

Smart Die™ II / FlexDie™

3A1738L
EN

- For professional application of thermoplastic traffic marking compound materials (reflective beads applied simultaneously with screeding) -
- For outdoor use only (not to be operated in rain or damp conditions) -



IMPORTANT SAFETY INSTRUCTIONS

For complete warnings and safety instructions, see ThermoLazer® 200/200TC/300TC and ThermoLazer ProMelt™ Pavement Marking Systems operation manual. Save all instructions.

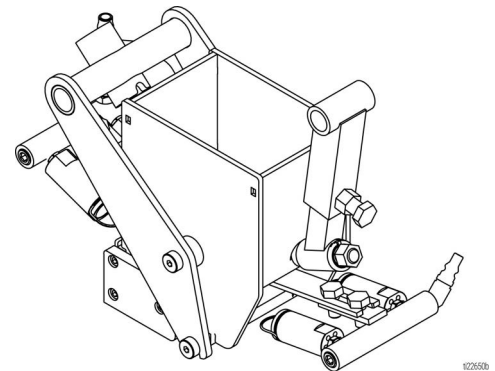
For use with ThermoLazer
300TC/ProMelt
For use with the following
SmartDie II Screed Box:

Part	Description
17A173	2 in. (5 cm)
24H431	3 in. (8 cm)
24H426	4 in. (10 cm)
17J250	4.75 in. (12 cm)
24H432	5 in. (13 cm)
24H427	6 in. (15 cm)
24H433	7 in. (18 cm)
24H428	8 in. (20 cm)
24H434	9 in. (22.5 cm)
24H429	10 in. (25 cm)
24H430	12 in. (30 cm)
17A174	16 in. (40 cm)
26D111	18 in. (45 cm)
24H437	3-3-3 in. (8-8-8 cm)
24H435	4-3-4 in. (10-8-10 cm)
24H436	4-4-4 in. (10-10-10 cm)
24J785	4-6-4 in. (10-15-10 cm)
17R378	5-5-5 in. (13-13-13 cm)
26C273	6-3-6 in. (15-8-15 cm)

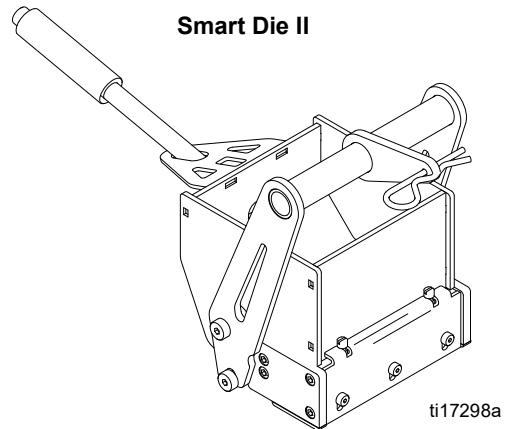
For use with ThermoLazer
200/200TC
For use with the following
FlexDie Screed Box:

Part	Description
16Y320	4 in. (10 cm)
16Y663	5 in. (12 cm)
16Y190	6 in. (15 cm)
16Y664	7 in. (18 cm)
16Y326	8 in. (20 cm)
16Y665	9 in. (22.5 cm)
16Y332	10 in. (25 cm)
16Y207	12 in. (30 cm)
26D189	18 in. (45 cm)
16Y352	4-3-4 in. (10-8-10 cm)
16Y666	4-2-4 in. (10-5-10 cm)
16Y363	4-4-4 in. (10-10-10 cm)
26D109	6-3-6 (15-8-15 cm)

FlexDie



Smart Die II



Related Manuals:

Operation	3A1319
Repair	3A1320
Parts	3A1321
Double Bead Box	3A0004
Quick Disconnect Replacement Kit	X048275

NOTE: This die is factory-set for 90 mil (1.8 mm) line thickness. See page 5 for adjusting line thickness.

Warnings

The following are general warnings related to the safe setup, use, grounding, maintenance and repair of this equipment. In the text of this manual, the exclamation point symbol alerts you to a warning and the hazard symbol refers to specific risks. Refer back to these General Warnings pages. Additional procedure-specific warnings will be included where applicable.

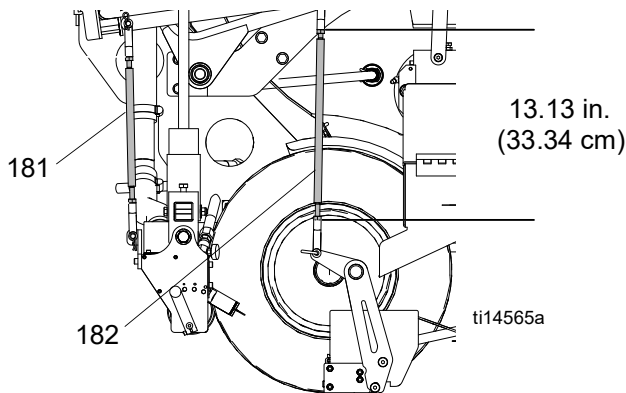
 WARNING	
	FIRE AND EXPLOSION HAZARD Flammable fumes and liquids, such as propane gas, gasoline and combustible fuel, in work area can ignite or explode. To help prevent fire and explosion: • Do not use equipment unless fully trained and qualified. • Do not allow open containers of flammables within 25 ft (7.6 m) of equipment. Do not operate equipment within 10 ft (3 m) of any structure, combustible material, or other gas cylinders. • Shut off all burners when adding fuel to equipment. • Close the tank shut-off valve immediately if you smell propane gas; extinguish all open flames. If gas odor continues, keep away from equipment and immediately call the fire department. • Follow lighting instructions for the burner and torch. • Do not heat thermoplastic traffic marking compound material above its maximum temperature rating. • Fire extinguisher equipment shall be present and working. • Keep work area free of debris, including solvent, rags and gasoline.
	EQUIPMENT MISUSE HAZARD Misuse can cause death or serious injury. • Do not leave equipment unattended. • Keep children and animals away from work area. • Do not exceed the maximum working pressure or temperature rating of the lowest rated system component. See Technical Data in all equipment manuals. • Check equipment daily. Repair or replace worn or damaged parts immediately with genuine manufacturer's replacement parts only. • Do not alter or modify equipment. • Use equipment only for its intended purpose. Call your Graco distributor for information. • Do not fill material beyond maximum capacity. • Route gas lines, hoses, wires and cables away from traffic areas, sharp edges, moving parts, and hot surfaces. • Do not kink or overbend gas lines. • Do not override or defeat safety devices. • Do not operate the unit when fatigued or under the influence of drugs or alcohol.
	BURN HAZARD Equipment surfaces and fluid that is heated can become very hot during operation. To avoid severe burns: • Do not touch hot fluid or equipment.
	CARBON MONOXIDE HAZARD Exhaust contains poisonous carbon monoxide, which is colorless and odorless. Breathing carbon monoxide can cause death. Do not operate in an enclosed area.

WARNING	
	TOXIC FLUID OR FUMES HAZARD Toxic fluids or fumes can cause serious injury or death if splashed in the eyes or on skin, inhaled, or swallowed. • Read MSDS to know the specific hazards of the materials you are using.
	PERSONAL PROTECTIVE EQUIPMENT You must wear appropriate protective equipment when operating, servicing, or when in the operating area of the equipment to help protect you from serious injury, including eye injury, inhalation of toxic fumes, burns, and hearing loss. This equipment includes but is not limited to: • Clothing and respirator as recommended by the fluid, material, and solvent manufacturer. • Gloves, shoes, overalls, face shield, hat, etc. rated for elevated temperatures of at least 500° F (260° C).

Linkage Rod Adjustment

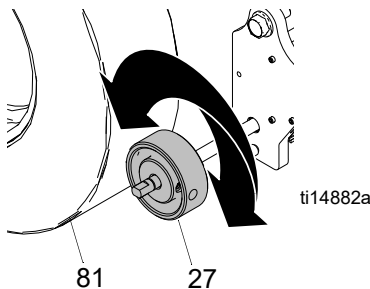
Adjustments can be made to linkage rods by removing clevis cotter hairpin (268), clevis pin from clevis (179), loosening nuts (128), and then turning clevis as required to lengthen or shorten rod connectors.

To ensure proper application of beads and thermoplastic, make sure screed box linkage rod (182) measures 13.13 in. (33.34 cm). Be sure to measure where nut (128) meets clevis (179) when checking for proper linkage rod length.

