DURO DYNE®

TECHNICAL BULLETIN

BULLETIN No: 12   **EFFECTIVE DATE:** 3/8/16

SUBJECT: Upper Weld Plate Replacement

MACHINERY MODELS AFFECTED:

☐ LF1000/2000	☐ MFPT	☐ MF12
☐ PBFS14	☐ PBF510	☐ MF12A
☑ RH	☑ FG Mach I&II	☐ CDMF110
☑ RH MachII	☑ RH MachIIA	☑ FG1
☐ LSU	☑ RH Mach III	☒ FG Mach IIA
☐ SuperSprayfast	☐ PLS	☑ FG Mach III
☐ Mini Sprayfast	☑ FGMH	☐ LS-5

ACTION:

An upper weld plate needs to be replaced as basic maintenance of your bulk feed pinspotter machine. Replacing the Upper Plate at the right time, will prevent you from having to replace the whole tip.

Video instructions for replacement can be found by scanning the QR code below or by visiting our YouTube page at: https://www.youtube.com/watch?v=wUuoC541Vac

Foe those without video access, here is a basic guideline for replacement:

1. Stop all electrical power to the machine before beginning this or any maintenance.
2. Shut off the air as well by sliding down the valve on the regulator. This will allow air in the system to escape and cause the dwell cylinder head to drop. This will allow access to the black set screw described below in step 3.
3. Use an allen key to loosen the black set screw on the side up of the upper tip. This will allow the whole tip to come out.
4. Use a screwdriver to remove the three screws on the top of the tip and the plate will come off of the tip.
5. Then, attach the new plate to the tip and attach it with the three new screws provided with your new upper plate.
6. Make sure that the screws are snug.
7. Then return to the machine and reinstall the tip with the new plate.
8. The sled of the new plate should align with the feed channel of the machine.
9. Reinsert and tighten the set screw on the side of the tip that you removed in step #3.
10. Slide the valve on the regulator (from step #2 above) back up to reintroduce air into the system.

Then installation should be complete. Be sure to also check out Tech Bulletin #13 for LOWER Plate replacement.

A worn upper weld plate will lead to poor welds as well as the washer bending and tearing the liner.
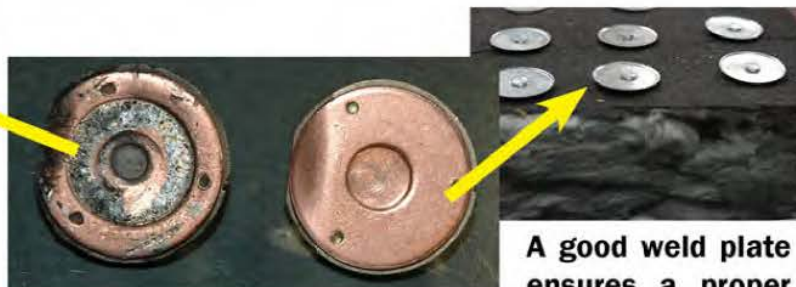
A good weld plate ensures a proper weld every time.

FOR ANY ADDITIONAL QUESTIONS PLEASE CONTACT: DURO DYNE TECHNICAL SERVICES AT 1-800-899-3876