

Replacing Airlock Seals

Objective:

Ensure your Intec Insulation Machine is operating at peak performance levels to provide optimal production levels and allow for proper arc length and coverage of material.

Tools Required for job:

- 7/16" Socket & Ratchet
- 7/16" Open-end wrench
- Airlock rotor plate gauge
- Torque wrench, in/lbs
- 45 - 90 minute job

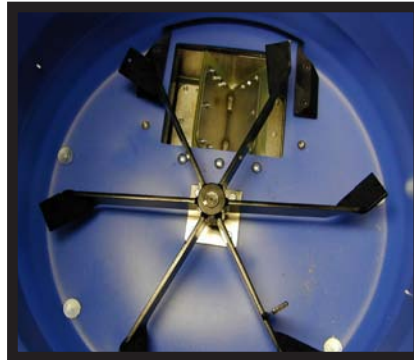
This Technical Bulletin covers all current models made by Intec.

- Force/1
- Force/2
- Force/3
- Wasp
- FiberForce

Process:



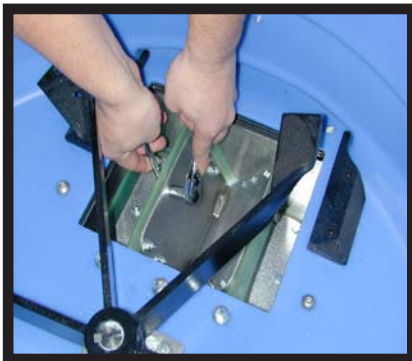
- ▲ 1. Make sure before replacing the seals that you unplug the power from the machine.



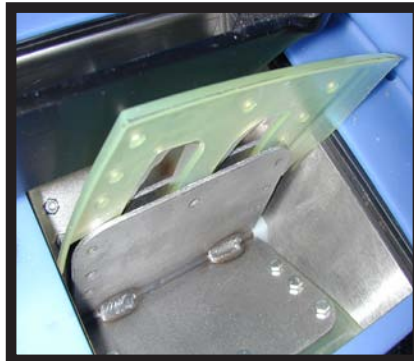
2. Remove all insulation material from hopper and airlock.



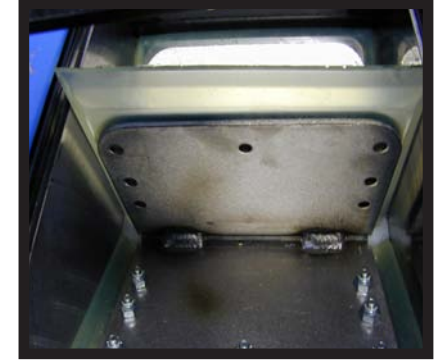
3. Using the airlock rotor plate gauge, check to make sure that there are no bent rotor plates. *(replace airlock rotor or airlock rotor plates if bent.)*



4. With the machine in an upright position, locate the bolts holding the seal. Loosen and remove the fasteners using a 7/16" socket and ratchet, and a 7/16" open-ended wrench.

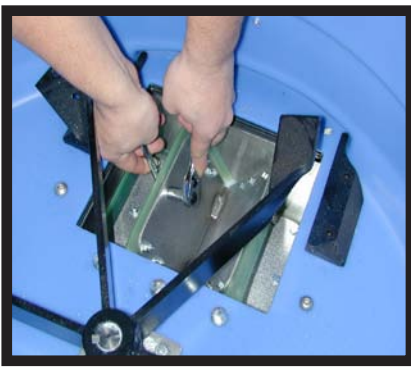


5. Remove the old seal from the airlock rotor shaft and replace with new airlock seal. Make sure the seal is going in the correct direction. *(See manual for correct rotation.)*



6. Make sure that the seal is equally wrapped on both sides and seated all the way down on the rotor shaft.

▲ Note: If there is insulation between rotor plates use a thin flat head screwdriver to get in between plates to remove insulation material.



6. Re-install bolts, hand tighten. Tighten the bolts but be sure not to overtighten. (Overtightening will cause the seal to bow out at the ends producing uneven wear and premature failure and excess amperage.)

⚠ Note: Installing the airlock seal backwards will cause excessive air to leak out of airlock.

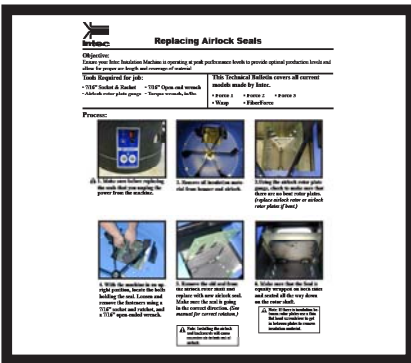


7. Set torque wrench to 30 in/lbs setting. Tighten each airlock seal bolt down until torque wrench “breaks”.



8. Re-connect electrical power and using the remote switch, move the airlock seal into the position for removal.

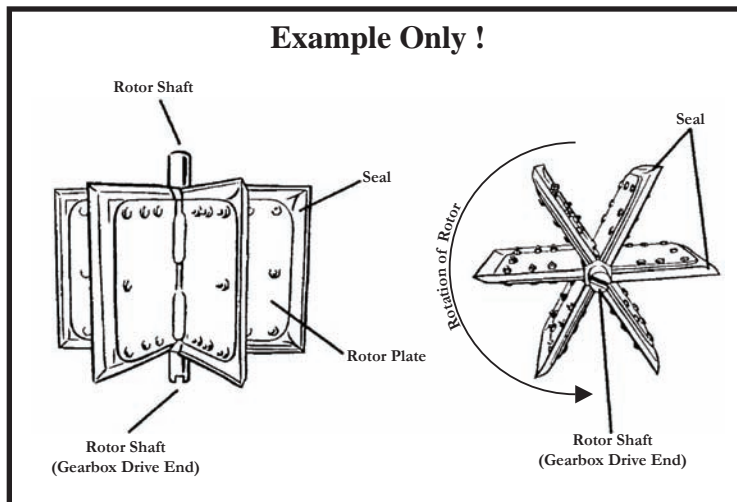
⚠ Note: (Disconnect power at machine before attempting.) FORCE/1 machine airlock rotor plates can be moved into position by removing motor fan cover and turning fan blade clock-wise to access seals.



9. Again, disconnect from electrical power and repeat steps 1-7.

Part Number:	Description:	Qty Needed:
• 12023	Force/1 Seal	6
• 22013	Force/2 - Wasp Seal	6
• 32013	Force/3 Seal	6
• 50224-00	FiberForce Seal	6
• 12229	Airlock Rotor Plate Tester	1

⚠ Note: We Recommend changing the airlock seals every 300 hours, 200,000 lbs of insulation or once a year, whichever comes first.



For Technical Assistance please contact:



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