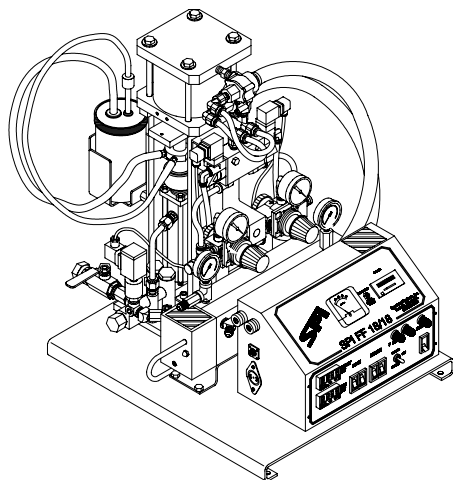
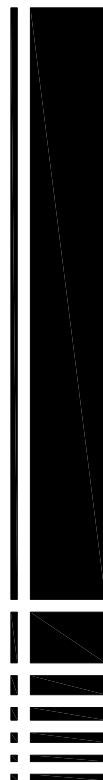
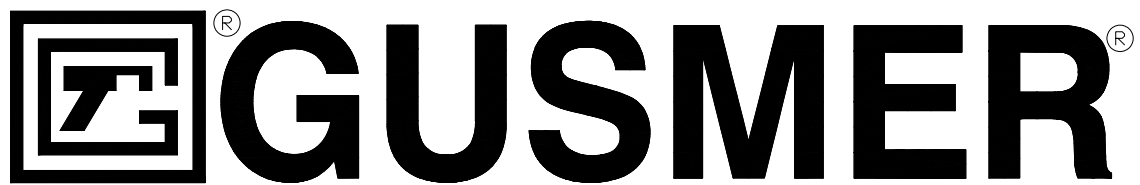




Model SPI FF 18/18 Proportioning Unit

Parts Identification Manual 17942-SPI-ID

February 1, 2005

Issue 7

GUSMER CORPORATION®

One Gusmer Drive
Lakewood, New Jersey, USA 08701-8055

Toll Free 1-800-367-4767 (USA & Canada)

Phone: (732) 370-9000

Fax: (732) 905-8968

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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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To ensure proper validation of your warranty, please complete the warranty card and return it to Gusmer within two weeks of receipt of equipment.

Revised 09/02

ASSEMBLIES

SPI FF 18/18 FINAL ASSEMBLY

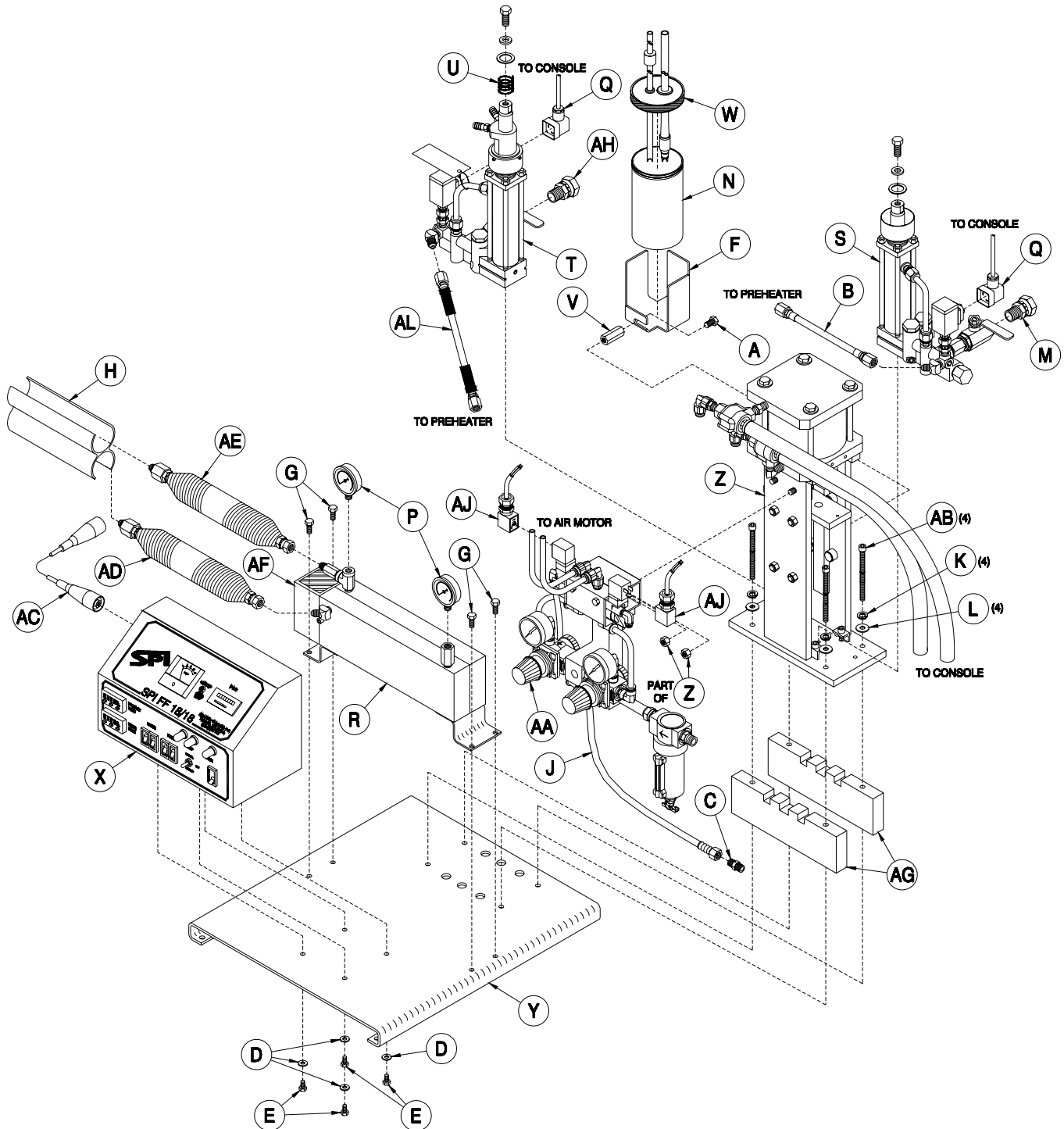


Figure 1. SPI FF 18/18 Assembly (Part No. 17000A-1-SPI), Exploded View

TABLE 1. SPI FF 18/18 ASSEMBLY (PART NO. 17000A-1-SPI), PARTS

Reference Letter	Part Number	Description	Quantity
A	0203-28	Hex Head Cap Screw	1
B	0372	Resin Pump-Heater Hose	1
C	0561	Hex Nipple	1
D	0562-11-3	Flat Washer	4
E	0760-3	Hex Head Cap Screw	4
F	1486A	Lube Reservoir Bracket	1
G	1701-4	Hex Head Cap Screw	4
H	5204	Electrical Isolator	1
J	5270A-4	Air Hose Assembly	1
K	5504-3	Helical Lockwasher	4
L	5829-7	Flat Washer	4
M	10420	Swivel Union	1
N	15586	Lube Bottle	1
P	17001	0-3000 PSI Gauge	2
Q	6690-16-76-2	DIN Connector	2
R	17360	LV Primary Heater Assembly	1
S	17400-60-SPI	Resin Proportioning Pump Assembly	1
T	17450-60-SPI	Iso Proportioning Pump Assembly	1
U	17482	Spring	1
V	17483	Coupling Hex Nut	1
W	17585	Lube Reservoir Hose Assembly	1
X	17650A-220-SPI	SPI 1818 Electric Console	1
Y	17750	Machine Base	1
Z	17755-SPI	Air Motor SPI	1
AA	17756	Air Control System	1
AB	20077-20-1	Socket Head Cap Screw	4
AC	20207-3	TSU Extension Adapter	1
AD	56273	R - Isolation Hose	1
AE	56274	A - Isolation Hose	1
AF	56355	Heater Electrical Box	1
AG	57754	Air Motor Standoff	2
AH	OP179-6	Swivel Union	1
AJ	8680-3-3	DIN Connector	2
AK	17358	Insulator Blanket (Not Shown)	1
AL	17372	Iso Pump-Heater Hose	1

