

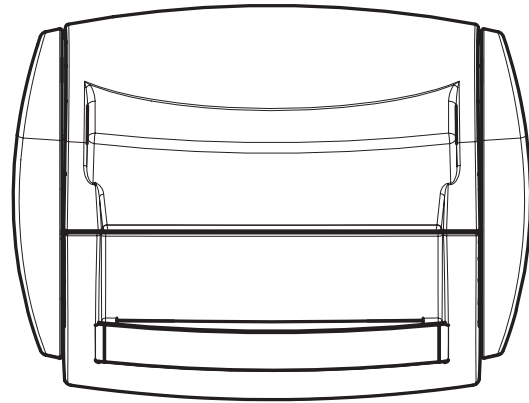
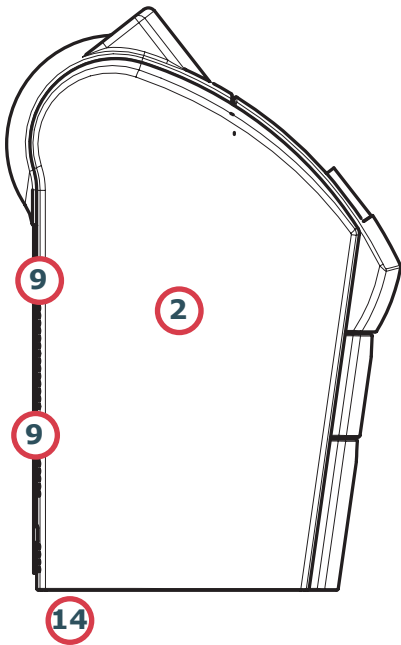
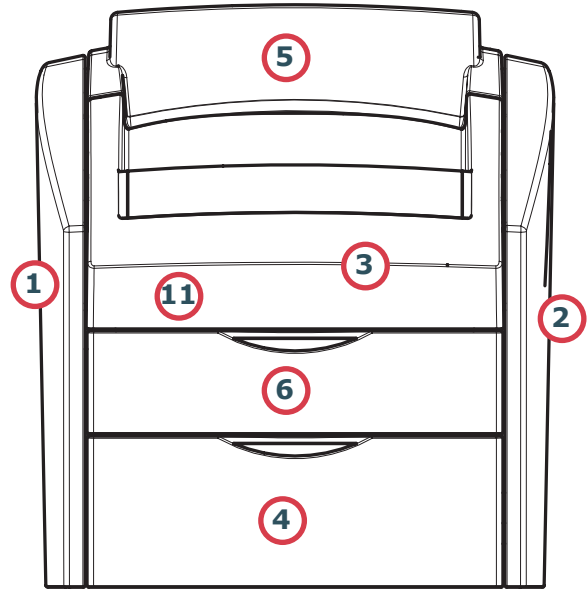
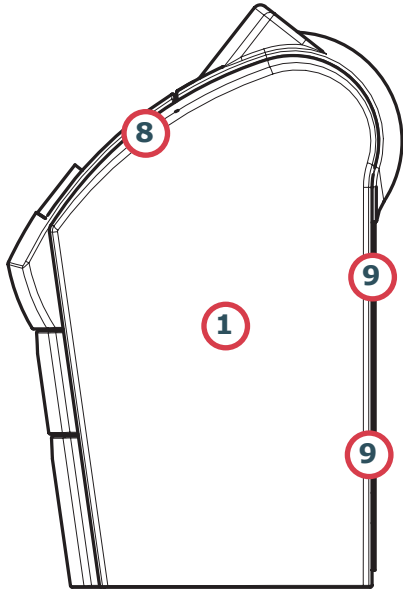
# Contents

Covers .....	2
Exposing Unit - right.....	4
Exposing Unit - front .....	6
Feed system, Upper media .....	8
Feed system, Lower media .....	10
Feed system, Buffer.....	12
Knife Punch module .....	14
Drum Input system .....	16
Media Shaft .....	18
Carriage.....	20
Optical Housing.....	22
Electronics.....	24
Cables 1.....	26
Cables 2.....	28
Cables 3.....	30
Cables 4.....	32
Cables 5.....	34
Cables 6.....	36
Cables Accessories .....	38
Processor 1 .....	40
Processor 2 .....	42
Processor Waste tank.....	44
Replenish Probe .....	46
Processor Dryer 1.....	48
Processor Dryer 2.....	50
Processor Activator .....	52
Processor Stabilizer .....	54
Processor Tanks .....	56
Processor Electrical.....	58
Processor Conveyor .....	60
Accessories .....	62
Recommended Spare Parts .....	63
Recommended Spare Parts cont. ....	64

*Note: Any changes since the last revision will in this section will be **highlighted**.*

*New: "C" column in sparepart tables indicates consumable parts*

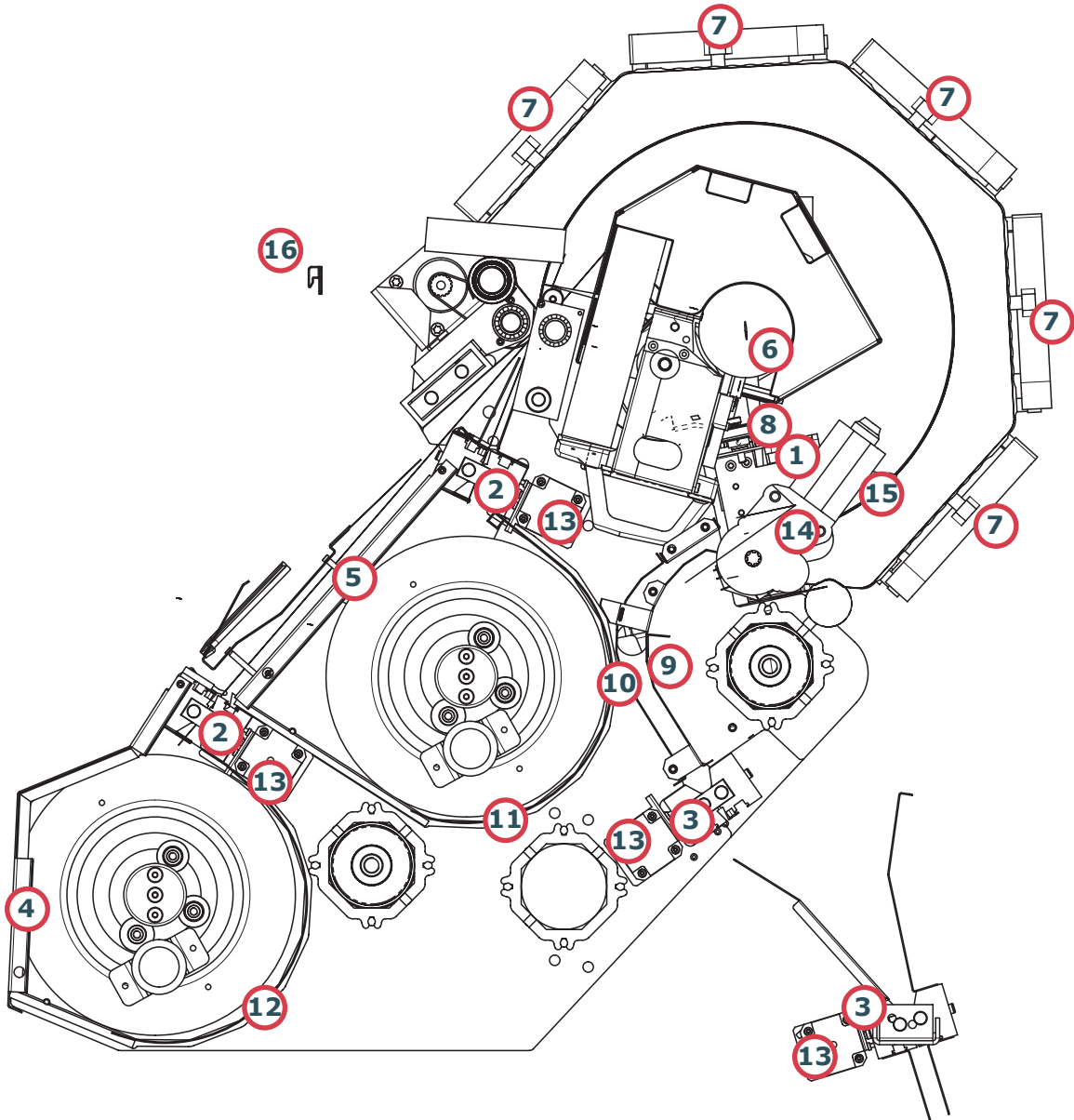
## Covers




## Covers

Item	C	Part number	Description	Notes
<b>1</b>		300730	Right door	incl. hinges
<b>2</b>		300731	Left Door	incl. hinges
<b>3</b>		300509	Media Cover	
<b>4</b>		500736	Cover, Replenish	
<b>5</b>		501967	Top Cover	changed from 500739
<b>6</b>		500740	Cover, Processor	
<b>7</b>		601893	Gas damper	300N
<b>7a</b>		602263	Gas damper	350N
<b>8</b>		601784	Hinges, Media Cover	
<b>9</b>		601783	Hinges, doors	
<b>10</b>		9604000160	Interlock	changed from 3400081302
<b>11</b>		501055	DPX-4 Label	
<b>12</b>		400181	Power switch, Red light	
<b>13a</b>		601923	Door lock, Hafele	from S/N 47420014
<b>13b</b>		602093	Door lock w. hole, Hafele	to S/N 47420013
<b>13c</b>		502205	Bracket for mini latch	
<b>14</b>		300808	Adjustment foot, DPX 4	new part number
<b>15</b>		6201100720	Actuator spring, Interlock	new part number

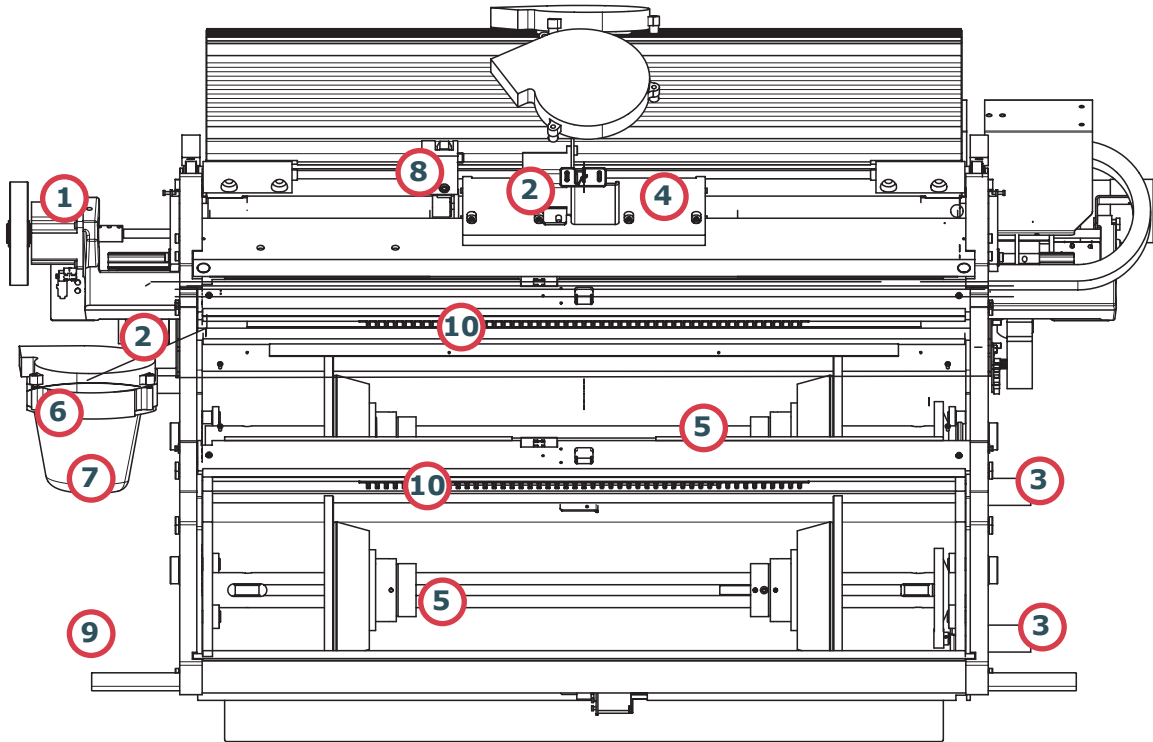
## Exposing Unit - right



## Exposing Unit - right

	C	Part number	Description	Notes
<b>1</b>		300524	Knife-punch module	w/o punch motor, punch and vacuum units
<b>2</b>		300532	Feed system Input	
<b>3</b>		300534	Feed system, Buffer	
<b>4</b>		300166	Media cover, lower	
<b>5</b>		300538	Media cover, Upper	
<b>6</b>		400490	Spinner 62,5 RPM 	changed from 400027
<b>7</b>		400072	Vacuum Fan	
<b>8</b>		400180	Switch-,Punch, Knife	
<b>9</b>		501964	Guide, Buffer-In rear incl. sensor	changed from 5001961
<b>10</b>		501965	Guide, Buffer-In, front incl. sensor	changed from 500304
<b>11</b>		500426	Media light shield, upper	
<b>12</b>		501966	Media light shield, lower	changed from 500427
<b>13</b>		9604000200	Motor, feed system	
<b>14</b>		300733	Motor, Punch	changed from 300198
<b>15</b>		300735	IR sensor with AMP plug	new part
<b>16</b>		501352	hook for upper media cover	

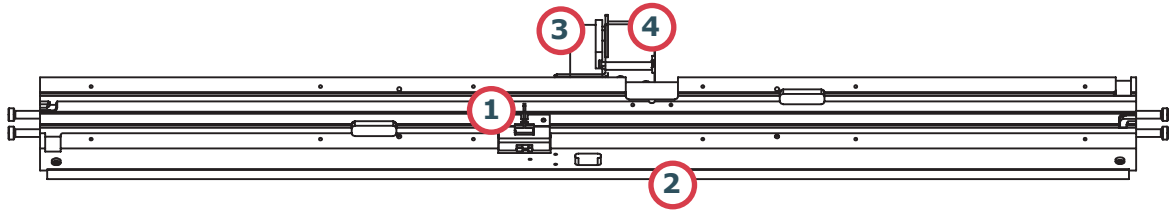
## Exposing Unit - front



## Exposing Unit - front

	C	Part number	Description	Notes
<b>1</b>		9604500170	Motor, carriage	
<b>2</b>		400137	Motor-, Drum-Input, Knife_Punch	
<b>3</b>		300084	Media Motor 24V	changed from 400084
<b>4</b>		300535	Drum input system	
<b>5</b>		300533	Media shaft complet	
<b>6</b>		300527	Punch vacuum complete	
<b>7</b>		500298	Punch Waste container	
<b>8</b>		300160	Media encoder	
<b>9</b>		400182	Switch, Pre-load	
<b>10</b>		300639	Anti-static Brush DPX 4	

