

# *SUPER PRO GUN & SUPER PRO GUN II*



## **MAGNUM VENUS PRODUCTS**

### **Maintenance & Repair Manual**

Part No. M6707-1-1  
Revision 04.14.01

# *SUPER PRO GUN & SUPER PRO GUN II*

## Maintenance & Repair

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# SUPER PRO GUN Repair Kit



## NOTE

To order the correct repair kit, refer to the gun handle before ordering parts.

### 6702-02-01 REPAIR KIT - SUPERPRO CHOPPER/SATURATOR GUN

- |       |  |                             |      |  |  |
|-------|--|-----------------------------|------|--|--|
| 1 PC  |  | 7301-3-007 O-RING           | 1 PC |  | 5104-21-1 SPLIT SEAL                         |
| 1 PC  |  | 7301-11-008 O-RING          | 1 PC |  | 7304-4-1 LIP SEAL                            |
| 1 PC  |  | 7301-14-904 O-RING          | 1 PC |  | 5104-5-1 TEFLON RESIN SEAL                   |
| 1 PC  |  | 7301-15-125 O-RING          | 1 PC |  | 5104-6-1 TEFLON CATALYST SEAL                |
| 1 PC  |  | 7301-10-903 O-RING          |      |  |  |
| 3 PCS |  | 7301-3-020 O-RING           | 1 PC |  | 5107-27-2 CRITICAL MIXER<br>DEMPLE IN BOTTOM |
| 1 PC  |  | 5104-13-1 INJECTOR SEAL     |      |  |  |
| 4 PCS |  | 5106-3-1 GUN BLOCK SEAL     |      |  |  |
| 2 PCS |  | 5104-3-1 SECONDARY SEAL     |      |  | 1 PC<br>5105-4-1 PORTING GASKET              |
| 1 PC  |  | 5104-26-1 FLUSH VALVE SEAL  |      |  |  |
| 1 PC  |  | 5105-9-1 TRIGGER NUT SEAL   |      |  | 1 PC<br>5105-7-1 CYLINDER GASKET             |
| 1 PC  |  | 5104-12-1 MIX HOUSING SEAL  |      |  |  |
| 1 PC  |  | 5105-6-1 WASHER             |      |  |  |
| 2 PCS |  | 5104-7-1 PACKING RING       |      |  | 1 PC<br>04394-1 GUN OIL                      |
| 1 PC  |  | 9203-2-1 COMPRESSION SPRING |      |  | 1 PC<br>08469 HEX KEY SET                    |

## NOTE

A Turbulent Mixer is not used in FIT™ configurations.
























# SUPER PRO GUN II Repair Kit



## NOTE

The Super Pro Gun II is identified by either the blue handle or (on earlier versions) by the #2 stamped on the handle side.

### 6702-013-01 REPAIR KIT - SUPERPRO II CHOPPER/SATURATOR GUN

1 PC		7301-3-007 O-RING	1 PC		5104-21-1 SPLIT SEAL			
1 PC		7301-11-008 O-RING	1 PC		7304-4-1 LIP SEAL			
1 PC		7301-14-904 O-RING	1 PC		5104-5-1 TEFLON RESIN SEAL			
1 PC		7301-15-125 O-RING	1 PC		5104-6-1 TEFLON CATALYST SEAL			
1 PC		7301-10-903 O-RING	1 PC		5107-27-2 CRITICAL MIXER DEMPE IN BOTTOM			
3 PCS		7301-3-020 O-RING	1 PC		9203-2-1 COMPRESSION SPRING			
1 PC		5104-13-1 INJECTOR SEAL	 1 PC 5110-5-1 PORTING GASKET					
4 PCS		5106-3-1 GUN BLOCK SEAL						
2 PCS		5104-3-1 SECONDARY SEAL						
1 PC		5104-26-1 FLUSH VALVE SEAL						
1 PC		5105-9-1 TRIGGER NUT SEAL						
1 PC		5104-12-1 MIX HOUSING SEAL						
1 PC		5105-6-1 WASHER				 1 PC 5110-6-1 CYLINDER GASKET		
1 PC		5105-6-1 WASHER				1 PC 04394-1 GUN OIL		
2 PCS		5104-7-1 PACKING RING				1 PC 08469 HEX KEY SET		

# ***SUPER PRO GUN***

## **Actuator Assembly** 5106-01-01

See Figs. 9.1 & 9.2 for exploded schematic drawings

1. Install the 7301-3-020 (O-Ring) onto the 5106-7-1 (Actuator Piston) and the two 5106-4-1 (Cylinder Caps)
2. Using 6706-3-1 (Pro Gun Oil), lightly coat the Inside of the 5106-1-01 (Cylinder Body) and the 5106-7-1 (Actuator Piston).
3. Install the 5106-5-1 (Actuator Bushing) into the 5106-7-1 (Actuator Piston).
4. Push the 5106-7-1 (Actuator Piston) into the 5106-1-01 (Cylinder Body) through the long end. See Fig. 1.1

**Fig. 1.1**





#### **NOTE**

The Piston should be inserted "bushing end first", with the bushing on the top side of center.

5. Install the two 5106-4-1 (Cylinder Caps).
6. Place the 5106-2-1 (Actuator Seal) over the 5106-1-01 (Cylinder Body) so the Mounting screw holes line up.
7. Place the 5104-00-01 (Gun Block Assembly) onto the 5106-2-1 (Actuator Seal).



#### **NOTE**

The 5104-11-1 (Actuating Stem) must be inserted into the 5106-5-1 (Bushing) located in the 5106-7-1 (Actuating Piston).

8. Secure the 5104-00-01 (Gun Block Assembly) onto the 5106-01-01 (Gun Actuator) with the four 5106-6-1 (Mounting Screws) and the 5106-3-1 (Mounting Seals).

# ***SUPER PRO GUN***

## **Handle Assembly** 5105-00-01

See Figs. 9.3 & 9.4 for exploded schematic drawings

1. Carefully install the 5105-9-1 (Trigger Nut Seal) over the 5105-10-1 (Trigger Nut).
2. Coat the 7304-4-1 (Lip Seal) with 6706-3-1 (Pro Gun Oil), and push it into the 5105-10-1 (Trigger Nut).



### **NOTE**

Once in place the spring of the 7304-4-1 (Lip Seal) should be facing out.

3. Screw the 5105-10-1 (Trigger Nut) into the 5105-1-1 (Gun Handle), and tighten. Coat the 5105-14-1 (Trigger Stem) with 6706-3-1 (Pro Gun Oil) and install from the inside cavity of the 5105-1-1 (Gun Handle) through the 5101-10-1 (Trigger Nut).
4. Place the 5105-15-01 (Pivot Plate) into the slot in the 5105-1-1 (Gun Handle Assembly), and push the 7203-4-9 (Slotted Spring Pin) located on the back side of the 5105-16-1 (Trigger) into the hole in the 5105-14-1 (Trigger Stem). Line up the 5105-15-2 (Pivot Plate Bushing) to the lower pivot hole in the Gun Handle, insert the 7102-10-12 (Slotted Flat Head Screw) and tighten.



### **NOTE**

When installing the Trigger Assembly the 5105-8-1 (Trigger Lock) must be in the "down" position.



5. Set the 9203-2-1 (Compression Spring) into the spring seat located in the upper cavity of the 5105-1-1 (Gun Handle).
6. Place the small pinhole in the 5105-3-1 (Slide Valve) over the pin through the 5105-14-1 (Trigger Stem), and push down compressing the spring into the handle cavity.
7. Place the 5105-4-1 (Porting Plate Gasket) over the screws, matching the slot to the slot in the 5105-1-1 (Gun Handle).
8. Lightly lubricate the flat side of the 5105-5-1 (Porting Plate) with 6706-3-1 (Pro Gun Oil) and push it over the 5105-3-1 (Slide Valve) keeping the Slide Valve connected to the 7203-4-9 (Slotted Spring Pin) in the 5105-14-1 (Trigger Stem).



#### NOTE

The slot in the side of the 5105-5-1 (Porting Plate) must line up with the slot in the 5105-1-1 (Gun Handle).

9. Set the 5105-6-1 (Toggle Washer) into the washer seal seat of the 5105-5-1 (Porting Plate) large side down.
10. Set the 5105-7-1 (Cylinder Gasket) over the screws, matching the slots in the 5105-5-1 (Porting Plate)
11. Carefully position the 5106-00-01 (Gun Actuator Assembly) over the 5105-00-01 (Gun Handle Assembly) and fasten with the two 5105-12-1 (Front Screws) and the 5105-13-1 (Rear Screws).
12. If necessary, adjust the 5105-8-1 (Trigger Lock) by pulling the 5105-16-1 (Trigger) to “full out”, then flip the Trigger Lock up until it hits the smallest part of the 5105-11-1 (Trigger Lock Screw). Loosen the 7102-6-4 (Socket Cup Point Set Screw) and adjust the Trigger Lock Screw until it clears with minor interference. The locking legs on the Trigger Lock Screw must be vertical. The Trigger Lock should lock the trigger in both the open and closed position. Once adjusted, tighten the 7102-6-4 (Socket Cup Point Set Screw).
13. With the two 7102-8-8 (Slotted Pan Head Screws), mount the 5105-2-1 (Trigger Guard).

## ***SUPER PRO GUN II***

Handle Assembly 5110-7-1

**See Figs. 9.5 & 9.6 for exploded schematic drawings**

1. Carefully install the 5105-9-1 (Trigger Nut Seal) over the 5105-10-1 (Trigger Nut).
2. Coat the 7304-4-1 (Lip Seal) with 6706-3-1 (Pro Gun Oil), and push it into the 5105-10-1 (Trigger Nut).



#### NOTE

Once in place the spring of the 7304-4-1 (Lip Seal) should be facing out.

3. Screw the 5105-10-1 (Trigger Nut) into the 5110-7-1 (Gun Handle) and tighten. Coat the 5110-4-1 (trigger stem) with 6706-3-1 (Pro Gun Oil) and install from the inside cavity of the 5110-7-1 (Gun Handle) through the 5105-10-1 (trigger nut).
4. Place the 5105-15-01 (Pivot Plate) into the slot in the 5110-7-1 (Gun Handle Assembly), and push the 7203-4-10 (Slotted Spring Pin) located on the backside of the 5105-16-1 (Trigger) into the hole in the 5110-4-1 (Trigger Stem). Line up the 5105-15-2 (Pivot Plate Bushing) to the lower pivot hole in the Gun Handle, insert the 7102-10-12 (Slotted Flat Head Screw) and tighten.



#### NOTE

When installing the Trigger Assembly the 5105-8-1 (Trigger Lock) must be in the "down" position. You may find it easier to assemble the gun handle by placing the flats at the back of the 5110-7-1 (Gun Handle) in a vise. This will support the rear screws (5105-13-1) from pushing down during assembly.

5. Set the 9203-2-1 (Compression Spring) into the spring seat located in the upper cavity of the 5110-7-1 (Gun Handle).



#### NOTE

For 2-stage chopper only.

Set the 5110-3-1 (two position gun detent plate) over the 9203-2-1 (Compression Spring). The elevated shoulder of the 5110-3-1 (two position detent plate) faces up.

6. Place the small pinhole in the 5110-2-1 (Slide Valve) over the pin through the 5110-4-1 (Trigger Stem), and push down compressing the spring into the handle cavity.
7. Place the 5110-5-1 (Gun Handle Gasket) over the screws, matching the slot to the slot in the 5110-7-1 (Gun Handle).
8. Lightly lubricate the topside of the 5110-1-1 (Porting Plate) with 6706-3-1 (Pro Gun Oil) and push it over the 5110-2-1 (Slide Valve) keeping the Slide Valve connected to the 7203-4-9 (Slotted Spring Pin) in the 5110-4-1 (Trigger Stem).



#### NOTE

The slot in the side of the 5110-1-1 (Porting Plate) must line up with the slot in the 5110-7-1 (Gun Handle).

9. Set the 5105-6-1 (Toggle Washer) into the washer seal seat of the 5110-1-1 (Porting Plate) large side down.
10. Set the 5110-6-1 (Cylinder Gasket) over the screws, matching the slots in the 5110-1-1 (Porting Plate)
11. Carefully position the 5106-00-01 (Gun Actuator Assembly) over the 5110-7-1 (Gun Handle Assembly) and fasten with the two 5105-12-1 (Front Screws) and the 5105-13-1 (Rear Screws).
12. If necessary, adjust the 5105-8-1 (Trigger Lock) by pulling the 5105-16-1 (Trigger) to “full out”, then flip the Trigger Lock up until it hits the smallest part of the 5110-8-1 (Trigger Lock Screw). Loosen the 7102-6-4 (Socket Cup Point Set Screw) and adjust the Trigger Lock Screw until it clears with minor interference. The locking legs on the Trigger Lock Screw must be vertical. The Trigger Lock should lock the trigger in both the open and closed position. Once adjusted, tighten the 7102-6-4 (Socket Cup Point Set Screw).
13. With the two 7102-8-8 (Slotted Pan Head Screws), mount the 5105-2-1 (Trigger Guard).