ELECTRIC CONSOLE

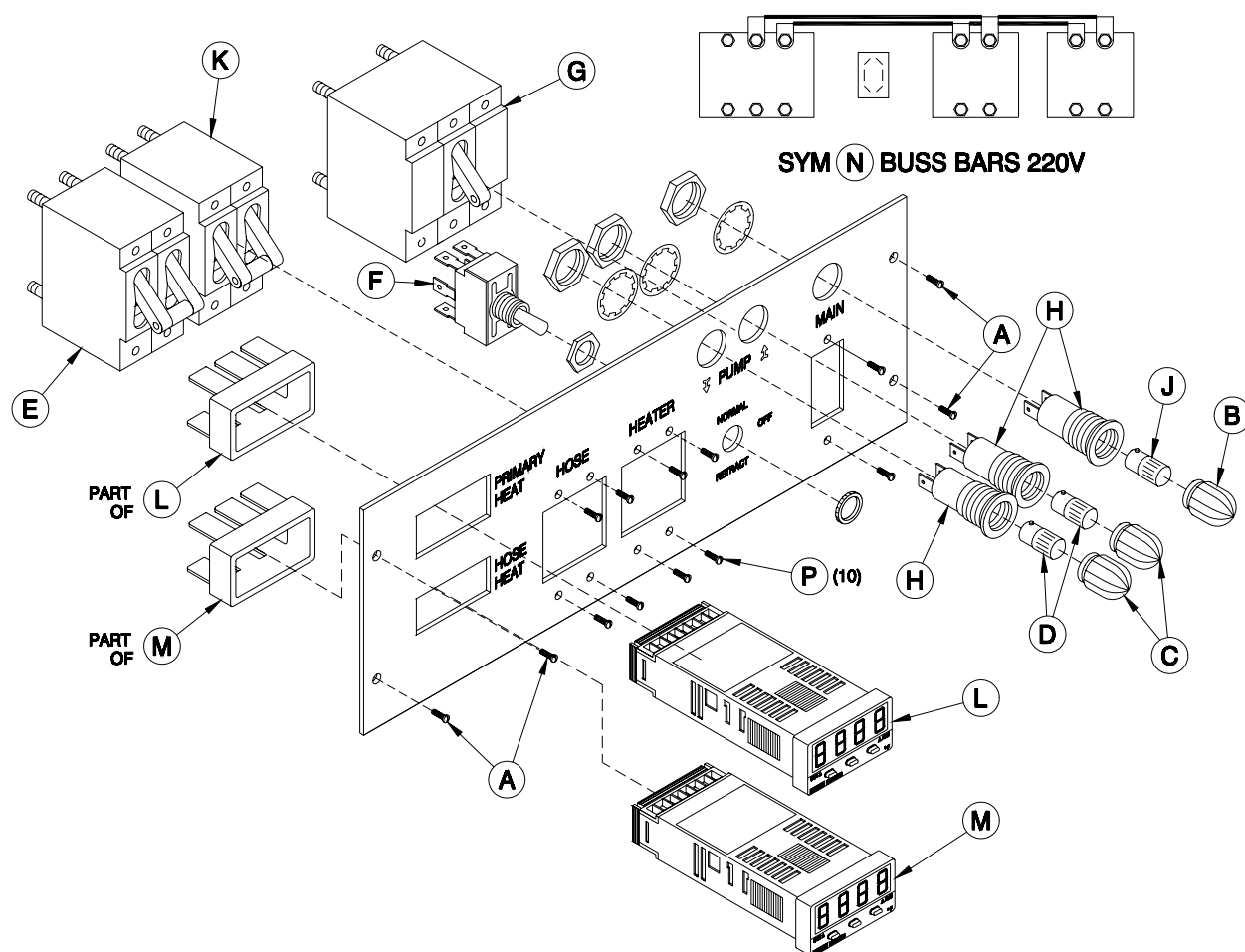


Figure 2. Electric Console (Part No. 17650A-220-SPI), Exploded View, Sheet 1 of 3

TABLE 2. ELECTRIC CONSOLE (PART NO. 17650A-220-SPI), PARTS, SHEET 1 OF 3

Reference Letter	Part Number	Description	Quantity
A	0368	Binder Head Machine Screw	4
B	0656	White Lens	1
C	0660	Amber Lens	2
D	0662A	Incandescent Bulb	2
E	0692-1-25	25 Amp Circuit Breaker	1
F	6690-16-6	Toggle Switch	1
G	6690-16-10	Switch	1
H	6690-19-25	Light Base	3
J	6690-19-24	Bulb	1
K	6690-25-31	40 Amp Circuit Breaker	1
L	6690-26-23	Primary Heater Temperature Controller	1
M	6690-26-24	Hose Heat Temperature Controller	1
N	17650-5	Buss Bar (220V)	1
P	0205-1	Binder Head Machine Screw	10

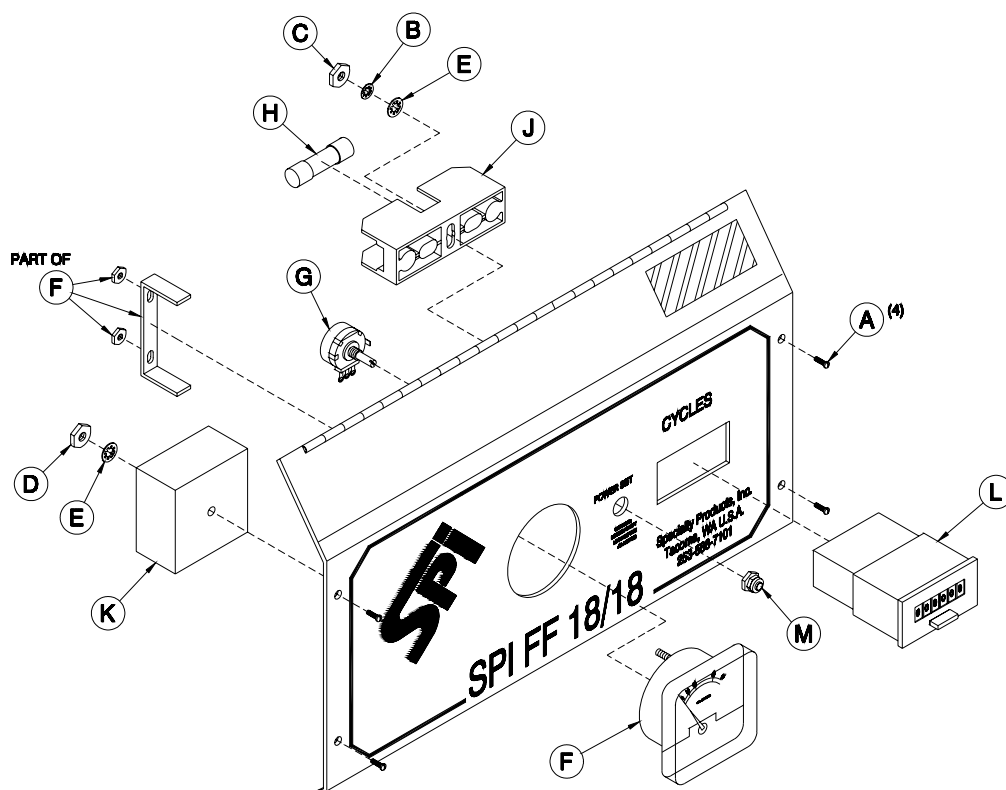


Figure 3. Electric Console (Part No. 17650A-220-SPI), Exploded View, Sheet 2 of 3

TABLE 3. ELECTRIC CONSOLE (PART NO. 17650A-220-SPI), PARTS, SHEET 2 OF 3

Reference Letter	Part Number	Description	Quantity
A	0368	Binder Head Machine Screw	4
B	0651A-10	Internal Lockwasher	1
C	0668-3-1	Hex Nut	1
D	1701-15-9	Hex Nut	1
E	4702-7-4	Internal Lockwasher	2
F	5616-Kit	Ammeter	1
G	6690-5-17	Potentiometer	1
H	6690-24-1	Fuse	1
J	6690-24-2	Fuse Block	1
K	6690-26-18	Phase Control	1
L	9651-6-2	Counter	1
M	9651-6-5	Shaft Lock	1