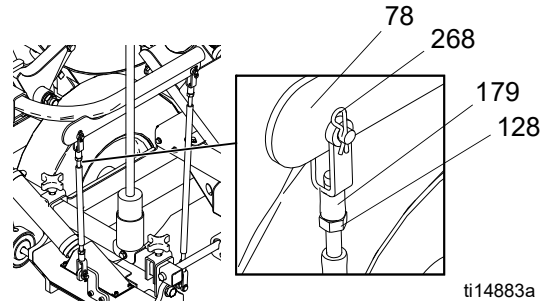


Adjust the bead box linkage rod (181) so bead box drive wheel (27) is touching ThermoLazer tire (81) when screed box is in down (but not open) position. A slight downward force on the bead box rod (181) should be required when inserting the clevis pin through the clevis (179) and deployment bar (78).

1. With screed box in down (but not open) position, rotate the bead box wheel by hand.



2. If the wheel does not cause the ThermoLazer tire to rotate both forward and backwards, loosen nuts (128), remove clevis cotter hairpin (268), remove clevis pin from clevis (179), and rotate the clevis (179) one turn counterclockwise.



3. Reconnect clevis to deployment bar and again rotate bead box wheel to see if adjustments cause ThermoLazer to move forward and backwards.
4. Continue to rotate clevis 1/2 turn counterclockwise until rotating bead box wheel causes ThermoLazer to move forward and backwards.
5. Lock nut (128) to clevis when final adjustment has been made.

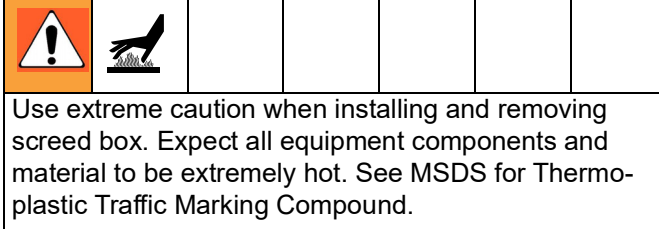
NOTE: Linkage rod (182): If converting from SmartDie to SmartDie II, use Die Link Kit 24J714.

6. **26D189 SmartDie only:** Install bracket as shown.

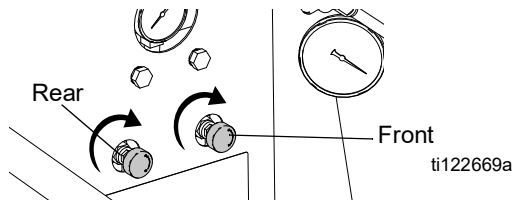


Screed Box ThermoLazer 200/200TC

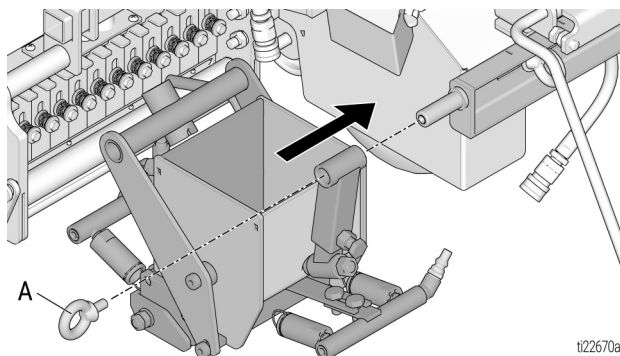
Installation



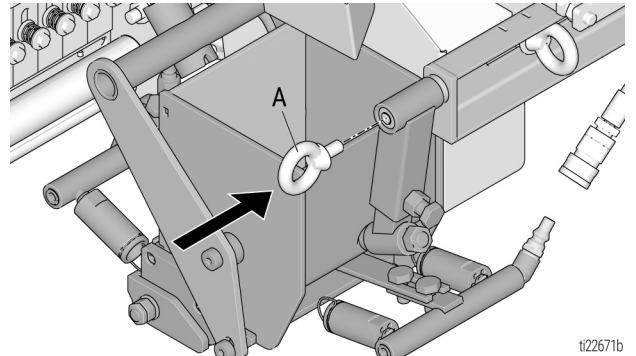
1. Shut off screed box burners.



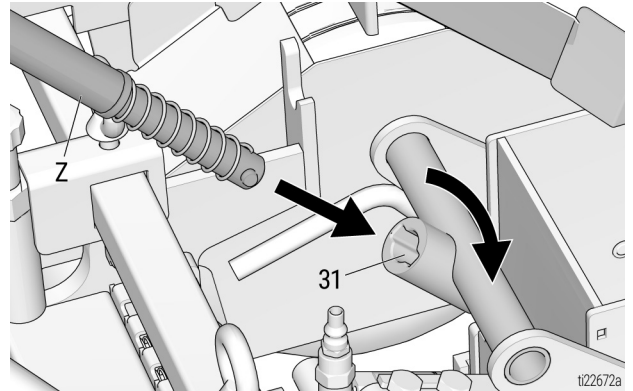
2. Remove bolt (A) and slide FlexDie into place.



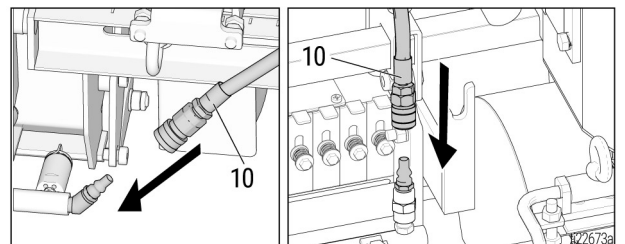
3. Replace and tighten bolt (A).



4. Attach spring loaded handle (Z) to the yoke (31) and turn 90 degrees to lock into place.



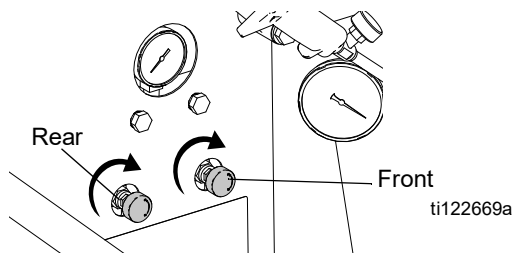
5. Attach both gas hoses to quick release couplings (10).



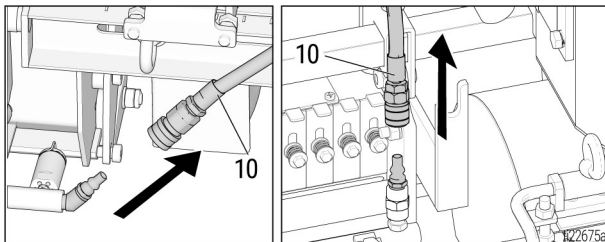
6. Re-light screed box burners as required.

Removal

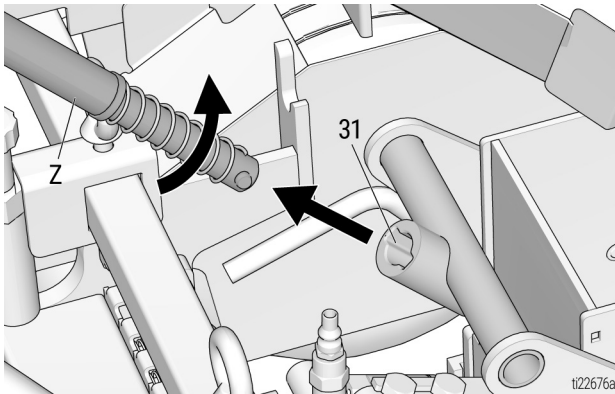
1. Shut off screed box burners.



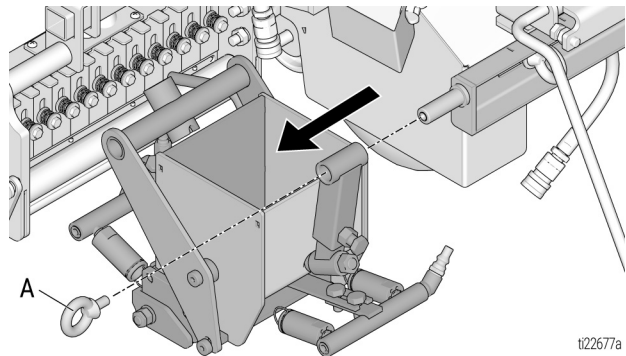
2. Remove the two gas hoses from quick release couplings (10).



