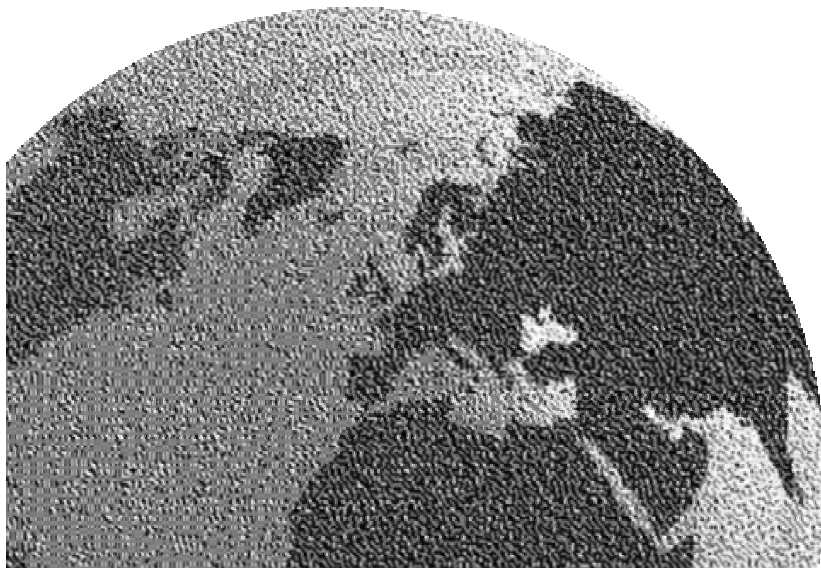


# ***Model FF-2500 Proportioning Unit***

## ***Parts Identification Manual 25942-ID***

***February 12, 2004***

***Issue 3***



**GUSMER CORPORATION®**

A Subsidiary of Gusmer Machinery Group, Inc.

One Gusmer Drive

Lakewood, New Jersey, USA 08701-8055

Toll Free 1-800-367-4767 (USA & Canada)

Phone: (732) 370-9000

Fax: (732) 905-8968

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## WARRANTY

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Gusmer Corporation (Gusmer) provides a limited warranty to the original purchaser (Customer) of Gusmer manufactured parts and equipment (Product) against any defects in material or workmanship for a period of one year from the date of shipment from Gusmer facilities.

In the event Product is suspected to be defective in material or workmanship, it must be returned to Gusmer, freight prepaid. If Product is found to be defective in material or workmanship, as determined solely by Gusmer, Gusmer will issue full credit to Customer for the freight charges incurred in returning the defective Product, and either credit will be issued for the replacement cost of the Product or a replacement part will be forwarded no-charge, freight prepaid to Customer.

This warranty shall not apply to Product Gusmer finds to be defective resulting from: installation, use, maintenance, or procedures not accomplished in accordance with our instructions; normal wear; accident; negligence; alterations not authorized in writing by Gusmer; use of "look alike" parts not manufactured or supplied by Gusmer; or Product used in conjunction with any other manufacturer's pumping or proportioning equipment. For such Product, a written estimate will be submitted to the Customer at a nominal service charge, itemizing the cost for repair. Disposition of Product will be done in accordance with the terms stated on the written estimate.

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To ensure proper validation of your warranty, please complete the warranty card and return it to Gusmer within two weeks of receipt of equipment.

Revised 09/02

# ASSEMBLIES

## FF-2500 FINAL ASSEMBLY

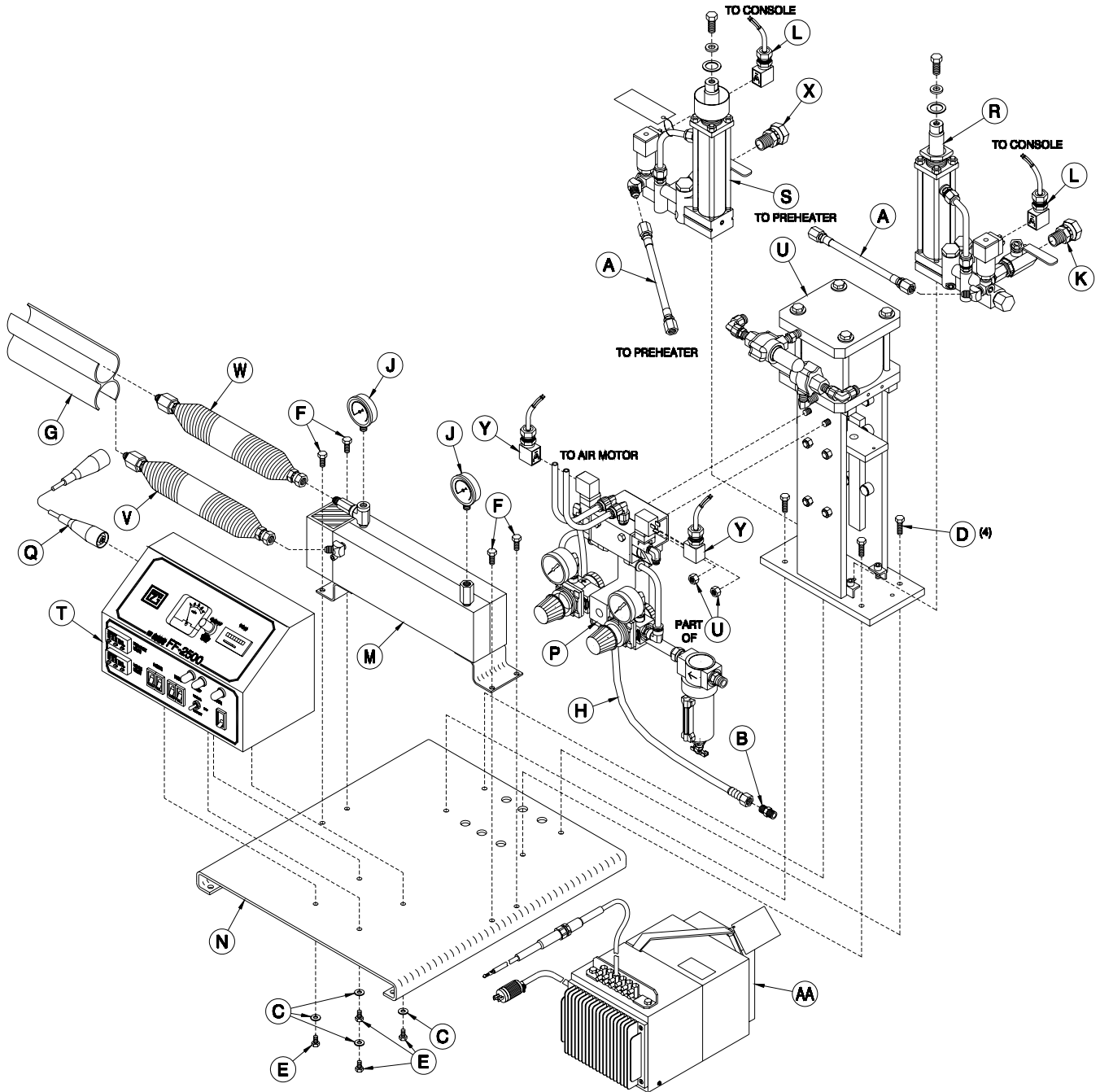


Figure 1. FF-2500 Assembly (Part No. 25000-SIZE), Exploded View

TABLE 1. FF-2500 ASSEMBLY (PART NO. 25000-SIZE), PARTS

Reference Letter	Part Number	Description	Quantity
A	0372	Interconnect Hose	2
B	0561	Hex Nipple	1
C	0562-11-3	Flat Washer	4
D	0759	Hex Head Cap Screw	4
E	0760-3	Hex Head Cap Screw	4
F	1701-4	Hex Head Cap Screw	4
*G	5204	Electrical Isolator	1
*H	5270A-4	Air Hose	1
J	6314-13	0-5000 PSI Liquid Fill Gauge	2
*K	10420	Swivel Union	1
L	6690-16-76-2	Pressure Switch Harness	2
M	17360	6000W LV Primary Heater	1
N	17750	Machine Base	1
P	17756	Air Control System	1
*Q	20207-3	TSU Extension Adapter	1
R	25400-40	Resin Proportioning Pump Assembly	1
S	25450-40	Iso Proportioning Pump Assembly	1
T	25650-220	Electric Console (220V)	1
	25650-380	Electric Console (380V)	1
U	25755	Air Motor Assembly	1
*V	56273	R-Isolation Hose	1
*W	56274	A-Isolation Hose	1
*X	OP179-6	Swivel Union	1
Y	8680-3-3	DIN Connector	2
Z	17358	Insulator Blanket (Not Shown)	1
AA	17276	70V Power Pack	1

\* Part of Accessory Package (AP25000), Shown for Reference ONLY.