## Feed system, Upper media



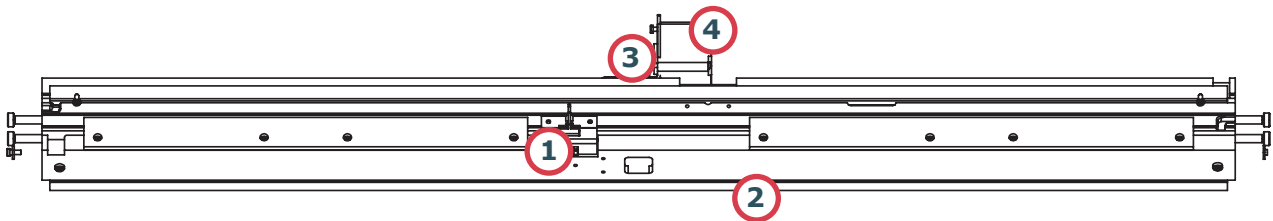


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## Feed System, Upper media

	C	Part number	Description	Notes
		300532	Feed system, Media	
<b>1</b>		300142	Sensor feed system	
<b>2</b>		300639	Anti-static Brush DPX 4	
<b>3</b>		600047	Belt AT3x16x150	
<b>4</b>		9604000200	Motor, feed system	

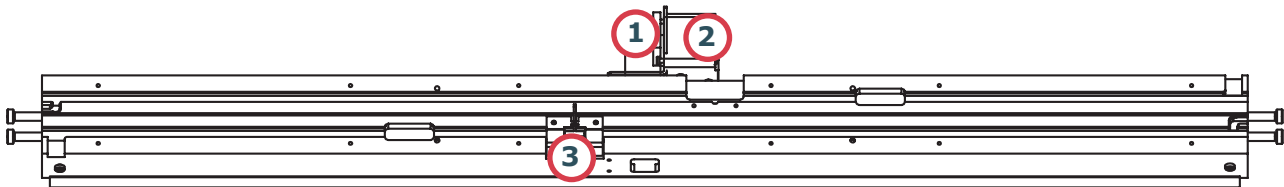
## Feed system, Lower media



## Feed System, Lower media

	<b>C</b>	<b>Part number</b>	<b>Description</b>	<b>Notes</b>
		300532	Feed system, Lower Media	
<b>1</b>		300142	Sensor feed system	
<b>2</b>		300639	Anti-static Brush DPX 4	
<b>3</b>		600047	Belt AT3x16x150	
<b>4</b>		9604000200	Motor, feed system	

## Feed system, Buffer



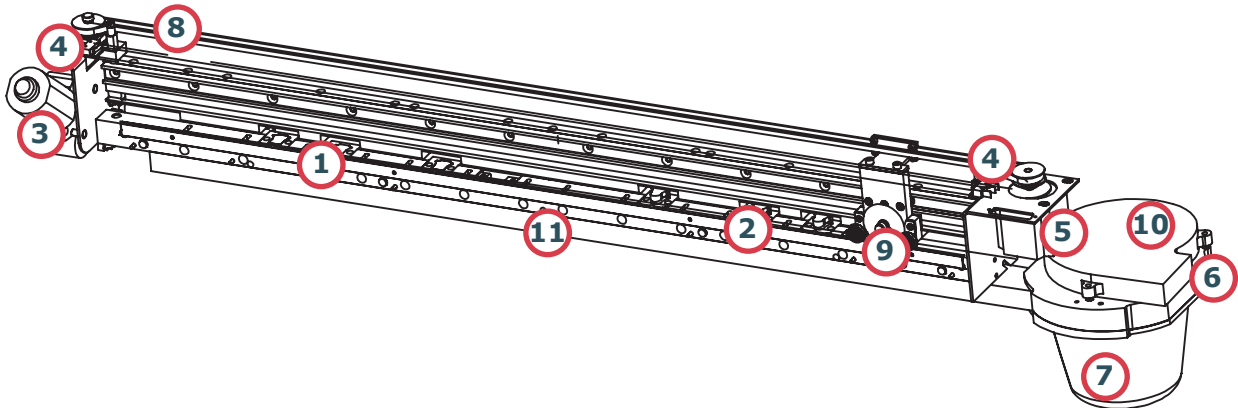
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## Feed System, Buffer

	C	Part number	Description	Notes
<b>1</b>		600047	Belt AT3x16x150	
<b>2</b>		9604000200	Motor, feed system	
<b>3</b>		300142	Sensor feed system	Sensor not on Buffer-In feed system

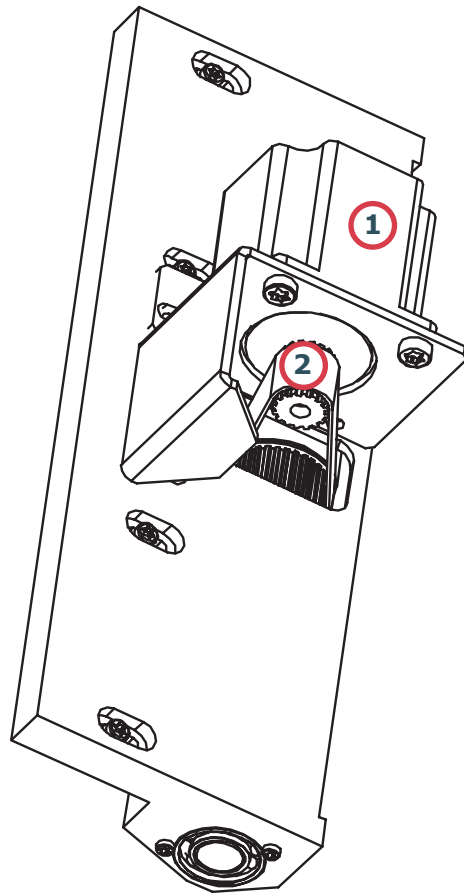
## Knife Punch module



## Knife Punch module

	C	Part number	Description	Notes
		300524	Punch knife module	w/o punch motor, punch and vacuum units
<b>1</b>		300525	Punch-unit Bacher Square	
<b>2</b>		300526	Punch-unit Bacher Round	
<b>3</b>		300733	Motor, Punch	
<b>4</b>		400180	Switch-,Punch, Knife	
<b>5</b>		400137	Motor-, Drum-Input, Knife_Punch	
<b>6</b>		300527	Punch vacuum complete	
<b>7</b>		500298	Punch Waste container	
<b>8</b>		300759	Belt, knife 2.8m.	
<b>9</b>		6400554000	Cutter blade. Ø42	
<b>9a</b>		6400358400	Spring	
<b>9b</b>		470-704-000	Ring Retaining	
<b>10</b>		400072	Vacuum Fan	
<b>11</b>		500048	Cutting bar	replaces 000485
		500791	U-bracket, punch waste container	
		500044	Punch drive shaft	not yet available

## Drum Input system



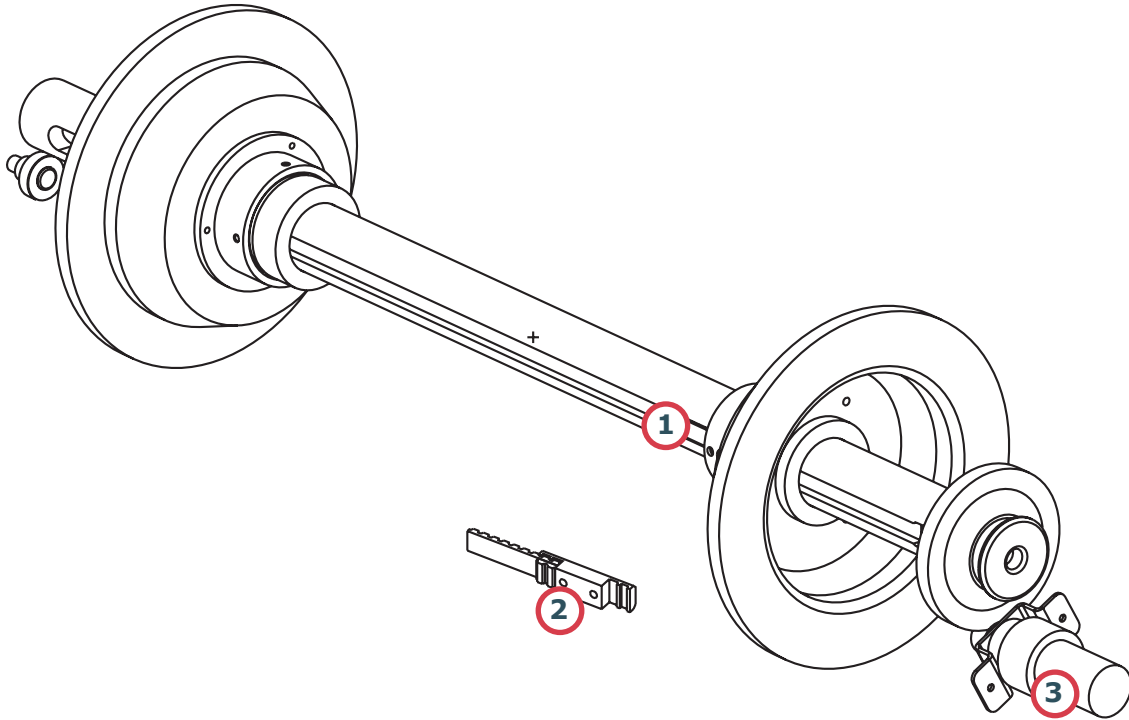


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## Drum Input system

	C	Part number	Description	Notes
<b>1</b>		400137	Motor-, Drum-Input, Knife_Punch	
<b>2</b>		600035	Belt AT3x16x201	

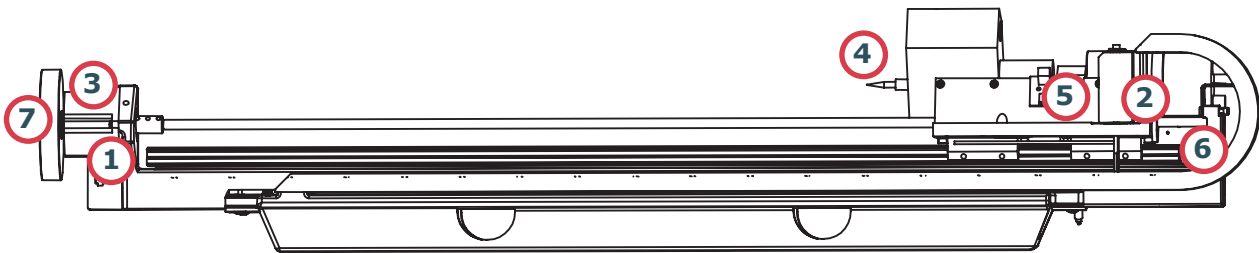
## Media Shaft



## Media Shaft

	C	Part number	Description	Notes
<b>1</b>		600202	Belt 10AT 5-M	0,770m.
<b>2</b>		500102	Belt lock	
<b>3</b>		300084	Media Motor 24V	changed from 400084

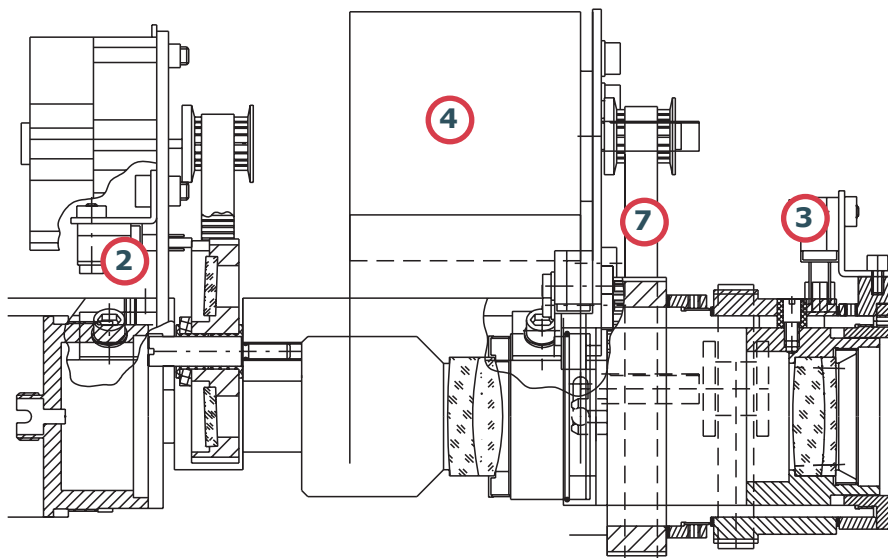
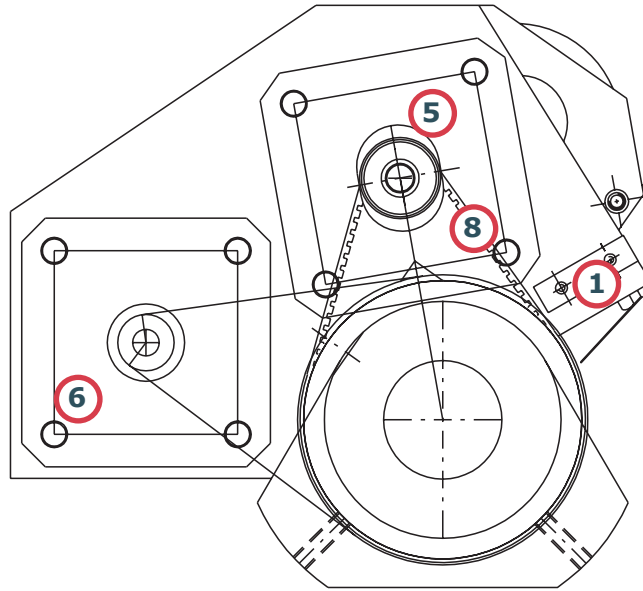
## Carriage



## Carriage

	C	Part number	Description	Notes
<b>1</b>		300199	Switch w. overtravel	
<b>2</b>		400490	Spinner 62,5 RPM	changed from 400027
<b>3</b>		9604500170	Motor, carriage	
<b>4</b>		501343	Laser fiber extension cord 3 meters	
<b>5</b>		9605500110	Digital Thermometer	changed from 5600840100
<b>6</b>		400094	Switch, carriage zero	
<b>7</b>		300856	Flywheel assy	15xo40x20