3. Push in and turn spring loaded handle 90 degrees and remove from yoke (31).



4. Remove bolt (A) and slide FlexDie box off.



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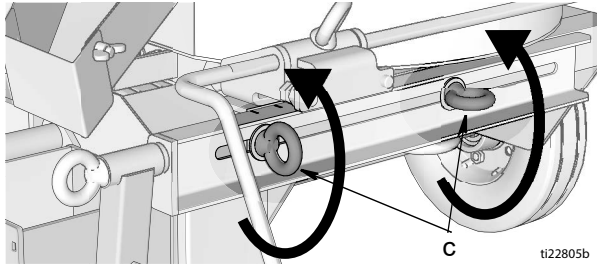
BURN HAZARD
Make sure to use two hands when picking up screed box. Place one hand on yoke and one hand on rod.

Do **NOT** pick up screed box with one hand and/or at one location.

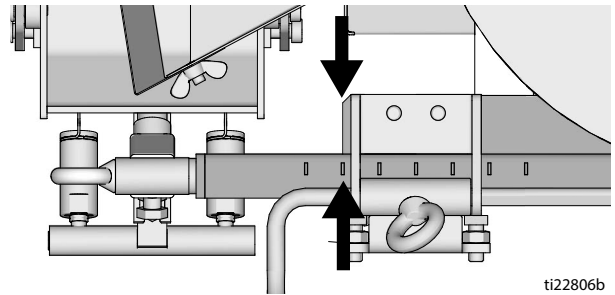
Adjustments

For optimum delivery of the thermoplastic material, make sure the screed box is aligned to center on kettle trough.

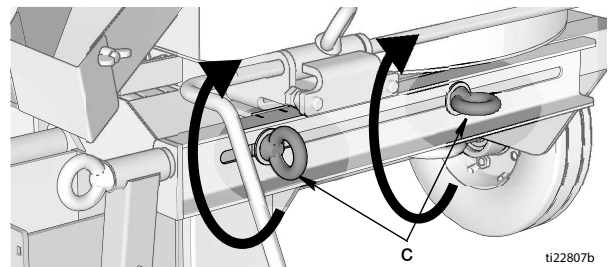
1. Loosen two bolts (c) on mounting bracket.



2. Slide mount left or right until edge of the frame is aligned with desired markings on bracket.



3. Tighten bolts (c) on screed box mounting bracket.

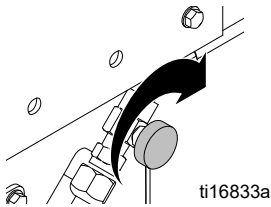


Screed Box Thermolazer 300TC/ProMelt

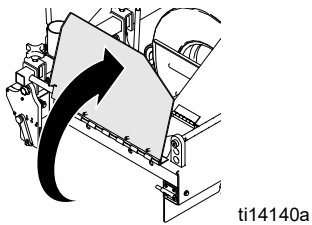
Installation

						
Use extreme caution when installing and removing screed box. Expect all equipment components and material to be extremely hot. See MSDS for Thermo-plastic Traffic Marking Compound.						

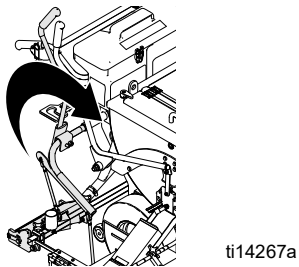
1. Shut off front and rear screed box burners.



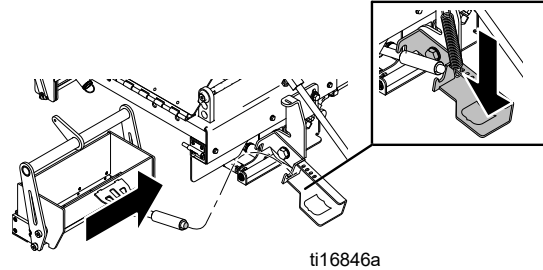
2. Open screed shroud door.



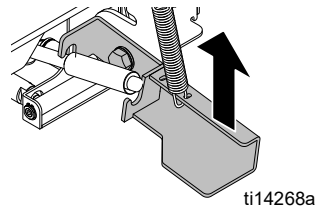
3. Move screed box actuator out of full raised locked position.



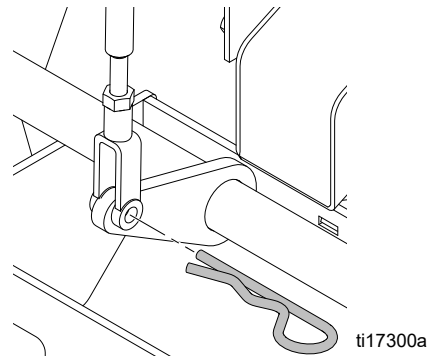
4. Slide screed box under screed shroud and press down on screed box lever.



5. Engage screed box rod into screed box lever.



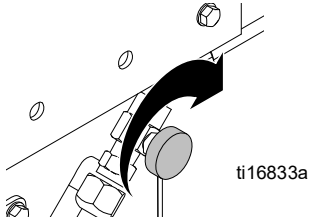
6. Align hole of rod clevis with connecting hole in screed box yoke and install hairpin cotter pin.



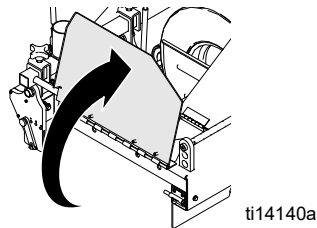
7. Close and lock screed shroud door.

Removal

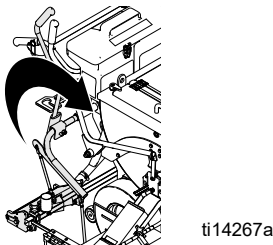
1. Shut off screed box burner.



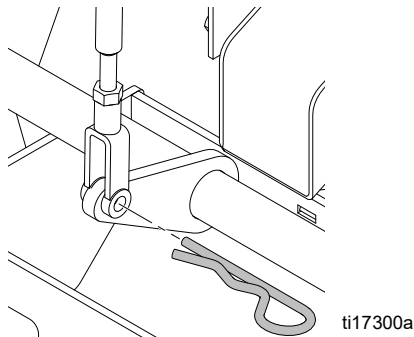
2. Open screed shroud door.



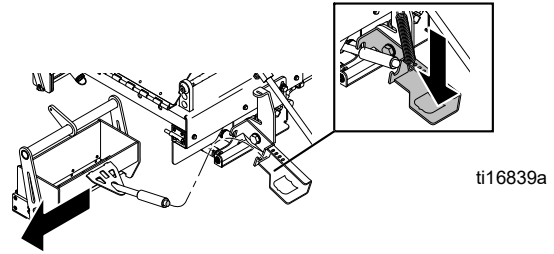
3. Set screed box on ground but not in locked open position.



4. Remove hairpin cotter pin connecting screed box to rod clevis.



5. Press down screed box lever.



6. Disengage screed box rod from screed box lever and carefully remove screed box.

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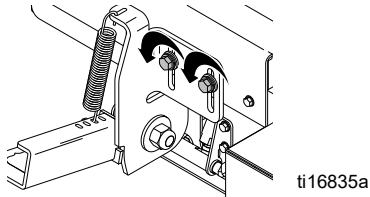
BURN HAZARD
Make sure to use two hands when picking up screed box. Place one hand on yoke and one hand on rod.

Do **NOT** pick up screed box with one hand and/or at one location.

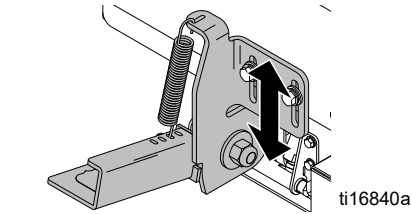
Adjustment

The height and angle of the screed box can be adjusted to ensure a solid line of material on any surface. For optimum delivery of thermoplastic material, make sure the screed box runner is adjusted as described.

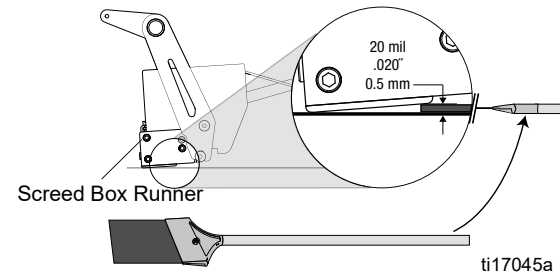
1. Loosen two bolts on screed box mounting bracket.