**ELECTRICAL CONSOLE**

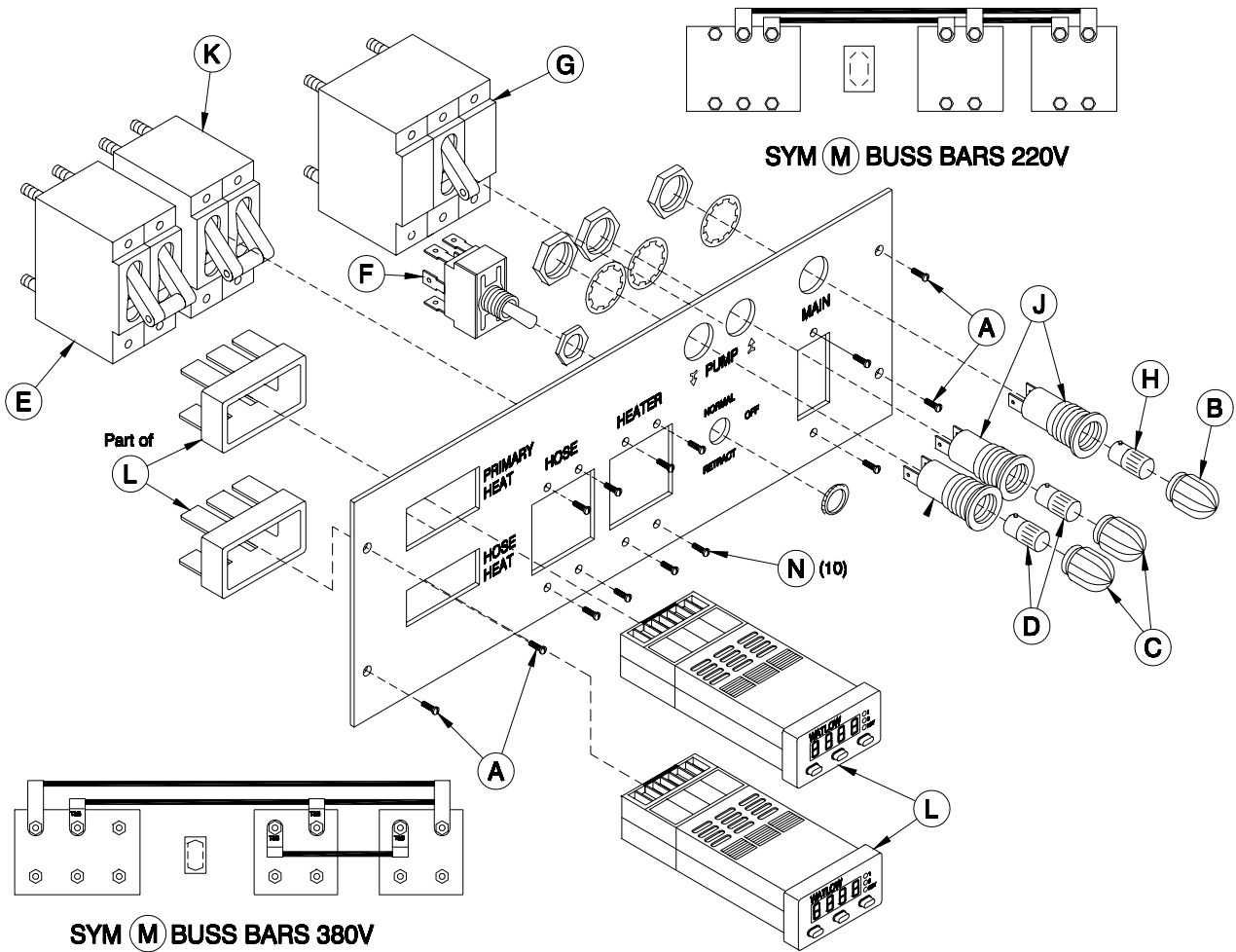


Figure 2. Electric Console (Part No. 25650-SIZE), Exploded View, Sheet 1 of 3

TABLE 2. ELECTRIC CONSOLE (PART NO. 25650-SIZE), PARTS, SHEET 1 OF 3

Reference Letter	Part Number	Description	Quantity
A	0368	Binder Head Machine Screw	4
B	0656	White Lens	1
C	0660	Amber Lens	2
D	0662A	Incandescent Bulb	2
E	0692-1-25	25 Amp Circuit Breaker	1
F	6690-16-6	Toggle Switch	1
G	6690-16-10	Switch	1
H	6690-19-24	Bulb	1
J	6690-19-25	Light Base	3
K	6690-25-31	40 Amp Circuit Breaker	1
L	6690-26-22-1	Temperature Controller	2
M	17650-5	Buss Bar (220V)	1
	17650-5-380	Buss Bar (380V)	1
N	0205-1	Binder Head Machine Screw	10