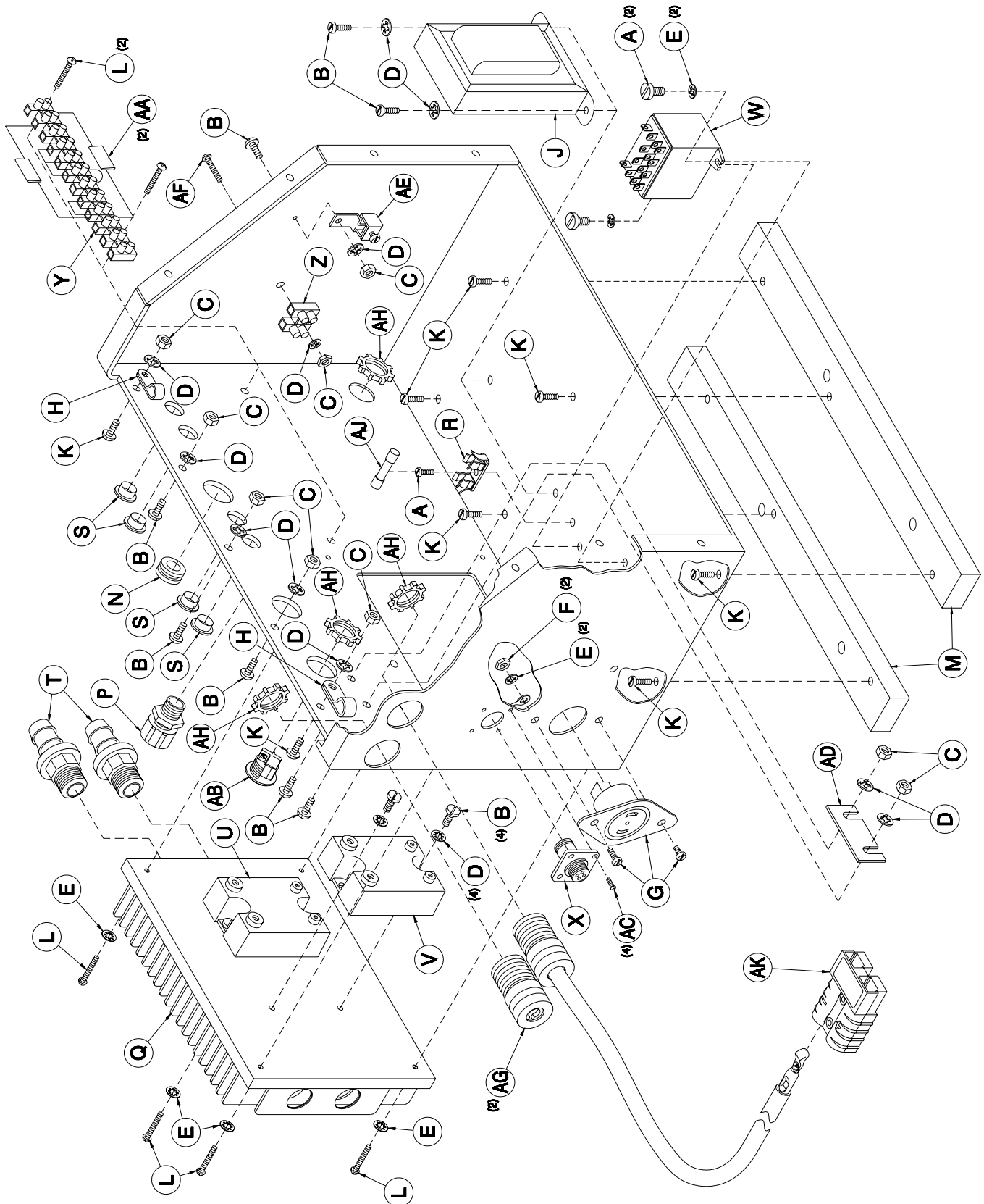


Figure 4. Electric Console (Part No. 17650A-220-SPI), Exploded View, Sheet 3 of 3

TABLE 4. ELECTRIC CONSOLE (PART NO. 17650A-220-SPI), PARTS, SHEET 3 OF 3

Reference Letter	Part Number	Description	Quantity
A	0368	Binder Head Machine Screw	3
B	0651A-8	Pan Head Machine Screw	12
C	0651A-9	Hex Nut	9
D	0651A-10	Internal Lockwasher	15
E	0655-4	Lockwasher	8
F	0668-3	Hex Nut	2
G	0670A-1-1	Socket	1
H	0681A	Cable Clamp	2
J	0689-1	Transformer	1
K	0689-2	Pan Head Machine Screw	8
L	0698-3	Pan Head Machine Screw	6
M	0760A-1	Console Mounting Bar	2
N	1701-16	Grommet	1
P	17650-1	Strain Relief	1
Q	17708	Heat Sink	1
R	5653B	Fuse Holder	1
S	5703D-10	Bushing	4
T	6310-27	Hose Fitting	2
U	6690-1-55-1	Solid State Relay 480/50 AM	1
V	6690-1-46	Solid State Relay 480/90 Amp	1
W	6690-1-14	Relay 10 Amp	1
X	6690-13-2-11-4	4 CKT MA Pin Housing	1
Y	6690-20-1-12	Terminal Block	1
Z	6690-20-5-2	Terminal Block	1
AA	6690-21-3	Quencharc	2
AB	6690-31-1-1	Thermocouple Socket	1
AC	9651-4	Pan Head Machine Screw	4
AD	14667	Jumper	1
AE	17650-2	Wire Lug	1
AF	60302	Round Head Machine Screw	1
AG	OP482-17-1	Bushing	2
AH	OP482-17-2	Locknut	4
AJ	OP5193-3-3	1 Amp Fuse	1
AK	0684-2	Power-Lock™ Connector Housing	1