# ***SUPER PRO GUN***

## **Gun Block Assembly** 5104-00-01

See Figs. 9.9 - 9.12 for exploded schematic drawings

### **Flush Valve Assembly**

1. Install the 7301-11-008 (O-Ring) onto the 5104-25-1 (Flush Valve Button).
2. Install the 7301-3-007 (O-Ring) onto the 5104-23-1 (Flush Seal Body).
3. Install the 9203-2-3 (Compression Spring) into the 5104-24-1 (Flush Valve Body).
4. Smear 6706-2-1 (White Grease) onto the 5104-25-1 (Flush Valve Button), and the 5104-23-1 (Flush Seal Body). Thread the Flush Valve Button through the 9203-2-3 (Compression Spring) located in the 5104-24-1 (Flush Valve Body), and screw on and tighten the Flush Seal Body.
5. Install the 5104-26-1 (Flush Valve Seal) onto the 5104-24-1 (Flush Valve Body) and thread through the 5104-22-1 (Flush Valve Neck).
6. Install the 5104-02-01 (Flush Elbow Assembly) onto the 5104-22-1 (Flush Valve Neck).
7. Install the 5104-21-1 (Flush Valve Split Seal) onto the 5104-24-1 (Flush Valve Body).

## Gun Block Assembly

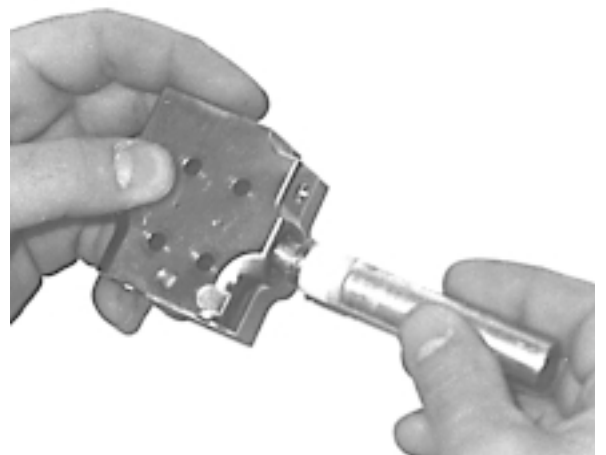
1. Check for and remove debris and burrs in 5104-1-1 (Gun Block).
2. Install the two 5104-3-1 (Secondary Seals) in the 5104-1-1 (Gun Block). See Fig. 3.1

**Fig. 3.1**



3. Install the 5104-10-1 (Center Spacer) into the center area of the 5104-1-1 (Gun Block).
4. Insert the 9301-5-1 (Seal Installation Tool) through the side of the gun block to align the 5104-10-1 (Center Spacer) with the 5104-3-1 (Secondary Seals).
5. Install the catalyst seal components onto the 9301-5-1 (Seal Installation Tool) in the following order; 5104-7-1 (Packing Ring), 5104-6-1 (Teflon Catalyst Seal), and the 5104-4-1 (Relief Spacer). See Fig. 3.2.
6. Insert the Seal Installation Tool with the catalyst seal components into the catalyst port of the 5104-1-1 (Gun Block) See Fig. 3.2.

**Fig. 3.2**





#### NOTE

Before inserting the Seal Alignment Tool, align the holes in the 5401-6-1 (Teflon Catalyst Seal) with the holes in the 5104-1-1 (Gun Block) as closely as possible.

7. Press firmly, or tap with a hammer until the seal assembly bottoms out in the 5104-1-1 (Gun Block), then gently remove the Seal Installation Tool.
8. Hold the 9301-4-1 (Catalyst Seal Alignment Tool) firmly with a pair of pliers.
9. Insert the tapered end of the 9301-4-1 (Catalyst Seal Alignment Tool), into the 5104-1-1 (Gun Block) through the catalyst fitting port on the back of the Gun Block.
10. Gently press and move the Seal Alignment Tool around until the holes in the 5104-6-1 (Teflon Catalyst Seal) align with the catalyst port in the 5104-1-1 (Gun Block) See Fig. 3.3.

**Fig. 3.3**



11. Install and hand tighten the 5104-8-1 (Packing Nut).
12. Install the resin seal components into the 9301-5-1 (Seal Installation Tool) in the following order: 5104-7-1 (Packing Ring), 5104-5-1 (Teflon Resin Seal), and the 5104-4-1 (Relief Spacer). See Fig. 3.4.
13. Insert the Seal Installation Tool into the resin port of the 5104-1-1 (Gun Block) See Fig. 3.4.



#### NOTE

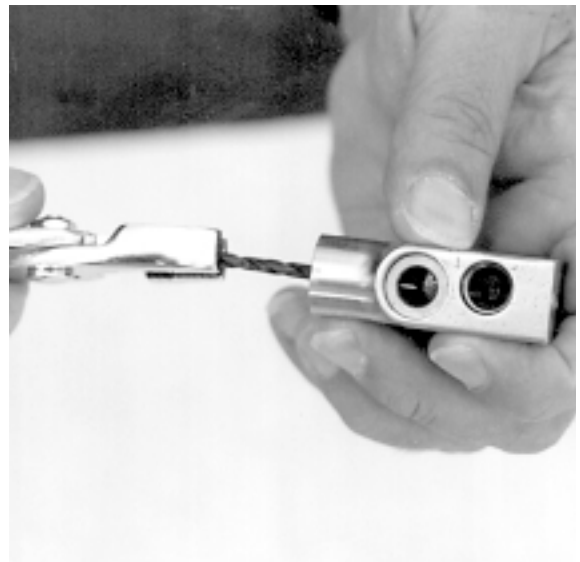
Before inserting the Seal Alignment Tool, align the holes in the 5401-5-1 (Teflon Resin Seal) with the holes in the 5401-1-1 (Gun Block) as closely as possible.

**Fig. 3.4**



14. Press firmly, or tap with a hammer until the seal assembly bottoms out in the 5104-1-1 (Gun Block), then gently remove the Seal Alignment Tool.
15. Hold the 9301-4-2 (Resin Seal Alignment Tool) firmly with a pair of pliers.
16. Insert the tapered end of the 9301-4-2 (Resin Seal Alignment Tool), into the 5104-1-1 (Gun Block) through the resin fitting port on the back of the Gun Block.
17. Gently press and move the Seal Alignment Tool around until the holes in the 5104-5-1 (Teflon Resin Seal) align with the resin port in the 5104-1-1 (Gun Block). See Fig. 3.5

**Fig. 3.5**



18. Install the 5104-2-1 (Valve Rod) through the resin side of the gun. Use the 9301-5-1 (Seal Installation Tool) to center the Valve Rod in the 5104-1-1 (Gun Block).



**NOTE**

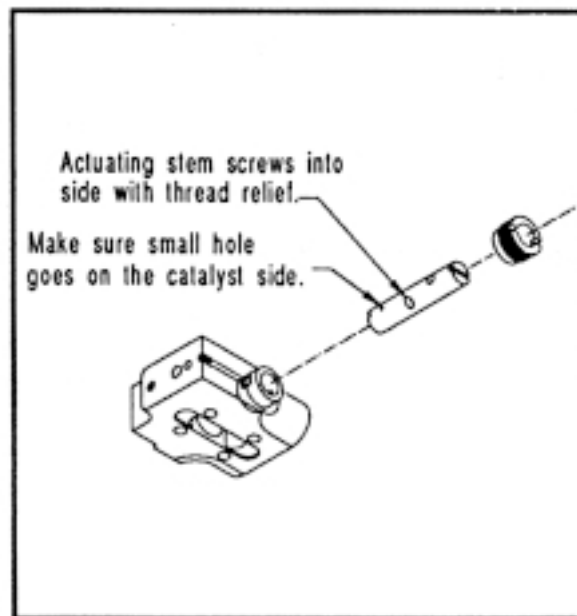
Make sure that the Valve Rod is correctly aligned; the larger hole goes on the resin side, while the smaller hole goes on the catalyst side. See Fig. 3.6.



**NOTE**

The middle hole, into which the actuating stem will be inserted, must also be correctly aligned. One end of the hole has a relief in the threads, which should face down. See Fig. 3.6.

**Fig. 3.6**



19. Install and hand tighten the 5104-8-1 (Packing Nut) onto the resin side of the 5401-1-1 (Gun Block).



20. Install the 5104-11-1 (Actuating Stem) into the 5104-2-1 (Valve Rod).



**NOTE**

Use removable strength thread locking compound on Actuating Stem threads.

21. Actuate the 5104-11-1 (Valve Stem) back and forth 3 or 4 times, then snug both 5104-8-1 (Packing Nuts) with 9301-2-3 (Packing Bit) until firm. Again, actuate the Valve Stem back and forth 3 or 4 times.
22. Install the 5104-32-1 (Plug), and the 7301-15-125 (O-Ring) in the port provided on the catalyst side of the 5104-1-1 (Gun Block).
23. Install the 5104-32-1 (Plug) into the flush port on the resin side of the 5104-1-1 (Gun Block). See Fig. 3.7

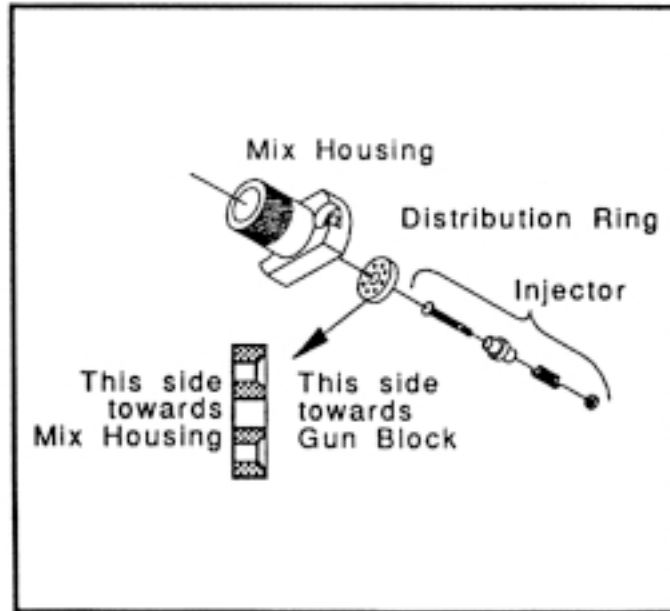
**Fig. 3.7**



24. Install the 5104-27-1 (Catalyst Fitting), and the 7301-10-903 (O-Ring) onto the 5104-1-1 (Gun Block).
25. Install the 5104-9-1 (Resin Fitting) and the 7301-14-904 (O-Ring) onto the 5104-1-1 (Gun Block).
26. Insert the 5104-03-01 (Injector Assembly) and 5104-17-1 (Distribution Ring) into the 5104-20-1 (Mix Housing).

27. Position the 5104-12-1 (Mix Housing Seal) onto the backside of the 5104-20-1 (Mix Housing). See Fig. 3.8.

**Fig. 3.8**



28. Using the two 7102-1-6 (Socket Head Cap Screws), mount the 5104-20-1 (Mix Housing) onto the 5104-1-1 (Gun Block).

# ***SUPER PRO GUN***

## **SuperCutter Assembly** 5101-01-01

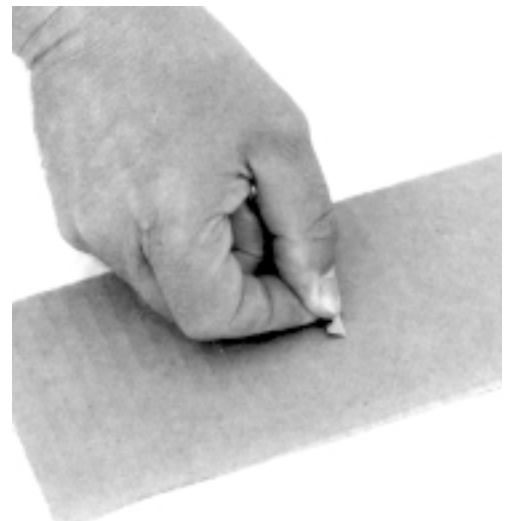
See Figs. 9.13 - 9.20 for exploded schematic drawings



### **NOTE**

The sharp edge of the Chopper Blades should be slightly dulled by stropping them on cardboard prior to installation into Rotor Assembly. This intentional dulling of the blades by the whetting process will avoid slicing and nicking of the Rubber Roll and will assure longer life of both Blades and Rubber Roll. See Fig. 4.1.

**Fig. 4.1**



## Rotor Assembly

1. Insert 9210-1-1 (Chopper Blades) between the 5103-28-1 (Rotor Hub) and 5103-29-1 (Wedge Insert). The back edge of the Blade must be bottomed against the Rotor Hub. See Fig. 4.2.

**Fig. 4.2**



2. Align the edges of the blade with the end of the 5103-28-1 (Rotor Hub). Tighten the 7102-13-6 (Socket Flat Head Screw) in the 5103-29-1 (Wedge Insert) to secure the blades in place.
3. Wipe a small amount of grease on the 8402-1-1 (Air Motor) shaft.
4. Slide the 5103-03-01 (Wedge Rotor Assembly) onto the 8402-1-1 (Air Motor) shaft, so the 7102-14-6 (Set Screws) in the 5103-28-1 (Rotor Hub) ride on the flat of the chopper motor shaft.



### **NOTE**

The rotor must be positioned on the Air Motor shaft so it aligns with the Rubber Roll. See Fig. 4.3

**Fig. 4.3**



### **Rubber Roll Assembly**

5. Press the 5103-6-1 (Rubber Roll) onto the 5103-5-01 (Mandrel Assembly). Secure the Rubber Roll by inserting the 7205-3-31 (E-Ring) into the groove in the Mandrel. See Fig. 4.4.
6. Insert the Mandrel/Rubber Roll Assembly into the top of the T-Slot on the 5103-1-1 (Base Plate). Align the 5103-4-1 (Slide Adjust Nut) with the T-Slot. See Fig. 4.5.



