

# Module Rebuild Kits

332513B

InvisiPac™ GS35 Plug-Free™ Hot Melt Applicator

EN

Replacement parts for InvisiPac GS35 Plug-Free Hot Melt Applicators. For professional use only.

## Part No. 24T046

Single Module Rebuild Kit

## Part No. 24T047

5 Pack Module Rebuild Kit

## Part No. 24P801

Single Module Filter Replacement Kit

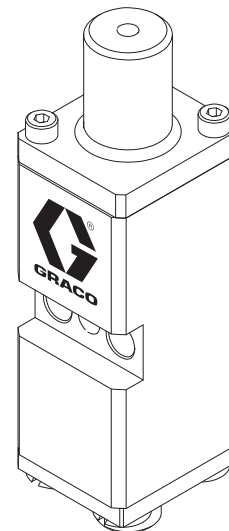
## Part No. 24T045

3 Pack Module Filter Replacement Kit



### Important Safety Instructions

Read all warnings and instructions in this manual and in the GS35 Hot Melt Applicator instruction manual. Save all instructions.



ti21585a

# Disassembly



## Required Tools

- 5/32 in. (4 mm) Allen wrench
- 7/64 in. Allen wrench
- Flat blade screw driver
- O-ring pick
- Compatible solvent in container
- Installation Tool Kit 24T206 (includes seal and piston installation tools, purchase separately)

1. Disable gun assembly. See InvisiPac system manual for instructions.



Material inside the applicator can be near setpoint temperature. Wear protective clothing to avoid severe burns.

2. Remove module from manifold while module is still hot.

### NOTICE

Do not allow adhesive to enter the air ports, to allow air to flow through valve. Adhesive in the air ports will obstruct the flow of air and damage the valve.

3. Soak module in compatible solvent.
4. Disassemble the module.

**NOTE:** Complete steps 4a-4c to only replace the module filter (E).

- a. Remove the spring retainer (A) and spring (B).
- b. Remove the nozzle seat (C) and o-ring (D). Discard the o-ring.
- c. Remove the module filter assembly (E). Discard the filter assembly.

- d. Remove the piston assembly (F).
- e. Remove the air rod u-cup seal (G).
- f. Remove the fluid rod u-cup seal (H).
- g. Remove the module body o-rings (J).

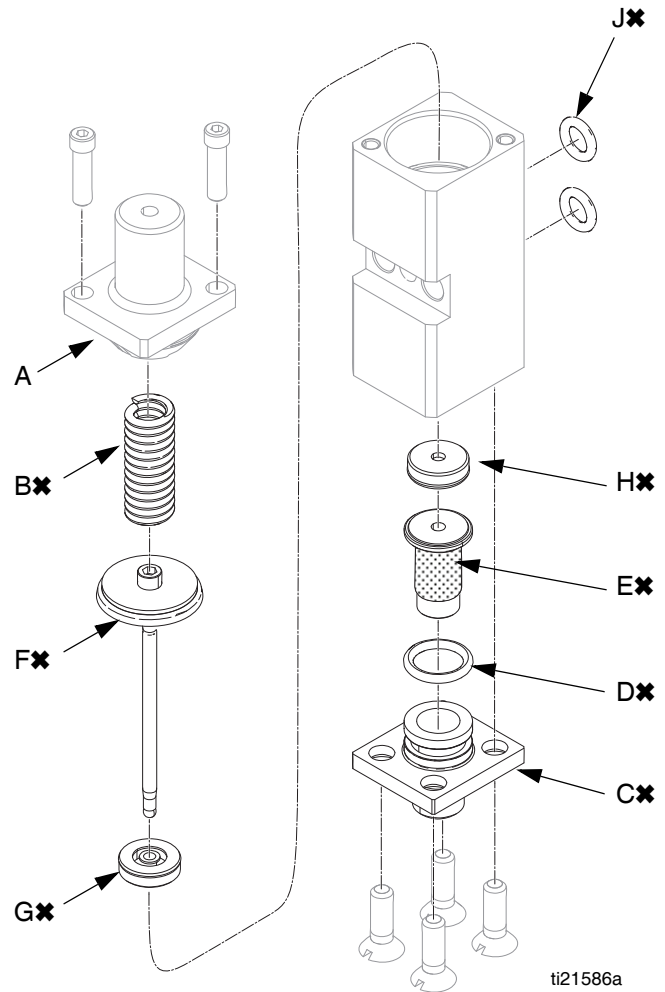


FIG. 1

✘ Discard if rebuilding the entire module.