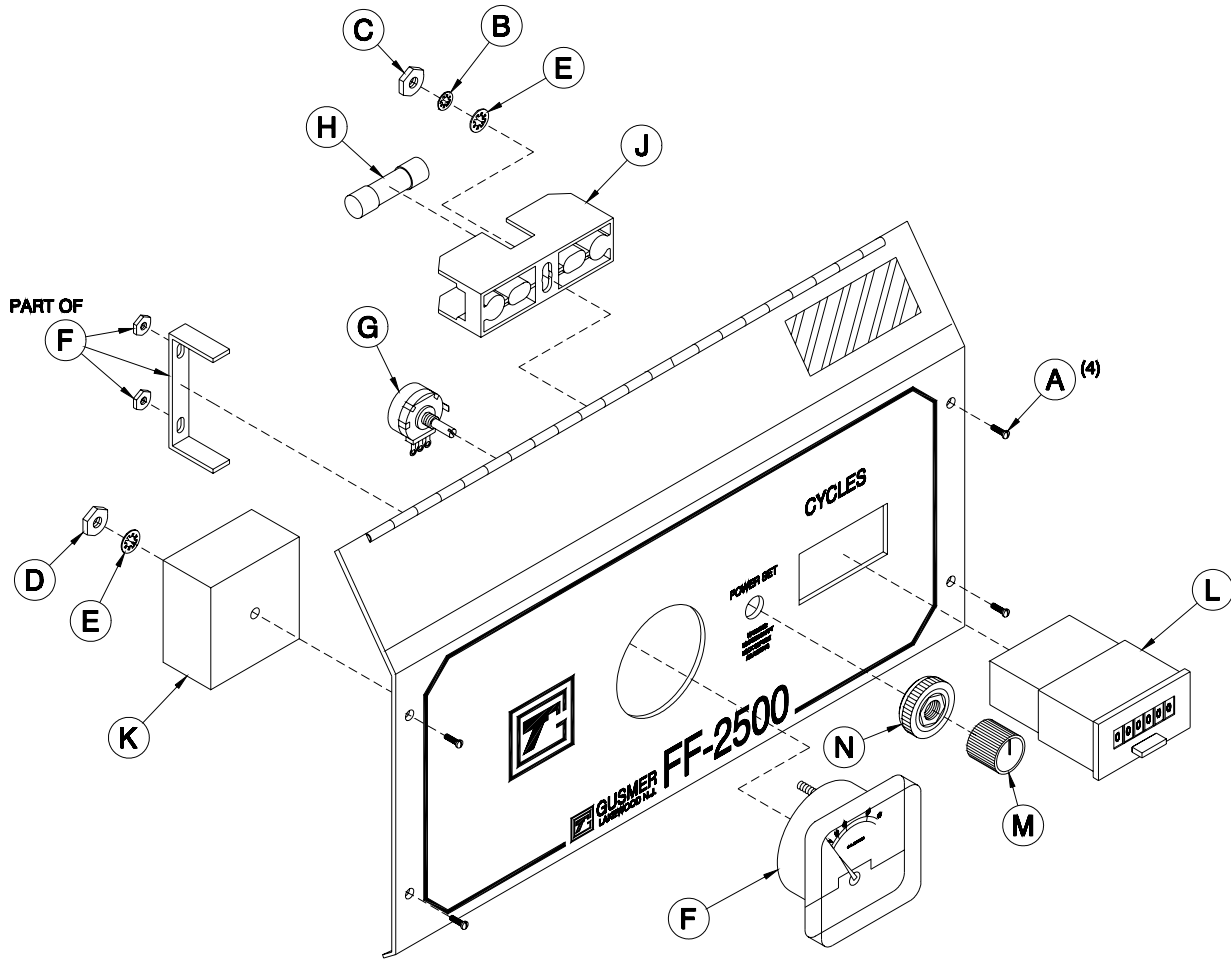
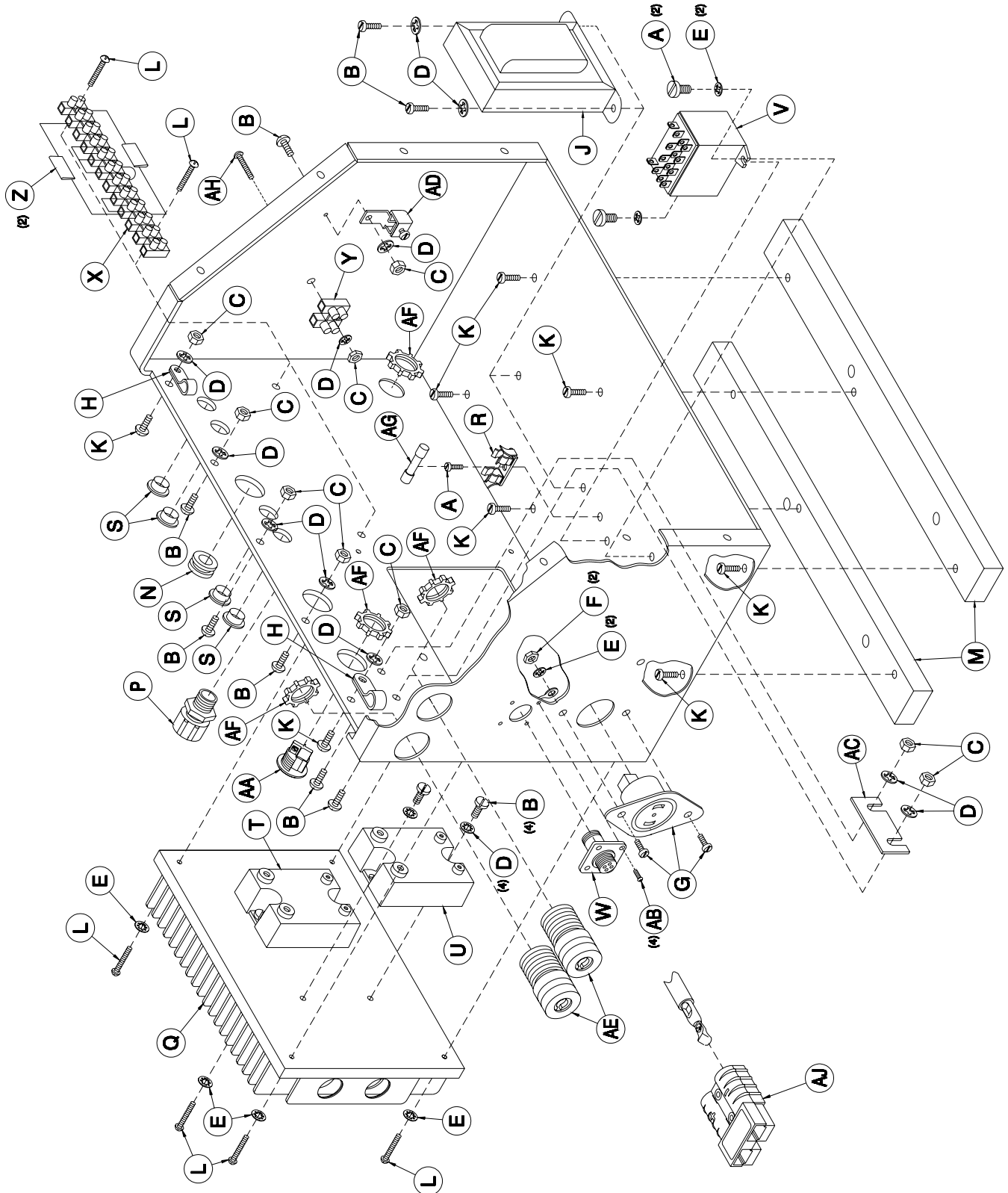


Figure 3. Electric Console (Part No. 25650-SIZE), Exploded View, Sheet 2 of 3

TABLE 3. ELECTRIC CONSOLE (PART NO. 25650-SIZE), PARTS, SHEET 2 OF 3

Reference Letter	Part Number	Description	Quantity
A	0368	Binder Head Machine Screw	4
B	0651A-10	Internal Lockwasher	1
C	0668-3-1	Hex Nut	1
D	1701-15-9	Hex Nut	1
E	4702-7-4	Internal Lockwasher	2
F	5616-Kit	Ammeter	1
G	6690-5-17	Potentiometer	1
H	6690-24-1	Fuse	1
J	6690-24-2	Fuse Block	1
K	6690-26-18	Phase Control	1
L	9651-6-2	Counter	1
M	25650-1	Knob	1
N	25650-2	Knob Lock	1