**Fig. 4.4**



**Fig. 4.5**

7. Slide Rubber Roll Assembly toward the 5103-03-01 (Wedge Rotor Assembly) and tighten the 7102-2-20 (Socket Head Cap Screw)

## Rubber Roll Adjustment

1. Slightly loosen the 7102-2-20 (Socket Head Cap Screw), just enough so the Rubber Roll Assembly will slide in the T-Slot. See Fig. 4.6.

**Fig. 4.6**



2. Apply slight pressure of the Rubber Roll Assembly to the 5103-03-01 (Wedge Rotor Assembly), and tighten the 7102-2-20 (Socket Head Cap Screw).



### NOTE

When making this adjustment, Rubber Roll must **not** be in contact with Chopper Blade.

## Idler Adjustment

1. Slightly loosen the 7102-2-20 (Socket Head Cap Screw), just enough so the Idler Assembly will slide in the T-Slot. See Fig. 4.7.

**Fig. 4.7**



2. Slide the 5103-7-01 (Sleeve w/ Bearing) until it just makes contact with the 5106-6-1 (Rubber Roll).



### **NOTE**

Proper adjustment has Idler Assembly touching the Rubber Roll, but still able to rotate with minimum effort.

# ***SUPER PRO GUN***

## **Actuator Disassembly** 5106-01-01

See Figs. 9.1 & 9.2 for exploded schematic drawings

1. Unscrew the two 5105-13-1 (Rear Screws), and the two 5105-12-1 (Front Screws) to remove the 5106-00-01 (Cylinder Body Assembly) from the 5105-00-01 (Gun Handle Assembly).
2. Remove the two 5106-4-1 (Cylinder Caps) from the 5106-1-1 (Cylinder Body). Remove and discard the two 7301-3-020 (O-Rings) from the 5106-4-1 (Cylinder Caps).
3. Push the 5106-7-1 (Actuator Piston) out of the back of the 5106-1-1 (Cylinder Body). Remove and discard the 7301-3-020 (O-Ring) from the Actuator Piston.



### **NOTE**

Discard all parts to be replaced by repair kit. All remaining parts should be thoroughly cleaned, inspected for damage, and replaced if necessary.



# ***SUPER PRO GUN***

## **Handle Disassembly** 5105-00-01

See Figs. 9.3 & 9.4 for exploded schematic drawings

1. Remove and discard the 5105-7-1 (Cylinder Gasket), and the 5105-6-1 (Toggle Washer) from the 5105-5-1 (Porting Plate).
2. Remove the 5105-5-1 (Porting Plate) from the 5105-1-1 (Gun Handle).
3. Remove the 5105-4-1 (Porting Plate Gasket), 5105-3-1 (Slide Valve), and the 9203-2-1 (Compression Spring) from the 5105-1-1 (Gun Handle). Discard the Porting Plate Gasket and Compression Spring.
4. Remove the two 7102-8-8 (Slotted Pan HD Mach Screws) to remove the 5105-2-1 (Trigger Guard).
5. Remove 7102-10-12 (Slotted Flat Head Screw), and slide the 5105-16-01 (Trigger Assembly) out from under the 5105-14-1 (Trigger Stem).
6. Remove the 5105-10-1 (Trigger Nut) from the 5105-1-1 (Gun Handle).

7. Remove and discard the 5105-9-1 (Trigger Nut Seal), and the 7304-4-1 (Lip Seal) from the 5105-10-1 (Trigger Nut)



**NOTE**

Discard all parts to be replaced by repair kit. All remaining parts should be thoroughly cleaned, inspected for damage, and replaced if necessary.

## ***SUPER PRO GUN II***

Handle Disassembly 5110-7-1

**See Figs. 9.5 & 9.6 for exploded schematic drawings**

1. Remove and discard the 5110-6-1 (Cylinder Gasket), and the 5105-6-1 (Toggle Washer) from the 5110-1-1 (Porting Plate).
2. Remove the 5110-1-1 (Porting Plate) from the 5110-7-1 (Gun Handle).
3. Remove the 5110-5-1 (Handle Gasket) and the 5110-2-1 (Slide Valve).



**NOTE**

For two stage trigger, chopper gun handle only. Remove the 5110-3-1 (Detent Plate).

Remove the 9203-2-1 (Compression Spring) from the 5110-7-1 (Gun Handle). Discard the Gun Handle Gasket and Compression Spring.

4. Remove the two 7102-8-8 (Slotted Pan HD Mach Screws) to remove the 5105-2-1 (Trigger Guard).
5. Remove 7102-10-12 (Slotted Flat Head Screw), and slide the 5105-15-01 (Pivot Plate) out from under the 5110-4-1 (Trigger Stem).
6. Remove the 5105-10-1 (Trigger Nut) from the 5110-7-1 (Gun Handle).
7. Remove and discard the 5105-9-1 (Trigger Nut Seal), and the 7304-4-1 (Lip Seal) from the 5105-10-1 (Trigger Nut)



**NOTE**

Discard all parts to be replaced by repair kit. All remaining parts should be thoroughly cleaned, inspected for damage, and replaced if necessary.

# ***SUPER PRO GUN***

## **Gun Block Disassembly** 5104-00-01

See Figs. 9.9 - 9.12 for exploded schematic drawings

1. Remove the four 5106-6-1 (Mounting Screws), and the four 5106-3-1 (Mounting Seals) to remove the 5104-00-01 (Gun Block Assembly) from the 5106-00-01 (Gun Actuator Assembly).
2. Remove the two 7102-1-6 (Socket Head Cap Screws) to remove the 5104-20-1 (Mix Housing) from the Gun Block Assembly.
3. Remove the 5104-12-1 (Mix Housing Seal), and the 5104-17-1 (Distribution Ring) from the 5104-20-1 (Mix Housing).
4. Remove the 5104-03-01 (Injector Assembly), from the Gun Block Assembly.
5. Remove the 5104-32-1 (Plug) from the 5104-1-1 (Gun Block).
6. Remove the 5104-32-1 (Plug), and the 7301-15-125 (O-Ring) from the 5104-1-1 (Gun Block).
7. Remove the 5104-9-1 (Resin Fitting), and the (7301-14-904 (O-Ring) from the 5104-1-1 (Gun Block).
8. Remove the 7701-3-6 (Catalyst Fitting), and 7301-10-903 (O-Ring), from the 5104-1-1 (Gun Block).
9. Remove 5104-11-1 (Actuating Stem) from the 5104-2-1 (Valve Rod).
10. Remove both 5104-8-1 (Packing Nuts) from the 5104-1-1 (Gun Block).
11. Gently tap the 5104-2-1 (Valve Rod) from Gun Block using the 9301-5-1 (Seal-Installation Tool).
12. Remove 5104-10-1 (Center Spacer).

13. Using the 9301-5-1 (Seal Installation Tool), force the Seal Assembly out of the Gun Block.



**NOTE**

Seal Assembly consists of; two 5104-7-1 (Packing Rings), two 5104-4-1 (Relief Spacers), two 5104-3-1 (Secondary Seals), One 5104-6-1 (Teflon Catalyst Seal), and one 5104-5-1 (Teflon Resin Seal).

**Flush Valve Disassembly Procedures:**

1. Remove and discard the 5104-21-1 (Flush Valve Split Seal) from the 5104-24-1 (Flush Valve Body).
2. Remove the 5104-02-01 (Flush Elbow Assembly) from 5104-22-1 (Flush Valve Neck).
3. Remove the 5104-22-1 (Flush Valve Neck) and 5104-26-1 (Flush Valve Seal) from the 5104-24-1 (Flush Valve Body). Discard the 5104-26-1 (Flush Valve Seal).
4. Remove the 5104-23-1 (Flush Seal Body) from the 5104-25-1 (Flush Valve Button).
5. Remove the 9203-2-3 (Compression Spring) from the 5104-24-1 (Flush Valve Body).
6. Remove and discard the 7301-3-007 (O-Ring) from the 5104-23-1 (Flush Seal Body).
7. Remove and discard the 7301-11-008 (O-Ring) from the 5104-25-1 (Flush Valve Button).



**NOTE**

Discard all parts to be replaced by repair kit. All remaining parts should be thoroughly cleaned, inspected for damage, and replaced if necessary.

# ***SUPER PRO GUN***

## **SuperCutter Disassembly**

**5103-00-01**

**See Figs. 9.13 - 9.20 for exploded schematic drawings**

1. Unscrew the 5103-14-1 (Cover Nut) and remove the 5103-13-1 (Chopper Cover) from the 5103-00-01 (Roving Cutter Basic Assembly).

*The remainder of the disassembly covered in this manual pertains to the rubber roll and the rotor.*

### **Rubber Roll Disassembly**

2. To remove the Rubber Roll Assembly, loosen the 7102-2-20 (Socket Cap Screw) enough to slide the 5103-4-1 (Slide Adjust Nut) from the slot in the 5301-1-1 (Base Plate)
3. With a screw Driver, remove the 7205-3-31 (E-Ring), and slide the 5103-6-1 (Rubber Roll) off the 5403-5-01 (Mandrel Assembly).

## Rotor Disassembly

4. Loosen the two 7102-14-6 (Socket Cup Point Set Screws), and slide the 5103-03-01 (8-Blade Rotor Assembly) off of the 8402-1-1 (Air Motor) shaft.



### NOTE

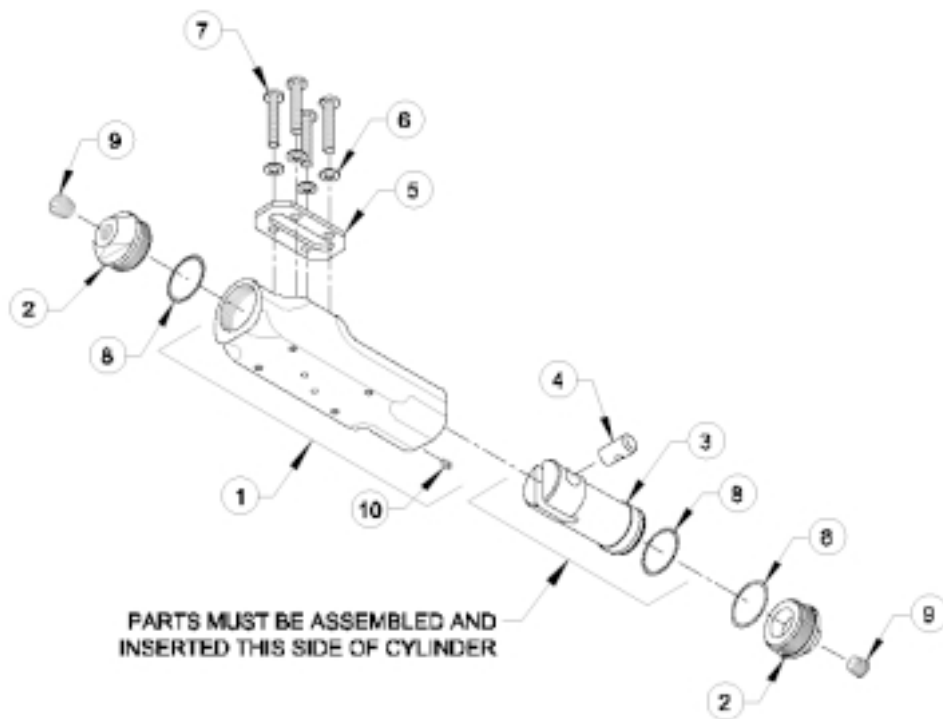
Be very careful when handling the Rotor Assembly as the blades are sharp and could cause injury.

5. Loosen the 7102-13-6 (Socket Flat Head Screws) used to secure the 5103-29-1 (Wedge Inserts), and remove the 9210-1-1 (Chopper Blades) from the 5103-03-01 8-Blade Wedge Rotor Assembly)

# ***SUPER PRO GUN & SUPER PRO GUN II***

## **Assembly Drawings**

Fig. 9.1



# MAGNUM VENUS PRODUCTS

Gun Actuator Assy

VFTC-4200

VFTC-4200-DWG REV. - 3-22-01



# Fig. 9.2

## Gun Actuator Assy VFTC-4200

### PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	5106-1-01	1	CYLINDER BODY SPA
2	5106-4-1	2	CYLINDER CAP
3	5106-7-1	1	ACTUATOR PISTON
4	5106-5-1	1	ACTUATOR BUSHING
5	5106-2-1	1	ACTUATOR SEAL
6	5106-3-1	4	MOUNTING SEAL
7	5106-6-1	4	MOUNTING SCREW
8	7301-3-020	3	O-RING
9	7701-4-2	2	PLUG
10	7102-7-1	1	SS METRIC SET SCREW
11	VFTC-4200-DWG	1	GUN ACTUATOR ASSY DWG

