FENV386	O-ring	1	1
8	1202996	Vortex outer cover - D: 65 mm	1	1
9	1519555	Equipped solvent pipette - stainless steel	1	1
10	J3STKL027	O-ring - chemically inert (included in item 9)	2	1

6.6.3. Shaping air assembly for PPH 607, Accubell 607 and PPH 308, direct charge
Vortex 55° - Holes in the metallic vortex insert - Single rinsing



Item	Part number	Description	Qty	Sale unit
	1519985	EC 65 Shaping air assembly - 55°	1	1
1	1310370	Vortex Shaping air nut - D: 65 mm	1	1
2	J2FENV622	O-ring	1	1
3	1202995	Vortex shaping air shroud - D: 65 mm	1	1
4	J3STKL014	O-ring - chemically inert	1	1
5	J2FENV385	O-ring	1	1
6	1203406	Vortex shaping air insert, D: 65 mm - 55°	1	1
7	J2FENV386	O-ring	1	1
8	1202996	Vortex outer cover - D: 65 mm	1	1
9	1519555	Equipped solvent pipette - stainless steel	1	1
10	J3STKL027	O-ring - chemically inert (included in item 9)	2	1

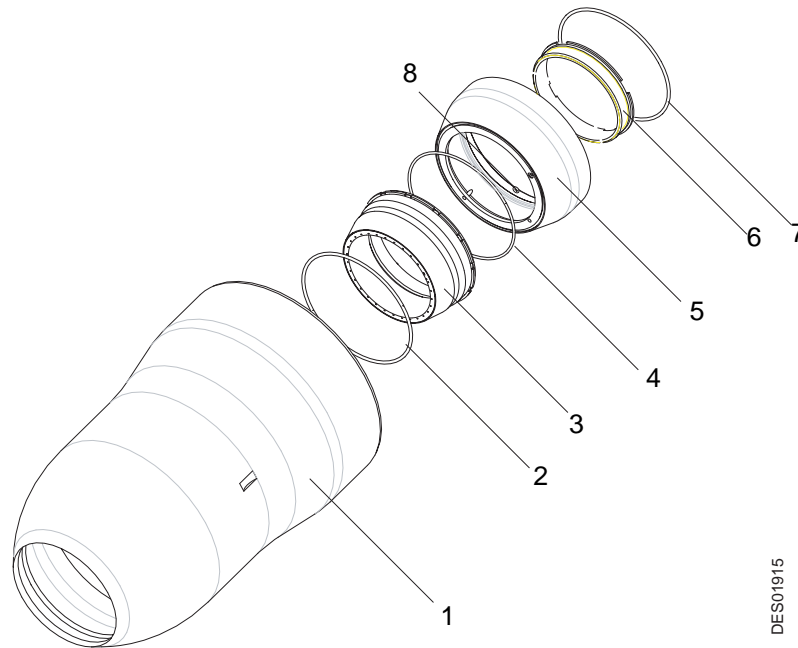
6.6.4. Monoblock shaping air assembly for PPH 607, Accubell 607 and PPH 308 direct charge
Vortex 45° - Holes in the plastic shaping air shroud



DES02406

Item	Part number	Description	Qty	Sale unit
	1523813	Monoblock shaping air assembly	1	1
1	1104962	Outer cover, aluminium	1	1
2	J2FENV622	O-ring - Teflon encapsulated (included in item 3)	1	1
3	1104960	Plastic shaping air shroud with holes	1	1

6.6.5. Shaping air assembly for PPH 605 direct charge
Vortex 45° - Holes in the metallic vortex insert - Single rinsing



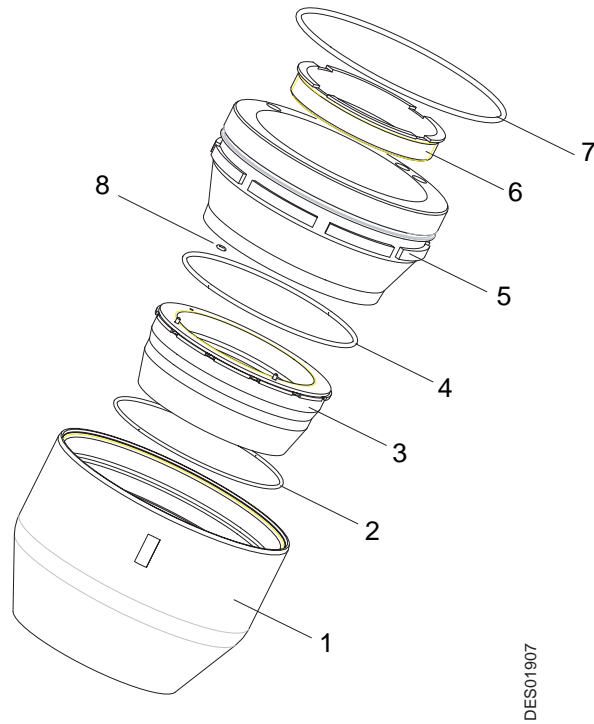
DES01915

Item	Part number	Description	Qty	Sale unit
	1519546	EC 65 shaping air assembly of PPH 605	1	1
1	1203229	Plastic cover	1	1
2	J2FENV386	O-ring	1	1
3	1202570	Shaping air insert OD: 65 mm	1	1
4	J2FENV385	O-ring	1	1
5	1203228	Shaping air shroud	1	1
6	1310370	Shaping air nut OD: 65 mm	1	1
7	J2CTPB612	O-ring	1	1
8	J3STKL014	O-ring - chemically inert	1	1