AIR MOTOR

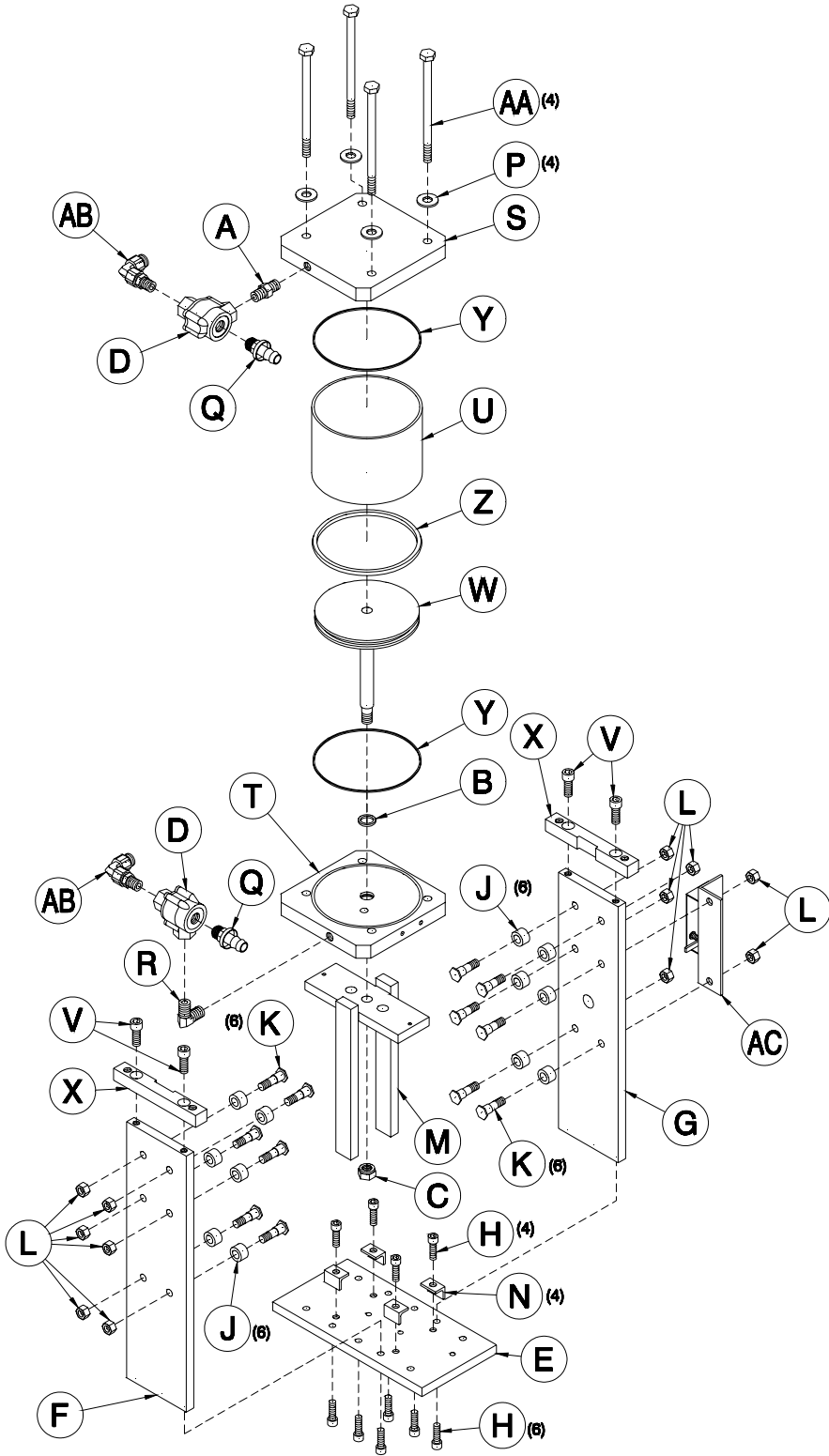


Figure 5. Air Motor (Part No. 17755-SPI), Exploded View

TABLE 5. AIR MOTOR (PART NO. 17755-SPI), PARTS

Reference Letter	Part Number	Description	Quantity
A	0466A	Hex Nipple	1
B	0551	O-Ring	1
C	0557	Piston Rod Nut	1
D	0562-12	Exhaust Valve	2
E	0751	Proportioner Base	1
F	0752	Air Cylinder Upright	1
G	0753	Air Cylinder Upright-Switch Side	1
H	0754	Socket Head Cap Screw	10
J	0755-1	Bearings	12
K	0755-2	Cam Roller Stud	12
L	0756	Hex Nut	12
M	0757A	Pump Yoke	1
N	0765	Pump Mounting Bracket	4
P	1516A-3	Washer	4
Q	6310-27	Hose Barb	2
R	14501-20	Elbow	1
S	17745-1	Air Cylinder Top Plate	1
T	17745-2	Air Cylinder Bottom Plate	1
U	17745-3	Air Cylinder	1
V	17745-4	Socket Head Cap Screw	4
W	17745-5	Air Piston W/Rod	1
X	17745-6	Air Cylinder Adapter	2
Y	17745-7	O-Ring	2
Z	17745-8	O-Ring	1
AA	17745-9	Hex Head Cap Screw	4
AB	20042	Tube Fitting	2
AC	25745-10	Reversing Switch Assembly	1
Not Shown	6310-26	Air Hose	A/R

Air Cylinder Rebuild Kit (Part # 17745-3-1)- Includes B, Z, AA, & Air Cylinder Lubricant (Part No. 553-2) Order as required from SPI.

Exhaust Valve Repair Kit (Part No. 0562-12-1-D) Order as required from SPI.

REVERSING SWITCH

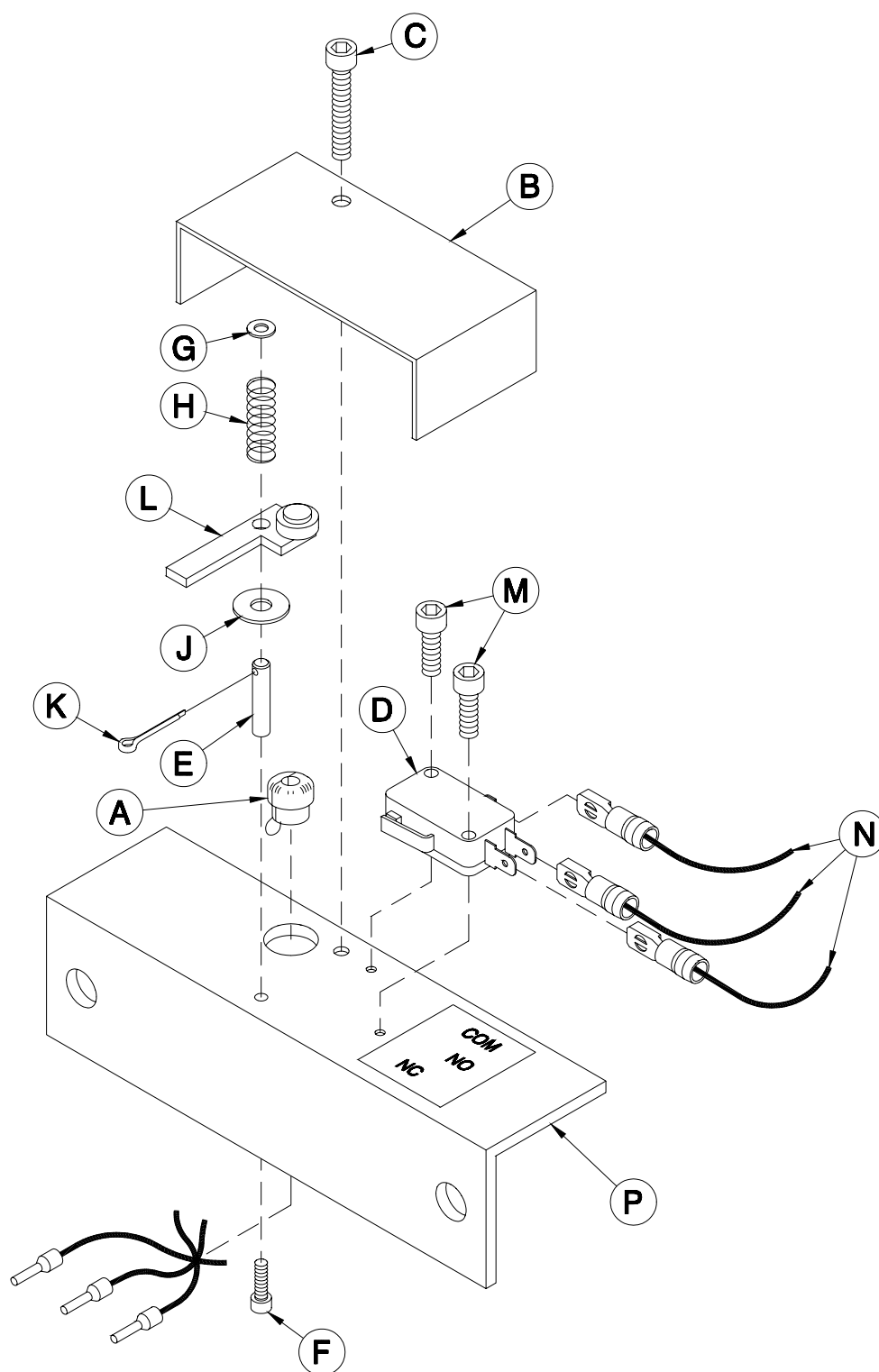


Figure 6. Reversing Switch (Part No. 25745-10), Exploded View

TABLE 6. REVERSING SWITCH (PART NO. 25745-10), PARTS

Reference Letter	Part Number	Description	Quantity
A	0364	Bushing	1
B	0577B-1	Reversing Switch Bracket (Includes N, F, & G)	1
C	0577-2	Reversing Switch Cover Box	1
D	0577-3	Socket Head Cap Screw	1
E	0578A	Reversing Switch	1
F	0579-2	Pivot Arm	1
G	0579-3	Socket Head Cap Screw	1
H	0579-4	Flat Washer	1
J	0579-5	Spring	1
K	0579-6	Fiber Washer	1
L	0579-7	Cotter Pin	1
M	0579A-1	Reversing Switch Lever	1
N	9577-10	Socket Head Cap Screw	2