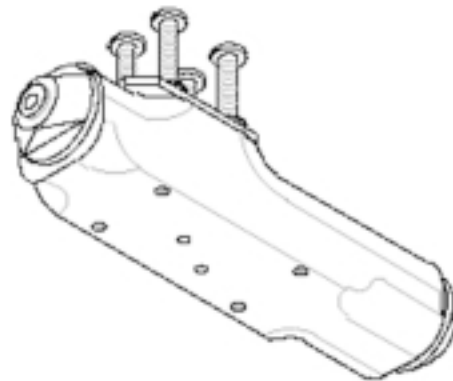
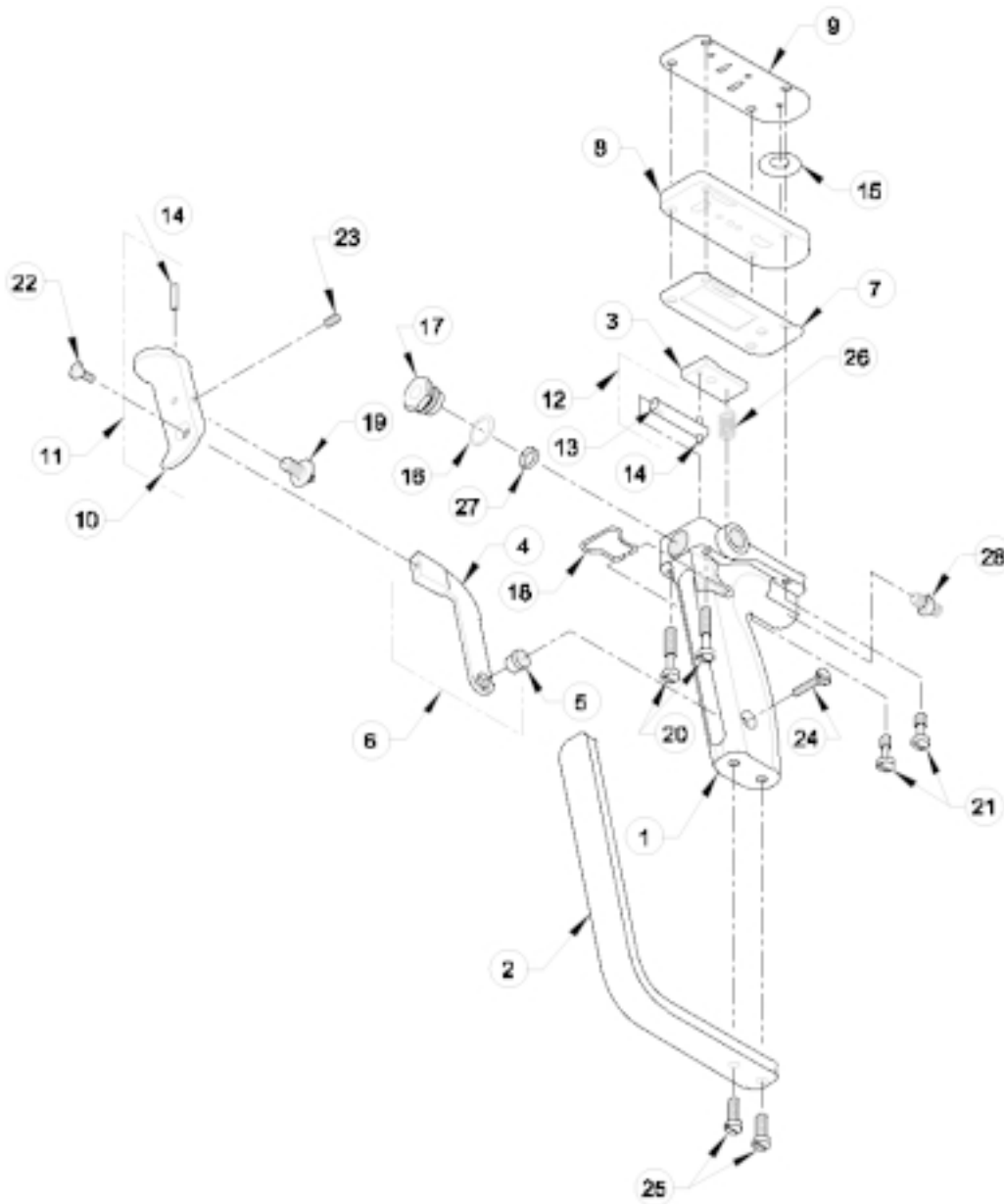


Fig. 9.3



# ***SUPER PRO GUN***

## **MAGNUM VENUS PRODUCTS**

**GH1S1 Gun Handle Assy**

**5105-00-01**

05105-00-1 REV. - 3/20/00

# Fig. 9.4

## GH1S1 Gun Handle Assy 5105-00-01

### PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	5105-1-1	1	GUN HANDLE
2	5105-2-1	1	TRIGGER GUARD
3	5105-3-1	1	SLIDE VALVE
4	5105-15-1	1	PIVOT PLATE
5	5105-15-2	1	PIVOT PLATE BUSHING
6	5105-15-01	1	PIVOT PLATE SPA
7	5105-4-1	1	PORTING PLATE GASKET
8	5105-5-1	1	PORTING PLATE
9	5105-7-1	1	CYLINDER GASKET
10	5105-16-1	1	TRIGGER
11	5105-18-01	1	TRIGGER SPA
12	5105-14-01	1	TRIGGER STEM SPA
13	5105-14-1	1	TRIGGER STEM
14	7203-4-9	2	SLOTTED SPRING PIN
15	5105-8-1	1	TOGGLE WASHER
16	5105-9-1	1	TRIGGER NUT SEAL
17	5105-10-1	1	TRIGGER NUT
18	5105-8-1	1	TRIGGER LOCK
19	5105-11-1	1	TRIGGER LOCK SCREW
20	5105-12-1	2	FRONT SCREW
21	5105-13-1	2	REAR SCREW
22	7102-10-8	1	SLOTTED FLAT HD SCREW
23	7102-6-4	1	SOCKET CUP POINT SET SCREW
24	7102-10-12	1	SLOTTED FLAT HD SCREW
25	7102-6-8	2	SLOTTED PAN HD SCREW
26	9203-2-1	1	COMPRESSION SPRING
27	7304-4-1	1	LIP SEAL
28	7701-3-9	1	BUSHING FITTING
29	05105-00-1	1	GH1S1 GUN HANDLE ASSY DRAWING

### REPAIR KITS

PART NO.	DESCRIPTION
6702-2-1	SUPER PRO GUN REPAIR KIT

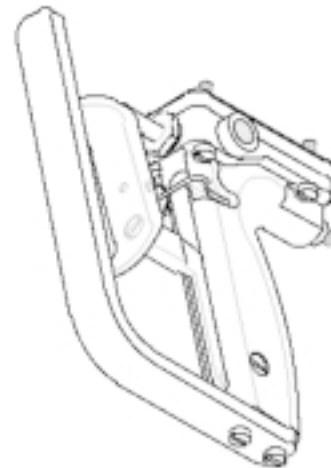
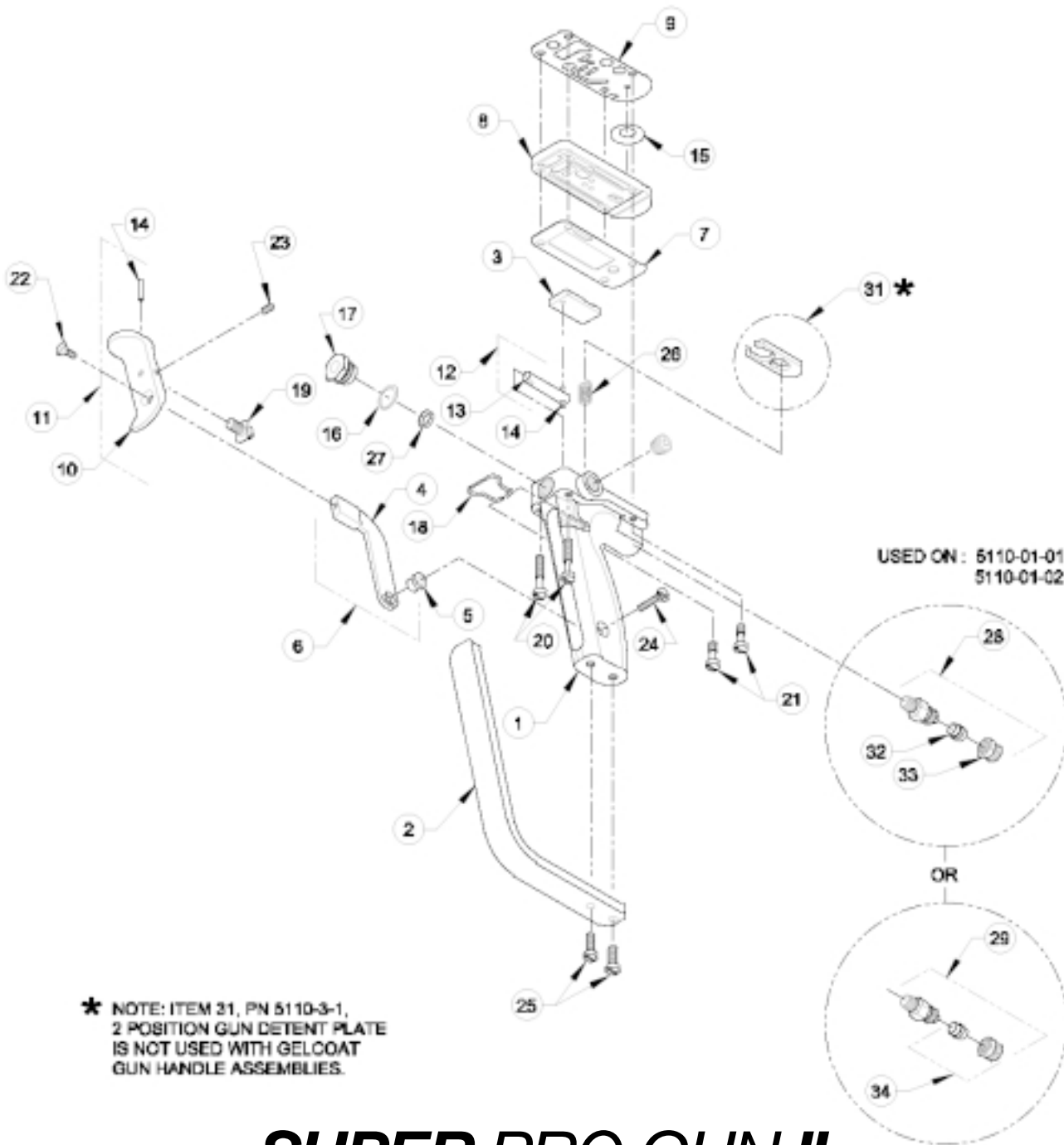


Fig. 9.5



\* NOTE: ITEM 31, PN 5110-3-1, 2 POSITION GUN DETENT PLATE IS NOT USED WITH GELCOAT GUN HANDLE ASSEMBLIES.

USED ON: 5110-01-01  
5110-01-02

USED ON: 5110-01-03

# SUPER PRO GUN II

## MAGNUM VENUS PRODUCTS

- GH2S1 Chopper Gun Handle Assy 5110-01-01
- GH2S1 Gelcoat Gun Handle Assy 5110-01-02
- Retro Gelcoat Gun Handle Assy 5110-01-03

D5110-01-1 REV. B 02/19/01

# Fig. 9.6

## Common Assembly Parts For:

GH2S1 Chopper Gun Handle Assy 5110-01-01

GH2S1 Gelcoat Gun Handle Assy 5110-01-02

Retro Gelcoat Gun Handle Assy 5110-01-03

ITEM	PART NO.	QTY	DESCRIPTION
1	5110-7-1	1	2 POSITION GUN HANDLE
2	5105-2-1	1	TRIGGER GUARD
3	5110-2-1	1	2 POSITION GUN SLIDE VALVE
4	5105-15-1	1	PIVOT PLATE
5	5105-15-2	1	PIVOT PLATE BUSHING
7	5110-5-1	1	GUN HANDLE GASKET
8	5110-1-1	1	2 POSITION GUN PORTING PLATE
9	5110-6-1	1	2 POSITION GUN CYLINDER GASKET
10	5105-16-1	1	TRIGGER
13	5110-4-1	1	2 POSITION GUN TRIGGER STEM
14	7203-4-8	2	SLOTTED SPRING PIN
15	5105-6-1	1	TOGGLE WASHER
16	5105-8-1	1	TRIGGER NUT SEAL
17	5105-10-1	1	TRIGGER NUT
18	5105-8-1	1	TRIGGER LOCK
19	5110-8-1	1	TRIGGER LOCK SCREW
20	5105-12-1	2	FRONT SCREW
21	5105-13-1	2	REAR SCREW
22	7102-10-8	1	SLOTTED FLAT HD SCREW
23	7102-6-4	1	SOCKET CUP POINT SET SCREW
24	7102-10-12	1	SLOTTED FLAT HD SCREW
25	7102-8-8	2	SLOTTED PAN HD SCREW
26	9203-2-1	1	COMPRESSION SPRING
27	7304-4-1	1	LIP SEAL
35	D5110-01-1	1	GH2S1 GUN HANDLE ASSY DRAWING

GH2S1 Chopper Gun Handle Assy 5110-01-01

ITEM	PART NO.	QTY	DESCRIPTION
*31	5110-3-1	1	2 POSITION GUN DETENT PLATE
28	7701-6-4	1	STRAIGHT POLY FITTING

GH2S1 Gelcoat Gun Handle Assy 5110-01-02

ITEM	PART NO.	QTY	DESCRIPTION
28	7701-6-4	1	STRAIGHT POLY FITTING

Retro Gelcoat Gun Handle Assy 5110-01-03

ITEM	PART NO.	QTY	DESCRIPTION
29	7701-6-14	1	STRAIGHT POLY FITTING

## OPTIONAL PARTS AND ASSEMBLIES

ITEM	PART NO.	QTY	DESCRIPTION
6	5105-15-01	1	PIVOT PLATE SPA
11	5105-16-01	1	TRIGGER SPA
12	5110-4-01	1	2 POSITION GUN TRIGGER STEM SPA
32	7701-6-5	1	POLY-FLO FERRULE
33	7701-6-6	1	POLY-FLO NUT
34	7701-6-11	1	POLY-FLO NUT W/ FERRULE

