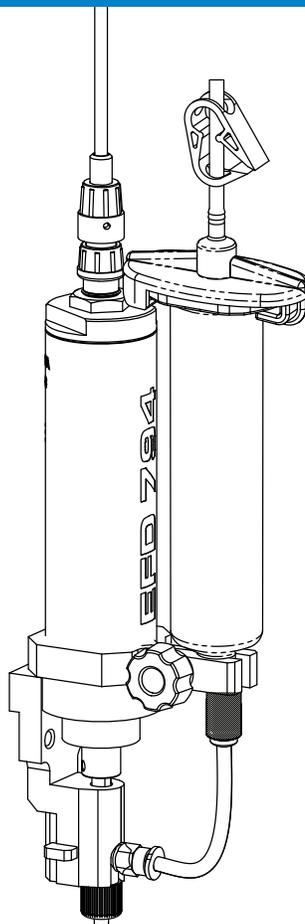


794 Series Auger Valve

Service & Replacement Parts Manual



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Tools and Supplies

- Valve purge compound (P/N 7019147)
- Cotton swab
- Cleaning brushes and solvent or ultrasonic cleaning device

Valve Service Procedures

Follow these procedures to properly purge the valve and clean the auger assembly. Inspect, clean, and replace components as needed. Refer to “Replacement Parts” on page 4 for part numbers and for an exploded diagram of the valve components.

CAUTION

Before any component change or service activity, relieve air pressure from the fluid reservoirs.

Purging

The use of valve purge compound between production shifts or after every eight hours of run time is highly recommended. The compound cleans any material residue from the fluid path and conditions the valve for future use.

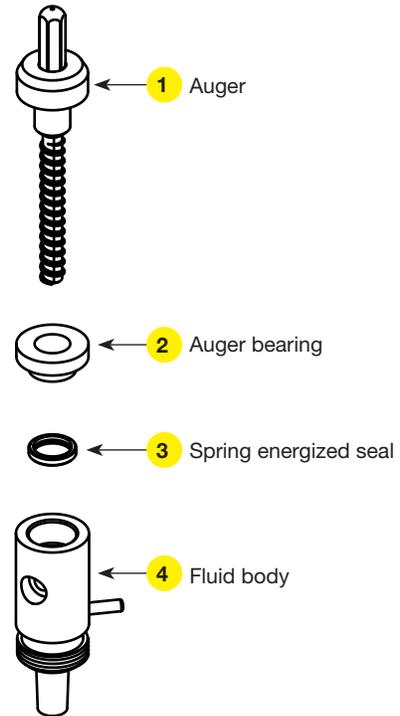
1. Install the barrel of valve purge compound on the fluid inlet fitting.
2. Apply reservoir pressure and cycle the valve until the valve purge compound has pushed all residual material from the valve. Leave the compound in the valve until future use.
3. To remove the valve purge compound, replace it with the material to be dispensed and cycle the valve until all compound is pushed from the valve.

Valve Service Procedures (continued)

Cleaning the Auger Assembly

If the purging procedure detailed above is not sufficient to clean the valve, disassemble the auger assembly as follows:

1. Pull the auger **1** straight out of the fluid body **4**, being careful not to damage the spring energized seal.
2. Use your fingernail to carefully pry the auger bearing **2** out of the fluid body.
3. Use a cotton swab to remove the spring energized seal **3**.
4. Clean all parts using any suitable solvent and brushes or an ultrasonic cleaning device.
5. Inspect the seal and bearing for signs of wear or damage and replace if needed.
6. Insert the seal, spring side inward, into the fluid body and use the auger bearing to gently push it.
7. Fully press the auger bearing into the fluid body.
8. Insert the auger, being careful not to damage the seal.

