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ALUMINUM CRACKED INDEX RING REPLACEMENTS SERVICE BULLETIN

Remove cracked Index Ring

1. Remove the broken index ring by placing a screw driver under the crack. Place screwdriver between the index ring and the nozzle.

Note: Do not push down on the screwdriver/Raise it up and do not twist the screw driver. Take extra caution, if the necktube is damaged it will result in high NER performance.



2. Hit the screwdriver with a hammer, straight between the index ring and nozzle.
3. After a piece of the index rings falls off, put the screwdriver under the broken index ring and break remainder of index ring loose.



4. Remove the left-over glue on the nozzle.

Replace cracked Index Ring

5. Retrieve the required index ring, and index ring extension if required.
6. Insert the index ring extension into the index aligning the front clip and rear hinge gaps accordingly.
7. Apply DP640 Urethane adhesive using an adhesive nozzle and small glue gun.
8. Apply a uniform bead of adhesive around the mid-section of the top nozzle.

Warning: Do not allow adhesive to get inside the unit.



9. Add DP100 glue in the corner of the index ring.



10. Install the index ring onto the container top nozzle, twisting the index ring back and forth to uniformly spread the adhesives.
11. Align the index ring hinge joint with the pump out nozzle on the back side of the container.
12. Wait at least 10 minutes to allow the DP100 plus glue to cure before handling the unit.
13. For 20XT, 34XT, and 34HC units alignment
 - A. Locate the ½" slot on the index ring extension. Place the ½" slot into the lock tab and the 1" cut-out over the hinge slots.
 - B. Align the index ring until the hinge slots are centered with the vacuum pump out.