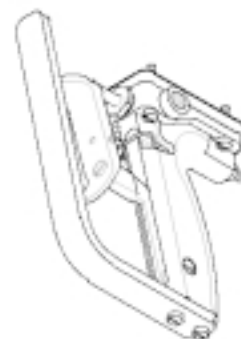
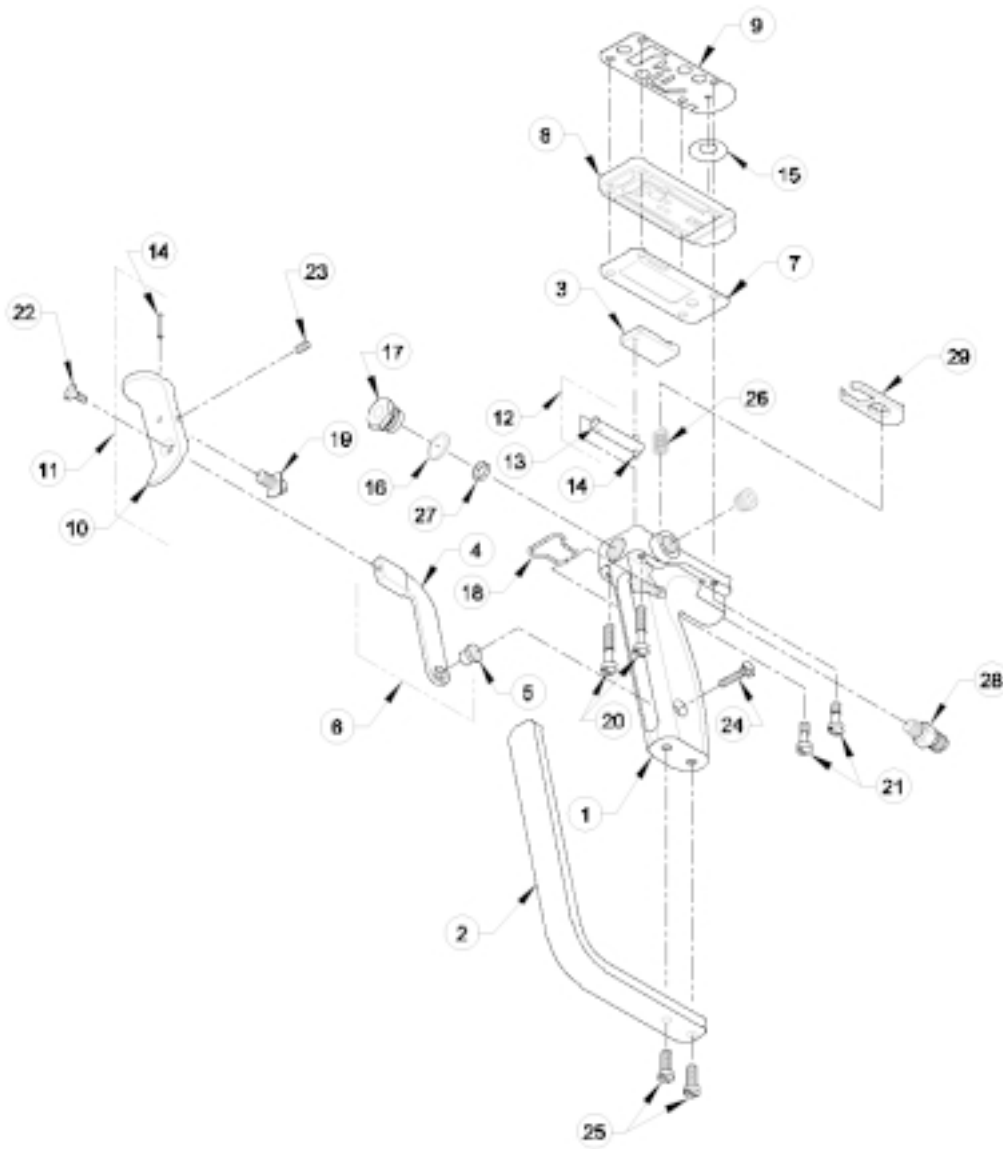


Fig. 9.7



## MAGNUM VENUS PRODUCTS

SuperPro II - FIT Chopper Gun Handle Assy

VFTC-4300

VFTC-4300-DWG REV. - 3-22-01

# Fig. 9.8

## SuperPro II - FIT Chopper Gun Handle Assy VFTC-4300

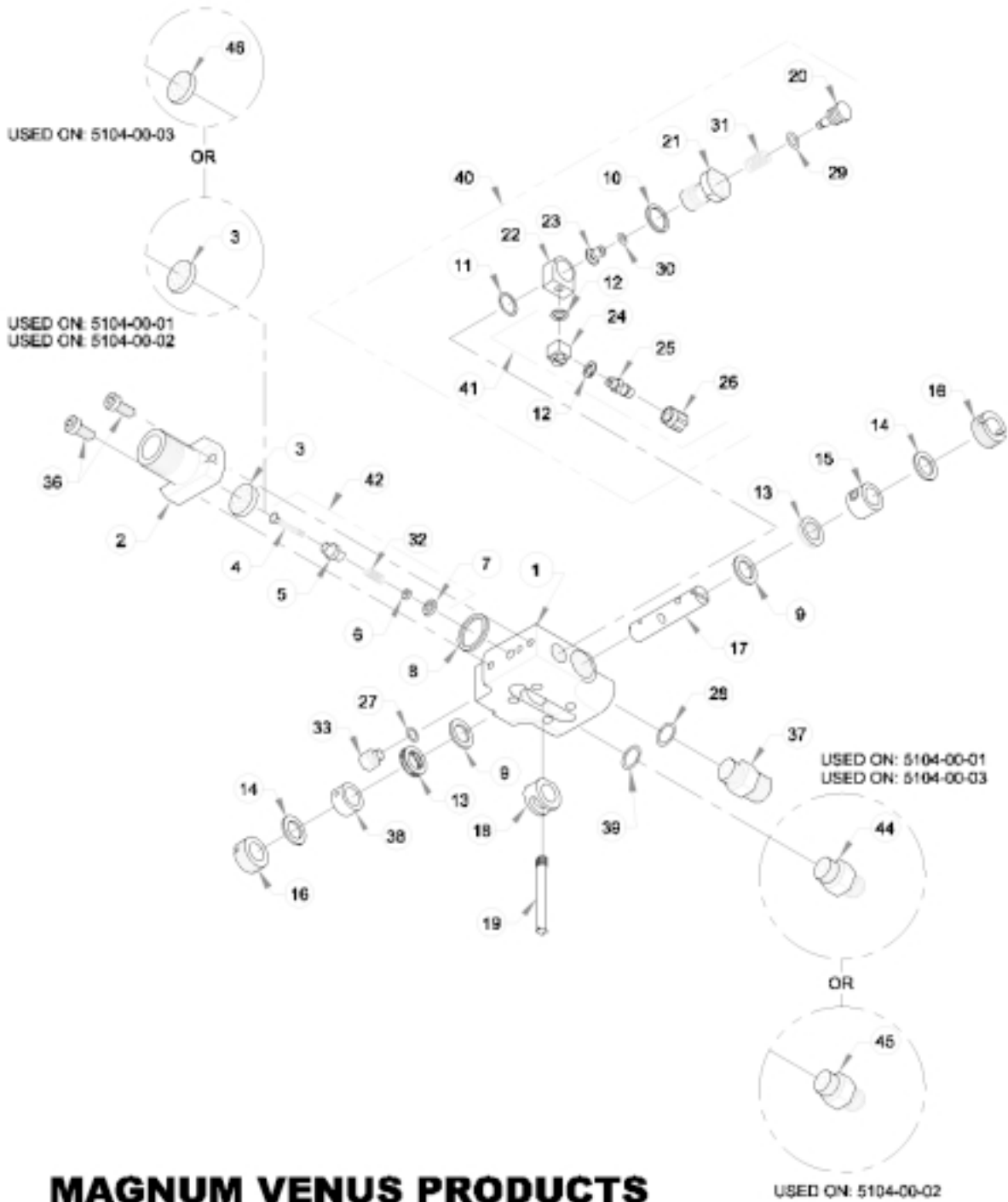
ITEM	PART NO.	QTY	DESCRIPTION
1	5110-7-1	1	2 POSITION GUN HANDLE
2	5105-2-1	1	TRIGGER GUARD
3	5110-2-1	1	2 POSITION GUN SLIDE VALVE
4	5105-15-1	1	PIVOT PLATE
5	5105-15-2	1	PIVOT PLATE BUSHING
7	5110-5-1	1	GUN HANDLE GASKET
8	5110-1-1	1	2 POSITION GUN PORTING PLATE
9	5110-6-1	1	2 POSITION GUN CYLINDER GASKET
10	5105-16-1	1	TRIGGER
13	5110-4-1	1	2 POSITION GUN TRIGGER STEM
14	7203-4-9	2	SLOTTED SPRING PIN
15	5105-8-1	1	TOGGLE WASHER
16	5105-9-1	1	TRIGGER NUT SEAL
17	5105-10-1	1	TRIGGER NUT
18	5105-8-1	1	TRIGGER LOCK
19	5110-8-1	1	TRIGGER LOCK SCREW
20	5105-12-1	2	FRONT SCREW
21	5105-13-1	2	REAR SCREW
22	7102-10-8	1	SLOTTED FLAT HD SCREW
23	7102-6-4	1	SOCKET CUP POINT SET SCREW
24	7102-10-12	1	SLOTTED FLAT HD SCREW
25	7102-8-8	2	SLOTTED PAN HD SCREW
26	9203-2-1	1	COMPRESSION SPRING
27	7304-4-1	1	LIP SEAL
28	PF-HN-02-04S	1	FITTING
29	5110-3-1	1	2 POSITION GUN DETENT PLATE
30	VFTC-4300-DWG	1	SUPERPRO II - FIT CHOPPER GUN HANDLE ASSY DWG

### OPTIONAL PARTS AND ASSEMBLIES

ITEM	PART NO.	QTY	DESCRIPTION
6	5105-15-01	1	PIVOT PLATE SPA
11	5105-16-01	1	TRIGGER SPA
12	5110-4-01	1	2 POSITION GUN TRIGGER STEM SPA
32	7701-6-5	1	POLY-FLO FERRULE
33	7701-6-6	1	POLY-FLO NUT
34	7701-6-11	1	POLY-FLO NUT W/ FERRULE



**Fig. 9.9**



**MAGNUM VENUS PRODUCTS**

- GB1S1 Gun Block Assy	5104-00-01
- Chargeable Gun Block Assy	5104-00-02
- GB1S1 Abrasive Gun Block Assy	5104-00-03

DS104-00-1 REV. D 3/9/01



# Fig. 9.10

Common Assembly Parts For:  
 GB1S1 Gun Block Assy 5104-00-01  
 Chargeable Gun Block Assy 5104-00-02  
 GB1S1 Abrasive Gun Block Assy 5104-00-03

## OPTIONAL PARTS AND ASSEMBLIES

PARTS LIST			
ITEM	PART NO.	QTY	DESCRIPTION
1	5104-1-1	1	GUN BLOCK
2	5104-20-1	1	MX HOUSING
4	5104-18-1	1	INJECTOR PLUNGER
5	5104-15-1	1	INJECTOR BODY
6	5104-14-1	1	PLUNGER RETAINER
7	5104-13-1	1	INJECTOR SEAL
8	5104-12-1	1	MIX HOUSING SEAL
9	5104-3-1	2	SECONDARY SEAL
10	5104-28-1	1	FLUSH VALVE SEAL
11	5104-21-1	1	FLUSH VALVE SPLIT SEAL
12	7304-3-1	2	NYLON SEAL
13	5104-4-1	2	RELIEF SPACER
14	5104-7-1	2	PACKING RING
16	5104-29-01	1	FILLED RESIN SEAL ASSY
16	5104-8-1	2	PACKING NUT
17	5104-2-1	1	VALVE ROD
18	5104-10-1	1	CENTER SPACER
19	5104-11-1	1	ACTUATING STEM
20	5104-25-1	1	FLUSH VALVE BUTTON
21	5104-24-1	1	FLUSH VALVE BODY
22	5104-22-1	1	FLUSH VALVE NECK
23	5104-23-1	1	FLUSH SEAL BODY
24	7701-6-1	1	ELBOW FITTING
25	7701-6-3	1	BARB FITTING
26	7701-2-1	1	HOSE CLAMP
27	7301-15-125	1	O-RING
28	7301-14-004	1	O-RING
29	7301-11-008	1	O-RING
30	7301-3-007	1	O-RING
31	9203-2-3	1	COMPRESSION SPRING
32	9203-2-2	1	COMPRESSION SPRING
33	5104-32-1	1	PLUG
36	7102-1-8	2	SOCKET HEAD CAP SCREW
37	5104-9-1	1	RESIN FITTING
38	5104-6-1	1	TEFLON CATALYST SEAL
39	7301-10-803	1	O-RING
40	D5104-00-1	1	GB1S1 GUN BLOCK ASSY DRAWING

ITEM	PART NO.	QTY	DESCRIPTION
38	5104-18-1	1	CRITICAL MIX DIST RING
29B	7301-13-008	1	O-RING EPR (USE WITH ACETONE)
40	5104-01-01	1	FLUSH VALVE ASSEMBLY - GB1S1
41	5104-02-01	1	FLUSH ELBOW ASSEMBLY - GB1S1
42	5104-03-01	1	INJECTOR ASSEMBLY - GB1S1