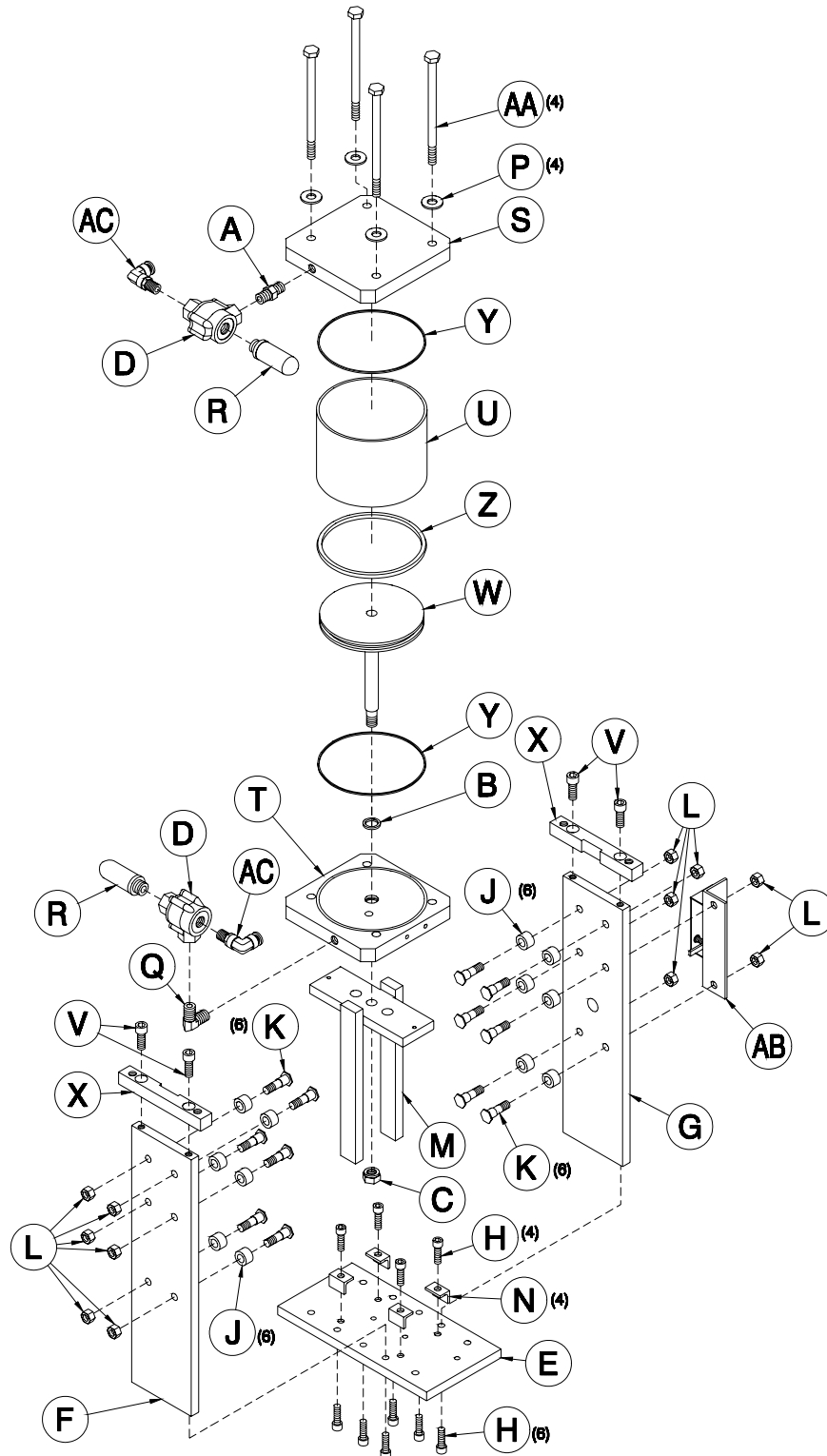


**Figure 4. Electric Console (Part No. 25650-SIZE), Exploded View, Sheet 3 of 3**  
(25650-220 Shown)

TABLE 4. ELECTRIC CONSOLE (PART NO. 25650-SIZE), PARTS, SHEET 3 OF 3

Reference Letter	Part Number	Description	Quantity
A	0368	Binder Head Machine Screw	3
B	0651A-8	Pan Head Machine Screw	12
C	0651A-9	Hex Nut	9
D	0651A-10	Internal Lockwasher	15
E	0655-4	Lockwasher	8
F	0668-3	Hex Nut	2
G	0670A-1-1	Socket	1
H	0681A	Cable Clamp	2
J	0689-1	Transformer	1
K	0689-2	Pan Head Machine Screw	8
L	0698-3	Pan Head Machine Screw	6
M	0760A-1	Console Mounting Bar	2
N	1701-16	Grommet	1
P	17650-1	Strain Relief	1
Q	17708	Heat Sink	1
R	5653B	Fuse Holder	1
S	5703D-10	Bushing	4
T	6690-1-55-1	Solid State Relay 480/50 Amp	1
U	6690-1-46	Solid State Relay 480/90 Amp	1
V	6690-1-14	Relay 10 Amp	1
W	6690-13-2-11-4	4 CKT MA Pin Housing	1
X	6690-20-1-12	Terminal Block	1
Y	6690-20-5-2	Terminal Block (220V)	1
	6690-20-5-4	Terminal Block (380V)	1
Z	6690-21-3	Quencharc Assembly with Wires	2
AA	6690-31-1-1	Thermocouple Socket	1
AB	9651-4	Button Head Machine Screw	4
AC	14667	Jumper	1
AD	17650-2	Wire Lug	1
AE	OP482-17-1	Bushing	2
AF	OP482-17-2	Locknut	4
AG	OP5193-3-3	1 Amp Fuse	1
AH	60302	Round Head Machine Screw	1
AJ	0684-2	Power-Lock™ Connector Housing	1

**AIR MOTOR**



**Figure 5. Air Motor (Part No. 25755), Exploded View**

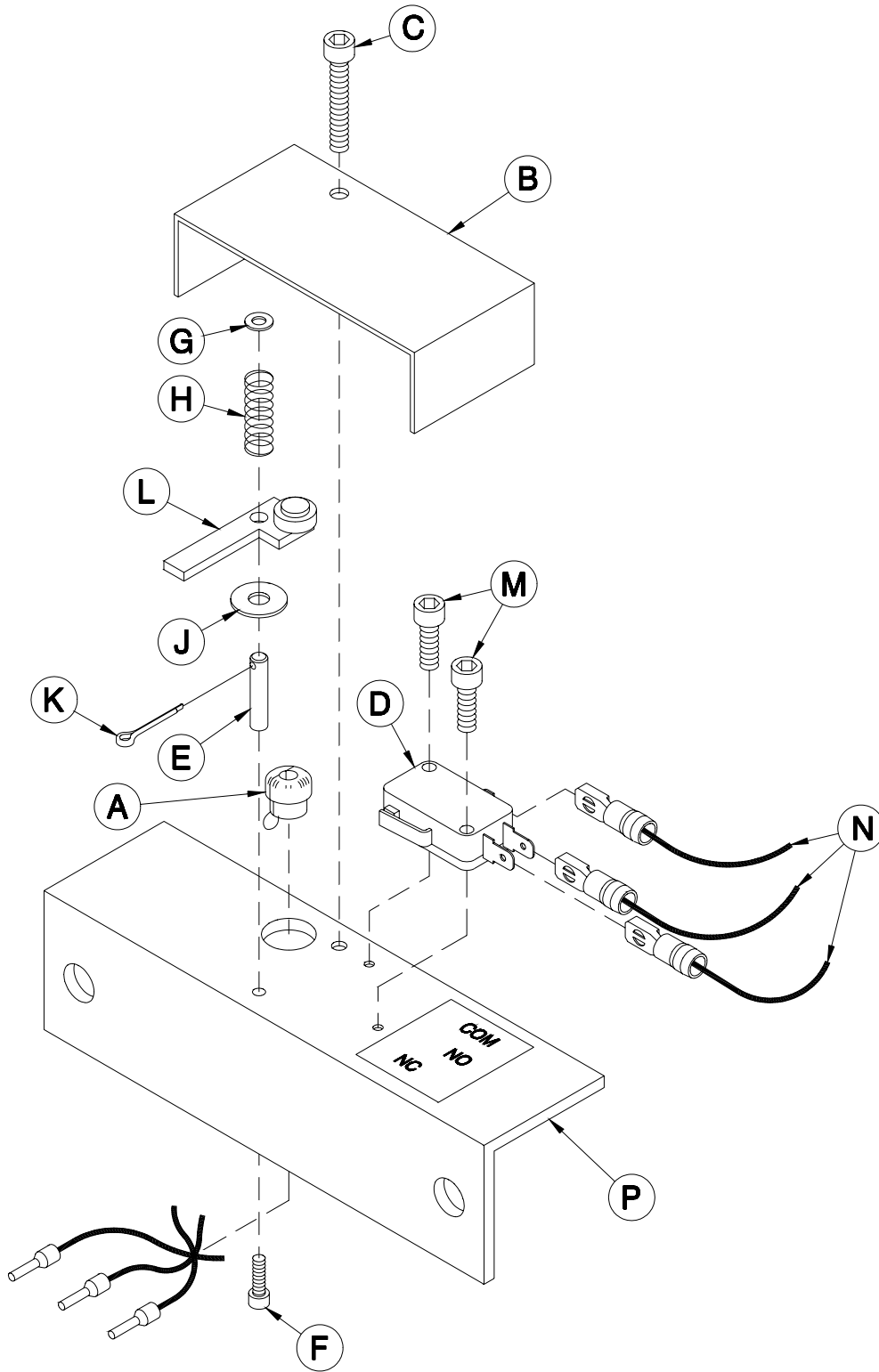
TABLE 5. AIR MOTOR (PART NO. 25755), PARTS