6.6.6. Shaping air assembly for Aquabell direct charge

6.6.6.1. Vortex Shaping air assembly

Vortex 45° - Holes in the metallic vortex insert - Single rinsing

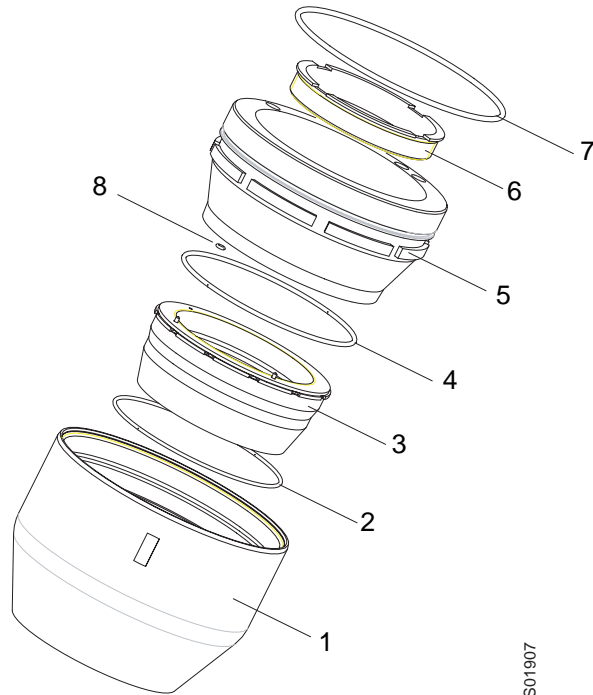


DES01907

Item	Part number	Description	Qty	Sale unit
	1517466	EC 65 shaping air assembly	1	1
1	1203027	Aluminium cover	1	1
2	J2FENV386	O-ring	1	1
3	1202570	Shaping air insert OD: 65 mm	1	1
4	J2FENV385	O-ring	1	1
5	1203026	Shaping air shroud	1	1
6	1310370	Shaping air nut OD: 65 mm	1	1
7	J2FENV999	O-ring	1	1
8	J3STKL014	O-ring - chemically inert	1	1

6.6.6.2. Vortex Shaping air assembly

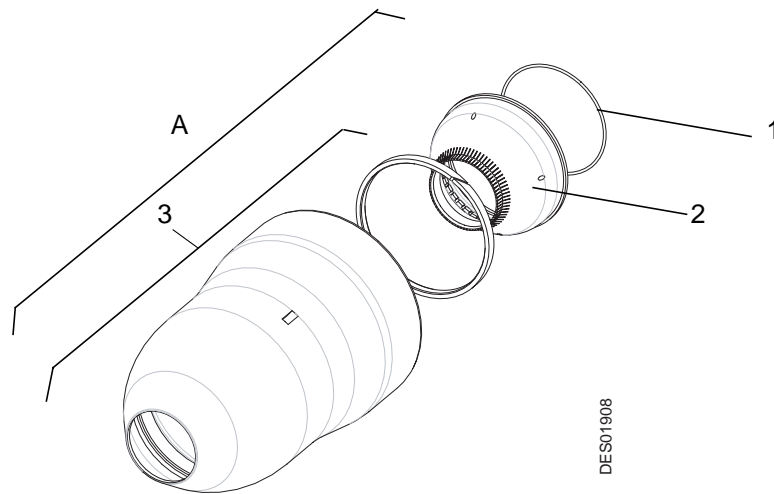
Vortex 45° - Holes in the metallic vortex insert - Dual rinsing



DES01907

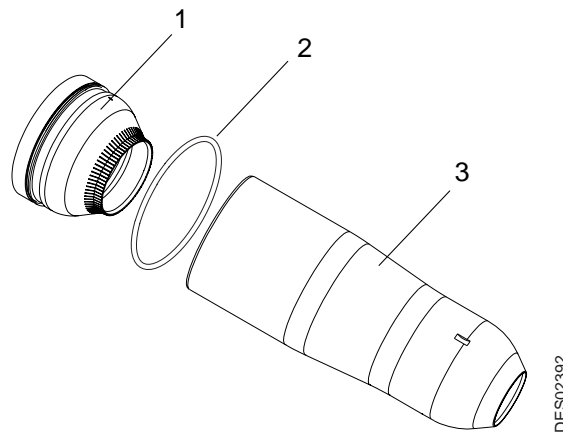
Item	Part number	Description	Qty	Sale unit
	1523830	EC 65 shaping air assembly, dual rinsing	1	1
1	1203027	Aluminium cover	1	1
2	J2FENV386	O-ring	1	1
3	1204012	Shaping air insert OD: 65 mm, dual rinsing	1	1
4	J2FENV385	O-ring	1	1
5	1203026	Shaping air shroud	1	1
6	1310370	Shaping air nut OD: 65 mm	1	1
7	J2FENV999	O-ring	1	1
8	J3STKL014	O-ring - chemically inert	1	1

6.6.7. With EC 65 bellcup for PPH 605 external charge



Item	Part number	Description	Qty	Sale unit
A	1514412	65 EC shaping air assembly of PPH 605	1	1
1	J2CTPB612	O-ring	1	1
2	1100982	Shaping air shroud	1	1
3	1517488	Outer cover assembly	1	1

6.6.8. With EC 65 bellcup for PPH 308 external charge



Item	Part number	Description	Qty	Sale unit
	1521092	65 EC shaping air assembly	1	1
1	1104843	Shaping air shroud	1	1
2	J2FENV622	O-ring	1	1
3	1104907	Outer cover	1	1