### GB1S1 Gun Block Assy 5104-00-01

ITEM	PART NO.	QTY	DESCRIPTION
44	4114-2-1	1	CONNECTOR FITTING
3	5104-17-1	1	DISTRIBUTION RING

### Chargeable Gun Block Assy 5104-00-02

ITEM	PART NO.	QTY	DESCRIPTION
45	5104-27-1	1	CATALYST FITTING
3	5104-17-1	1	DISTRIBUTION RING

### GB1S1 Abrasive Gun Block Assy 5104-00-03

ITEM	PART NO.	QTY	DESCRIPTION
44	4114-2-1	1	CONNECTOR FITTING
46	5104-18-1	1	FILLED RESIN DIST RING

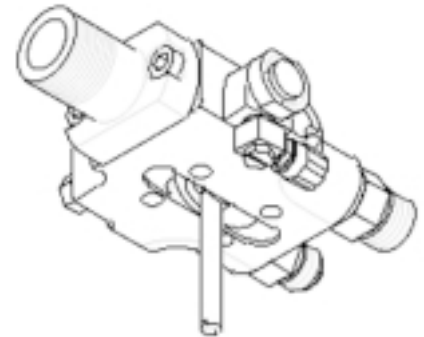
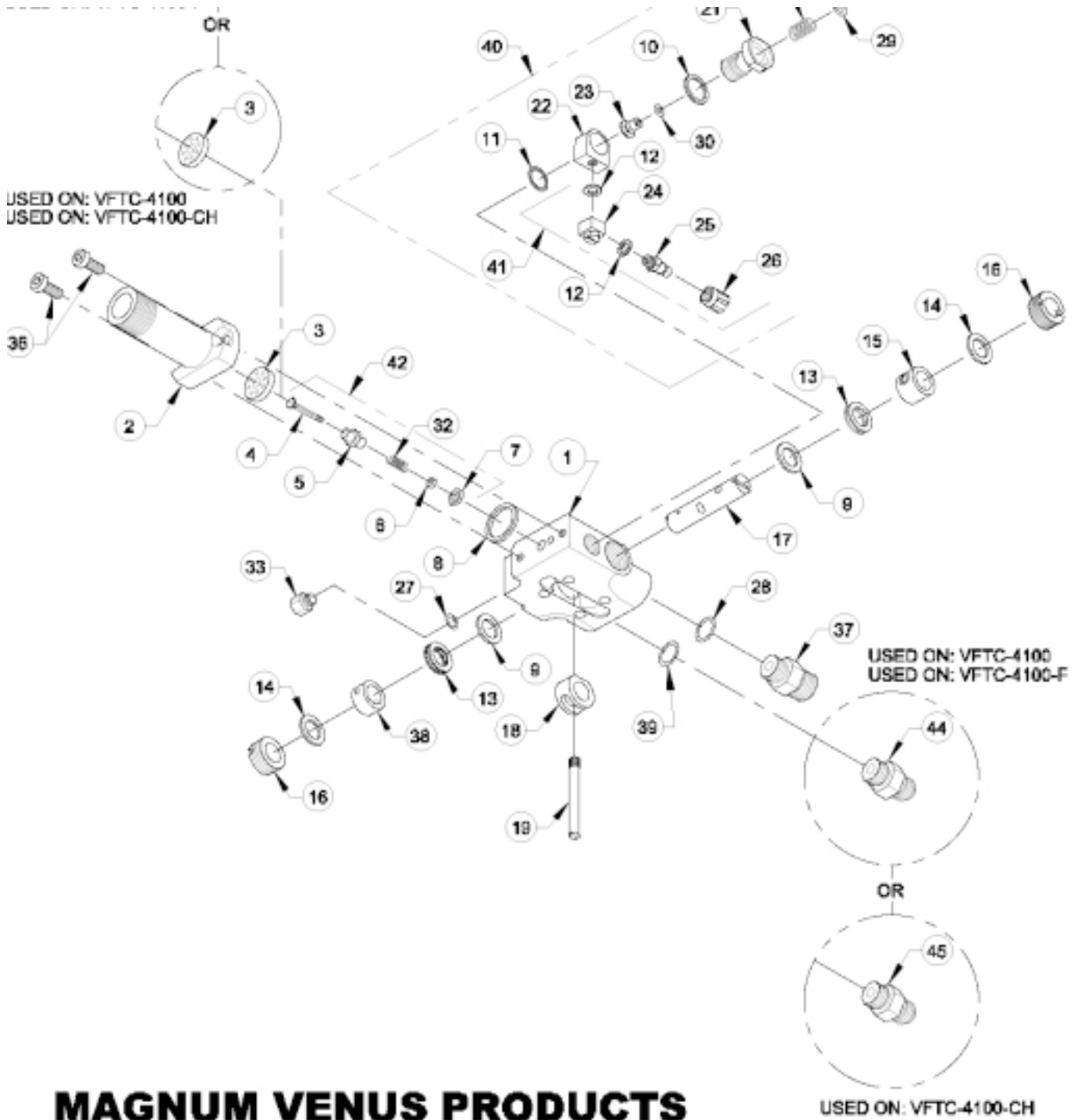


Fig. 9.11



## MAGNUM VENUS PRODUCTS

SuperPro II - FIT Gun Head Assy  
 SuperPro II - FIT Chargeable Gun Head Assy  
 SuperPro II - FIT Filled Gun Head Assy

VFTC-4100  
 VFTC-4100-CH  
 VFTC-4100-F

VFTC-4100-DWG REV. - 3-22-01

# Fig. 9.12

SuperPro II - FIT Chargeable Gun Head Assy VFTC-4100-CH  
 SuperPro II - FIT Filled Gun Head Assy VFTC-4100-F

PARTS LIST				OPTIONAL PARTS AND ASSEMBLIES			
ITEM	PART NO.	QTY	DESCRIPTION	ITEM	PART NO.	QTY	DESCRIPTION
1	5104-1-1	1	GUN BLOCK	38	5104-18-1	1	CRITICAL MIX DIST RING
2	VPG-1001	1	MIX HOUSING	29B	7301-13-008	1	O-RING EPR (USE WITH ACETONE)
4	5104-10-1	1	INJECTOR PLUNGER	40	5104-01-01	1	FLUSH VALVE ASSEMBLY
5	5104-15-1	1	INJECTOR BODY	41	5104-02-01	1	FLUSH ELBOW ASSEMBLY
6	5104-14-1	1	PLUNGER RETAINER	42	5104-03-01	1	INJECTOR ASSEMBLY
7	5104-13-1	1	INJECTOR SEAL				
8	5104-12-1	1	MIX HOUSING SEAL				
9	5104-3-1	2	SECONDARY SEAL				
10	5104-26-1	1	FLUSH VALVE SEAL				
11	5104-21-1	1	FLUSH VALVE SPLIT SEAL				
12	7304-3-1	2	NYLON SEAL				
13	5104-4-1	2	RELIEF SPACER				
14	5104-7-1	2	PACKING RING				
15	5104-29-01	1	FILLED RESIN SEAL ASSY				
16	5104-8-1	2	PACKING NUT				
17	5104-2-1	1	VALVE ROD				
18	5104-10-1	1	CENTER SPACER				
19	5104-11-1	1	ACTUATING STEM				
20	5104-25-1	1	FLUSH VALVE BUTTON				
21	5104-24-1	1	FLUSH VALVE BODY				
22	5104-22-1	1	FLUSH VALVE NECK				
23	5104-23-1	1	FLUSH SEAL BODY				
24	7701-6-1	1	ELBOW FITTING				
25	7701-6-3	1	BARB FITTING				
26	7701-2-1	1	HOSE CLAMP				
27	7301-15-125	1	O-RING				
28	7301-14-904	1	O-RING				
29	7301-11-008	1	O-RING				
30	7301-3-007	1	O-RING				
31	9203-2-3	1	COMPRESSION SPRING				
32	9203-2-2	1	COMPRESSION SPRING				
33	5104-32-1	1	GUN HEAD PLUG				
36	7102-1-6	2	SOCKET HEAD CAP SCREW				
37	VPG-1066	1	RESIN FITTING				
38	5104-6-1	1	TEFLON CATALYST SEAL				
39	7301-10-903	1	O-RING				
48	VFTC-4100-DWG	1	SUPERPRO II - FIT GUN BLOCK ASSY DWG				

SuperPro II - FIT Gun Head Assy VFTC-4100

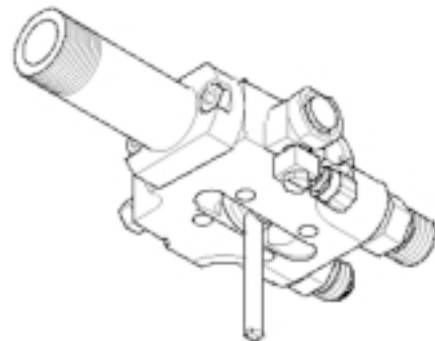
ITEM	PART NO.	QTY	DESCRIPTION
44	4114-2-1	1	CONNECTOR FITTING
3	5104-17-1	1	DISTRIBUTION RING

SuperPro II - FIT Chargeable Gun Head Assy VFTC-4100-CH

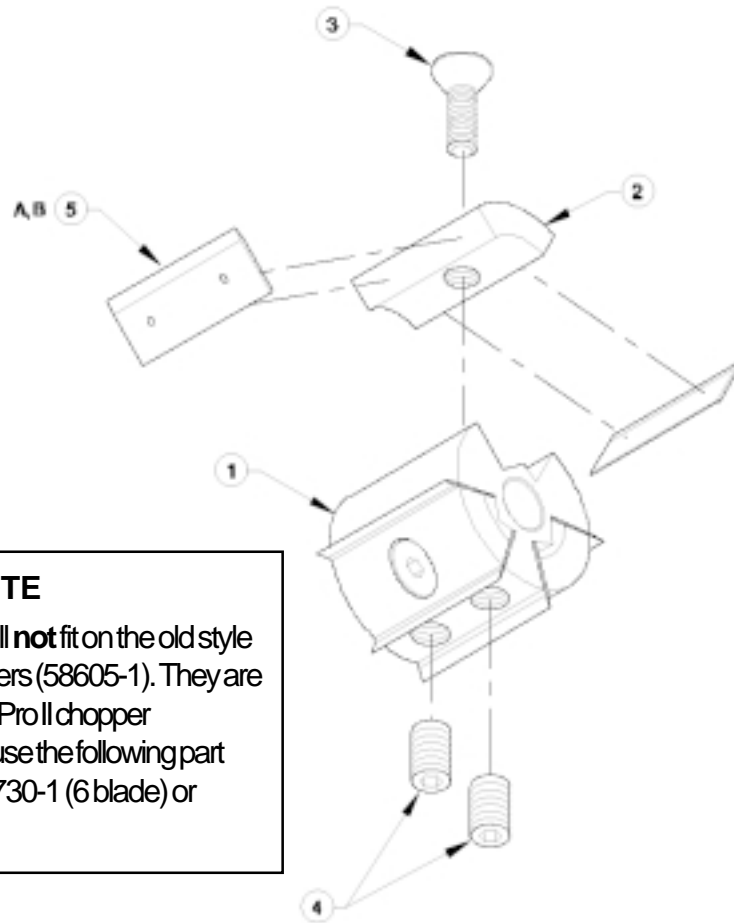
ITEM	PART NO.	QTY	DESCRIPTION
45	5104-27-1	1	CATALYST FITTING
3	5104-17-1	1	DISTRIBUTION RING

SuperPro II - FIT Filled Gun Head Assy VFTC-4100-F

ITEM	PART NO.	QTY	DESCRIPTION
44	4114-2-1	1	CONNECTOR FITTING
46	5104-18-1	1	FILLED RESIN DIST RING



**Fig. 9.13**



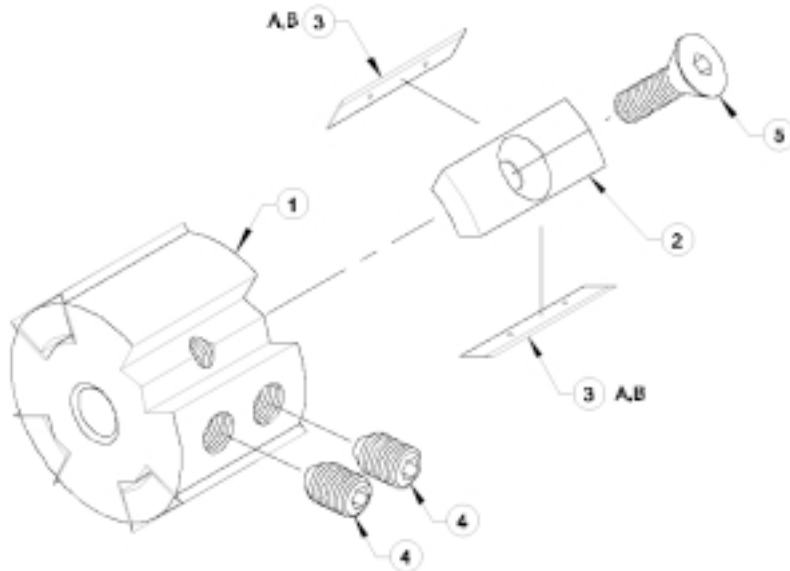
**NOTE**

These wedge rotors will **not** fit on the old style "classic" pro gun choppers (58605-1). They are for SuperPro and SuperPro II chopper configurations. Please use the following part numbers for rotors: 77730-1 (6 blade) or 77731-1 (8 blade).