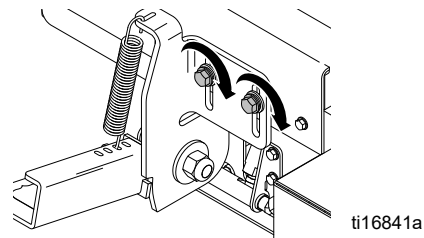
2. Slide mount down until leading box edge of screed box runner is just off of the ground surface. For best performance, raise leading edge .020 in. (0.5 cm) off ground surface. Scraper blade may be used to set this depth.



Screed Box

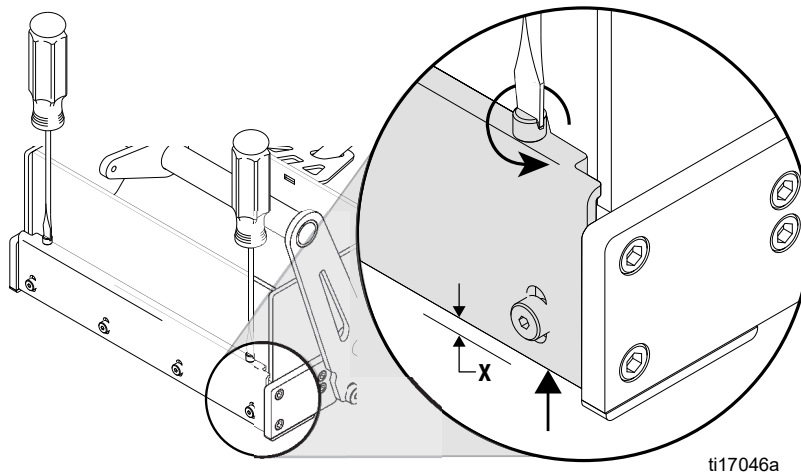


3. Tighten bolts on screed box mounting bracket.



4. Spring position may be moved to a different hole. The farthest holes provide greatest force to close the gate.

Screed Box Line Thickness Adjustment



X ↑	↻
mil	# Turns
30	0,6
60	1,2
90	1,8
120	2,4
150	3,0
mm	# Turns
0,5	0,4
1,0	0,8
1,5	1,2
2,0	1,6

NOTE: 1/4 turn will change line thickness by .013 in. (0.3 mm). Turn the line adjustment screw clockwise for a thinner line, or counterclockwise for a thicker line.

Typical settings on pavement: 0.060 - 0.125 in. (0.153 - 0.318 cm).

Typical settings on metal stencil: Flush - 0.0 in. (0.0 cm).

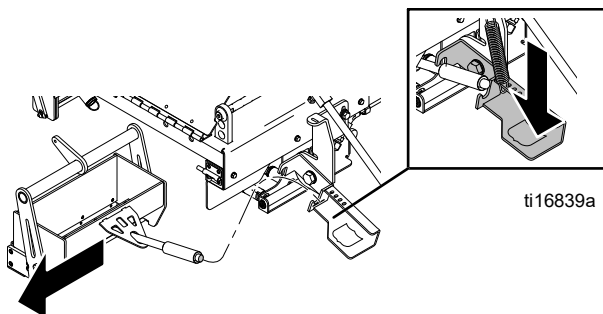
1. Move screed box actuator to middle position. Make sure screed box is closed and resting on the ground. **NOTE:** All screed boxes are initially set at 90 mil (1.8 mm). Adjustment may be required before first use.
2. Use a flat screwdriver to turn line adjustment screw clockwise so that line thickness is zero.
3. Turn line adjustment screw counter-clockwise until desired line thickness is reached.
4. Measure line thickness after applying thermoplastic and adjust as necessary.

Carbide Runner Replacement on Screed Box (1 on each side)

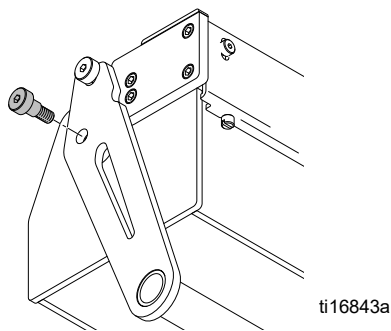
NOTICE

Carbide runners need to be replaced one side at a time. If both runners are removed, adjustment will be lost and screed box will need to be reassembled by a Graco approved technician.

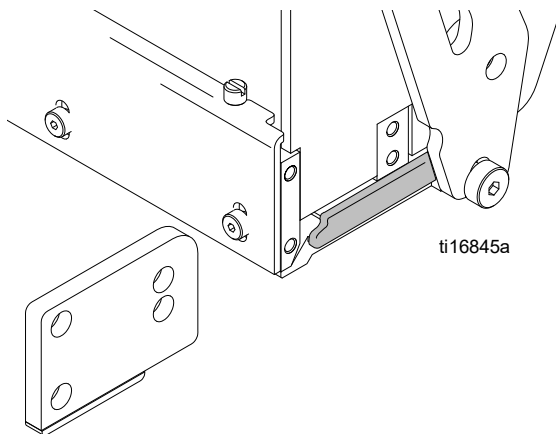
1. Remove screed box.



2. Use allen wrench to loosen and remove upper pivot bolt (511) to free yoke (502).

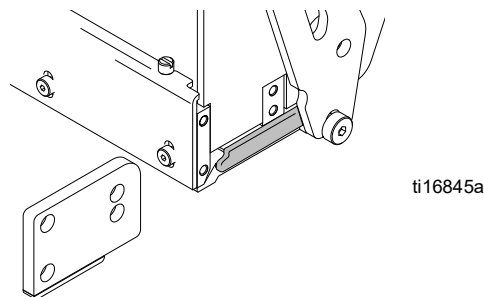


3. Turn unit upside-down and use an allen wrench to remove four screws (513) and plate, die runner (504).

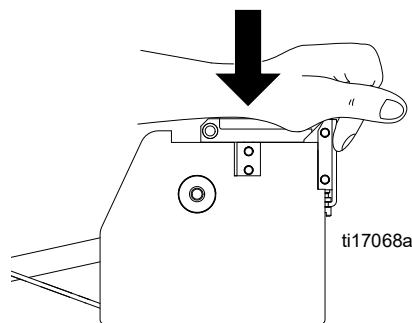


Installation

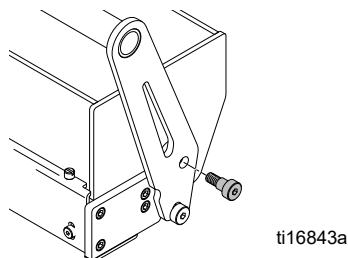
1. Apply grease to groove where carbide runner sits.



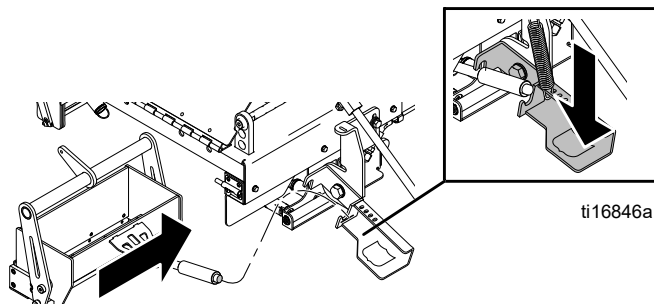
2. Replace plate, die runner (504) with new plate, die runner.
3. While applying pressure to shear bar (506) directly over support bar (509), use allen wrench to replace and tighten four screws (513). There should be no gap between the shear bar and support bar when applying pressure.



