

Nozzle Replacement for a ServoJet™ Spray Head

1. Identify the clogged nozzle(s) in the head assembly.
2. Turn the power off to the fluxer unit; there is a single pole circuit breaker located inside of the fluxer control unit. *(Figure 1)*
3. On the fluxer control box; turn the air pressure regulator to zero psi.
4. Slide the fluxer head assembly to the rear of the fluxer.
5. Remove the six Allen head screws from the cover on the head assembly. *(Figure 2)*
6. Remove the feeder hose on one nozzle at a time. If more than one nozzle is clogged; remove only one hose and nozzle at a time. To remove the feeder hose; pull the larger clear retaining ring away from the nozzle, then pull the tube off of the nozzle. *(Figure 3 & 4)*

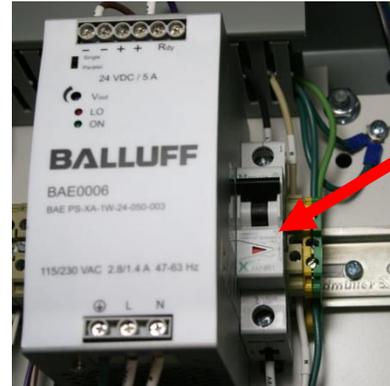


Figure 1

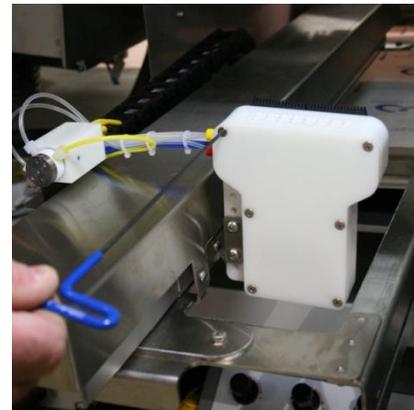


Figure 2

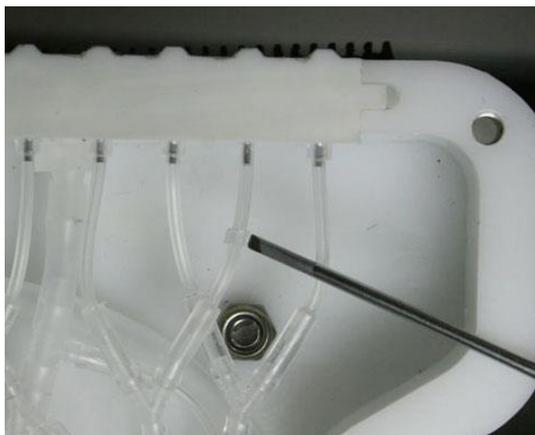


Figure 3

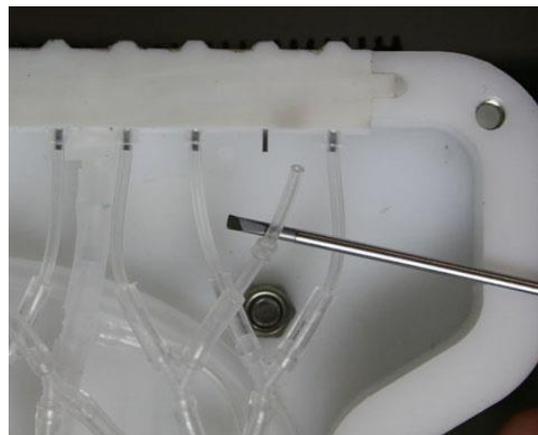


Figure 4

7. Using a small piece of plastic or soft wood from the inside of the head assembly press the nozzle through the plastic nozzle housing until it is flush with the bottom of the plastic nozzle housing. (Figure 5)



Figure 5

8. Attach the pin vise tool to the nozzle; ensure the nozzle is in the center of the vice; tighten the pin vise on the nozzle securely. With slight pressure pull the nozzle out of the nozzle housing. (Figure 6)

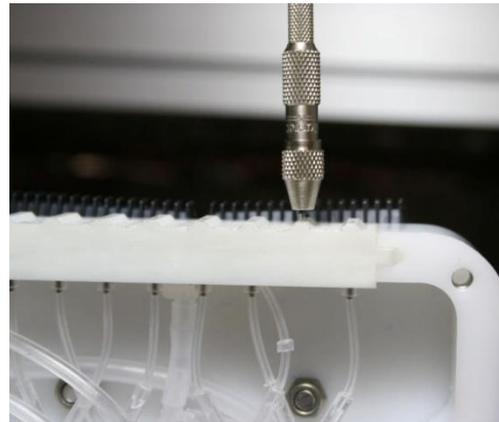


Figure 6

9. Re-trace your steps to install the new nozzle (the pin vise tool is not required in replacing the new nozzle). The round end of the nozzle goes back in the top of the plastic nozzle housing first. Ensure there is an air space all around the nozzle then, press the nozzle in with the plastic tool until it is flush with the top of the plastic nozzle housing. (Figure 7)

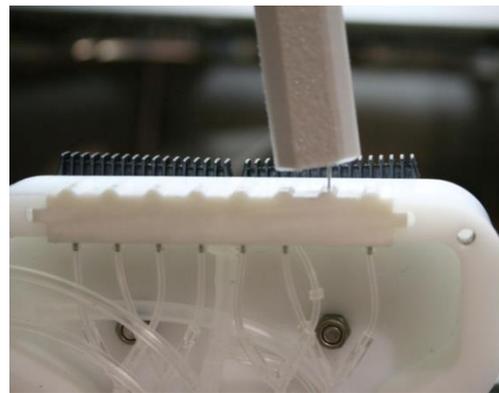


Figure 7

10. Re-apply air and power to the fluxer unit. Run the fluxer in maintenance mode to verify all eight nozzles are spraying properly. Repeat the procedure if necessary.

The Pin Vise can be purchased from any Fastenal store. The part number is 0324856 Pin Vise.

Store Code: CHSHA

Hours: Monday - Friday 8:00am - 5:00pm

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Store Code: SG001

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