**MAGNUM VENUS PRODUCTS**

- 6-BLADE WEDGE ROTOR ASSY - RC1S1 5103-04-01

06103-04-1 REV. - 3/20/00



**MAGNUM VENUS PRODUCTS**

- 8-Blade Wedge Rotor Assy - RC1S1 5103-03-01

## Fig. 9.14

### 8-Blade Wedge Rotor Assy - RC1S1 5103-03-01

#### PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	5103-25-1	1	ROTOR HUB - 8-BLADE
2	5103-29-1	4	WEDGE INSERT - 8-BLADE
3	5103-5-1	8	CHOPPER BLADE
4	7102-11-6	2	SOCKET HD CLIP POINT SET SCREW
5	7102-13-6	4	SOCKET FLAT HEAD SCREW
6	D5103-03-1	1	8-BLADE WEDGE ROTOR ASSY - RC 1S1 DWG

#### ASSOCIATED PARTS AND ASSEMBLIES

ITEM	PART NO.	QTY	DESCRIPTION
3A	9210-1-100	1	BLADES (PACKAGE OF 100)
3B	5103-5-1000	1	BLADES (PACKAGE OF 1000)

### 6-Blade Wedge Rotor Assy - RC1S1 5103-04-01

#### PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	5103-30-1	1	ROTOR HUB - 6-BLADE
2	5103-31-1	3	WEDGE INSERT - 6-BLADE
3	7102-13-8	3	SOCKET FLAT HEAD SCREW
4	7102-11-6	2	SOCKET CUT POINT SET SCREW
5	5103-5-1	6	CHOPPER BLADE
6	D5103-04-1	1	6-BLADE WEDGE ROTOR ASSY - RC1S1 DWG

#### ASSOCIATED PARTS AND ASSEMBLIES

ITEM	PART NO.	QTY	DESCRIPTION
5A	9210-1-100	1	BLADES (PACKAGE OF 100)
5B	5103-5-1000	1	BLADES (PACKAGE OF 1000)

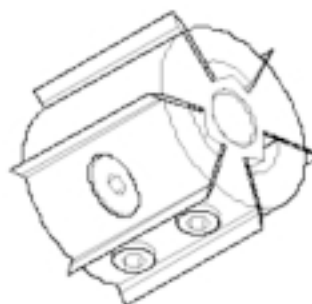
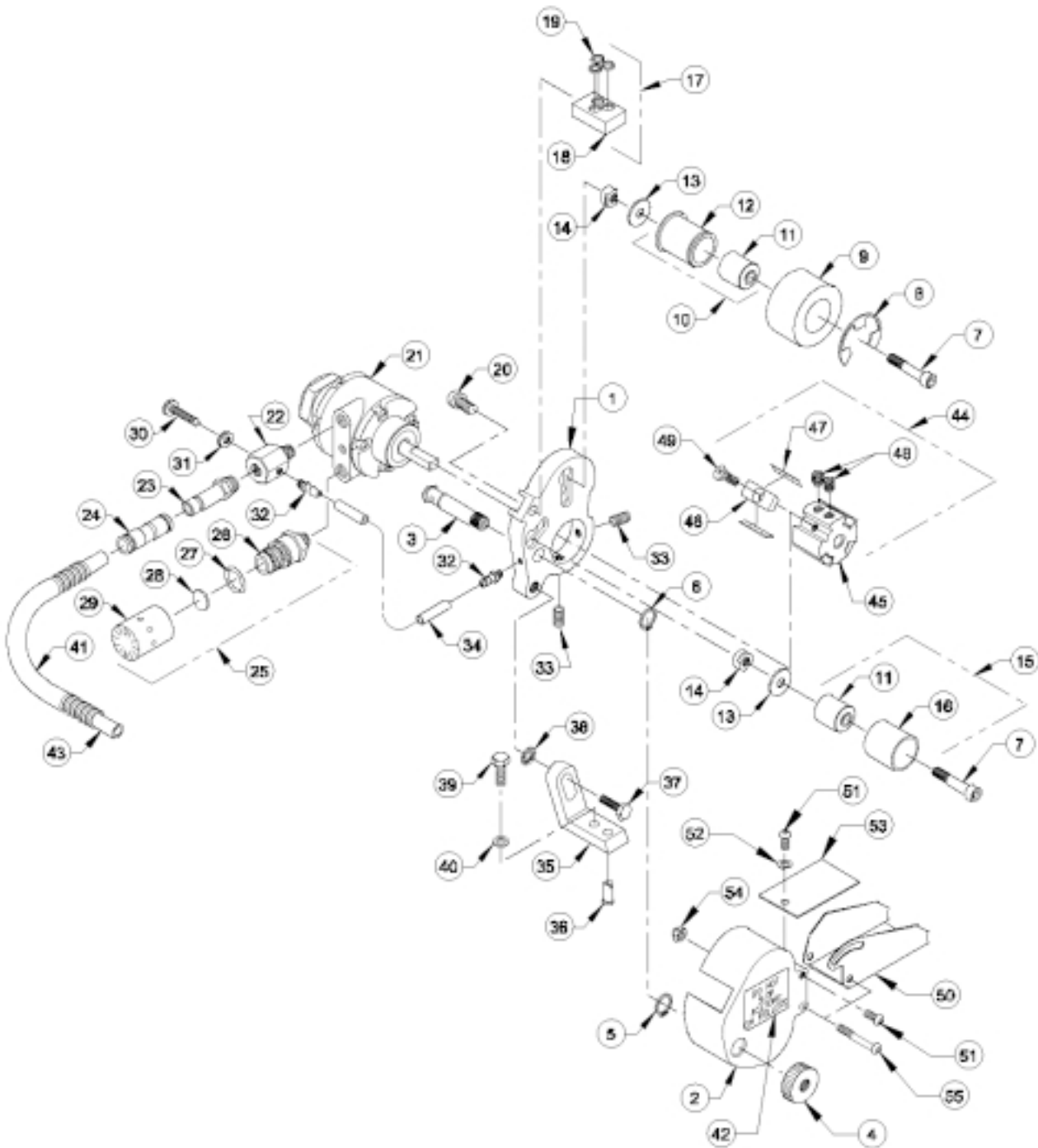


Fig. 9.15



## MAGNUM VENUS PRODUCTS

- SuperPro II - FIT Roving Cutter Assy

VRC-1000

VRC-1000-DWG8 REV. - 02/29/01

# Fig. 9.16

## SuperPro II - FIT Roving Cutter Assy VRC-1000

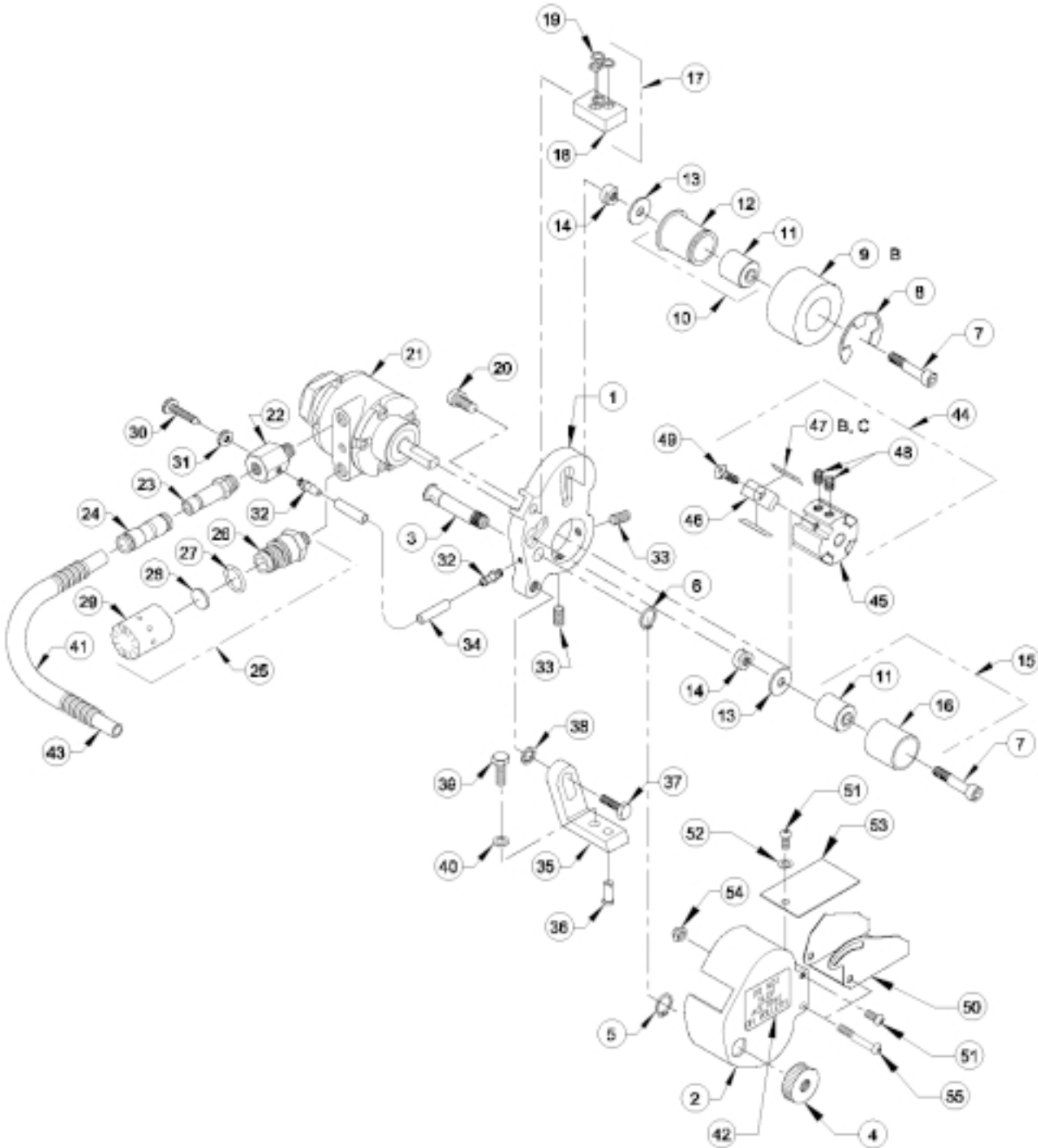
### PARTS LIST

PARTS LIST				OPTIONAL PARTS AND ASSEMBLIES			
ITEM	PART NO.	QTY	DESCRIPTION	ITEM	PART NO.	QTY	DESCRIPTION
1	5103-1-1	1	BASE PLATE	9B	5103-6-2	1	80 DURO RUBBER ROLL
2	5103-13-1	1	CHOPPER COVER	10	5103-5-01	1	MANDREL SPA
3	5103-2-01	1	AIR STUD SPA	15	5103-7-01	1	SLEEVE WEARING
4	5103-14-1	1	COVER NUT	16	5103-3-1	1	GUIDE BLOCK
5	7205-2-8	1	SNAP RING DIA 1/2"	19	9209-1-1	3	GUIDE
6	7205-2-8	1	SNAP RING DIA 3/8"	26	5103-02-01	1	SPEED CONTROL ASSY
7	7102-2-20	2	SOCKET HD CAP SCREW	44	5103-03-01	1	8-BLADE WEDGE ROTOR ASSY
8	7205-3-31	1	E-RING	47A	9210-1-100	1	BLADES (PACKAGE OF 100)
9	5103-6-1	1	70 DURO RUBBER ROLL	47B	9210-1-1000	1	BLADES (PACKAGE OF 1000)
11	9202-2-1	2	SEALED BALL BEARING				
12	5103-5-1	1	MANDREL				
13	5103-18-1	2	SPACER WASHER				
14	5103-4-1	2	SLIDE ADJ NUT				
16	5103-7-1	1	SLEEVE				
17	5103-3-01	1	ROVING GUIDE SPA				
20	7102-2-8	1	SOCKET HD CAP SCREW				
21	8402-1-1	1	AIR MOTOR				
22	5103-9-1	1	CHOPPER AIR VALVE				
23	5103-12-1	1	OILER DISCONNECT				
24	7701-6-8	1	PUSH-IN FITTING				
26	5103-19-1	1	SPEED CONTROL HOUSING				
27	7301-3-016	1	O-RING				
28	5103-20-1	1	SPEED CONTROL SEAL				
29	5103-21-1	1	SPEED CONTROL COVER				
30	5103-11-1	1	THUMBSCREW				
31	5103-10-1	1	LOCK RING				
32	7701-6-3	2	BARB FITTING				
33	7102-11-6	2	SOCKET CUP POINT SET SCREW				
34	09073	.331	URETHANE TUBING 1/4" OD				
35	5103-16-1	1	MOUNT BRACKET				
36	5103-17-1	1	ECCENTRIC STUD				
37	7101-7-8	1	HEX HD BOLT				
38	7202-5-10	1	INTERNAL STAR WASHER HEAVY DUTY				
39	7101-1-8	1	HEX HEAD BOLT				
40	7202-4-8	1	LOCK WASHER				
41	5103-15-01	1	CHOPPER CONDUIT				
42	6701-5-EN	1	LABEL				
43	00004	1	3/8" POLY TUBING BLACK				
45	5103-28-1	1	ROTOR HUB 8-BLADE				
46	5103-29-1	4	WEDGE INSERT 8-BLADE				
47	5103-8-1	8	CHOPPER BLADE				
48	7102-11-6	2	SOCKET CUP POINT SET SCREW				
49	7102-13-8	4	SOCKET FLAT HEAD SCREW				
50	5103-24-1	1	CHOPPER CHUTE				
51	7102-16-6	2	SOCKET BUTTON HEAD SCREW				
52	7202-6-10	1	LOCK WASHER				
53	5103-25-1	1	TOP DEFLECTOR				
54	7201-11-10	1	NYLOCK HEX NUT				
55	7102-16-28	1	SOCKET BUTTON HEAD SCREW				
58	VRC-1000-DWG	1	DRAWING - SUPERPRO II - FIT ROVING CUTTER				