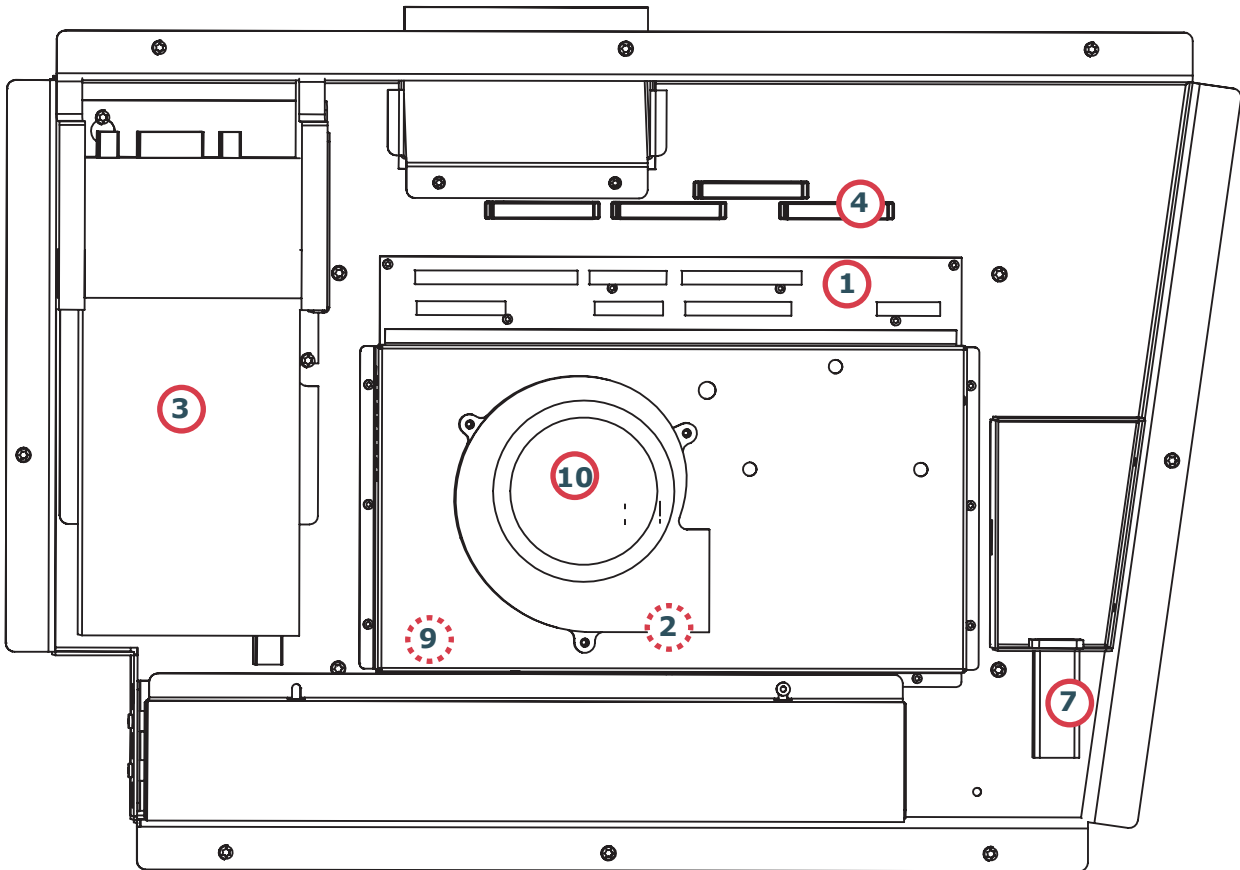
## Optical Housing



## Optical Housing

	C	Part number	Description	Notes
		500245	Optical Housing, Complete	Screw torque 0.8 Nm (Newton meter)
<b>1</b>		200517	Switch,Iris	
<b>2</b>		200518	Switch,Filter and Focus	
<b>3</b>		200518	Switch,Filter and Focus	
<b>4</b>		200519	Motor assy, focus	
<b>5</b>		200520	Motor assy, iris	
<b>6</b>		200521	Motor assy, filter	
<b>7</b>		200522	Tooth belt for focus	
<b>8</b>		200523	Tooth belt for iris	

## Electronics



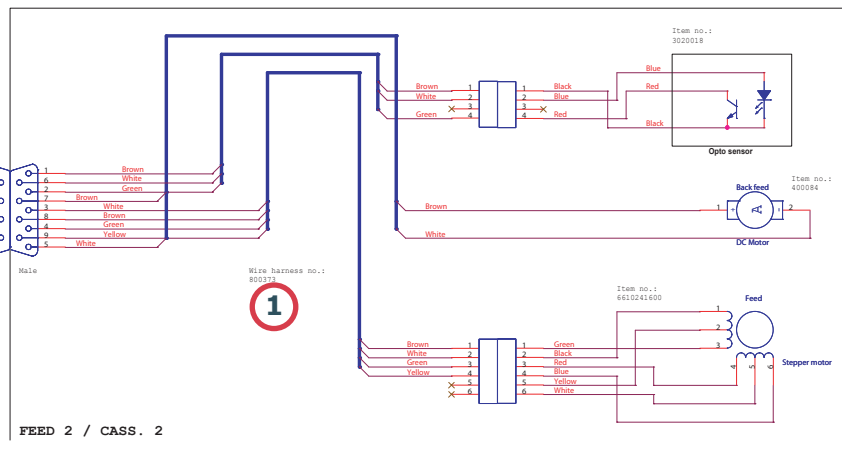
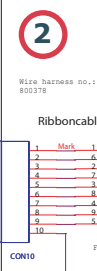
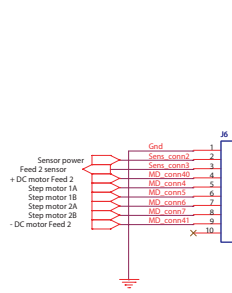
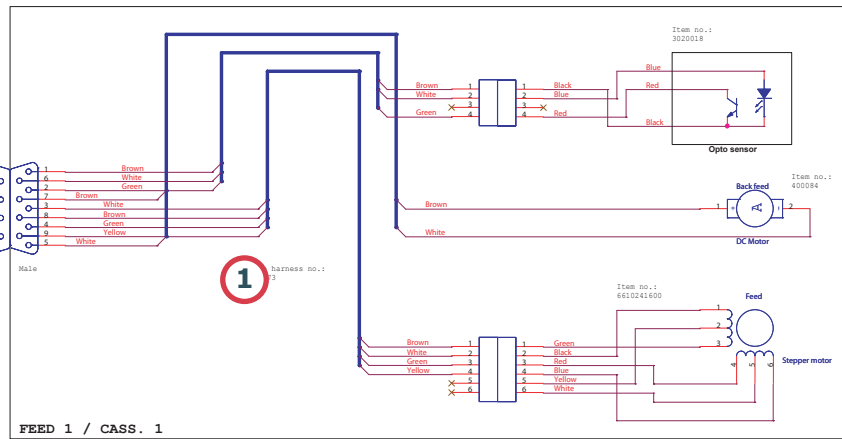
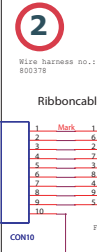
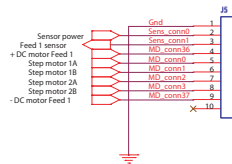


## Electronics

	C	Part number	Description	Notes
<b>1</b>		300536	Control board	
<b>2</b>		300537	Laser driver	
<b>3</b>		400484	Power Supply, 5/12/24V	changed from 400105
<b>4</b>	<b>C</b>	601749	Flat cable clamp	
	<b>C</b>	600219	Cable tie, Nylon, Ø7,9 X 8,7, tie width	
	<b>C</b>	600229	Cable tie anker	
<b>7</b>		3380400010	Main plug AC Inlet	
		400181	Power switch, Red light	
<b>9</b>		400489	Spinner driver	changed from 400027
<b>10</b>		400072	Vacuum fan	
	<b>C</b>	400562	T4A Pico Fuse, DPX 4 CB	new part number

# Cables 1

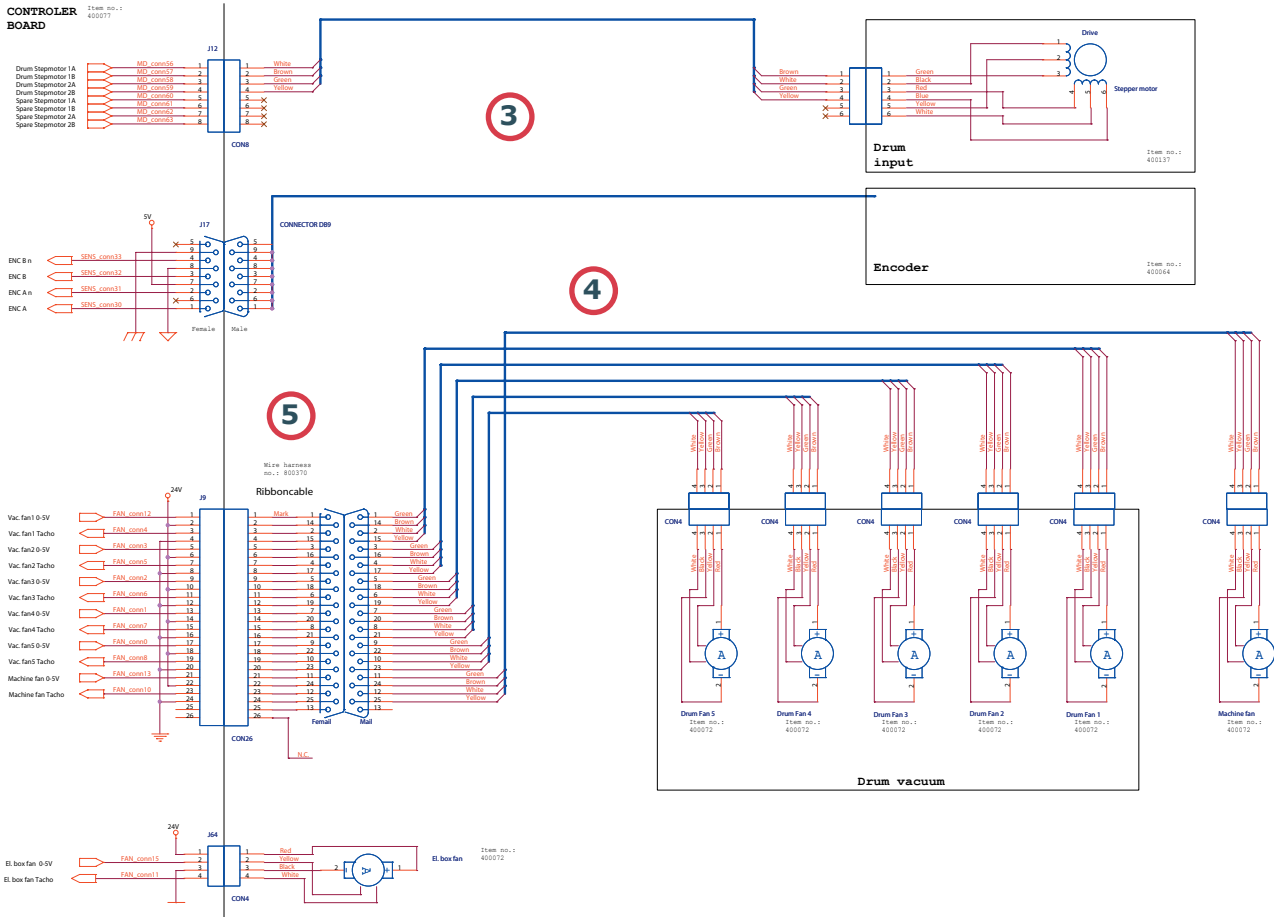
**CONTROLLER BOARD**  
Item no.: 400077



## Cables 1

	C	Part number	Description	Notes
<b>1</b>		800373	Cable feed system internal, input	
<b>2</b>		800378	Wire Ribbon 9 P	

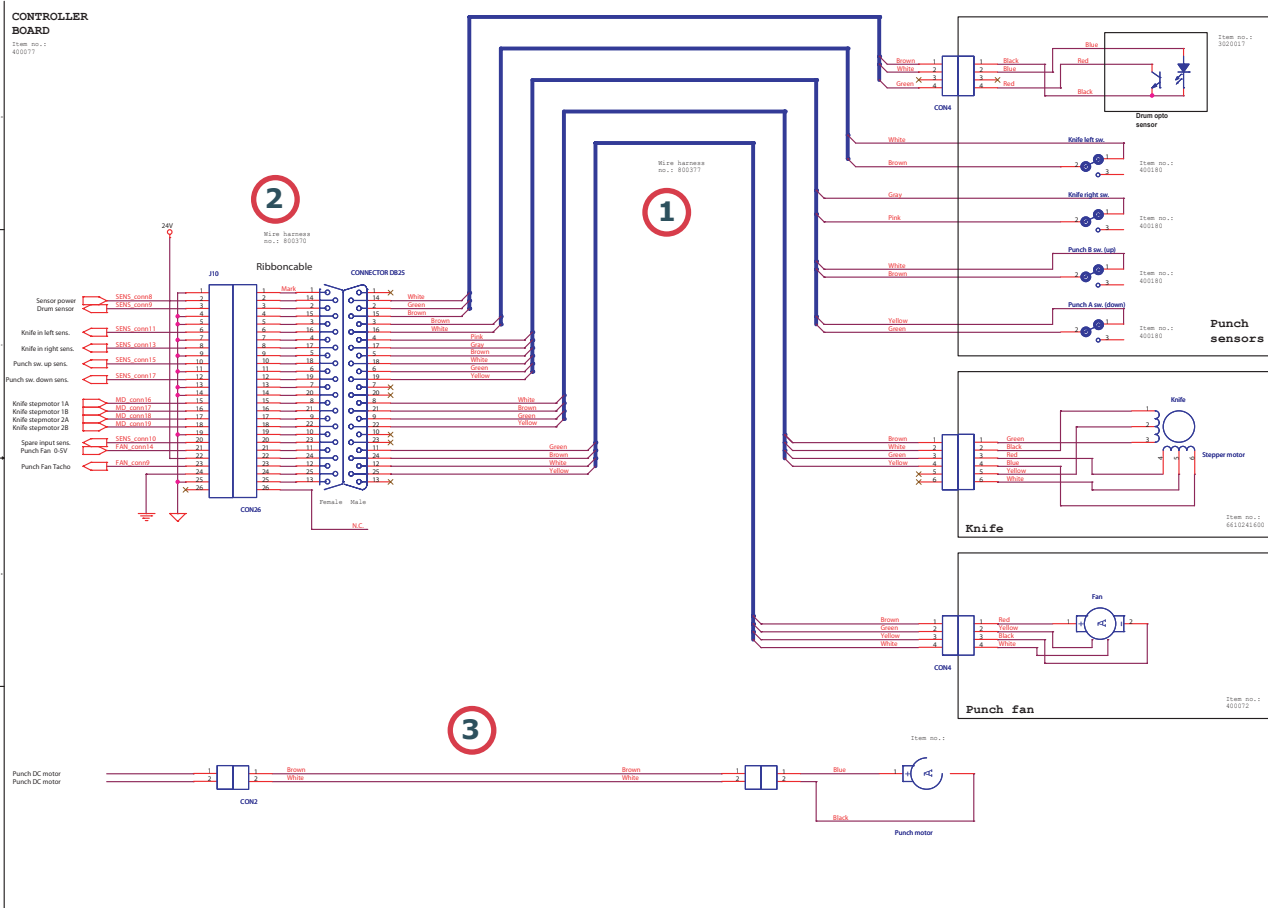
# Cables 2



## Cables 2

	C	Part number	Description	Notes
<b>3</b>		800406	Cable, Motor drum In	
<b>4</b>		800369	Wire assy. Drum vacuum fans	
<b>5</b>		800370	Wire Ribbon 25P	