# Reassembly

**NOTICE**  
To prevent damage to the seals always use the Seal Installation Tool (S) and Piston Installation Tool (P).

**NOTICE**  
Do not scratch the piston rod. Damage to the piston rod will shorten module life.

Complete steps 2-3 and 9 to only reassemble the module filter.

1. Lubricate fluid rod u-cup seal (4) and air rod u-cup seal (4) with high temperature grease (8). Place seals on the Seal Installation Tool (S), with the spring facing the tool, and install seals in the module housing. Seals (4) will snap in place.

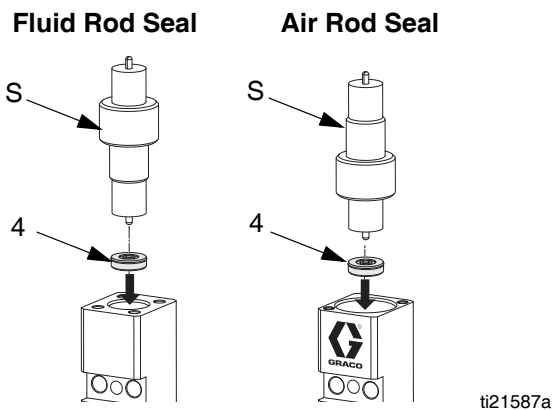


FIG. 2: U-Cup Seals

2. Install module filter assembly (5).

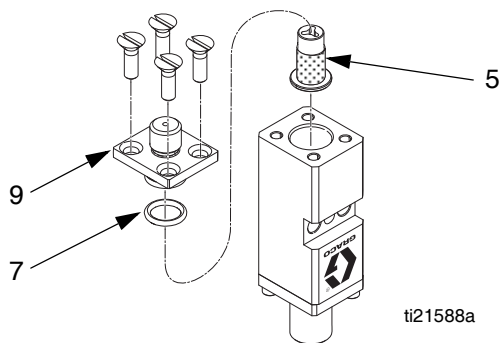


FIG. 3

3. Install o-ring (7) on nozzle seat (9). Lubricate with high temperature grease (8).
4. Install nozzle seat on module. Torque screws to 15-20 in.-lbs (1.7-2.3 N•m).

5. Slide piston assembly (2) backwards through the Installation Tool (P) to press the seal in the piston.

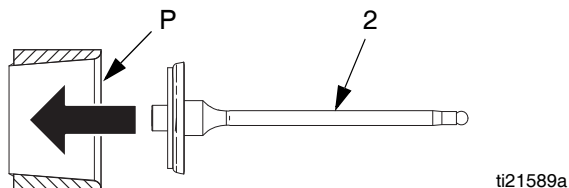


FIG. 4

6. Lubricate piston assembly seal (2) with high temperature grease (8). Install piston assembly into module housing with the Piston Installation Tool (P).