### REPAIR KIT

PART NO.	DESCRIPTION
6702-03-01	RC1S1 ROVING CUTTER REPAIR KIT

Fig. 9.17



## MAGNUM VENUS PRODUCTS

RC1S1 Roving Cutter Assy

5103-01-01

05103-01-1 REV. B 0203R01



# Fig. 9.18

## RC1S1 Roving Cutter Assy 5103-01-01

### PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	5103-1-1	1	BASE PLATE
2	5103-13-1	1	CHOPPER COVER
3	5103-2-01	1	AIR STUD SPA
4	5103-14-1	1	COVER NUT
5	7205-2-8	1	SNAP RING DIA 1/2"
6	7205-2-6	1	SNAP RING DIA 3/8"
7	7102-2-20	2	SOCKET HD CAP SCREW
8	7205-3-31	1	E-RING
9	5103-6-1	1	70 DURO RUBBER ROLL
11	9202-2-1	2	SEALED BALL BEARING
12	5103-5-1	1	MANDREL
13	5103-18-1	2	SPACER WASHER
14	5103-4-1	2	SLIDE ADJ NUT
16	5103-7-1	1	SLEEVE
17	5103-3-01	1	ROVING GUIDE SPA
20	7102-2-8	1	SOCKET HD CAP SCREW
21	8402-1-1	1	AIR MOTOR
22	5103-9-1	1	CHOPPER AIR VALVE
23	5103-12-1	1	OILER DISCONNECT
24	7701-8-8	1	PUSH-IN FITTING
26	5103-19-1	1	SPEED CONTROL HOUSING
27	7301-3-01B	1	O-RING
28	5103-20-1	1	SPEED CONTROL SEAL
29	5103-21-1	1	SPEED CONTROL COVER
30	5103-11-1	1	THUMBSCREW
31	5103-10-1	1	LOCK RING
32	7701-5-3	2	BARB FITTING
33	7102-11-6	2	SOCKET CUP POINT SET SCREW
34	09073	.33R	URETHANE TUBING 1/4" OD
35	5103-16-1	1	MOUNT BRACKET
36	5103-17-1	1	ECCENTRIC STUD
37	7101-7-8	1	HEX HD BOLT
38	7202-5-10	1	INTERNAL STAR WASHER HEAVY DUTY
39	7101-1-6	1	HEX HEAD BOLT
40	7202-4-8	1	LOCK WASHER
41	5103-15-01	1	CHOPPER CONDUIT
42	8701-5-EN	1	LABEL
43	00004	1	3/8" POLY TUBING BLACK
45	5103-28-1	1	ROTOR HUB 8-BLADE
46	5103-29-1	4	WEDGE INSERT 8-BLADE
47	5103-9-1	8	CHOPPER BLADE
48	7102-11-6	2	SOCKET CUP POINT SET SCREW
49	7102-13-6	4	SOCKET FLAT HEAD SCREW
50	5103-23-1	1	CHOPPER CHUTE
51	7102-16-6	2	SOCKET BUTTON HEAD SCREW
52	7202-8-10	1	LOCK WASHER
53	5103-25-1	1	TOP DEFLECTOR
54	7201-11-10	1	NYLOCK HEX NUT
55	7102-18-28	1	SOCKET BUTTON HEAD SCREW
58	05103-01-1	1	DRAWING - ROVING CUTTER ASSY

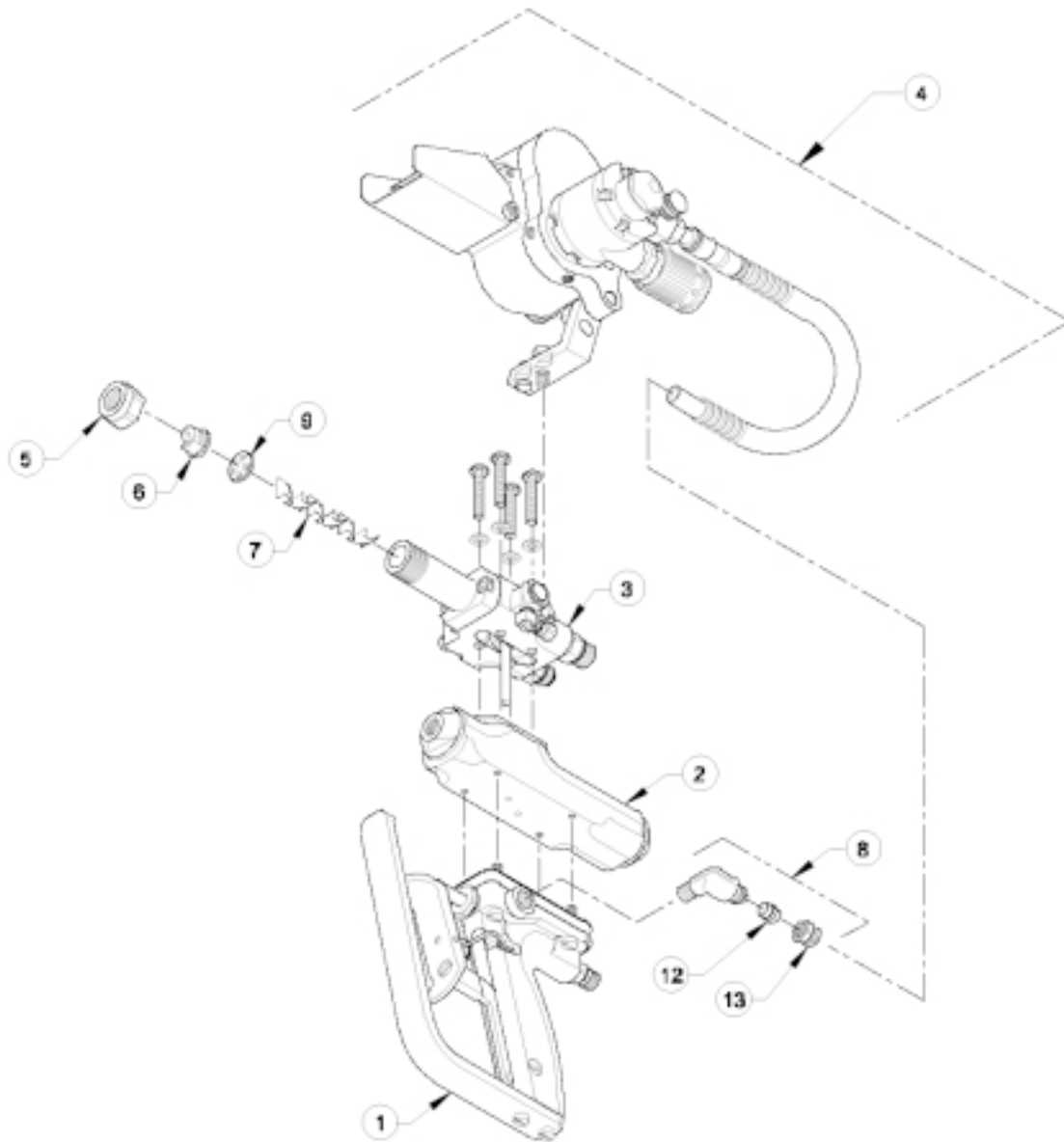
### ASSOCIATED PARTS AND ASSEMBLIES

ITEM	PART NO.	QTY	DESCRIPTION
9B	5103-6-2	1	60 DURO RUBBER ROLL
10	5103-6-01	1	MANDREL SPA
15	5103-7-01	1	SLEEVE W/BEARING
18	5103-3-1	1	GUIDE BLOCK
19	9208-1-1	3	GUIDE
26	5103-02-01	1	SPEED CONTROL ASSY
44	5103-03-01	1	8-BLADE WEDGE ROTOR ASSY
47A	9210-1-100	1	BLADES (PACKAGE OF 100)
47B	9210-1-1000	1	BLADES (PACKAGE OF 1000)
50B	5103-24-1	1	CHOPPER CHUTE

### REPAIR KIT

PART NO.	DESCRIPTION
8702-03-01	RC1S1 ROVING CUTTER REPAIR KIT

Fig. 9.19



## MAGNUM VENUS PRODUCTS

- SuperFIT Chopper Gun Assy      FIT-CCK-MVP

FIT-CCK-MVP-DWG REV. - 4-9-01

# Fig. 9.20

Common Assembly Parts For:  
SuperFIT Chopper Gun Assy FIT-CCK-MVP

### PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	VFTC-4300	1	CHOPPER GUN HANDLE ASSY
2	VFTC-4200	1	GUN ACTUATOR ASSY
3	VFTC-4100	1	GUN HEAD ASSY
4	VRC-1000	1	SUPERFIT ROVING CUTTER ASSY
5	8704-4-1	1	NOZZLE CAP
6	5107-9-00	1	CONVERGENCE NOZZLE
7	VPG-1003	1	3/8" MIXER
8	7701-6-18	1	POLY ELBOW FITTING
9	VPG-1002	1	DIFFUSER

### OPTIONAL PARTS AND ASSEMBLIES

ITEM	PART NO.	QTY	DESCRIPTION
11	7701-6-11	1	POLY-FLO FERRULE W/NUT
12	7701-6-5	1	POLY-FLO FERRULE
13	7701-6-6	1	POLY-FLO NUT

SPRAY CHOP CONFIGURATION

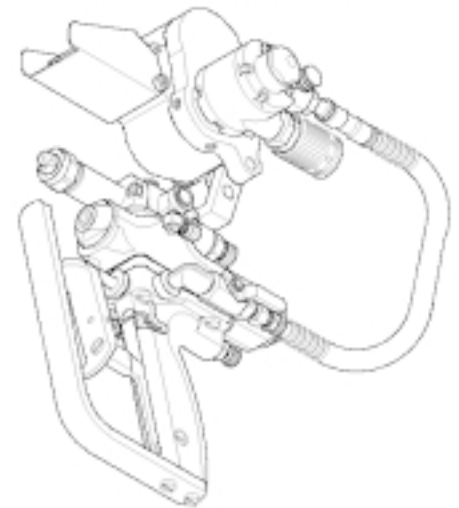
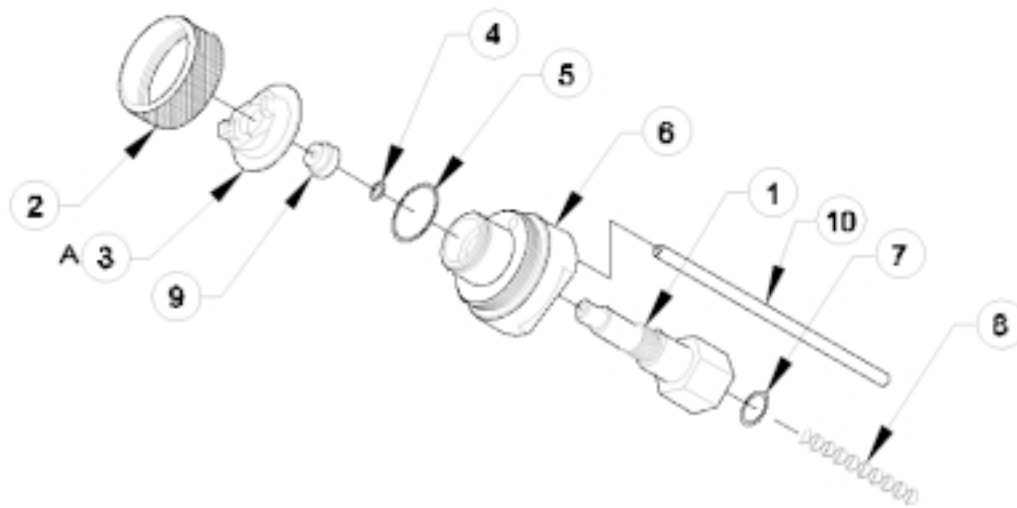


Fig. 9.21



## MAGNUM VENUS PRODUCTS

AN1S1 Air Assist Nozzle Assy

5109-01-01

DA109-01-1 REV. 0-6-02/26/03

# Fig. 9.22

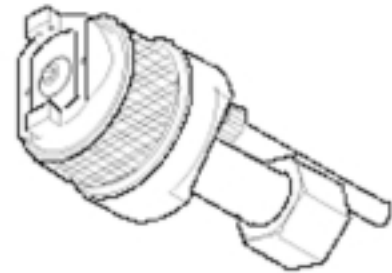
## AN1S1 Air Assist Nozzle Assy 5109-01-01

### PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	5109-3-1	1	3.63" EXTENSION BODY
2	8704-2-1	1	AIR ASSIST CAP RETAINER
3	8704-1-1	1	AIR ASSIST CAP FOR A-1 NOZZLES
4	7301-5-008	1	O-RING
6	7301-5-019	1	O-RING
8	5109-1-01	1	ADAPTER BODY SPA
8	8705-1-1	1	1/4" SPIRAL MIXER
9	A-1-0419	1	SPRAY TIP
10	D1417	1	1/4" DIA POLY TUBE
11	D6106-01-1	1	AN1S1 AIR ASSIST NOZZLE ASSY DWG

### ASSOCIATED PARTS AND SUB-ASSEMBLIES

ITEM	PART NO.	QTY	DESCRIPTION
3A	8704-3-1	1	AIR ASSIST CAP FOR A-2 NOZZLES
7	7301-5-112	1	O-RING









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