# Cables 3



## Cables 3

	C	Part number	Description	Notes
<b>1</b>		800377	Wire for punch / knife	description change
<b>2</b>		800370	Wire Ribbon 25P	description change
<b>3</b>		800375	Wire for punch motor	description change

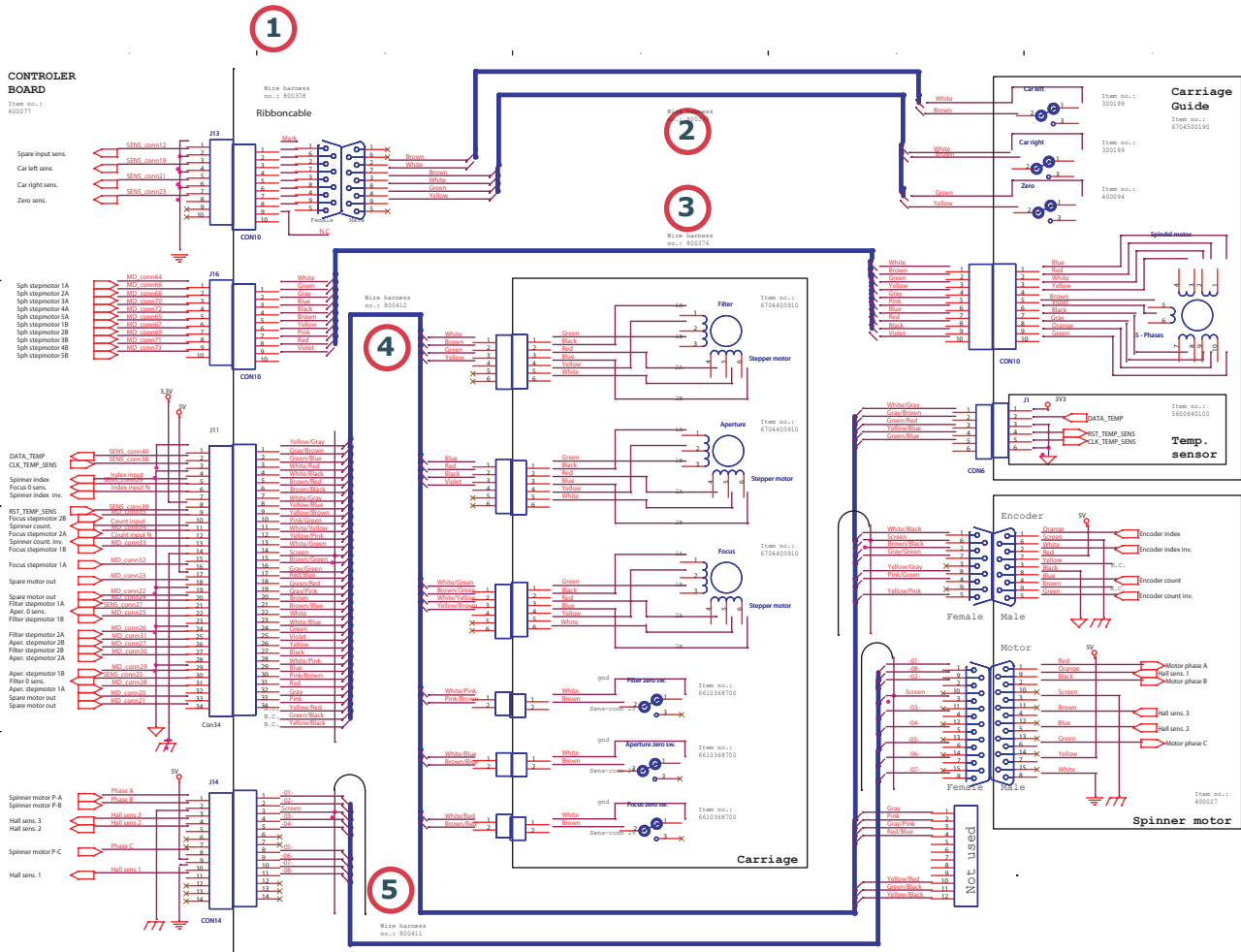




## Cables 4

	C	Part number	Description	Notes
<b>1</b>		800371	Wire for buffer feed system	
<b>2</b>		800466	Wire for conveyor/Preload	
<b>3</b>		400414	Wire, conveyor internal	

# Cables 5



## Cables 5

	<b>C</b>	<b>Part number</b>	<b>Description</b>	<b>Notes</b>
<b>1</b>		800378	Wire Ribbon 9 P	
<b>2</b>		800379	Wire for car switches	
<b>3</b>		800376	Wire for 5 phase CAR	
<b>4</b>		800412	Wire for spinner signal / optic	
<b>5</b>		800411	Wire for spinner motor	



## Cables 6

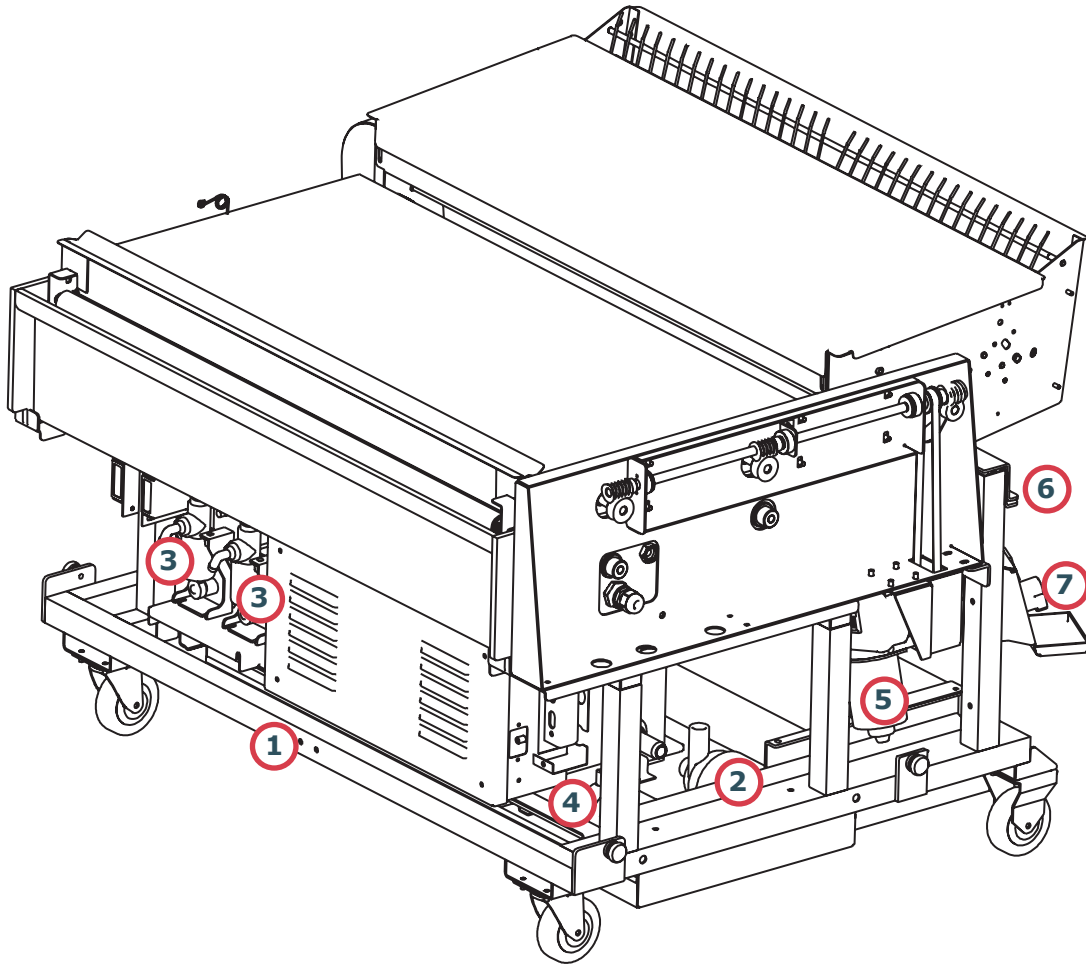
	C	Part number	Description	Notes
<b>1</b>		800407	Wire for DC-supply	
<b>2</b>		800480	Wire for interlocks	
<b>3</b>		800469	RS 232 cable for developer	
<b>4</b>	<b>C</b>	800468	USB2 cable	
<b>5</b>		800409	Wire for power supply in	
<b>6</b>		800410	Wire for main switch	
<b>7</b>		800408	Wire for main supply in	
<b>8</b>		800467	Wire for power connection developer	

## Cables Accessories

## Cables Accessories


	C	Part number	Description	Notes
<b>1</b>		601896	Flat cable clamp-20	
<b>2</b>	<b>C</b>	601898	Blind curly lock-Ø20, BHKL750-4-01	
<b>3</b>	<b>C</b>	601899	Blind curly lock-Ø20, BHKL450-4-01	
<b>4</b>	<b>C</b>	6600250080	RS232 cable, DPX-4 Monitor	

## Processor 1

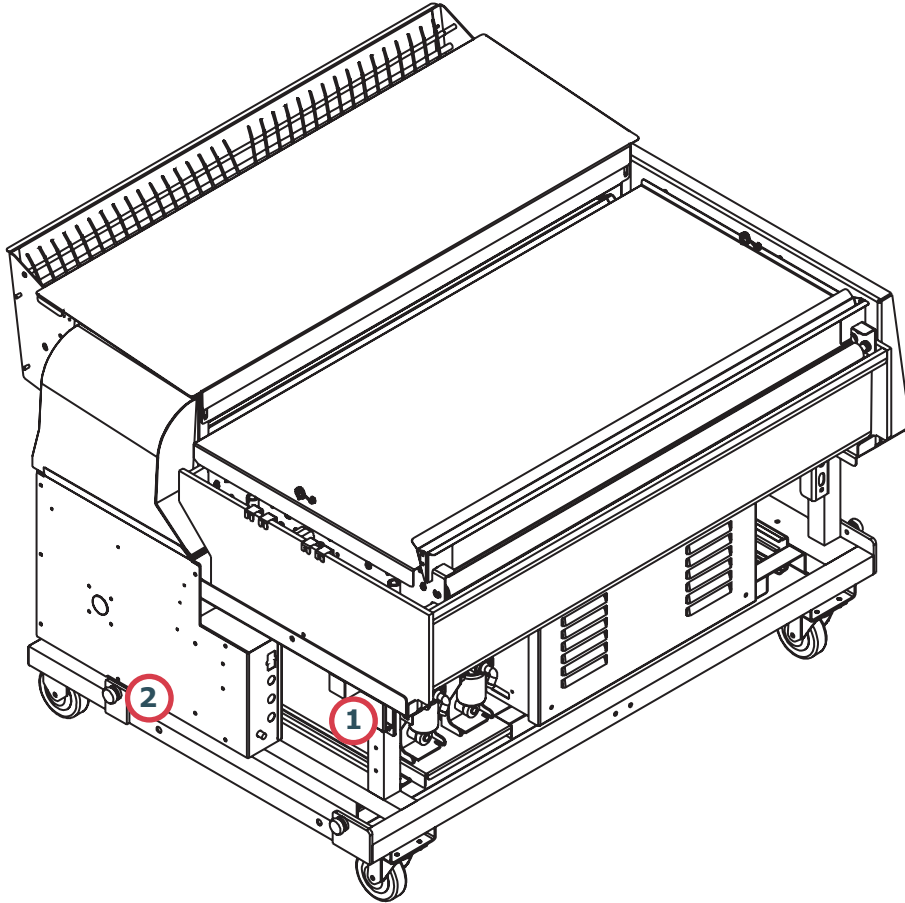




## Processor 1

	C	Part number	Description	Notes
<b>1</b>		601782	Proc. Lock Sugatsune MC-37	
<b>2</b>		300600	Pumpe, waste	changed from 413-137-000
<b>3</b>		400107	Pump, Replenish 	
<b>4</b>		400426	Circulation pump	
<b>5</b>		300718	Main motor 24V w. Encoder	changed from 413-917-000
<b>6</b>		400422	Switch, waste	
<b>7</b>		400424	Snap lock, Female	
<b>7</b>		400425	Snap lock, Male	