Reference Letter	Part Number	Description	Quantity
A	0466A	Hex Nipple	1
B	0551	O-Ring	1
C	0557	Piston Rod Nut	1
D	0562-12	Exhaust Valve	2
E	0751	Proportioner Base	1
F	0752	Air Cylinder Upright	1
G	0753	Air Cylinder Upright-Switch Side	1
H	0754	Socket Head Cap Screw	10
J	0755-1	Bearings	12
K	0755-2	Cam Roller Stud	12
L	0756	Hex Nut	12
M	0757A	Pump Yoke	1
N	0765	Pump Mounting Bracket	4
P	1516A-3	Washer	4
Q	14501-20	Elbow	1
R	17002	Muffler	2
S	17745-1	Air Cylinder Top Plate	1
T	17745-2	Air Cylinder Bottom Plate	1
U	17745-3	Air Cylinder	1
V	17745-4	Socket Head Cap Screw	4
W	17745-5	Air Piston W/Rod	1
X	17745-6	Air Cylinder Adapter	2
Y	17745-7	O-Ring	2
Z	17745-8	O-Ring	1
AA	17745-9	Hex Head Cap Screw	4
AB	25745-10	Reversing Switch Assembly	1
AC	20042	Tube Fitting	2

**Air Cylinder Rebuild Kit** (Part # 17745-3-1)- Includes B, Z, AA, & Air Cylinder Lubricant (Part No. 0553-2) Order as required from your local Distributor.

**Exhaust Valve Repair Kit** (Part No. 0562-12-1-H) Order as required from your local Distributor.

**REVERSING SWITCH**



**Figure 6. Reversing Switch (Part No. 25745-10), Exploded View**

TABLE 6. REVERSING SWITCH (PART NO. 25745-10), PARTS

Reference Letter	Part Number	Description	Quantity
A	0364	Bushing	1
B	0577-2	Reversing Switch Cover Box	1
C	0577-3	Socket Head Cap Screw	1
D	0578A	Reversing Switch	1
E	0579-2	Pivot Arm	1
F	0579-3	Socket Head Cap Screw	1
G	0579-4	Flat Washer	1
H	0579-5	Spring	1
J	0579-6	Fiber Washer	1
K	0579-7	Cotter Pin	1
L	0579A-1	Reversing Switch Lever	1
M	9577-10	Socket Head Cap Screw	2
N	17745-10-1	Reversing Switch Harness	1
P	25577-1	Reversing Switch Bracket (Includes M, E, & F)	1





TABLE 7. AIR CONTROL SYSTEM (PART NO. 17756), PARTS

Reference Letter	Part Number	Description	Quantity
A	0385-4	Hex Nut	2
B	0561	Hex Nipple	2
C	0575	Pipe Cap	1
D	0576	Pipe Plug	2
E	1701-4	Hex Head Cap Screw	2
F	5504-3	Helical Lock Washer	2
G	6304-21	Branch Tee	1
H	6306-3	Tube Fitting	2
J	6311-109	Valve (Includes 17756-2-24)	1
K	6311-124	Regulator	2
L	6312-26	Air Filter	1
M	6314	Gauge	2
N	9457	Swivel Union	1
P	9758	Lockwasher	2
Q	17746-5	Pipe Tee	1
R	17746-7	Hex Nipple	1
S	17746-12	Pipe Nipple	1
T	17756-2-24	Coil	2
U	17756-4	Mounting Bracket	1
V	17756-7	Air Manifold	1
W	20042	Tube Fitting	6
X	IP1119	Hex Head Cap Screw	2
<b>Not Shown</b>			
	8680-3-2	Din Connector	2

**Spool Replacement Kit** (Part No. 17756-2-1)- Order as required from your local Distributor.

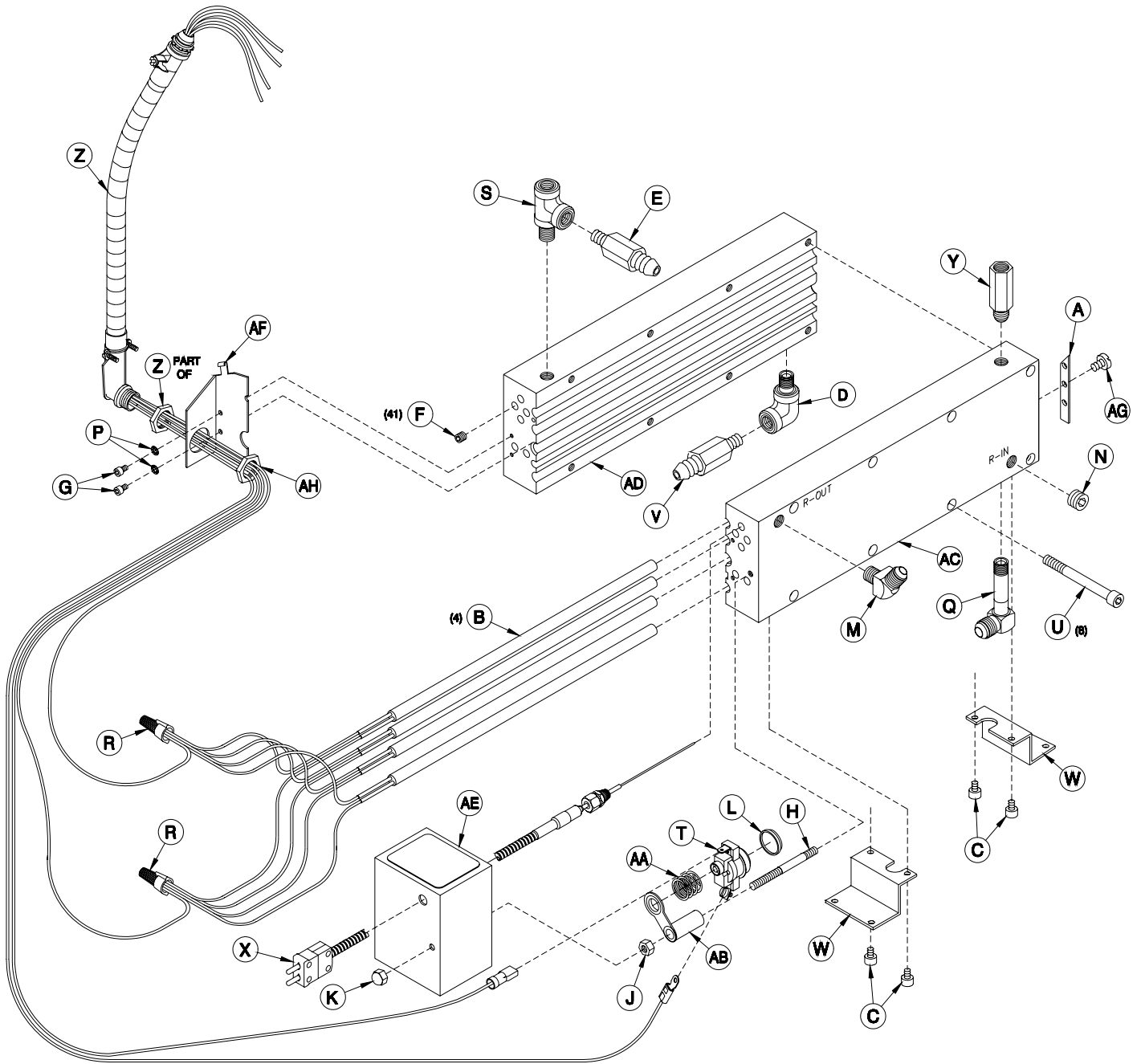
**Seal Kit** (Part No. 17756-2-3)- Order as required from your local Distributor.

**Valve Modification/Rebuild Kit** (Part No. 6311-109-1)- Two required per valve assembly. Spool Assembly not included. Order as required from your local Distributor.