AIR CONTROL SYSTEM

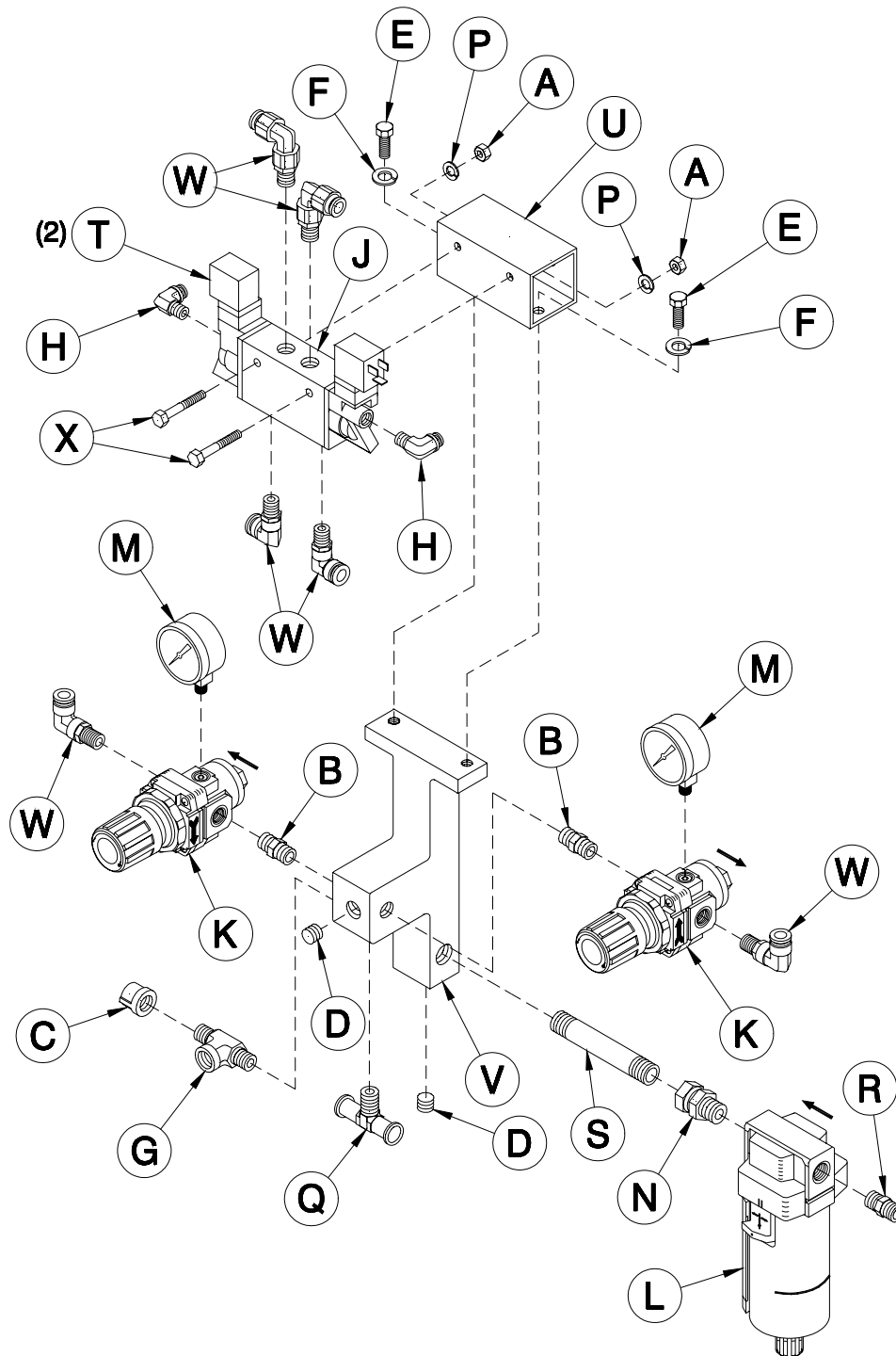


Figure 7. Air Control System (Part No. 17756), Exploded View

TABLE 7. AIR CONTROL SYSTEM (PART NO. 17756), PARTS

Reference Letter	Part Number	Description	Quantity
A	0385-4	Hex Nut	2
B	0561	Hex Nipple	2
C	0575	Pipe Cap	1
D	0576	Pipe Plug	2
E	1701-4	Hex Head Cap Screw	2
F	5504-3	Helical Lock Washer	2
G	6304-21	Branch Tee	1
H	6306-3	Tube Fitting	2
J	6311-109	Valve (Includes 17756-2-24)	1
K	6311-124	Regulator	2
L	6312-26	Air Filter	1
M	6314	Gauge	2
N	9457	Swivel Union	1
P	9758	Lockwasher	2
Q	17746-5	Pipe Tee	1
R	17746-7	Hex Nipple	1
S	17746-12	Pipe Nipple	1
T	17756-2-24	Coil	2
U	17756-4	Mounting Bracket	1
V	17756-7	Air Manifold	1
W	20042	Tube Fitting	6
X	IP1119	Hex Head Cap Screw	2
Not Shown	8680-3-2	Din Connector	2

Spool Replacement Kit (Part No. 17756-2-1)- Order as required from SPI.

Seal Kit (Part No. 17756-2-3)- Order as required from SPI.

Valve Modification/Rebuild Kit (Part No. 6311-109-1)- Two required per valve assembly. Spool Assembly not included. Order as required from SPI.