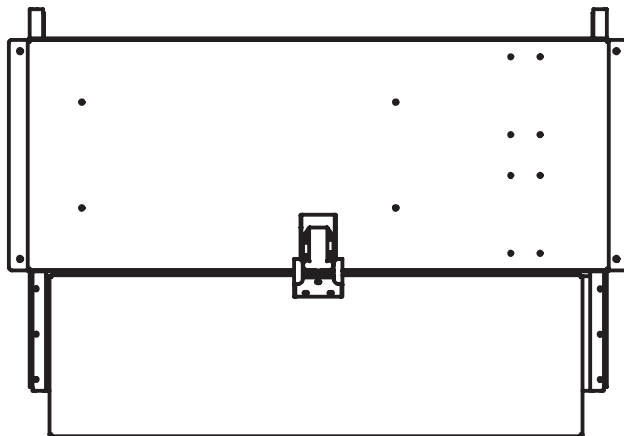
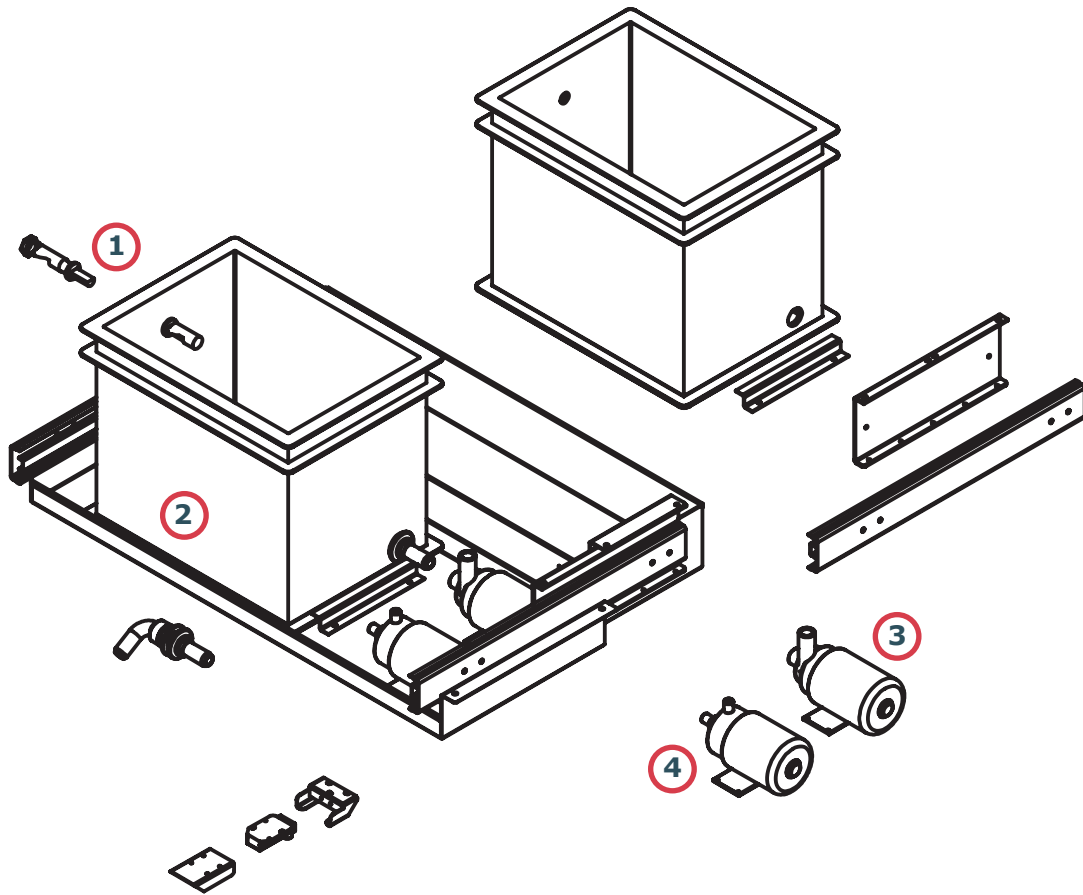
## Processor 2



## Processor 2

	<b>C</b>	<b>Part number</b>	<b>Description</b>	<b>Notes</b>
<b>1</b>		411-145-000	Interlock	
<b>2</b>		500995	Tool f. adj. bearings	

## Processor Waste tank

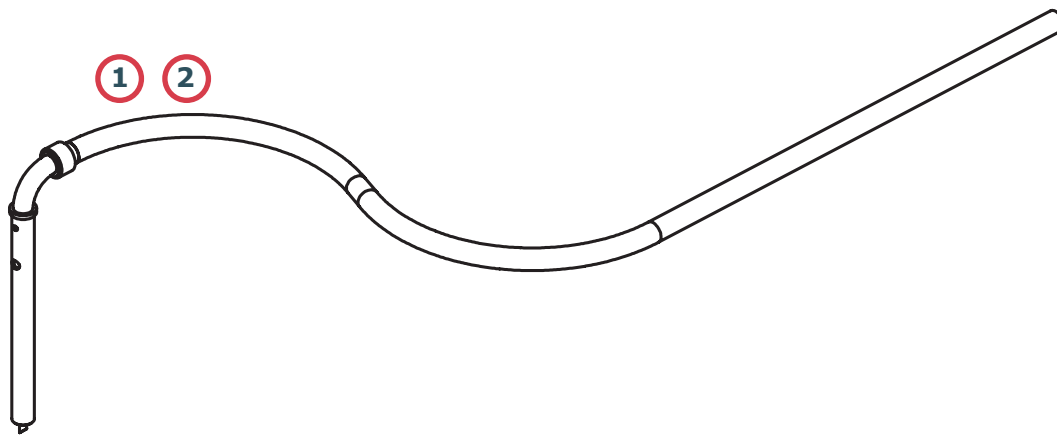


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## Processor Waste tank

	<b>C</b>	<b>Part number</b>	<b>Description</b>	<b>Notes</b>
<b>1</b>		400427	Float switch	
<b>2</b>		500864	Waste box	
<b>3</b>		300600	Pumpe, waste	new part
<b>4</b>		400426	Circulation pump	new part

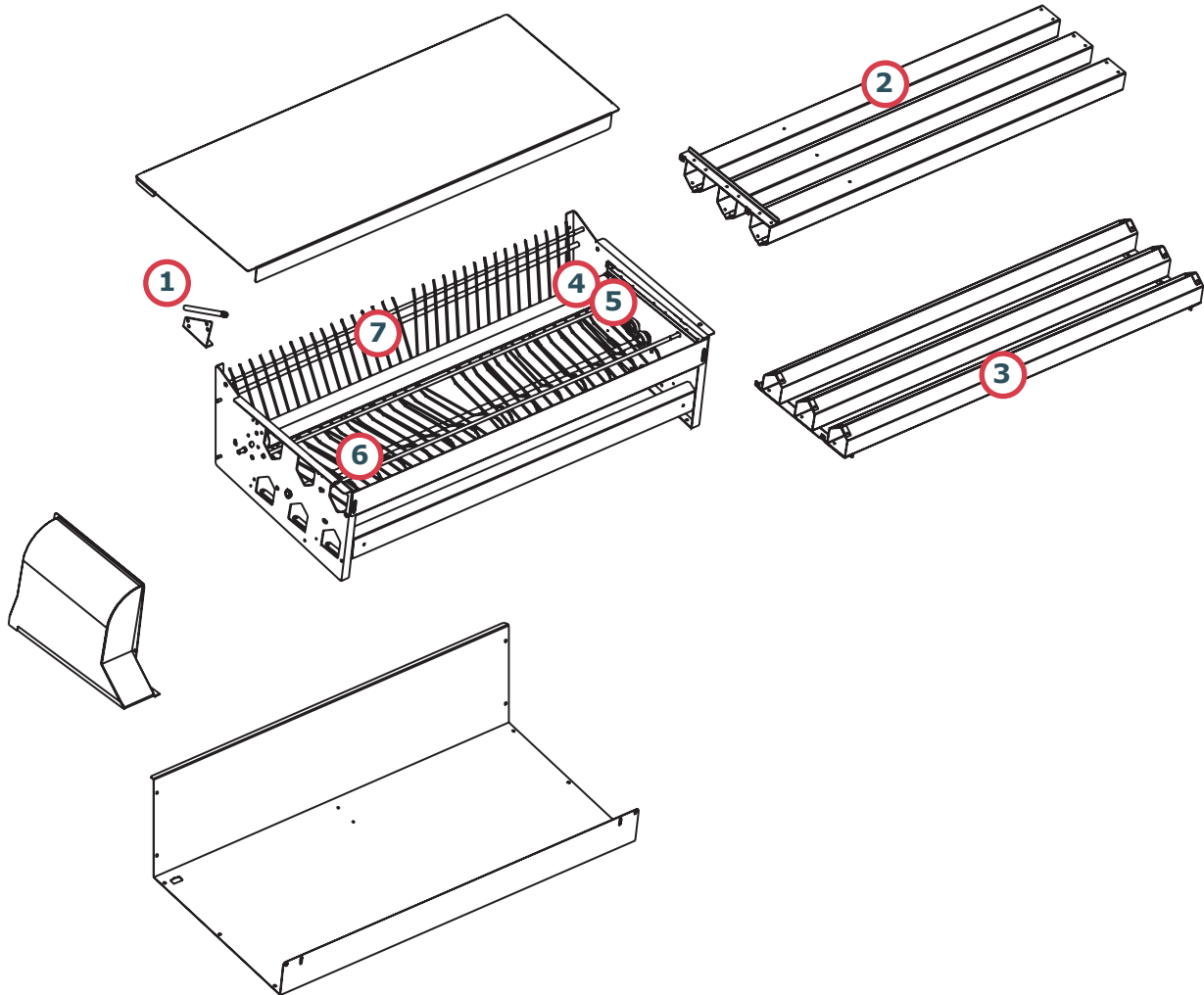
## Replenish Probe



## Replenish Probe

	<b>C</b>	<b>Part number</b>	<b>Description</b>	<b>Notes</b>
<b>1</b>		300317	Replenish probe, activator	
<b>2</b>		300318	Replenish probe, stabilizer	

## Processor Dryer 1

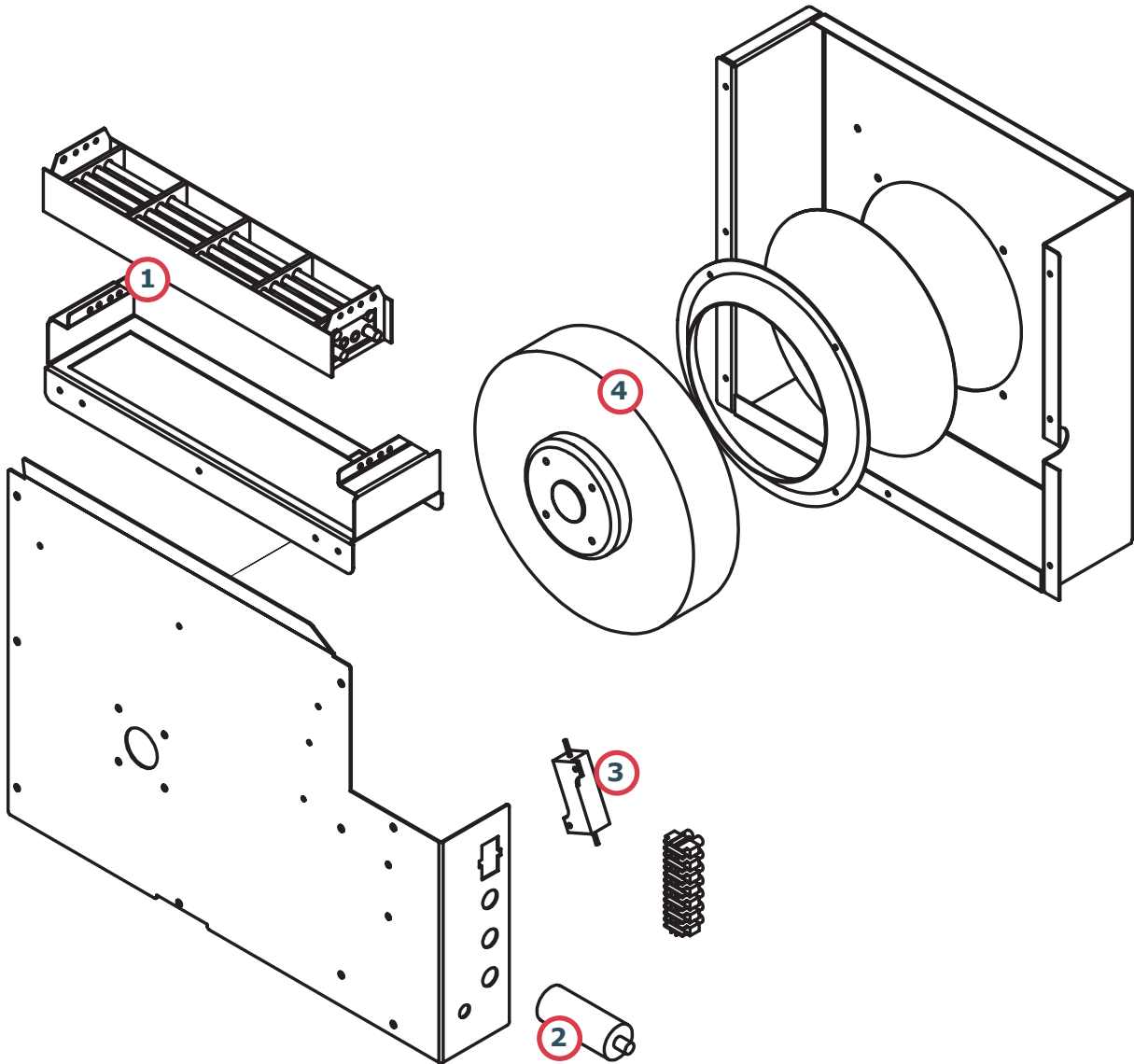




## Processor Dryer 1

	<b>C</b>	<b>Part number</b>	<b>Description</b>	<b>Notes</b>
<b>1</b>		400104	Temperature sensor, Dryer	
<b>2</b>		500051	Air channel, upper	
<b>3</b>		500068	Air channel, lower	
<b>4</b>	<b>C</b>	500987	Molleton roller	
<b>5</b>	<b>C</b>	501286	Teflon roller Ø25	
<b>6</b>		500193	Guide dryer type 1, Lower	
<b>6</b>		500197	Guide dryer type 5, Upper	
<b>7</b>		500194	Guide dryer type 2, Exit	