**Regulator Rebuild Kit** (Part #MK6311-124-1)- Order as required from your local distributor.

**Filter Rebuild Kit** (Part #MK6312-26-1)- Order as required from your local distributor.

**PRIMARY HEATER**



**Figure 8. Primary Heater (Part No. 17360), Exploded View**

TABLE 8. PRIMARY HEATER (PART NO. 17360), PARTS

Reference Letter	Part Number	Description	Quantity
A	0351B-1	Stop	1
B	0361-1500-220	Heating Element-220V	4
C	0371	Socket Head Cap Screw	4
D	0375B-2	Street Elbow	1
E	0375C-3	Hose Nipple	1
F	0377	Pipe Plug	41
G	0379-2	Socket Head Cap Screw	2
H	0385-3	Threaded Stud	1
J	0385-4	Hex Nut	1
K	0385-5	Acorn Nut	1
L	0385-6	Heat Transfer Plate	1
M	0465	Hose Elbow	1
N	0576	Pipe Plug	1
P	0651A-10	Lockwasher	2
Q	1323	Long Male Elbow	1
R	1650-14	Wire Pig Tail	2
S	6465	Pipe Tee	1
T	6690-7-29	Thermal Limit Switch	1
U	9463	Socket Head Cap Screw	8
V	10350-1	Extended Hose Nipple	1
W	10356	Bracket	2
X	17300-25-1	Thermocouple	1
Y	17357	Bushing	1
Z	17366	Primary Heater Wire Harness	1
AA	17385-1	Wave Spring	1
AB	17385-2	Mounting Bracket	1
AC	56300-1-1	R-Preheater Half ( <i>Includes F &amp; N</i> )	1
AD	56350-1-1	A-Preheater Half ( <i>Includes F</i> )	1
AE	56355	Heater Electrical Box	
AF	56379-1	Thermostat Mounting Bracket	1
AG	OP168B-1-2	Pan Head Machine Screw	1
AH	OP482-17-2	Locknut	1
<b>Not Shown</b>			
	0362C-6	Replacement Microswitch	1
	0365-9	Plastic Bushing	2
	1257	JIC Cap	1
	1258	JIC Cap	1
	17358	Insulator Blanket	1

**PROPORTIONING PUMP**

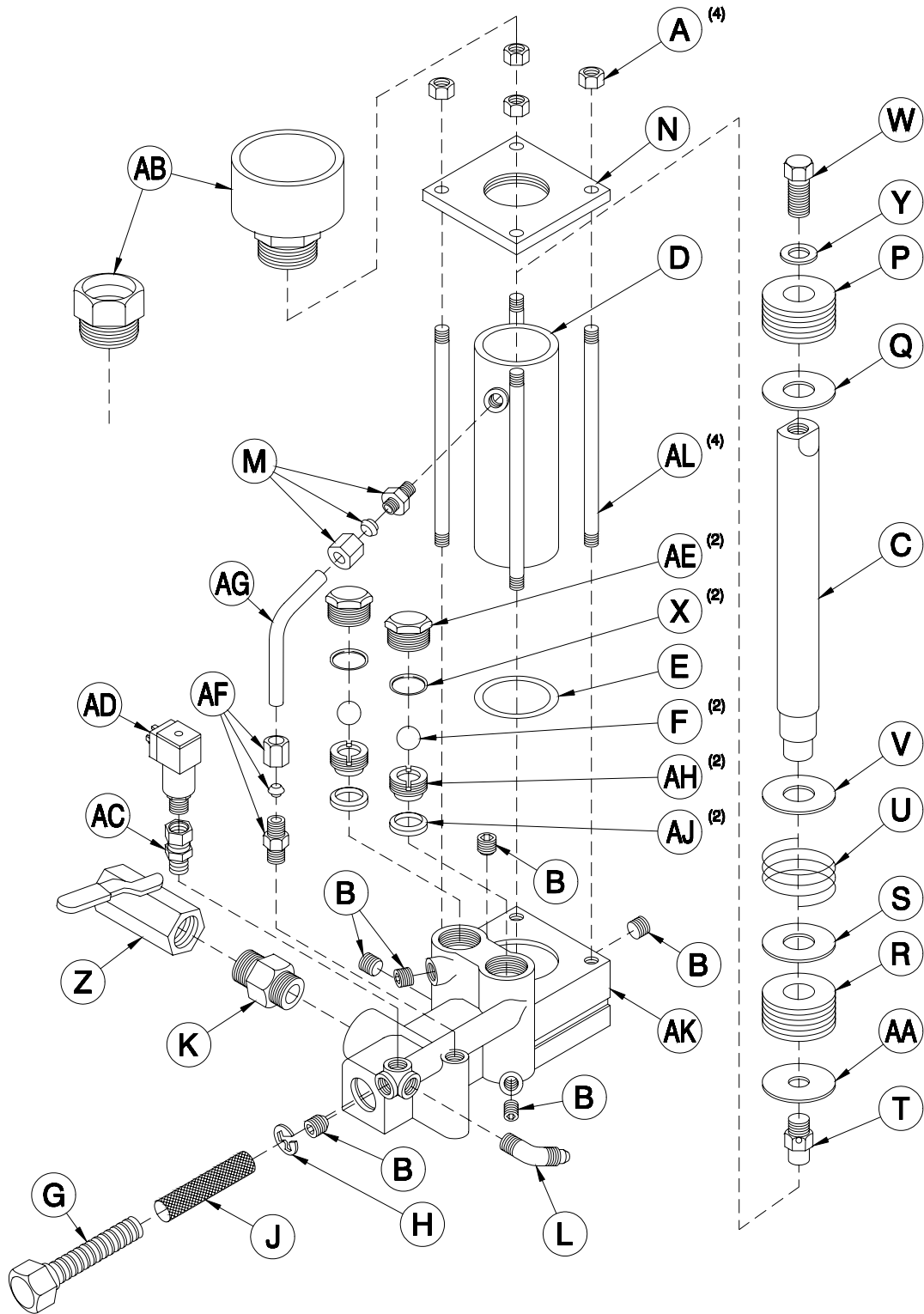


Figure 9. Proportioning Pump (Part No. 25400/25450-40), Exploded View

TABLE 9. PROPORTIONING PUMP (PART NO. 25400/25450-40), PARTS

Reference Letter	Part Number	Description	Quantity
A	0213-1	Hex Nut	4
B	0377	Pipe Plug	6
C	0451A-40	Pump Piston Rod	1
D	0452A-40	Pump Cylinder	1
E	0453	O-Ring	1
F	0455	Valve Ball	2
G	0460	Screen Screw	1
H	0461	Snap Ring	1
J	0462-40	Pump Screen	1
K	0463	Hex Nipple	1
L	0465	Hose Elbow	1
M	0470	Tube Nipple	1
N	0474	Cylinder Top	1
P	0476-40	Packing Set	1
Q	0477-40	Packing Support Washer	1
R	0478A-40	Packing Set	1
S	0479-40	Packing Support Washer	1
T	0480D-60/40	Packing Retainer Bolt	1
U	0481-44/40	Conical Spring	1
V	0482-40	Spring Retainer Washer	1
W	0483-7/16	Hex Head Cap Screw	1
X	0485	O-Ring	2
Y	0486-7/16	Washer	1
Z	0487A	Ball Valve	1
AA	0488-40	Packing Retainer Washer	1
AB	0475-40	R - Packing Nut ( <i>Resin Side ONLY</i> )	1
	0489-40	A - Packing Nut w/Lube Cup ( <i>Iso Side ONLY</i> )	1
AC	0562-15	Swivel Union	1
AD	6690-16-772800R	Pressure Switch	1
AE	17402	Check Valve Retainer	2
AF	17404	Tube Fitting	1
AG	17405	Crossover Tube w/Ferrule	1
AH	17406	Check Valve Seat	2
AJ	17407	Check Valve Seal	2
AK	17428	Resin Pump Base (Includes A)	1
	17478	Iso Pump Base (Includes A)	1
AL	56427	Tie Rod	4