4. Use allen wrench to replace and tighten pivot bolt (511) on yoke (502).



5. Install screed box.

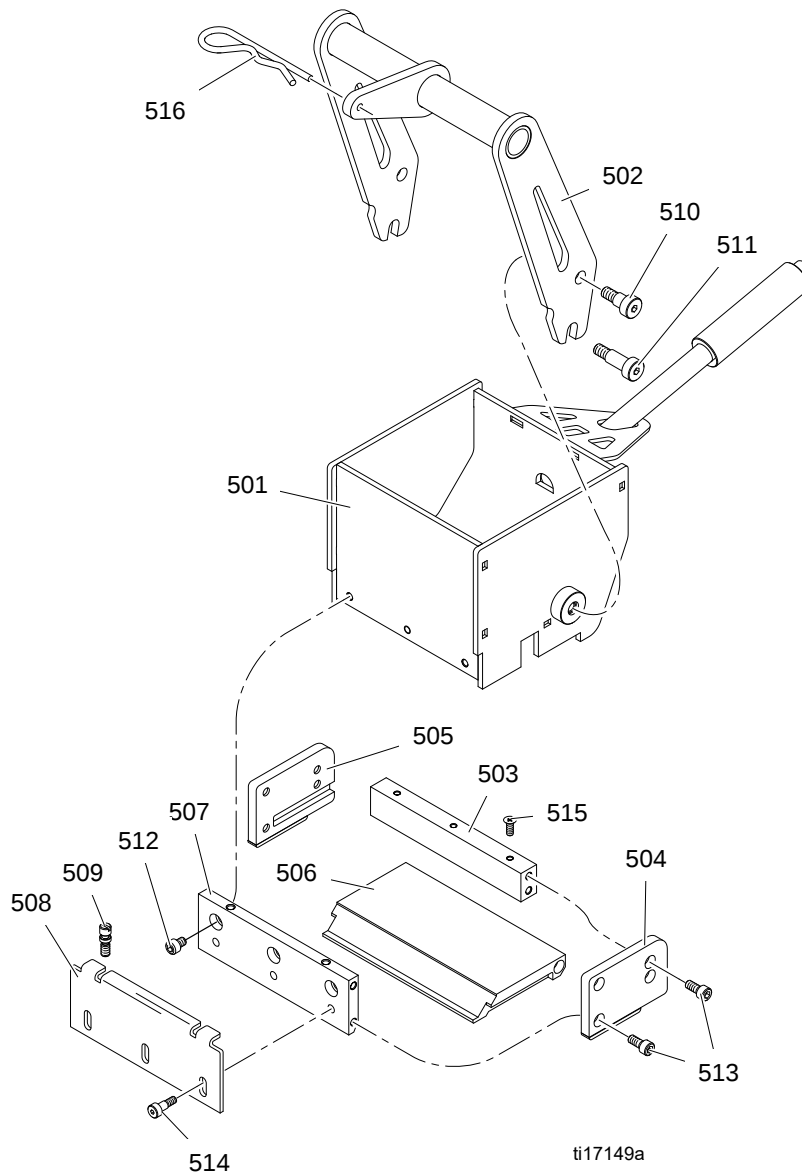


Notes

[illegible]

Parts - SmartDie II Box

17A173	2 in. (5 cm)
24H431	3 in. (8 cm)
24H426	4 in. (10 cm)
17J250	4.75 in. (12 cm)
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24H427	6 in. (15 cm)
24H433	7 in. (18 cm)
24H428	8 in. (20 cm)
24H434	9 in. (22.5 cm)
24H429	10 in. (25 cm)
24H430	12 in. (30 cm)
17A174	16 in. (40 cm)
26D111	18 in. (45 cm)



Parts List - SmartDie II Box

Ref.	Part	Description	Qty.	Ref.	Part	Description	Qty.
19	104541	NUT, lock (26D111) (not shown)	2		16H015	BAR, shear (24H427)	1
20	867539	SCREW, 5/16-18 x 3.75 hx (26D111) (not shown)	2		16H021	BAR, shear (24H433)	1
21	26D563	BRACKET, smart die (26D111) (not shown)	1		16H016	BAR, shear (24H428)	1
501	24H565	BOX, die, weldment (17A173)	1		16H022	BAR, shear (24H434)	1
	24H562	BOX, die, weldment (24H431)	1		16H017	BAR, shear (24H429)	1
	24H563	BOX, die, weldment (24H426)	1		16H018	BAR, shear (24H430)	1
	17J251	BOX, die, weldment (17J250)	1	507	17A185	BAR, shear (17A174)	1
	24H564	BOX, die, weldment (24H432)	1		18F296	BAR, shear (26D111)	1
	24H565	BOX, die, weldment (24H427)	1		16H025	BAR, shear, stop (17A173)	1
	24H566	BOX, die, weldment (24H433)	1		16H029	BAR, shear, stop (24H431)	1
	24H567	BOX, die, weldment (24H428)	1		16H024	BAR, shear, stop (24H426)	1
	24H568	BOX, die, weldment (24H434)	1		17J263	BAR, shear, stop (17J250)	1
	24H569	BOX, die, weldment (24H429)	1		16H030	BAR, shear, stop (24H432)	1
	24H570	BOX, die, weldment (24H430)	1		16H025	BAR, shear, stop (24H427)	1
	17A176	BOX, die, weldment (17A174)	1		16H031	BAR, shear, stop (24H433)	1
	26D124	BOX, die, weldment (26D111)	1		16H026	BAR, shear, stop (24H428)	1
502	24H574	YOKE, weldment (17A173)	1		16H032	BAR, shear, stop (24H434)	1
	24H571	YOKE, weldment (24H431)	1		16H027	BAR, shear, stop (24H429)	1
	24H572	YOKE, weldment (24H426)	1		16H028	BAR, shear, stop (24H430)	1
	17J256	YOKE, weldment (17J250)	1		17A187	BAR, shear, stop (17A184)	1
	24H573	YOKE, weldment (24H432)	1	508	18F295	BAR, shear, stop (26D111)	1
	24H574	YOKE, weldment (24H427)	1		17A188	PLATE, screed, adjustable (17A173)	1
	24H575	YOKE, weldment (24H433)	1		16H033	PLATE, screed, adjustable (24H431)	1
	24H576	YOKE, weldment (24H428)	1		16H034	PLATE, screed, adjustable (24H426)	1
	24H577	YOKE, weldment (24H434)	1		17J264	PLATE, screed, adjustable (17J250)	1
	24H578	YOKE, weldment (24H429)	1		16H035	PLATE, screed, adjustable (24H432)	1
	24H579	YOKE, weldment (24H430)	1		16H036	PLATE, screed, adjustable (24H427)	1
	17A179	YOKE, weldment (17A174)	1		16H037	PLATE, screed, adjustable (24H433)	1
	26D125	YOKE, weldment (26D111)	1		16H038	PLATE, screed, adjustable (24H428)	1
503	16G996	BAR, support (17A173)	1		16H039	PLATE, screed, adjustable (24H434)	1
	16H001	BAR, support (24H431)	1		16H040	PLATE, screed, adjustable (24H429)	1
	16G995	BAR, support (24H426)	1		16H041	PLATE, screed, adjustable (24H430)	1
	17J260	BAR, support (17J250)	1		17A189	PLATE, screed, adjustable (17A184)	1
	16H006	BAR, support (24H432)	1		18F297	PLATE, screed, adjustable (26D111)	1
	16G996	BAR, support (24H427)	1	509	16H044	SCREW, adjustment, screed	2
	16H007	BAR, support (24H433)	1	510	125028	SCREW, shoulder, socket head M8	2
	16G997	BAR, support (24H428)	1	511	125027	SCREW, shoulder, socket head M8	2
	16H008	BAR, support (24H434)	1	512	110501	SCREW, cap sch, M6 x 8	7
	16G998	BAR, support (24H429)	1			(24H431, 24H426, 24H432, 24H427, 24H433, 24H428, 24H434, 24H429, 24H430, 26D111)	
	16G999	BAR, support (24H430)	1	513	121518	SCREW, cap, shc	8
	17A183	BAR, support (17A174)	1	514	125029	SCREW, shoulder, socket head M5	5
	18F282	BAR, support (26D111)	1			(24H431, 24H426, 24H432, 24H427, 24H433, 24H428, 24H434, 24H429, 24H430, 26D111)	
504	24H581	PLATE, die runner, right	1	515	123340	SCREW, mach, flat head, undercut	6
505	24H580	PLATE, die runner, left	1			(24H431, 24H426, 24H432, 24H427, 24H433, 24H428, 24H434, 24H429, 24H430, 26D111)	
506	17A184	BAR, shear (17A173)	1	516	123385	PIN	1
	16H019	BAR, shear (24H431)	1				
	16H014	BAR, shear (24H426)	1				
	17J262	BAR, shear (17J250)	1				
	16H020	BAR, shear (24H432)	1				