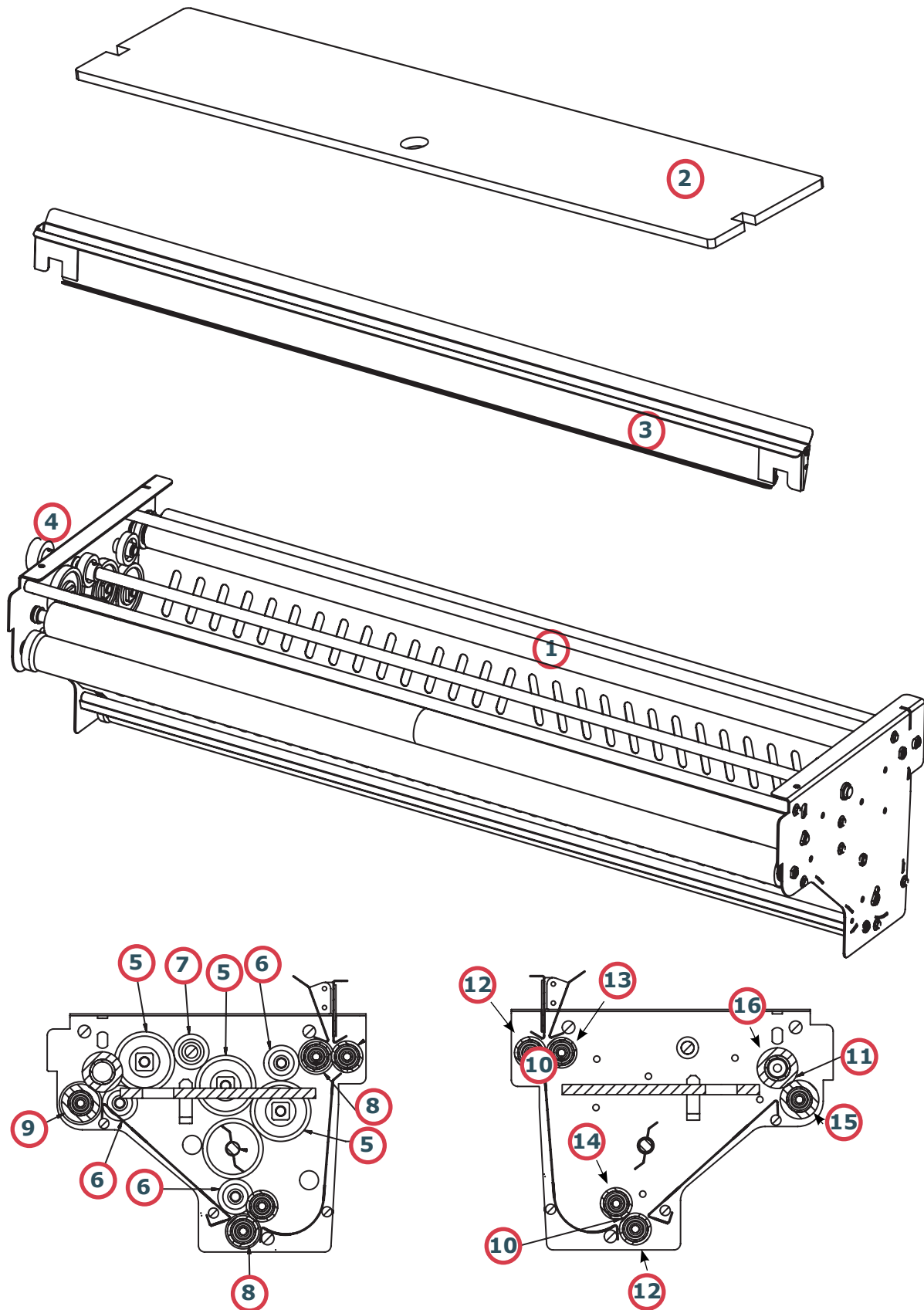
## Processor Dryer 2



## Processor Dryer 2

	<b>C</b>	<b>Part number</b>	<b>Description</b>	<b>Notes</b>
<b>1</b>		400423	Heater, dryer 2000W	
<b>2</b>		400467	Condensator, 2microF	(changed from 4343002001)
<b>3</b>		400170	Resistor 220Ohm,50W	
<b>4</b>		400430	Blower, Ecofit.	

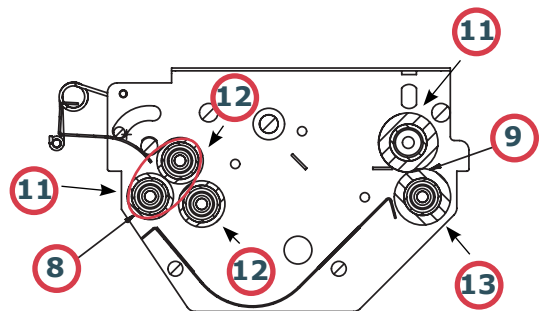
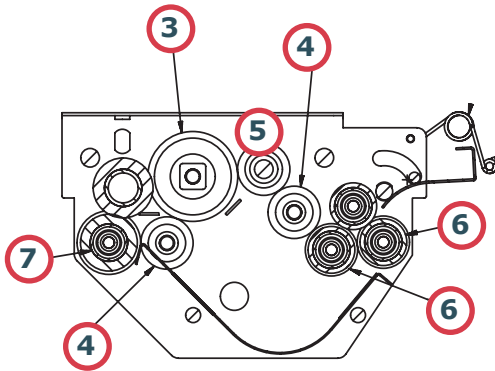
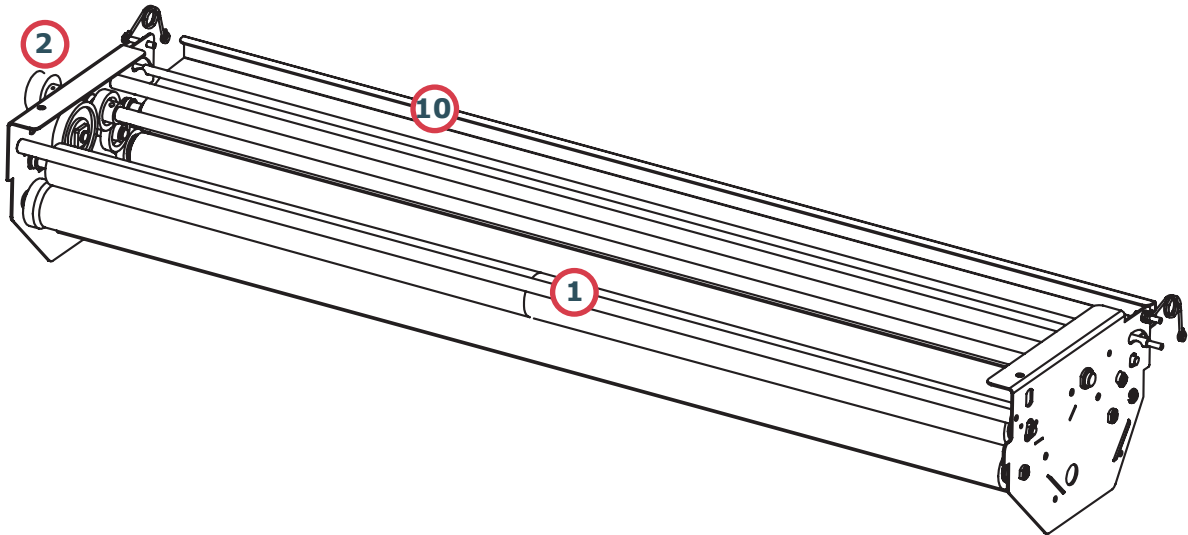
## Processor Activator



## Processor Activator

	C	Part number	Description	Notes
<b>1</b>	C	300637	Rack, Activator	
<b>2</b>		500641	Floating cover, act.	
<b>3</b>		300214	Inlet guide, processor	
<b>4</b>	C	300788	Drive gear, rack.	changed from 030-356-000
<b>5</b>	C	030-137-000	Gear Z48	
<b>6</b>	C	018-037-000	Gear Z28	
<b>7</b>		018-036-000	Gear Z28	
<b>8</b>	C	018-035-000	Gear Z28	
<b>9</b>	C	501334	Gear Z34	
<b>10</b>	C	602338	Spring Ø2.8 x 80	
<b>11</b>	C	602307	Spring ø3.5x0.65x76	changed from 6400432300
<b>12</b>	C	500121	Rubber roller Ø25mm.	
<b>13</b>	C	501542	Roller roller Ø24mm.	
<b>14</b>	C	500452	Roller (pur)Ø25mm.	
<b>15</b>	C	500560	Roller roller Ø30,36mm.	
<b>16</b>	C	501360	Roller roller Ø30,36/32mm.	Bomberet
<b>**</b>		055-222-000	Bushing Ø6,15mm.	Plastic
<b>**</b>		059-988-000	Support spring	

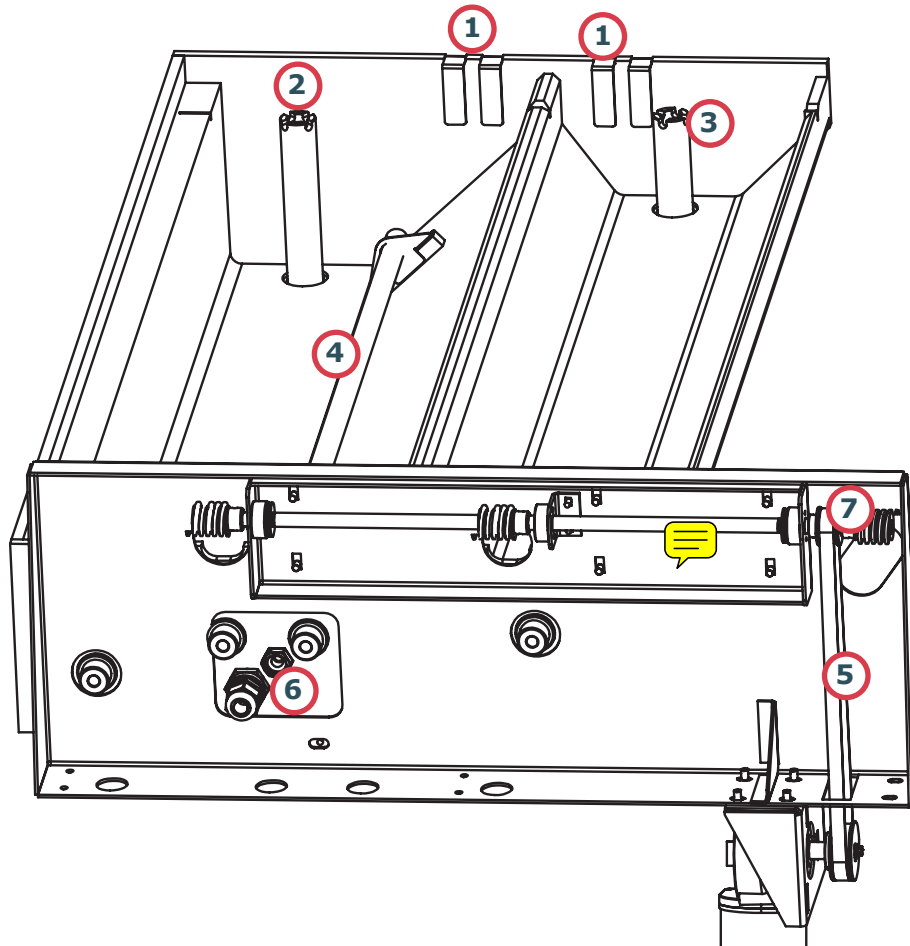
## Processor Stabilizer



## Processor Stabilizer

	C	Part number	Description	Notes
<b>1</b>	C	300638	Rack, Stabilizer	
<b>2</b>	C	300788	Drive gear, rack.	changed from 030-356-000
<b>3</b>	C	030-137-000	Gear Z48	
<b>4</b>	C	018-037-000	Gear Z28	
<b>5</b>	C	018-036-000	Gear Z28	
<b>6</b>	C	018-035-000	Gear Z28	
<b>7</b>	C	501334	Gear Z34	
<b>8</b>	C	602338	Spring Ø2.8 x 80	replaces 9604400160
<b>9</b>	C	602307	Spring Ø3.5x0,65x76	replaces 6400432300
<b>10</b>		500123	Crossover guide	new part
<b>11</b>	C	500121	Rubber roller Ø25	
<b>12</b>	C	500452	roller(pur) Ø25mm	
<b>13</b>	C	500560	Rubber roller Ø30,36	
<b>14</b>	C	501360	Rubber roller Ø30,36/32	Bomberet
**		055-222-000	Bushing Ø6,15	plastic
**		059-988-000	Support spring	

## Processor Tanks

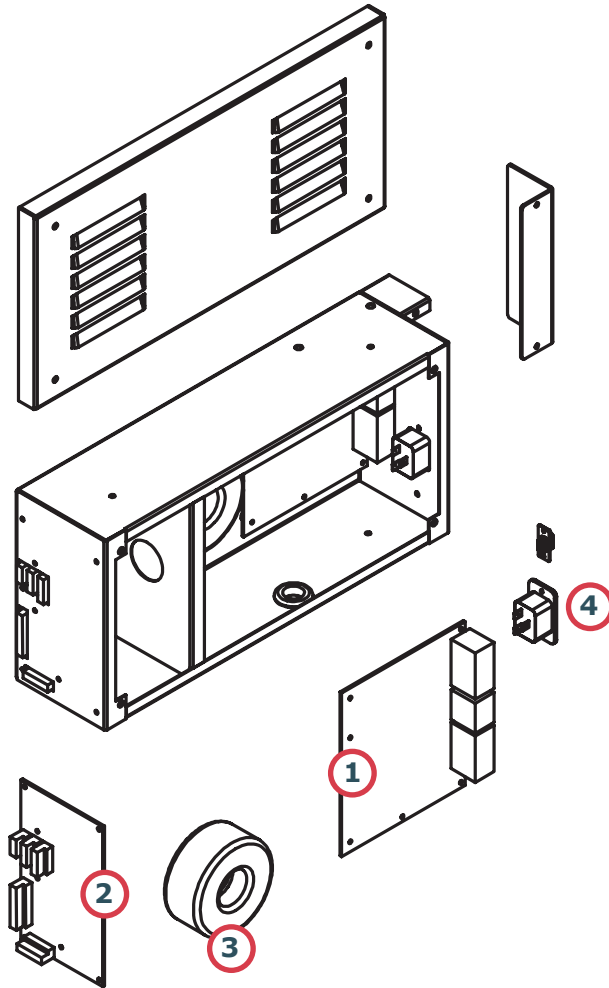




## Processor Tanks

	<b>C</b>	<b>Part number</b>	<b>Description</b>	<b>Notes</b>
<b>1</b>		500503	Sensor, level	
<b>2</b>		501197	Overflow pipe, Blue	
<b>3</b>		501198	Overflow pipe, Black	
<b>4</b>		400144	Heater 750W, activator	
<b>5</b>		601744	Belt T5/10/590	
<b>6</b>		400103	Temperature sensor	
<b>7</b>	<b>C</b>	030-099-000	Worm gear left	M=15
<b>7</b>	<b>C</b>	466-209-000	Pin 2X16	