PRIMARY HEATER

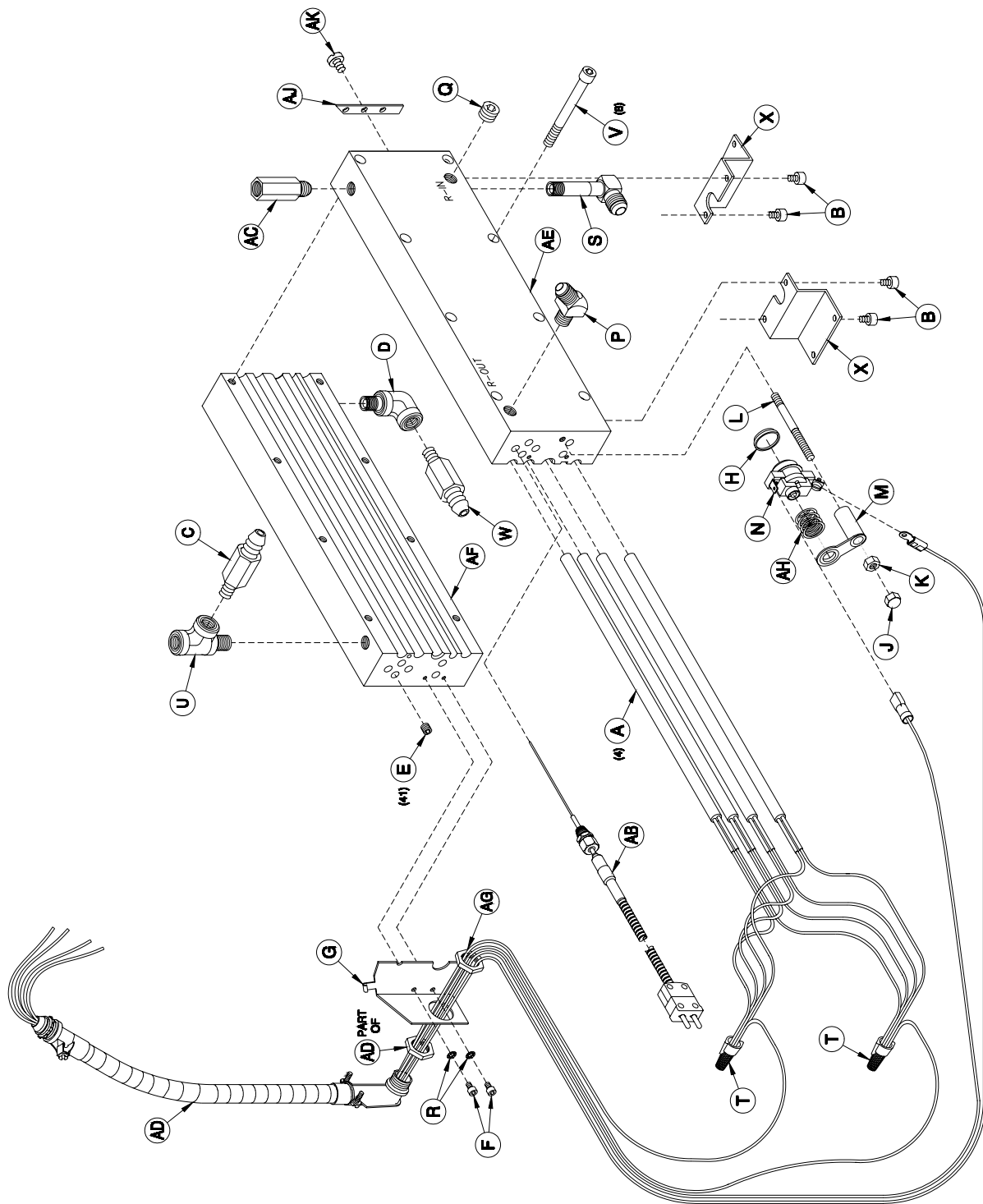


Figure 8. Primary Heater (Part No. 17360), Exploded View

TABLE 8. PRIMARY HEATER (PART NO. 17360), PARTS

Reference Letter	Part Number	Description	Quantity
A	0361-1500-220	Heating Element-220V	4
B	0371	Socket Head Cap Screw	4
C	0375C-3	Hose Nipple	1
D	0375B-2	Street Elbow	1
E	0377	Pipe Plug	41
F	0379-2	Socket Head Cap Screw	2
G	56379-1	Thermostat Mounting Bracket	1
H	0385-6	Heat Transfer Plate	1
J	0385-5	Acorn Nut	1
K	0385-4	Hex Nut	1
L	0385-3	Threaded Stud	1
M	17385-2	Mounting Bracket	1
N	6690-7-29	Thermal Limit Switch	1
P	0465	Hose Elbow	1
Q	0576	Pipe Plug	1
R	0651A-10	Lockwasher	2
S	1323	Long Male Elbow	1
T	1650-14	Wire Pig Tail	2
U	6465	Pipe Tee	1
V	9463	Socket Head Cap Screw	8
W	10350-1	Extended Hose Nipple	1
X	10356	Bracket	2
AB	17300-25-1	Thermocouple	1
AC	17357	Bushing	1
AD	17366	Preheater Wire Harness	1
AE	56300-1	R-Preheater Half	1
AF	56350-1	A-Preheater Half	1
AG	OP482-17-2	Locknut	1
AH	17385-1	Wave Spring	1
AJ	0351B-1	Stop	1
AK	OP168B-1-2	Pan Head Machine Screw	1
Not Shown	0362C-6	Replacement Microswitch	1
Not Shown	0365-9	Plastic Bushing	2
Not Shown	17358	Insulator Blanket	1

PROPORTIONING PUMP

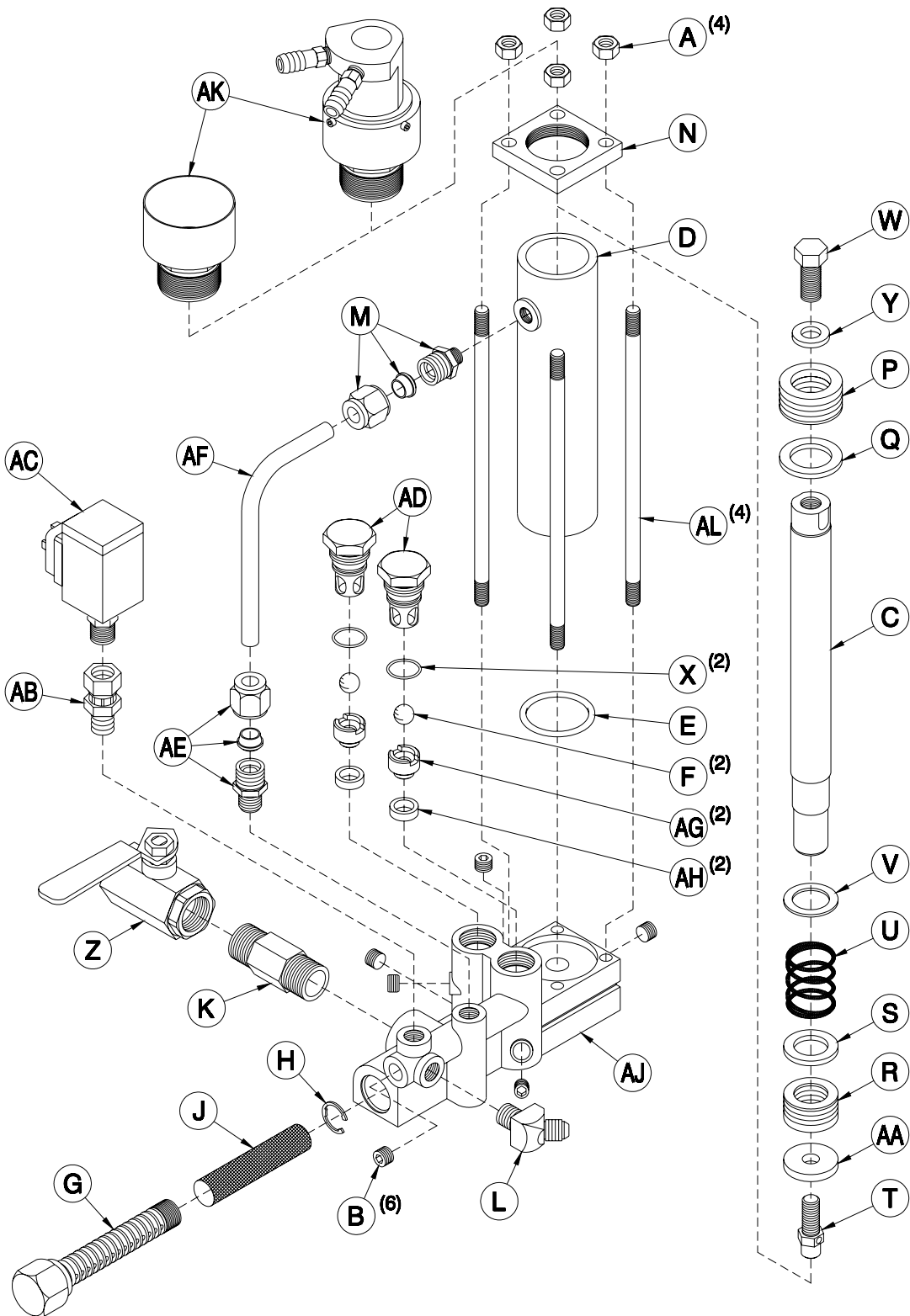


Figure 9. Proportioning Pump (Part No. 17400/17450-60-SPI), Exploded View

TABLE 9. PROPORTIONING PUMP (PART NO. 17400/17450-60-SPI), PARTS

Reference Letter	Part Number	Description	Quantity
A	0213-1	Hex Nut (<i>Torque to 10 Foot-Pounds</i>)	4
B	0377	Flush Seal Pipe Plug	6
C	0451A-60	Piston Rod	1
D	0452B-60	Cylinder	1
E	0453	O-Ring	1
F	0455	Valve Ball	2
G	0460	Screen Screw	1
H	0461	Snap Ring	1
J	0462-40	Pump Screen-40 Mesh	1
K	0463	Hex Nipple	1
L	0465	Hose Elbow	1
M	0470	Tube Nipple	1
N	0474	Cylinder Top	1
P	0476-60	Packing Set	1
Q	0477-60	Packing Support Washer	1
R	0478A-60	Packing Set	1
S	0479-60	Packing Support Washer	1
* T	0480D-60/40	Packing Retainer Bolt	1
U	0481-60/48	Conical Spring	1
V	0482-60	Spring Retainer Washer	1
W	0483-7/16	Hex Head Cap Screw	1
X	0485	O-Ring	2
Y	0486-7/16	Washer	1
Z	0487A	Ball Valve	1
AA	0488-60	Packing Retainer Washer	1
AB	0562-15	Swivel Union	1
AC	6690-16-772200R	Pressure Switch	1
AD	17402	Check Valve Retainer	2
AE	17404	Tube Fitting	1
AF	17405-1	Connecting Tube	1
AG	17406	Check Valve Seat	2
AH	17407	Check Valve Seal	2
AJ	17428 17478	Resin Pump Base Iso Pump Base Assembly	1
AK	17491-60 0489-60	Lube Pump Assembly A - Packing Nut with Lube Cup	1
AL	56427	Tie Rod	4

* Apply Blue Loctite #242 before assembly. Torque to 30 Foot-Pounds.