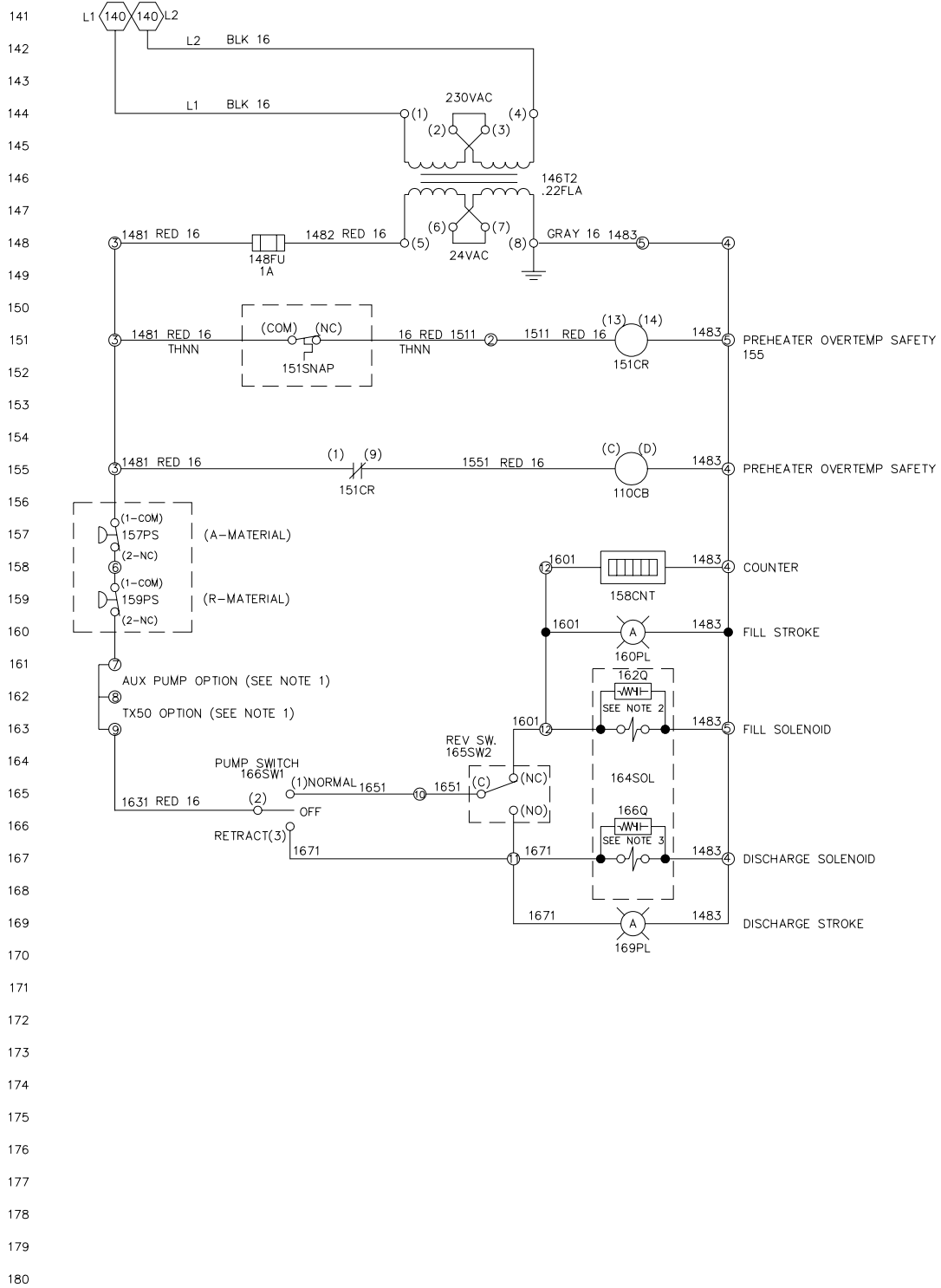


Figure 11. FF-2500 Electrical Schematic (SD25000-1), Sheet 2 of 2

**380V Three-Phase**

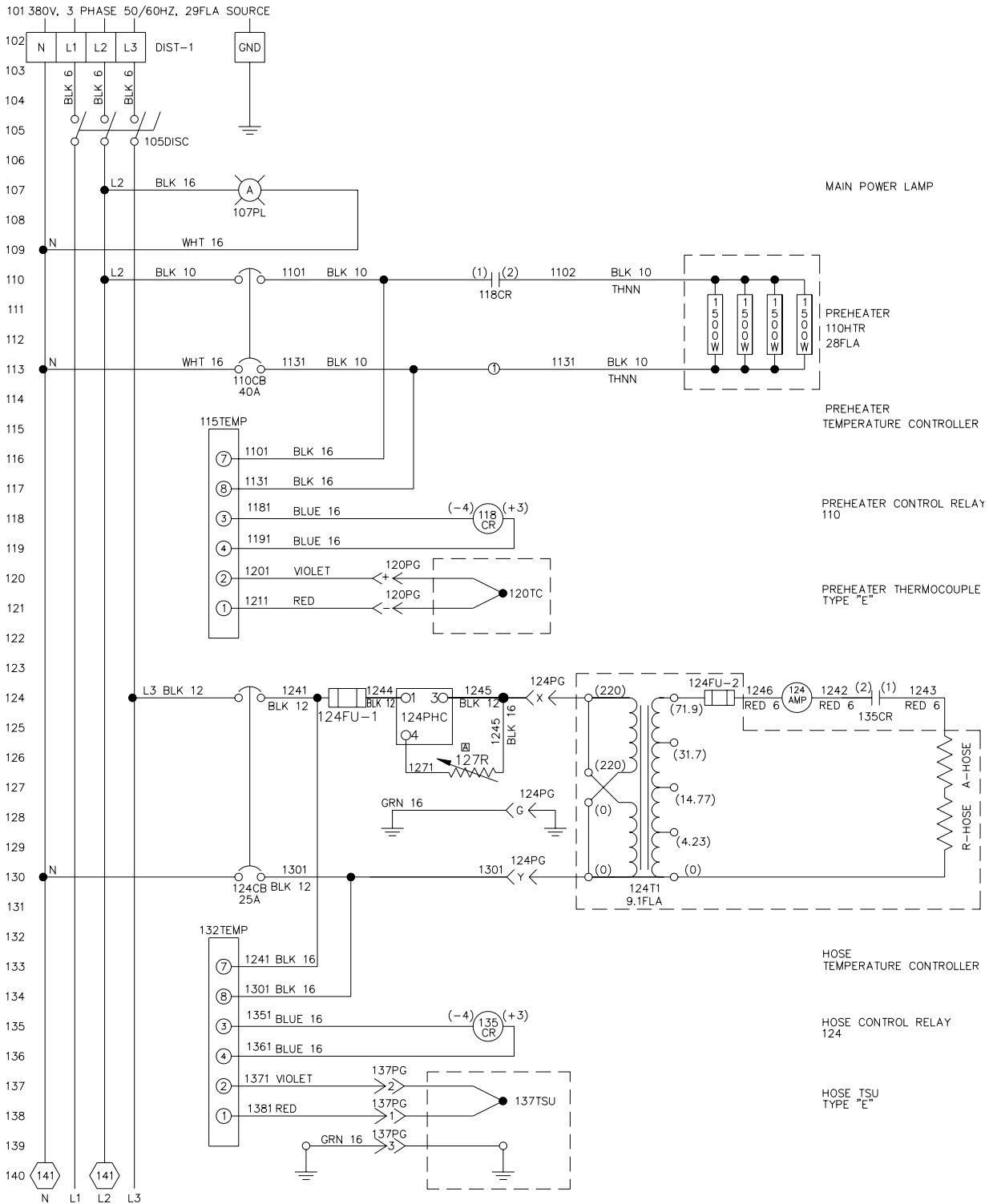


Figure 12. FF-2500 Electrical Schematic (SD25000-11), Sheet 1 of 2



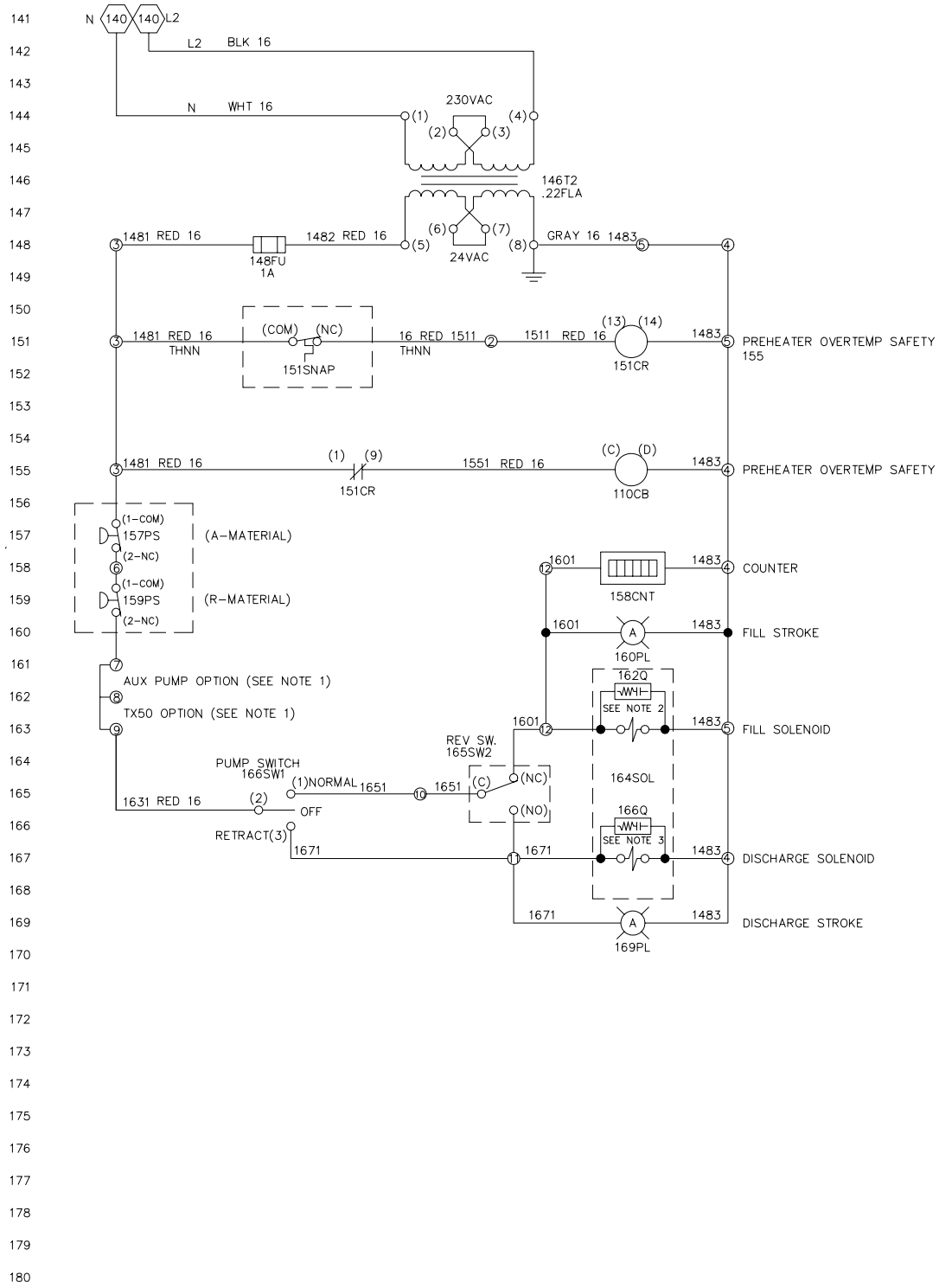


Figure 13. FF-2500 Electrical Schematic (SD25000-11), Sheet 2 of 2

TABLE 10. FF-2500 ELECTRICAL SCHEMATIC (SD25000-SIZE), PARTS

Reference Number.	Part Number	Description	Quantity
<b>DIST-1</b>	6690-20-5-2	Main Power Distribution Block, Single Phase 220V	1
	6690-20-5-4	Main Power Distribution Block, Three Phase 380V	1
	17650-2	Wire Terminal Lug	1
<b>105DISC-1</b>	6690-16-10	Switch	1
<b>107LP</b>	0656	Indicator Cap - White	1
	6690-19-25	Light Base	1
	6690-19-24	Bulb	1
<b>110CB</b>	6690-25-31	40 Amp Circuit Breaker	1
<b>111HTR</b>	361-1500-220	Heating Element	REF (4)
<b>115TEMP</b>	6690-26-22-1	Primary Heater Control	1
<b>118CR</b>	6690-1-55-1	Solid State Relay	1
<b>120PG</b>	6690-31-1-1	Thermocouple Socket	1
	6690-31-2-1	Thermocouple Plug	1
<b>120TC</b>	6690-7-14	Thermocouple	REF (1)
<b>124CB</b>	0692-1-25	25 Amp Circuit Breaker	1
<b>124FU-1</b>	6690-24-1	Fuse Holder	1
	6690-24-2	25 Amp Fuse	1
<b>124PHC</b>	6690-26-18	Phase Controller	1
<b>124PG</b>	0670A-1-1	Hose Socket / Wired	1
<b>124T1</b>	6690-15-5	Transformer	REF (1)
<b>124FU-2</b>	6690-24-13	In-Line Fuse Holder	REF (1)
	6690-24-14	50 Amp Fuse	REF (1)
<b>124AMP</b>	5616-Kit	Ammeter	1
<b>A-HOSE</b>		Iso Hose Assembly	REF (1)
<b>R-HOSE</b>		Poly Hose Assembly	REF (1)
<b>132TEMP</b>	6690-26-22-1	Hose Heat Control	1
<b>135CR</b>	6690-1-46	Solid State Relay	1
