

## SERVICE INSTRUCTION

### RMA-101 Rotary Atomizer

#### 77518-XXXX RMA-101

#### Fluid Coils 77517-00, 77531-00 and 78450-00

Due to the upgrades in the fluid manifolds of the RMA-101, the following precautions must be taken when replacing the fluid coils purchased separately.

1. Determine if you have fluid manifolds with push to connect fittings or PFA Teflon fittings that requires a front and a rear ferrule. (See Figure 1)
2. If you have push to connect fitting on the manifold, you must trim the long end of the coil to length as shown in Figure. 2. Do not cut the 77531-00 Solvent Line Tubing Coil. There is no further action required as the opposite end is already at the proper length. Simply insert either end into the proper push to connect fitting on the fluid manifold and the other end into the corresponding push to connect fitting on the robot plate end of the atomizer.
3. If you have PFA Teflon fittings on the fluid manifold, you must groove the outside diameter of the Teflon tubing on the long end of the coil. Use a Swagelok "Groove Cutter" tool #MS-GC (Instructions are packaged with each tool and are quite easy to follow) Once the groove has been cut, slide on the PFA fitting first, then the rear ferrule and then the front ferrule. (See Figure 3) Install the tubing, fitting and ferrule assembly into the proper hole in the fluid manifold and tighten. Insert the opposite end into the corresponding push to connect fitting on the robot plate end of the atomizer.

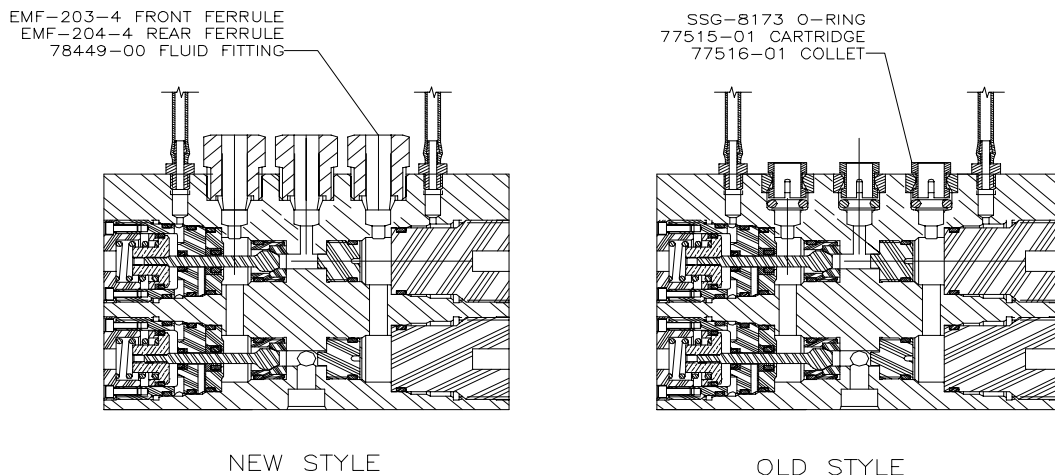
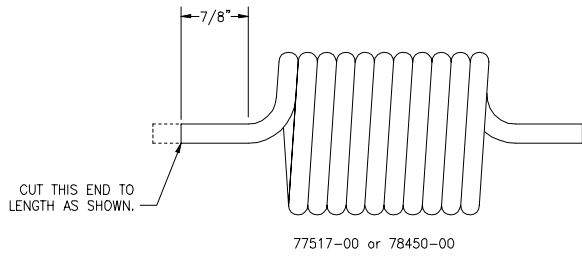
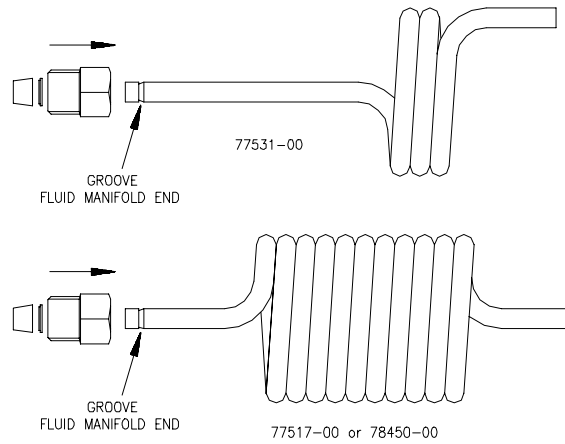


Figure 1



**Figure 2**



**Figure 3**

# **ITW Ransburg**

Electrostatic Systems

An Illinois Tool Works Company



**Industrial Systems**  
 ITW Ransburg Electrostatic Systems  
 320 Phillips Avenue  
 Toledo, OH 43612  
 Telephone: 419/470-2000  
 Fax: 419/470-2270

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