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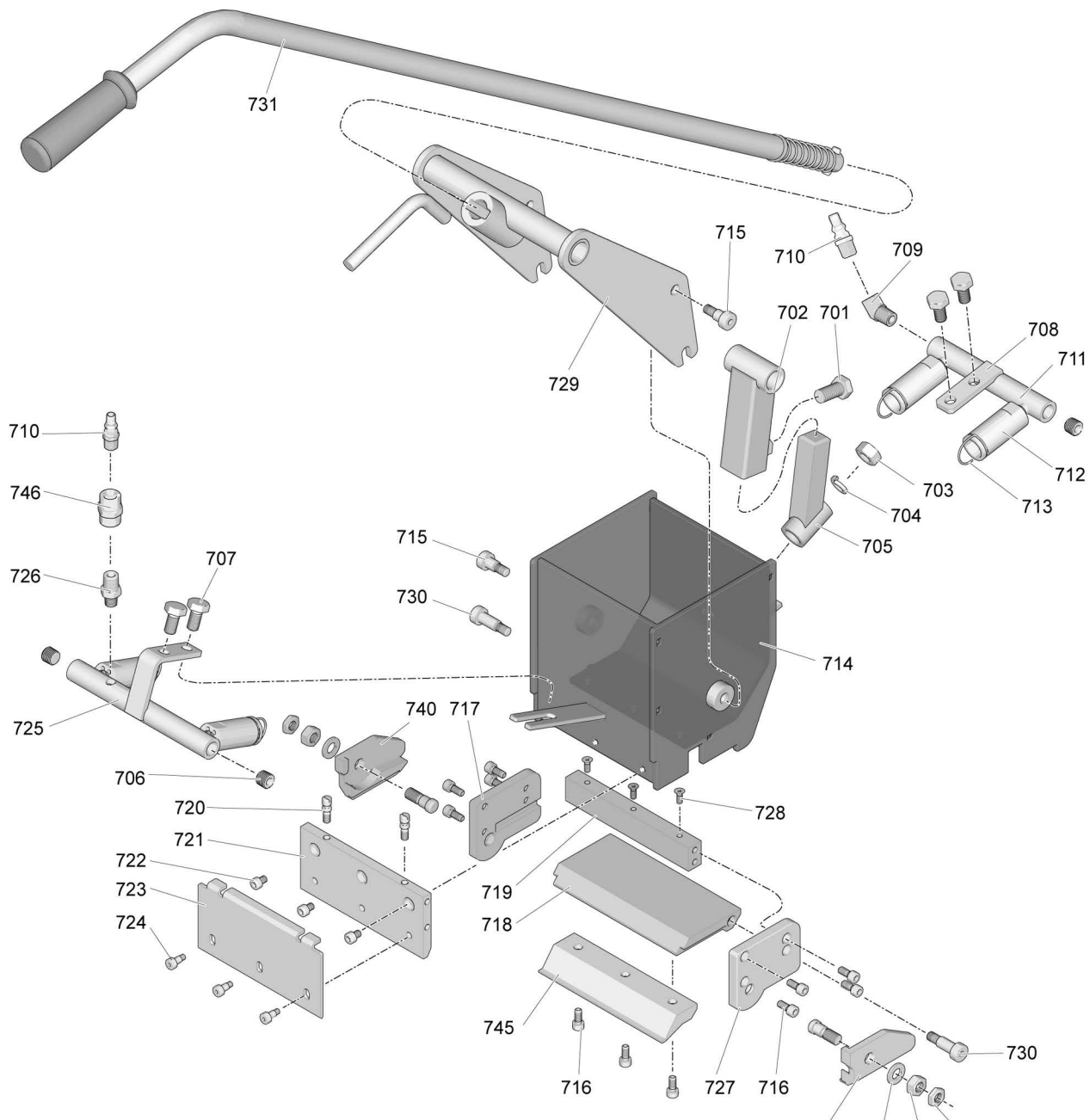
Ref.	Part	Description	Qty.
601	24H647	BOX, die, weldment (24H435)	1
	24H648	BOX, die, weldment (24H436)	1
	24H649	BOX, die, weldment (24H437)	1
	24J784	BOX, die, weldment (24J785)	1
	17R379	BOX, die, weldment (17R378)	1
	26C274	BOX, die, weldment (26C273)	1
602	24H652	YOKE, weldment (24H435)	1
	24H579	YOKE, weldment (24H436)	1
	24H577	YOKE, weldment (24H437)	1
	24J783	YOKE, weldment (24J785)	1
	17R382	YOKE, weldment (17R378)	1
		YOKE, weldment (26C273)	1
603	16G995	BAR, support (24H435, 24H436, 24J785)	1
	16H001	BAR, support (24H437)	1
	16H006	BAR, support (17R378)	1
	16G996	BAR, support (26C273)	1
604	24H581	PLATE, die runner, right	2
605	24H580	PLATE, die runner, left	2
606	16H159	BAR, shear, die, double (24H435, 24H436, 24J785)	2
	16H160	BAR, shear, die, double (24H437)	2
	17R384	BAR, shear, die, double (17R378)	2
	17A211	BAR, shear, die, double (26C273)	2
	16H024	BAR, shear, stop (24H435, 24H436, 24J785)	2
607	16H029	BAR, shear, stop (24H437)	2
	16H030	BAR, shear, stop (17R378)	2
	16H025	BAR, shear, stop (26C273)	2
	608	16H034	PLATE, screed, adjustable (24H435, 24H436, 24J785)
16H041		PLATE, screed, adjustable (24H437)	2
16H035		PLATE, screed, adjustable (17R378)	2
16H036		PLATE, screed, adjustable (26C273)	2
609		16H044	SCREW, adjustment, screed
610	125028	SCREW, shoulder, socket head M8	4
611	125027	SCREW, shoulder, socket head M8	4
612	110501	SCREW, cap, sch M6 x 8	4
		SCREW, cap, sch M6 x 8 (17R378)	6
		SCREW, cap, sch M6 x 8 (26C273)	6
613	121518	SCREW, cap, shc	20
614	125029	SCREW, shoulder, socket head M5	4
		SCREW, shoulder, socket head M5 (17R378)	6
		SCREW, shoulder, socket head M5 (26C273)	6
615	123340	SCREW, mach, flat head, undercut	4
		SCREW, mach, flat head, undercut (17R378)	6
		SCREW, mach, flat head, undercut (26C273)	6
616	16H189	GUIDE, bar, shear, double (24H435)	1
	16H161	GUIDE, bar, shear, double (24H436)	1
	16H162	GUIDE, bar, shear, double (24H437)	1
	16J802	GUIDE, bar, shear, double (24J785)	1
	17R385	GUIDE, bar, shear, double (17R378)	1
	17W534	GUIDE, bar, shear, double (26C273)	1
617	123385	PIN	1

Notes

This image shows a single sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.

Parts - FlexDie Box

16Y320	4 in. (10 cm)
16Y663	5 in. (12 cm)
16Y190	6 in. (15 cm)
16Y664	7 in. (18 cm)
16Y326	8 in. (20 cm)
16Y665	9 in. (22.5 cm)
16Y332	10 in. (25 cm)
16Y207	12 in. (30 cm)
26D189	18 in. (45 cm)