HOSE HEAT POWER PACK

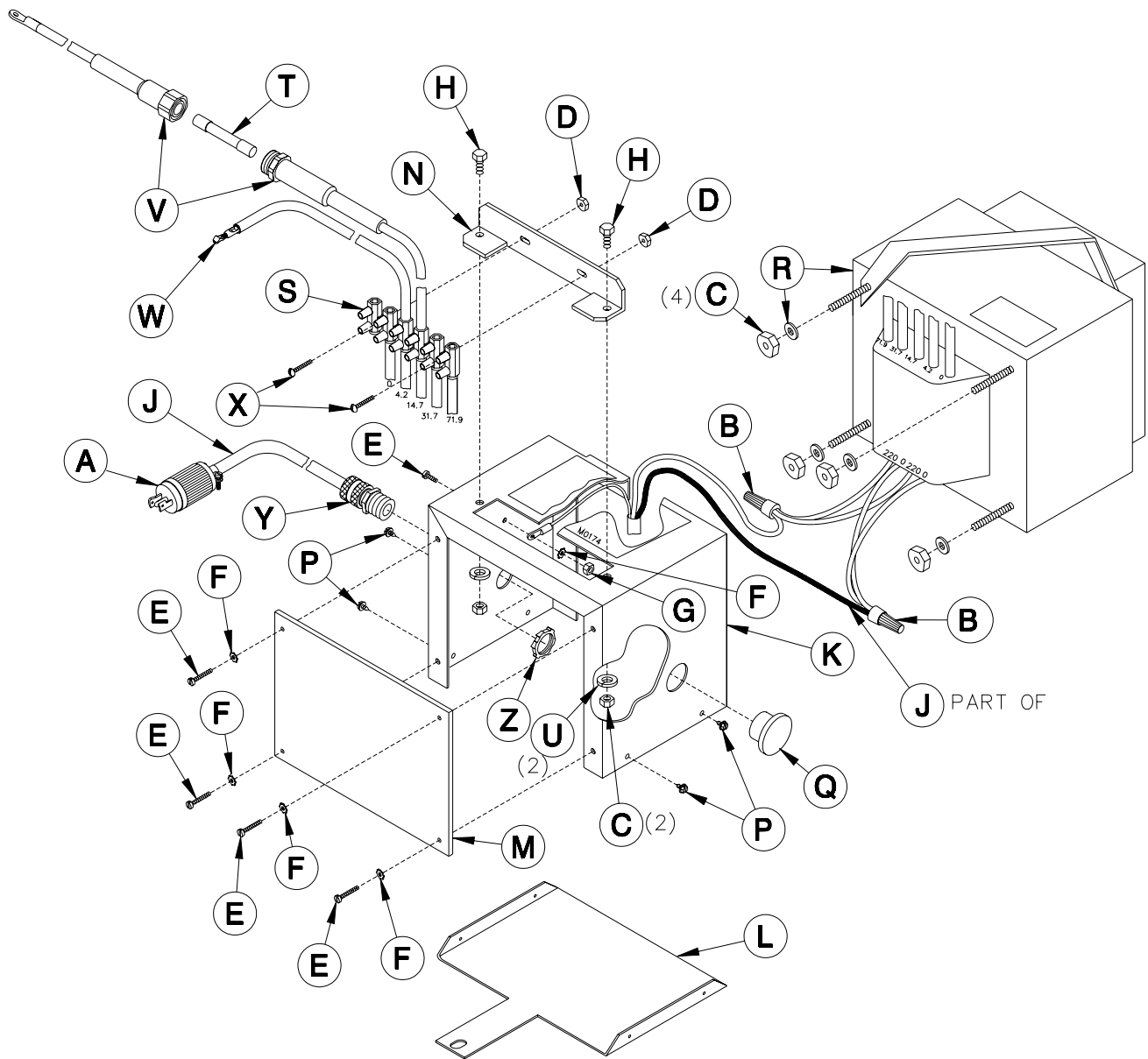


Figure 10. Power Pack (Part No. 17276), Exploded View

TABLE 10. POWER PACK (PART NO. 17276), PARTS

Reference Letter	Part Number	Description	Quantity
A	0251-1	Plug	1
B	0363A	Wire Nut	2
C	0385-4	Hex Nut	6
D	0651A-9	Hex Nut	2
E	0655-2	Pan Head Machine Screw	5
F	0655-4	Lockwasher	5
G	0668-3	Hex Nut	1
H	0760-3	Hex Head Cap Screw	2
J	1275B-2	Input (Power) Wire Harness (Includes A)	1
K	1277-1	Transformer Cover Box	1
L	1277-2	Bottom Cover	1
M	1277-3	Front Cover	1
N	1277-4	Terminal Block Mounting Bracket.	1
P	1615C-4	Sheet Metal Screw	4
Q	1704-5	Hole Plug	1
R	6690-15-5	Transformer	1
S	6690-20-5-6	Terminal Block	1
T	6690-24-14	50 AMP Fuse	2
U	9758	Helical Lockwasher	2
V	14001	Hose Conn. Lead	1
W	17276-1	Hose Conn. Lead Harness	1
X	60302	Round Head Machine Screw	2
Y	OP482-17-1	Bushing	1
Z	OP482-17-2	Locknut	1

LUBE PUMP ASSEMBLY

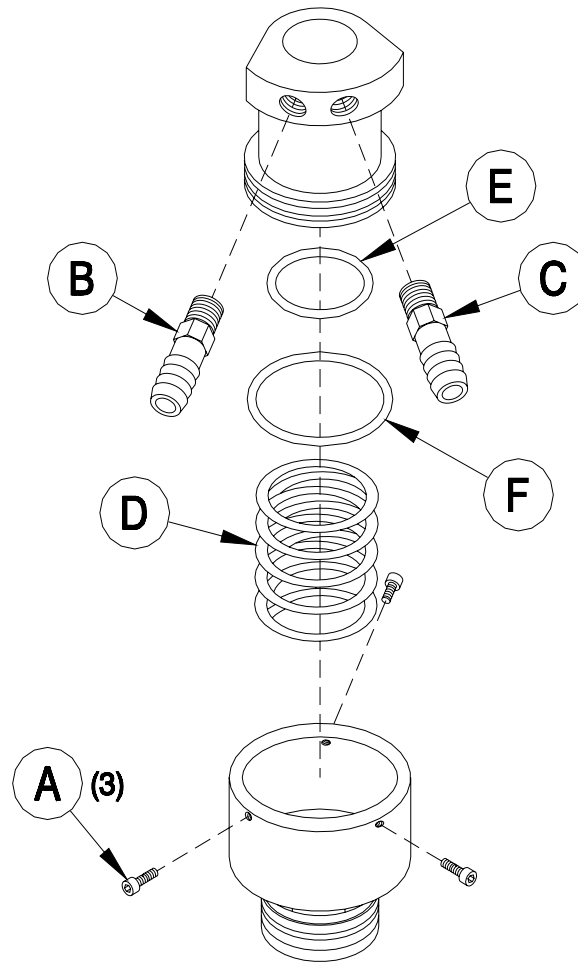


Figure 11. Lube Pump Assembly (Part No. 17491-60), Exploded View

TABLE 11. LUBE PUMP ASSEMBLY (PART No. 17491-60), PARTS

Reference Letter	Part Number	Description	Quantity
A	4406-11	Socket Head Cap Screw	3
B	6310-33	Hose Barb	1
C	6310-36	Hose Barb	1
D	17491-3	Spring	1
E	29101-5	O-Ring	1
F	OP200-2-3	O-Ring	1