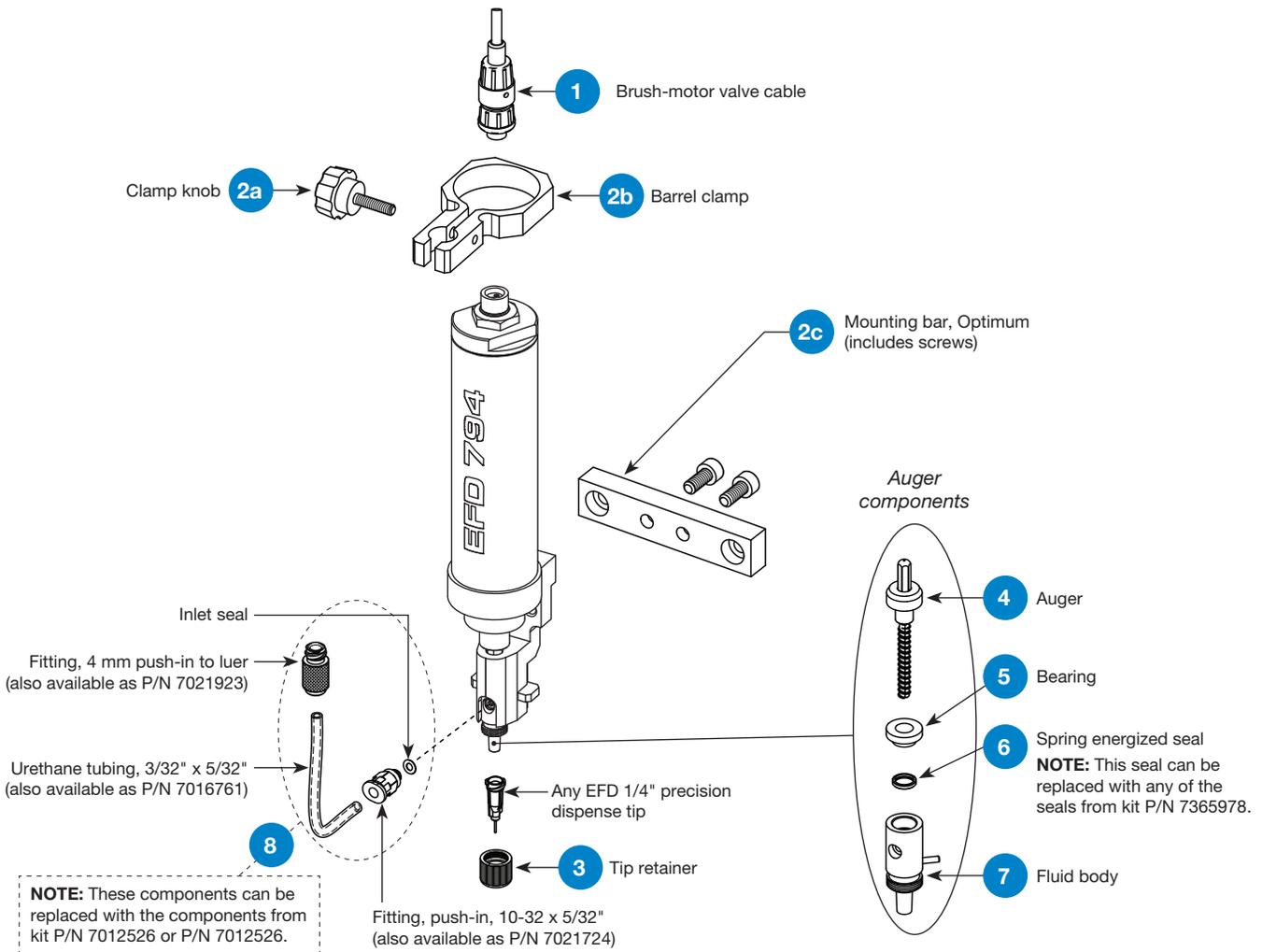


Valve Part Numbers

Part #	Pitch	Model	Description
7029745	8	794-FR	Auger valve, 8 pitch, brush motor, fixed head
7029746	16	794-FR	Auger valve, 16 pitch, brush motor, fixed head

Replacement Parts

Item	Part #	Kit Contents (Qty.)	Item	Part #	Kit Contents (Qty.)
1	7021981	• Brush-motor valve cable (1)	5	7021964	• Bearing (1)
2	7021960	Kit, mounting hardware a. Clamp knob, 4 x 16 mm (1) b. Barrel clamp (1) c. Mounting bar, Optimum (includes screws) (1)	6	7360706	• Spring energized seal (24)
				7365978 (not shown)	Kit, seals • O-ring, 0.180 x 0.035, Viton™, brown (10) • Auger seal, EPR (1) • Auger seal, Viton (1) NOTE: The seals in this kit are alternatives for the spring energized seal, P/N 7360706.
3	7021973	• Tip retainer (1)	7	7021921	• Fluid body (1)
4	7021988 (8 pitch) 7021978 (16 pitch)	• Auger (1)	8	7012526	Kit, high flow, standard • Tubing, 1/4" OD x 1/8" ID, PE, 46 cm (1.5 ft) (1) • 1/4 hose to barrel adapter, PP (3) • Fitting, 10-32T, female luer, nylon (3) • Inlet seal (washer), flat, 0.083 x 0.165 x 0.005", PTFE (10)
				7363399	Kit, high flow, stainless steel • Tubing, 1/4" OD x 1/8" ID, PE, black, 46 cm (1.5 ft) (1) • Fitting, 1/8" barb to luer, stainless-steel (3) • Fitting, 10-32T, 1/8" barb, stainless-steel (3) • Inlet seal (washer), flat, 0.083 x 0.165 x 0.005", PTFE (10)
				NOTE: The components above can be used to replace the components shown in the illustration.	



NORDSON EFD ONE YEAR LIMITED WARRANTY

This Nordson EFD product is warranted for one year from the date of purchase to be free from defects in material and workmanship (but not against damage caused by misuse, abrasion, corrosion, negligence, accident, faulty installation, or by dispensing material incompatible with equipment) when the equipment is installed and operated in accordance with factory recommendations and instructions.

Nordson EFD will repair or replace free of charge any defective part upon authorized return of the part prepaid to our factory during the warranty period. The only exceptions are those parts which normally wear and must be replaced routinely, such as, but not limited to, valve diaphragms, seals, valve heads, needles, and nozzles.

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This warranty is valid only when oil-free, clean, dry, filtered air is used, where applicable.



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