Parts List - FlexDie Box

Ref. Part	Description	Qty.	Ref. Part	Description	Qty.
701 16Y261	SCREW, cap, hex hd, M12 X 1.75 X 25	1	720 16H044	SCREW, adjustment, screed	2
702 16Y077	CONNECTOR, die pivot	1	721 17D545	BAR, shear, stop, 4 in. (16Y320)	1
703 107539	NUT, hex	1	17D546	BAR, shear, stop, 5 in. (16Y663)	1
704 124704	WASHER, spring, metallic	1	17D547	BAR, shear, stop, 6 in. (16Y190)	1
705 16Y081	HOLDER, die holder	1	17D548	BAR, shear, stop, 7 in. (16Y664)	1
706 557391	PLUG, dryseal 1/4 NPTF	3	17D549	BAR, shear, stop, 8 in. (16Y326)	1
707 105326	SCREW, cap hex hd	4	17D550	BAR, shear, stop, 9 in. (16Y665)	1
708 16Y252	TUBE, burner front, 4 in. (16Y320)	1	17D551	BAR, shear, stop, 10 in. (16Y332)	1
16Y681	TUBE, burner front, 5 in. (16Y663)	1	17D552	BAR, shear, stop, 12 in. (16Y207)	1
16Y237	TUBE, burner front, 6 in. (16Y190)	1	18F285	BAR, shear, stop, 18 in. (26D189)	1
16Y715	TUBE, burner front, 7 in. (16Y664)	1	722	SCREW, cap, sch (M6 X 8) (16Y320)	2
16Y689	TUBE, burner front, 8 in. (16Y326)	1		SCREW, cap, sch (M6 X 8) (16Y663)	3
16Y755	TUBE, burner front, 9 in. (16Y665)	1		SCREW, cap, sch (M6 X 8) (16Y190)	3
16Y486	TUBE, burner front, 10 in. (16Y332)	1		SCREW, cap, sch (M6 X 8) (16Y664)	3
16Y244	TUBE, burner front, 12 in. (16Y207)	1		SCREW, cap, sch (M6 X 8) (16Y326)	3
26D123	TUBE, burner front, 18 in. (26D189)	1		SCREW, cap, sch (M6 X 8) (16Y665)	4
709 113444	FITTING, elbow 45, 1/4 NPT	1		SCREW, cap, sch (M6 X 8) (16Y332)	4
710 2013903	COUPLING, quick release, male	2		SCREW, cap, sch (M6 X 8) (16Y207)	4
711	KIT, repair, torch head, die (16Y320)	4		SCREW, cap, sch (M6 X 8) (26D189)	4
	KIT, repair, torch head, die (16Y663)	4	723 17D527	PLATE, screed, adjustable, 4 in. (16Y320)	1
	KIT, repair, torch head, die (16Y190)	4	17D528	PLATE, screed, adjustable, 5 in. (16Y663)	1
	KIT, repair, torch head, die (16Y664)	4	17D529	PLATE, screed, adjustable, 6 in. (16Y190)	1
	KIT, repair, torch head, die (16Y326)	4	17D530	PLATE, screed, adjustable, 7 in. (16Y664)	1
	KIT, repair, torch head, die (16Y665)	6	17D531	PLATE, screed, adjustable, 8 in. (16Y326)	1
	KIT, repair, torch head, die (16Y332)	6	17D532	PLATE, screed, adjustable, 9 in. (16Y665)	1
	KIT, repair, torch head, die (16Y207)	6	17D533	PLATE, screed, adjustable, 10 in. (16Y332)	1
	KIT, repair, torch head, die (26D189)	6	17D534	PLATE, screed, adjustable, 12 in. (16Y207)	1
713 16H104	INDICATOR, burner (included in 711)	2	18F286	PLATE, screed, adjustable, 18 in. (26D189)	1
714	BOX, die, weldment, 4 in. (16Y320)	1	724	SCREW, shoulder, socket head M5 (16Y320)	2
	BOX, die, weldment, 5 in. (16Y663)	1		SCREW, shoulder, socket head M5 (16Y663)	3
	BOX, die, weldment, 6 in. (16Y190)	1		SCREW, shoulder, socket head M5 (16Y190)	3
	BOX, die, weldment, 7 in. (16Y664)	1		SCREW, shoulder, socket head M5 (16Y664)	3
	BOX, die, weldment, 8 in. (16Y326)	1		SCREW, shoulder, socket head M5 (16Y326)	3
	BOX, die, weldment, 9 in. (16Y665)	1		SCREW, shoulder, socket head M5 (16Y665)	4
	BOX, die, weldment, 10 in. (16Y332)	1		SCREW, shoulder, socket head M5 (16Y332)	4
	BOX, die, weldment, 12 in. (16Y207)	1		SCREW, shoulder, socket head M5 (16Y207)	4
	BOX, die, weldment, 18 in. (26D189)	1		SCREW, shoulder, socket head M5 (26D189)	4
715 125028	SCREW, shoulder, socket head M8	2	725 17D518	TUBE, back burner, 4 in. (16Y320)	1
716	SCREW, cap, sch (16Y320)	10		TUBE, back burner, 5 in. (16Y663)	1
	SCREW, cap, sch (16Y663)	11	17D520	TUBE, back burner, 6 in. (16Y190)	1
	SCREW, cap, sch (16Y190)	11		TUBE, back burner, 7 in. (16Y664)	1
	SCREW, cap, sch (16Y664)	11	17D522	TUBE, back burner, 8 in. (16Y326)	1
	SCREW, cap, sch (16Y326)	11	17D523	TUBE, back burner, 9 in. (16Y665)	1
	SCREW, cap, sch (16Y665)	12	17D524	TUBE, back burner, 10 in. (16Y332)	1
	SCREW, cap, sch (16Y332)	12	17D525	TUBE, back burner, 12 in. (16Y207)	1
	SCREW, cap, sch (16Y207)	12	26D122	TUBE, back burner, 18 in. (26D189)	1
	SCREW, cap, sch (26D189)	12	726 16Y235	FITTING, nipple, 1/4 NPT to 1/8 NPT	1
717 17D499	PLATE, pivot, left (16Y320)	1	727 17D497	PLATE, pivot, right (16Y320)	1
17D499	PLATE, pivot, left (16Y663)	1	17D497	PLATE, pivot, right (16Y663)	1
17D499	PLATE, pivot, left (16Y190)	1	17D497	PLATE, pivot, right (16Y190)	1
17D499	PLATE, pivot, left (16Y664)	1	17D497	PLATE, pivot, right (16Y664)	1
17D499	PLATE, pivot, left (16Y326)	1	17D497	PLATE, pivot, right (16Y326)	1
17D499	PLATE, pivot, left (16Y665)	1	17D497	PLATE, pivot, right (16Y665)	1
17D499	PLATE, pivot, left (16Y332)	1	17D497	PLATE, pivot, right (16Y332)	1
17D499	PLATE, pivot, left (16Y207)	1	17D497	PLATE, pivot, right (16Y207)	1
17D499	PLATE, pivot, left (26D189)	1	17D497	PLATE, pivot, right (26D189)	1
718 17D535	BAR, shear, 3 in., (16Y320)	1	728	SCREW, mach, flat head, undercut (16Y320)	2
17D537	BAR, shear, 5 in. (16Y663)	1		SCREW, mach, flat head, undercut (16Y663)	3
17D538	BAR, shear, 6 in. (16Y190)	1		SCREW, mach, flat head, undercut (16Y190)	3
17D539	BAR, shear, 7 in. (16Y664)	1		SCREW, mach, flat head, undercut (16Y664)	3
17D540	BAR, shear, 8 in. (16Y326)	1		SCREW, mach, flat head, undercut (16Y326)	3
17D541	BAR, shear, 9 in. (16Y665)	1		SCREW, mach, flat head, undercut (16Y665)	4
17D542	BAR, shear, 10 in. (16Y332)	1		SCREW, mach, flat head, undercut (16Y332)	4
17D543	BAR, shear, 12 in. (16Y207)	1		SCREW, mach, flat head, undercut (16Y207)	4
18F287	BAR, shear, 18 in. (26D189)	1		SCREW, mach, flat head, undercut (26D189)	4
719 16G995	BAR, support, 3 in., (16Y320)	1	729 16Y324	YOKE, weldment, 4 in. (16Y320)	1
16H006	BAR, support, 5 in. (16Y663)	1	16Y673	YOKE, weldment, 5 in. (16Y663)	1
16G996	BAR, support, 6 in. (16Y190)	1	16Y198	YOKE, weldment, 6 in. (16Y190)	1
16H007	BAR, support, 7 in. (16Y664)	1	16Y713	YOKE, weldment, 7 in. (16Y664)	1
16G997	BAR, support, 8 in. (16Y326)	1	16Y330	YOKE, weldment, 8 in. (16Y326)	1
16H008	BAR, support, 9 in. (16Y665)	1	16Y753	YOKE, weldment, 9 in. (16Y665)	1
16G998	BAR, support, 10 in. (16Y332)	1	16Y336	YOKE, weldment, 10 in. (16Y332)	1
16G999	BAR, support, 12 in. (16Y207)	1	16Y206	YOKE, weldment, 12 in. (16Y207)	1
18F282	BAR, support, 18 in. (26D189)	1	26D121	YOKE, weldment, 18 in. (26D189)	1