<b>137PG</b>	6690-13-2-11-4	TSU Plug	1
<b>137TSU</b>		TSU (Temperature Sensing Unit)	REF (1)
<b>146T2</b>	0689-1	Transformer	1
<b>148FU</b>	OP5193-3-3	1 Amp Slo Blo Fuse	1
	5653B	Fuse Holder	1
<b>151SNAP</b>	6690-7-29	Thermal Limit Switch	REF (1)
<b>151CR</b>	6690-1-14	24VAC Relay	1
<b>157PS</b>	6690-16-772800R	Pressure Switch	REF (1)
	6690-16-76-2	Din Connector	REF (1)
<b>158CNT</b>	9651-6-2	Counter	1
<b>159PS</b>	6690-16-772800R	Pressure Switch	REF (1)
	6690-16-76-2	Din Connector	REF (1)
<b>160LP</b>	6690-19-25	Incandescent Light Base	1
	0660	Indicator Cap (Amber)	1
	0662A	Incandescent Bulb	1
<b>162Q</b>	6690-21-3	Quencharc	1
<b>164SOL</b>	6311-109	Valve	REF (1)
<b>165SW1</b>	0578A	Reversing Switch	REF (1)
<b>166SW1</b>	6690-16-6	DPDT Toggle Switch	1
<b>166Q</b>	6690-21-3	Quencharc	1
<b>169LP</b>	6690-19-25	Incandescent Light Base	1
	0660	Indicator Light	1
	0662A	Incandescent Bulb	1



Field Number	Field Title	Description
1	<b>Date</b>	Enter date report is submitted.
2	<b>Name</b>	Enter name of person making report.
3	<b>IM Number</b>	Enter the Part Number of the Instruction Manual from the title page.
4	<b>Issue Number</b>	Enter the Issue number of the Instruction Manual from the title page. If there is no issue number, enter <b>NONE</b> .
5	<b>Date of Issue</b>	Enter the date of Issue of the Instruction Manual from the title page. If there is no issue date, enter <b>NONE</b> .
6	<b>Page Number</b>	Enter the page number containing the discrepancy.
7	<b>Discrepancy</b>	Provide a brief description of discrepancy.

**NOTE:** You may send a marked copy of the page as an attachment to your submittal.