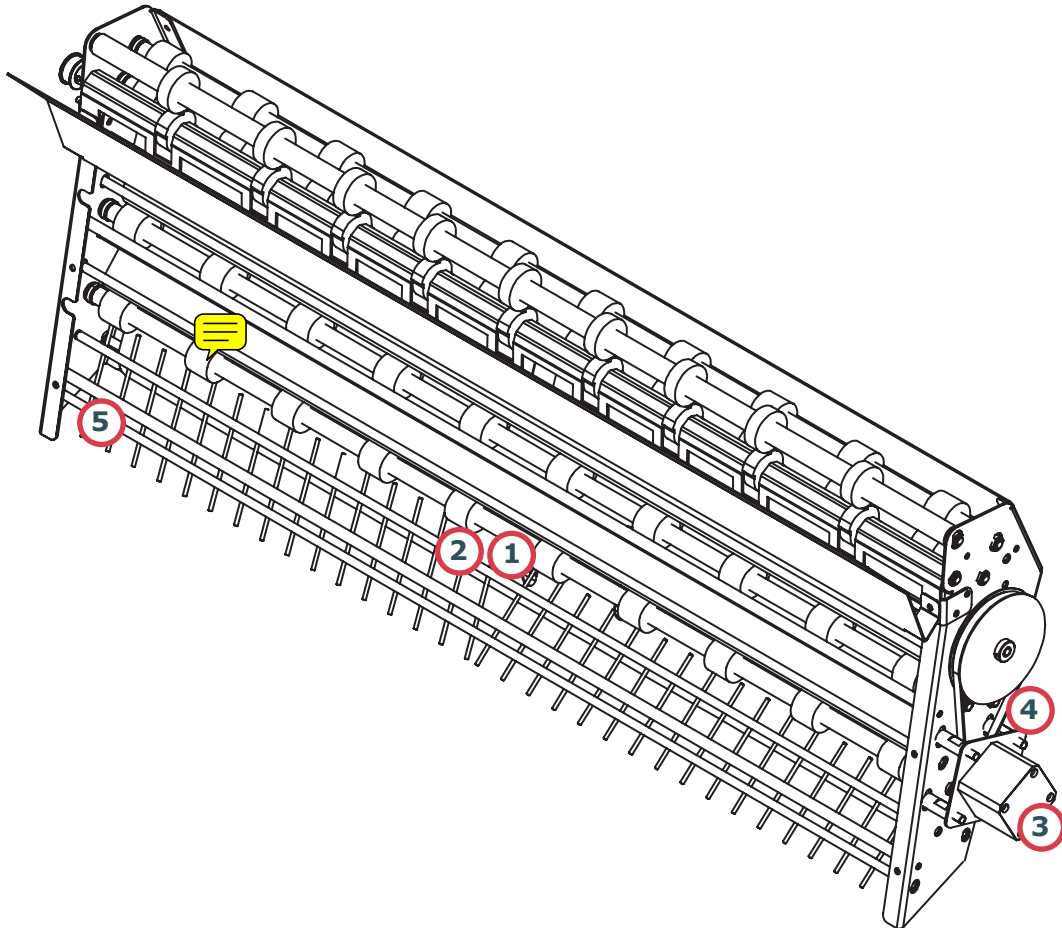
## Processor Electrical



## Processor Electrical

	<b>C</b>	<b>Part number</b>	<b>Description</b>	<b>Notes</b>
<b>1</b>		400101	Power board	
<b>2</b>		400102	Main board	
<b>3</b>		400108	Transformer	
<b>4</b>		400431	Main plug, Proc. AC Inlet	
	<b>C</b>	300786	Set of Fuses,DPX 4 processor	Fuse,T6,3A 5x20 Fuse,T1A 5x20 Fuse,T10A 5x20 Fuse,T50mA,micro fuse Fuse,T500mA,micro fuse Fuse,T800mA,micro fuse

## Processor Conveyor



## Processor Conveyor

	<b>C</b>	<b>Part number</b>	<b>Description</b>	<b>Notes</b>
<b>1</b>		400428	Sensor, Hamlin 59210-020	conveyor control, short arm
<b>2</b>		400429	Sensor, Hamlin 59200-020	exit sensor, long arm
<b>3</b>		9604000200	Motor, conveyor	changed from 6610241600
<b>4</b>		602030	Belt, T2.5-145	
<b>5</b>		500821	Guide, conveyor	
<b>6</b>		300264	conveyer inlet roller	

## Accessories

<b>C</b>	<b>Part number</b>	<b>Description</b>	<b>Notes</b>
	200440	Komori punch	
	300525	Punch-unit Bacher Square	
	300526	Punch-unit Bacher Round	
	200477	Drip tray, blue	
	200476	Drip tray, red	
<b>C</b>	405-128-000	Grease f. Spindle, 10g.	
<b>C</b>	9605500158	Phillips air cleaner	
	300458	Komori punch horizontal	DPX 4, asm.
	300459	Komori punch vertical	DPX 4, asm.

## Recommended Spare Parts

C	Part number	Description	Notes
	300142	Sensor feed system	
	300160	Media encoder	
	300733	Motor, Punch	changed from 300198
	300199	Switch w. Overtravel	
	300317	Replenish probe, activator	
	300318	Replenish probe, stabilizer	
	300524	Knife-punch module	w/o punch motor, punch and vacuum units
	300525	Punch-unit Bacher Square	
	300526	Punch-unit Bacher Round	
	300532	Feed System Input	
	300533	Media shaft complet	
	300534	Feed system, Buffer	
	300535	Drum input system	
	300536	Control board	
	300537	Laser driver	
<b>C</b>	300637	Rack, Activator	
<b>C</b>	300638	Rack, Stabilizer	
	400490	Spinner 62,5 RPM	changed from 400027
	400489	Spinner driver	new part
	400072	Vacuum Fan	
	300084	Media Motor 24V	changed from 400084
	400094	switch, carriage zero	
	400101	Power board	
	400102	Main board	
	400103	Temperature sensor	
	400104	Temperature sensor, Dryer	
	400484	Power Supply, 5/12/24V	changed from 400105
	400107	Pump, Replenish	
	400108	Transformer	
	400137	Motor-, Drum-Input, Knife_Punch	
	400144	Heater 750W, activator	
	400180	switch-,Punch, Knife	
	400423	Heater, dryer 2000W	
	400426	Cirkulations pump	
	400428	Sensor, Hamlin 59210-020	
	400429	Sensor, Hamlin 59200-020	
	400431	Main plug, Proc. AC Inlet	
	500102	Belt lock	

## Recommended Spare Parts cont.

<b>C</b>	<b>Part number</b>	<b>Description</b>	<b>Notes</b>
	6400554000	Cutter blade. Ø42	changed from 501230
<b>C</b>	501334	Gear Z34	
	501343	Laser fiber extension cord 3 meters	
	600035	Belt AT3x16x201	
	600047	Belt AT3x16x150	
	600202	Belt 10AT 5-M	
	601744	Belt T5/10/590	
	601782	Proc. Lock Sugatsune MC-37	
	601893	Gas damper	
	601923	Door lock, Hafele	1 set
	800370	Wire Ribbon 25P	
	800378	Wire Ribbon 9 P	
	800411	Wire for spinner motor	
	800412	Wire for spinner signal / optic	
<b>C</b>	800468	USB2 cable	
	800469	RS 232 cable for developer	
	9604000160	Interlock	changed from 3400081302
	602030	Belt, T2.5-145	
<b>C</b>	602307	Spring Ø3.5x0.65x76	changed from 6400432300
<b>C</b>	6600250080	RS232 cable, DPX-4 Monitor	
	300759	Belt, knife 2.8m.	changed from 6610241600
	9604000200	Motor, feed system	
<b>C</b>	9604400160	Spring Ø2.8 x 80	
	9604500170	Motor, carriage	
<b>C</b>	018-035-000	Gear Z28	
	018-036-000	Gear Z28	
<b>C</b>	018-037-000	Gear Z28	
<b>C</b>	030-137-000	Gear Z48	
<b>C</b>	300788	Drive gear, rack.	changed from 030-356-000
<b>C</b>	405-128-000	Grease f. Spindle, 10g.	
	411-145-000	Interlock	
	300600	Pump, waste	changed from 413-137-000
	413-917-000	Main motor 24V w. Encoder	
	200517	Switch, Iris	new part
	200518	Switch, Filter and focus	new part



<b>C</b>	<b>Partnumber</b>	<b>Description</b>	<b>Notes</b>
<b>C</b>	300786	set of Fuses,DPX 4 processor	Fuse,T6,3A 5x20 Fuse,T1A 5x20 Fuse,T10A 5x20 Fuse,T50mA, microfuse Fuse,T500mA, microfuse Fuse,T800mA, microfuse
<b>C</b>	300787	Sparekit DPX 4 Processor, Proc	Fuse,T6,3A 5x20 Fuse,T1A 5x20 Fuse,T10A 5x20 Fuse,T50mA,microfuse Fuse,T500mA,microfuse Fuse,T800mA,microfuse Drive gear, rack Pin for drive gear Bushing Ø6,15 plastic
<b>C</b>	300601	spacer-kit f processor.	
<b>C</b>	300927	DPX 4 Care Package Kit	4 x 602307 Spring ø3,5x0,65x76, 6 x 602338 Extension spring for roller ø2,85x0,55. 1 x 601923 Door lock, Hafele. 1 x 400180 Switch-, Punch, Knife. 1 x 300142 Sensor feed system. 1 x 405-128-000 Grease, Molykote PG75. 1 x 9605500158 Clean air filter, Philips 1 x 502205 Bracket for mini latch 4 x 600329 Screw Hex SocH M3x16 A4 DIN912 2 x 6001202241M2x12 unbrako 2 x 6022200002 washer Ø2

NOTES

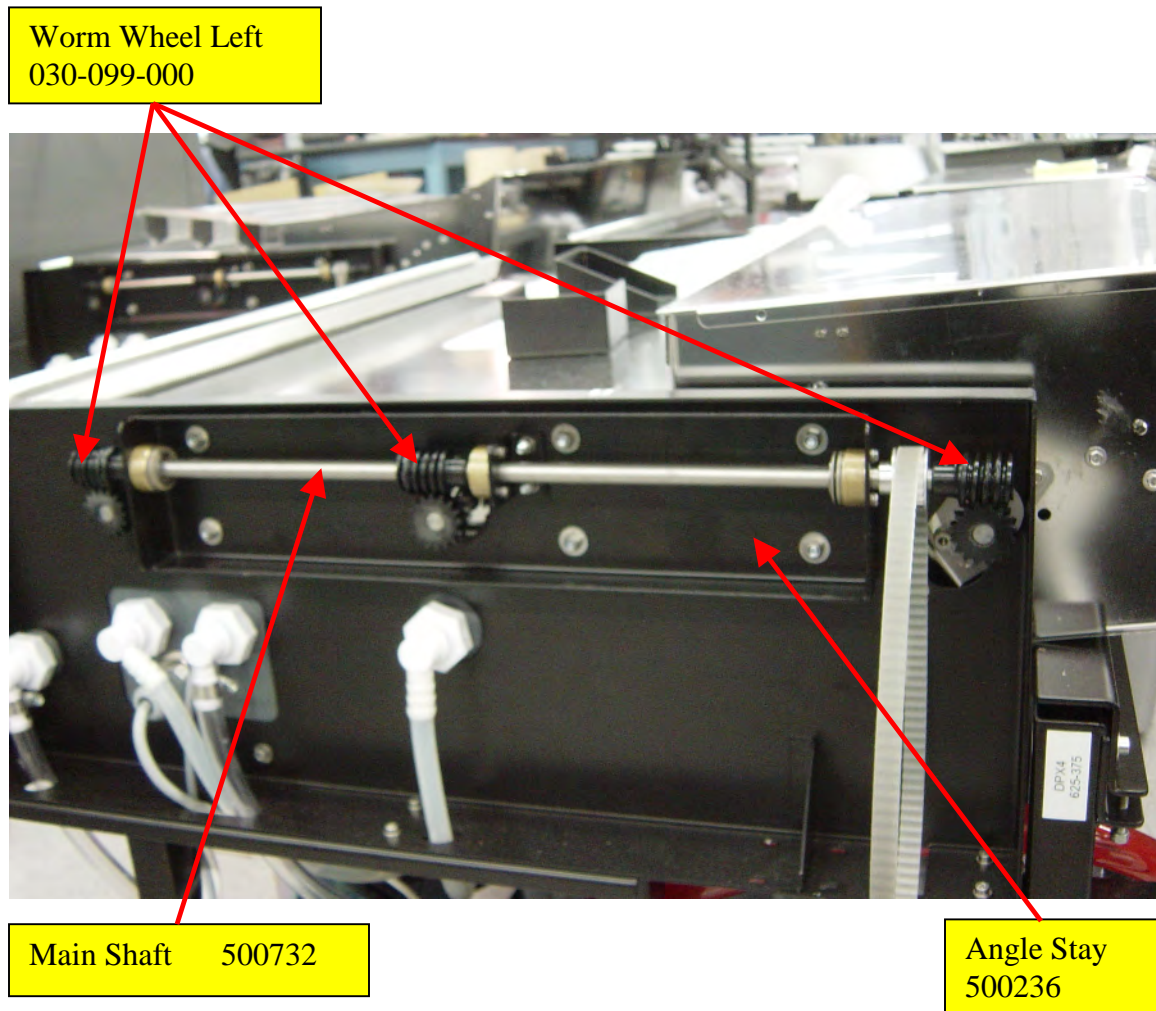
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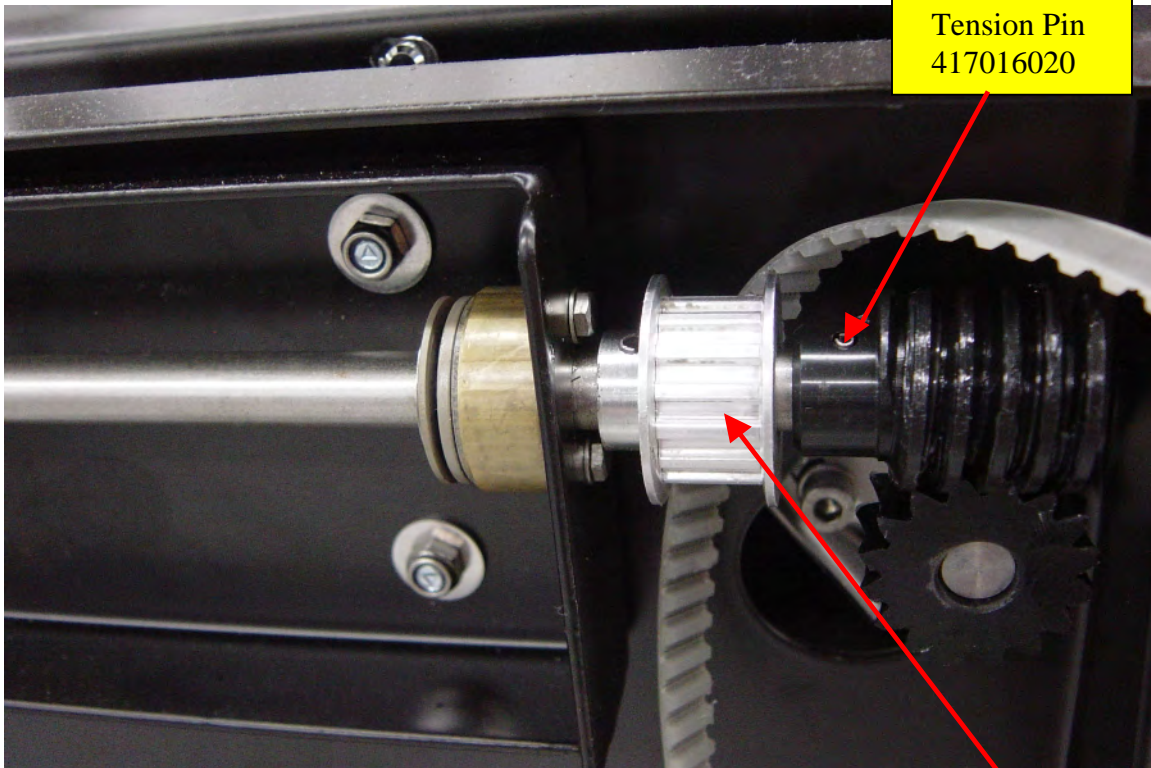
DPX 4 Plate Processor Drive Shaft