ELECTRICAL SCHEMATIC DIAGRAMS

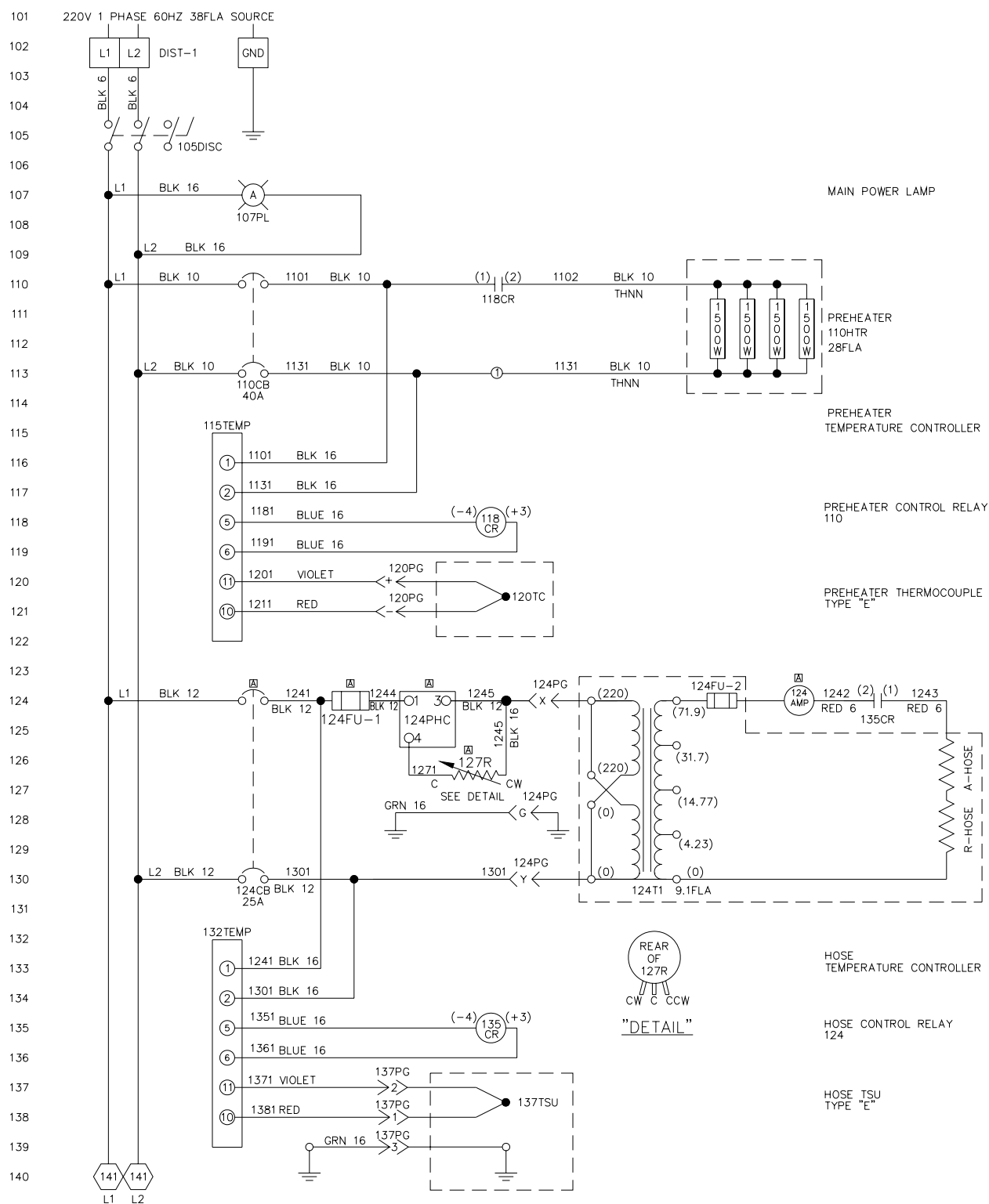


Figure 12. SPI FF 18/18 Electrical Schematic (SD17000A-1-SPI), Sheet 1 of 2



1. JUMPER MUST BE IN PLACE WHEN OPTION IS NOT INSTALLED
2. 162Q IS LOCATED BETWEEN TB1-5 & TB1-12
3. 166Q IS LOCATED BETWEEN TB1-4 & TB1-11

Figure 13. SPI FF 18/18 Electrical Schematic (SD17000A-1-SPI), Sheet 2 of 2

TABLE 12. SPI FF 18/18 ELECTRICAL SCHEMATIC (SD17000A-1-SPI), PARTS

Reference Number.	Part Number	Description	Quantity
	17715	Panel Box	1
	17706-SPI	Panel Box Cover with Hinge	1
	17707-SPI	Panel Front	1
DIST-1	6690-20-5-12	Main Power Distribution Block	1
	17650-2	Wire Terminal Lug	1
105DISC-1	6690-16-10	Switch	1
107LP	0656	Indicator Cap - White	1
	6690-19-25	Light Base	1
	6690-19-24	Bulb	1
110CB	6690-25-31	40 Amp Circuit Breaker	1
111HTR	361-1500-220	Heating Element	REF (4)
115TEMP	6690-26-23	Primary Heater Control	1
118CR	6690-1-5	Solid State Relay	1
120PG	6690-31-1-1	Thermocouple Socket	1
	6690-31-2-1	Thermocouple Plug	1
120TC	17300-25-1	Thermocouple	REF (1)
124CB	0692-1-25	25 Amp Circuit Breaker	1
124FU-1	6690-24-1	Fuse Holder	1
	6690-24-2	25 Amp Fuse	1
124PHC	6690-24-2	Phase Controller	1
124PG	0670A-1-1	Hose Socket / Wired	1
124T1	6690-15-5	Transformer	REF (1)
124FU-2	6690-24-13	In-Line Fuse Holder	REF (1)
	6690-24-14	50 Amp Fuse	REF (1)
124AMP	5616-KIT	Ammeter	1
127R	6690-5-17	Potentiometer	1
A-HOSE		Iso Hose Assembly	REF (1)
R-HOSE		Poly Hose Assembly	REF (1)
132TEMP	6690-26-24	Hose Heat Control	1
135CR	6690-1-46	Solid State Relay	1
137PG	6690-13-2-11-4	TSU Plug	1
137TSU		TSU (Temperature Sensing Unit)	REF (1)
146T2	0689-1	Transformer	1
148FU	OP5193-3-3	1 Amp Fuse	1
	5653B	Fuse Holder	1
151SNAP	0385-1	Thermal Limit Switch	REF (1)
151CR	6690-1-14	24VAC Relay	1
157PS	6690-16-772200R	Pressure Switch	REF (1)
	6690-16-76-2	Din Connector	REF (1)
158CNT	9651-6-2	Counter	1
159PS	6690-16-772200R	Pressure Switch	REF (1)
	6690-16-76-2	Din Connector	REF (1)
160LP	6690-19-25	Light Base	1
	0660	Indicator Cap (Amber)	1
	0662A	Incandescent Bulb	1
162Q	6690-21-1	Quencharc	1
164SOL	6311-109	Valve	REF (1)
165SW1	0578A	Reversing Switch	REF (1)
166SW1	6690-16-6	DPDT Toggle Switch	1
166Q	6690-21-1	Quencharc	1
169LP	6690-19-25	Light Base	1
	0660	Indicator Light	1
	0662A	Incandescent Bulb	1

NOTES

INSTRUCTION MANUAL DISCREPANCY REPORT

[illegible]

Instructions:

Complete the above fields of the form by following the instructions listed on the reverse side of this sheet and mail to:

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Mailing Address

9507 Santa Fe Springs Road
Santa Fe Springs, CA 90670

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Email

info@diamondliners.com