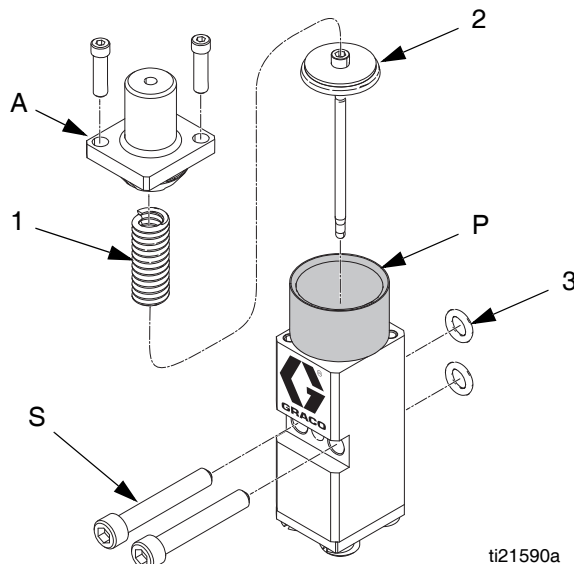
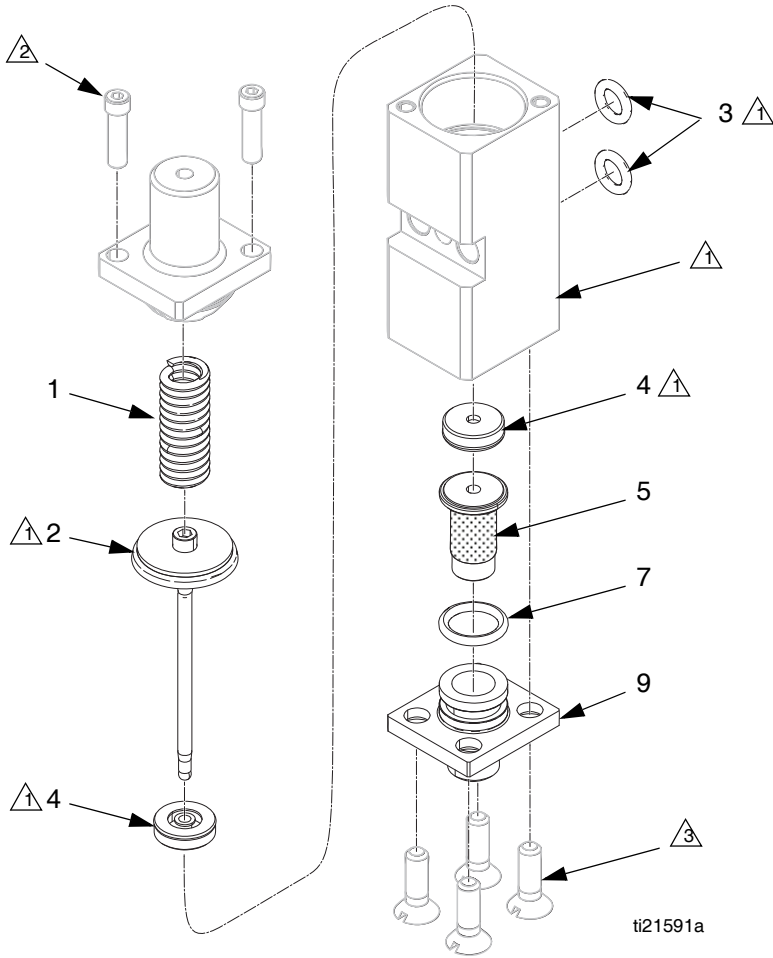


FIG. 5

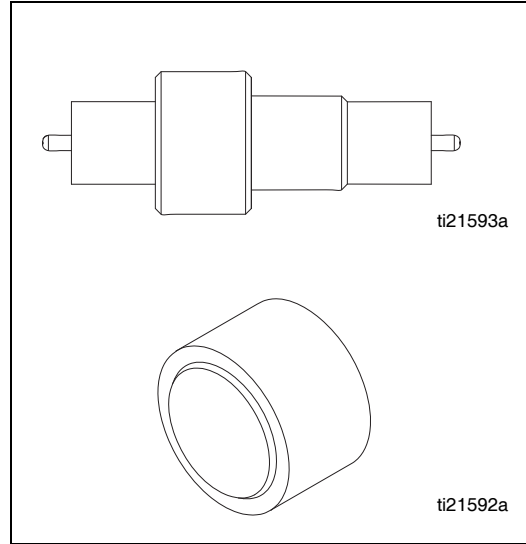
7. Install spring (1) and spring retainer (A) on top of piston. Torque screws to 10-15 in.-lbs (1.1 - 1.7 N•m).
8. Install module housing o-rings (3). Lubricate with high temperature grease (8).
9. Apply anti-seize to two screw threads (S). Install module on manifold with two screws. Torque to 28-32 in.-lbs (3.2-3.6 N•m).

# Parts



## 24T206 Installation Tool Kit

(purchase separately)



- Apply high temperature grease to all o-ring surfaces and to piston seal bore surfaces of module housing.
- Torque to 10-15 in.-lbs (1.1 - 1.7 N•m).
- Torque to 15-20 in.-lbs (1.7-2.3 N•m).

## Module Rebuild Kits

Ref.	Part	Description	Quantity	
			24T046 Single	24T047 5 Pack
1	---	SPRING, piston	1	5
2	---	ROD, piston, assy	1	5
3	24R835	O-RING (10 pack)	2	10
4	126676	SEAL, u-cup	2	10
5*	24P801	KIT, filter; 80 mesh	1	5
7*	---	O-RING	1	5
8	24T156	LUBRICANT, grease, high temp	1	5
9	---	SEAT, nozzle	1	5
10*	24T179	LUBRICANT, anti-seize	1	5

\* Included in Module Filter Replacement Kit 24P801 (single) and 24T045 (3 pack). Purchase separately.

--- Not for sale.



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Original instructions. This manual contains English. MM 332513

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