The whole drive assembly is called Worm Bracket Assembly, part number 300277

Consists of:

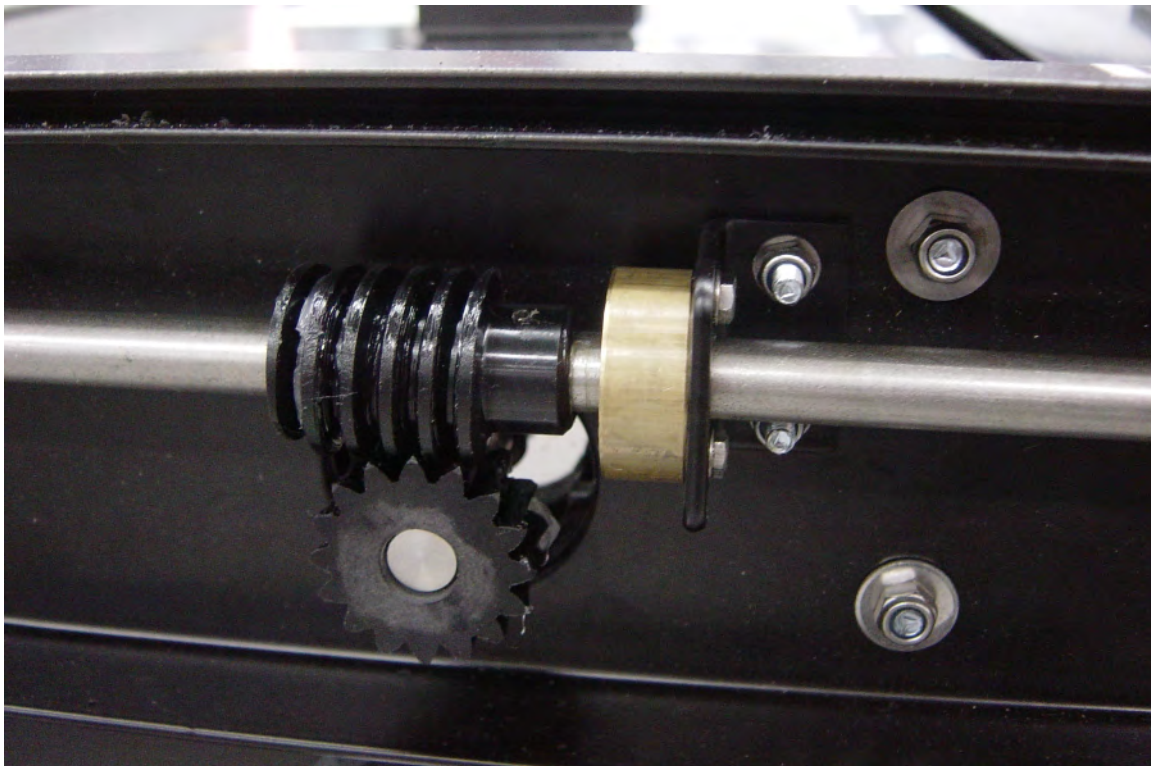
Worm Wheel Left	030-099-000	3 pieces
Bearing Block	057-139-000	3 pieces
Bearing Needle Axial	451-015-000	2 pieces
Plate Bearing Axial	451-016-000	4 pieces
Bearing Needle Radial	451-021-000	3 pieces
Angle Stay	500236	1 piece
Worm Bracket	500731	1 piece
Main Shaft	500732	1 piece
Toothed Wheel	500869	1 piece
Tension Pin	417016020	3 pieces

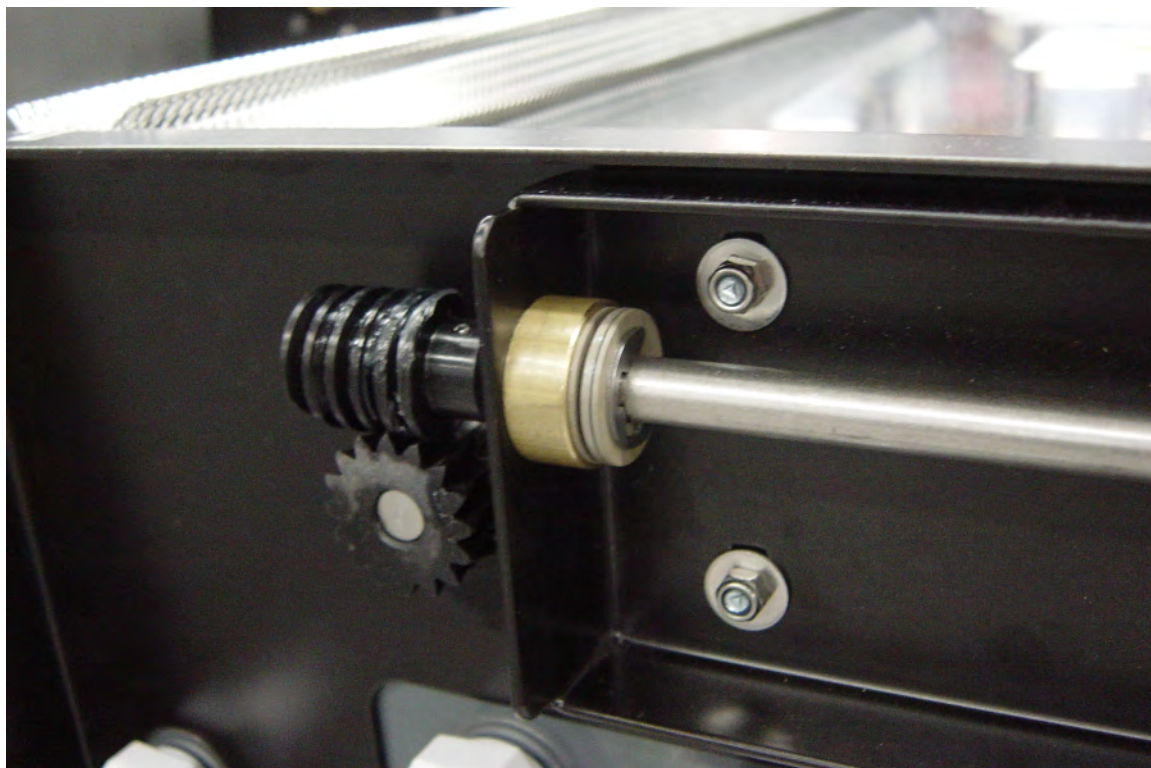




Tension Pin  
417016020

Toothed Wheel  
500869





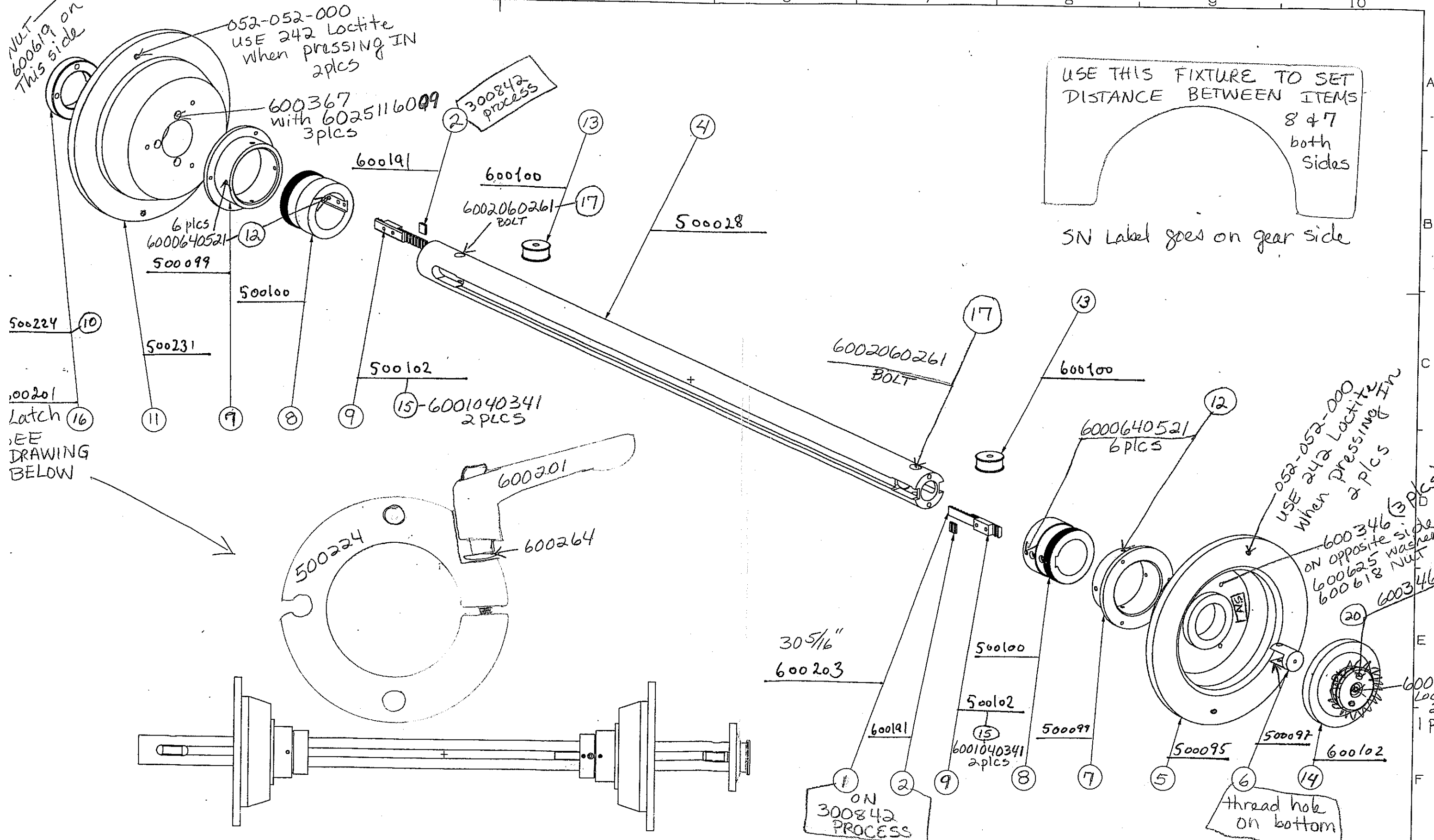
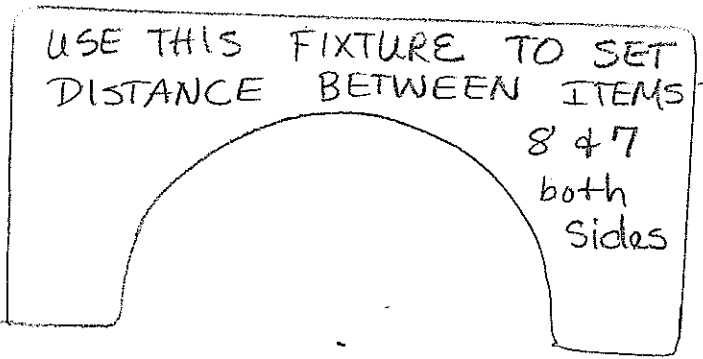
(23) DO NOT COMPLETELY TIGHTEN

NUT 600619 on this side

052-052-000 USE 242 Loctite when pressing IN 2 ples

600367 with 6025116099 3 ples

300842 process



500224 (10)

500231 (11)

500100 (12)

500102 (15)

6001040341 2 ples (15)

6002060261 BOLT (17)

600100 (13)

6000640521 6 ples (12)

052-052-000 USE 242 Loctite when pressing IN 2 ples

600346 (3 ples) ON opposite side 600625 washer 600618 Nut

600346-2 ples

600345 Loctite 242 1 plic

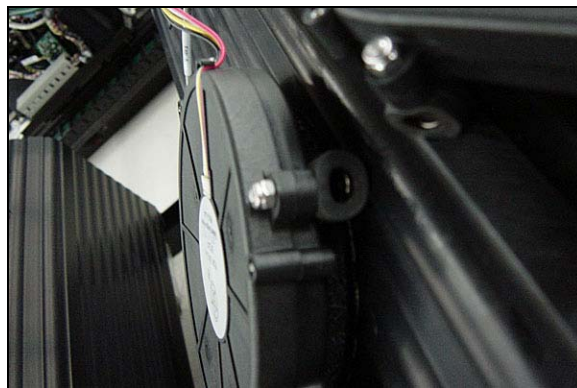
30 5/16" 600203

ON 300842 PROCESS

thread hole on bottom

ECO NO.	REV. DESCRIPTION	300017	
MATERIAL:		DIMENSIONS WITHOUT TOLERANCES:	EDGES NOT INDICATED:
SURFACE TREATMENT:		DS/EN 22768-mk	DS2159 -0.1/-0.3

## DPX 4 Drum fans and mounting hardware



Install five(5) Fans (400072) to the Drum as follows:

- a.) Remove the protective backing from Foam Seal (602286) and install around the fan holes. Press down to conform to the Drum profile. Repeat five(5) times.
- b.) Install three(3) Vibration Damper Rings (602262) around each fan hole using M4x14 Flat Hd Screws (600552) and Loctite 222 (HB0750). Do not over-tighten.
- c.) Insert a M4x20 Flat Hd Screw (600555) into each of the Vibration Rings (step b).
- d.) Place each Fan, oriented as shown, onto the three(3) Vibration Ring Screws (step c) and secure with M4 Hex Nuts (600604), M4 Rip-lock Washers (6024009102), and Loctite 222 (HB0750).

Note: Do not over tighten. Leave only one(1) thread exposed.