Parts - FlexDie Box

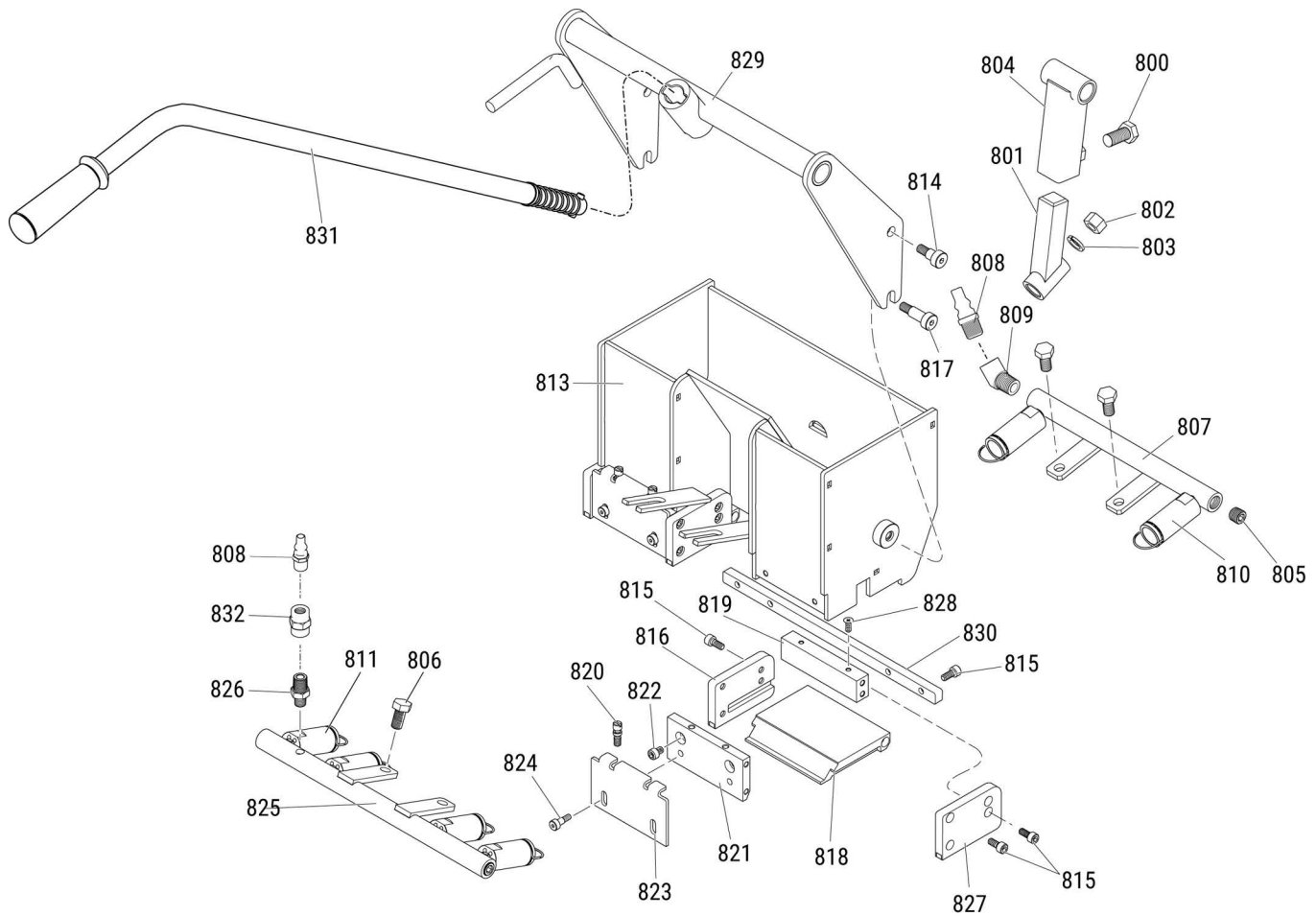
Ref. Part	Description	Qty.
730 125027	SCREW, shoulder, socket head M8	2
731 16Y205	HANDLE, die handle, assy	1
740 17D504	FLOAT RUNNER, left	1
741 16Y267	WASHER, flat, M10	2
742 105327	NUT, hex	2
743 17D593	NUT, thin nut, M10	2
744 17D502	FLOAT RUNNER, right	1
745 17D509	BAR, shear, 4 in., (16Y320)	1
17D510	BAR, shear, 5 in., (16Y663)	1
17D511	BAR, shear, 6 in., (16Y190)	1
17D512	BAR, shear, 7 in., (16Y664)	1
17D513	BAR, shear, 8 in., (16Y326)	1
17D514	BAR, shear, 9 in., (16Y665)	1
17D515	BAR, shear, 10 in., (16Y332)	1
17D516	BAR, shear, 12 in., (16Y207)	1
18F291	BAR, shear, 18 in., (26D189)	1
746 113093	CONNECTOR, pipe	1
747 2014491	KIT, quick disconnect (not shown)	1

Notes

This image shows a single sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.

Parts - Double Line FlexDie Box

16Y352 4-3-4 in. (10-8-10 cm)
 16Y666 4-2-4 in. (10-5-10 cm)
 16Y363 4-4-4 in. (10-10-10 cm)
 26D109 6-3-6 (15-8-15 cm)



ti23117a

Parts List - Double Line FlexDie Box

Ref.	Part	Description	Qty.	Ref.	Part	Description	Qty.
800	16Y261	SCREW, cap, hex hd, M12 x 1.75 x 25	1	819	16G995	BAR, support (16Y352)	2
801	16Y081	HOLDER, die holder	1		16G995	BAR, support (16Y666)	2
802	107539	NUT, hex	1		16H159	BAR, support (16Y363)	2
803	124704	WASHER, spring, metallic	1		16G996	BAR, support (26D109)	2
804	16Y077	CONNECT, die pivot	1	820	16H044	SCREW, adjustment, screed	4
805	557391	PLUG, dryseal, 1/4 NPTF	3	821	16H024	BAR, shear, stop (16Y352, 16Y666, 16Y363)	2
806	105326	SCREW, cap hex hd	4		16H025	BAR, shear, stop (26D109)	2
807	16Y361	TUBE, burner fron, 4-3-4 (16Y352, 16Y666)	1	822	110501	SCREW, cap, sch (M6 x 8)	4
	16Y371	TUBE, burner front, 4-4-4 (16Y363)	1	823	16H034	PLATE, sreed, adjustable, 4 in. (16Y352, 16Y666, 16Y363)	2
	26D117	TUBE, burner front, 6-3-6 (26D109)	1	824	125029	SCREW, shoulder, socket head, M5	4
808	2013903	COUPLING, quick release, male	2				
809	113444	FITTING, elbow street, 45 degree x 1/4 NPT	1	825	16Y358	TUBE, burner back, 4-3-4 (16Y352)	1
810		KIT, repair, torch head, die (model 16Y352)	6		16Y806	TUBE, burner back, 4-2-4 (16Y666)	1
		KIT, repair, torch head, die (model 16Y666)	6		16Y368	TUBE, burner back, 4-4-4 (16Y363)	1
		KIT, repair, torch head, die (model 16Y363)	6		26D128	TUBE, burner back, 6-3-6 (26D109)	1
		KIT, repair, torch head, die (model 26D109)	6	826	16Y235	FITTING, nipple 1/4 npt to 1/8 npt	1
				827	24H581	PLATE, die runner, proscreed, right	2
				828	123340	SCREW, mach, flat head, undercut	4
				829	16Y355	YOKE, weldment, 4-3-4 (16Y352)	1
					16Y336	YOKE, weldment, 4-2-4 (16Y666)	1
					16Y206	YOKE, weldment, 4-4-4 (16Y363)	1
					26D114	YOKE, weldment, 6-3-6 (26D109)	1
813	16Y353	DIE, box weldent, 4-3-4 (16Y352)	1	830	16H189	GUIDE, bar, shear, double, 4-3-4 (16Y352)	1
	16Y800	DIE, box weldent, 4-2-4 (16Y666)	1		16Y805	GUIDE, bar, shear, double, 4-2-4 (16Y666)	1
	16Y364	DIE, box weldent, 4-4-4 (16Y363)	1		16H161	GUIDE, bar, shear, double, 4-4-4 (16Y363)	1
	26D115	DIE, box weldent, 6-3-6 (26D109)	1		18F275	GUIDE, bar, shear, double, 6-3-6 (26D109)	1
814	125028	SCREW, shoulder, socket head M8	2				
815	121518	SCREW, cap, sch	20	831	16Y205	HANDLE, die handle, assy	1
816	24H580	PLATE, die runner, proscreed, left	2	832	113093	CONNECTOR, pipe	1
817	125027	SCREW, shoulder, socket head M8	2	833	2014491	KIT, quick disconnect (not shown)	1
818	16H159	BAR, shear, die, double, 4 in. (16Y352, 16Y666, 16Y363)	2				
	17A211	BAR, shear, die, double, 6 in. (26D109)	2				

California Proposition 65

CALIFORNIA RESIDENTS

 **WARNING:** Cancer and reproductive harm – www.P65warnings.ca.gov.

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Original instructions. This manual contains English. MM 3A1738

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