

# HTM Feed Hoppers

Use this instruction sheet for reference of overall Hopper top mount (HTM) feed hopper dimensions, capacity, and replacement parts. HTM 16, 26, 34, and 48 represent the number of pump ports on the top of each hopper.

## Specifications

See Figure 1 and refer to Table 1 for HTM feed hopper dimensions and capacity.

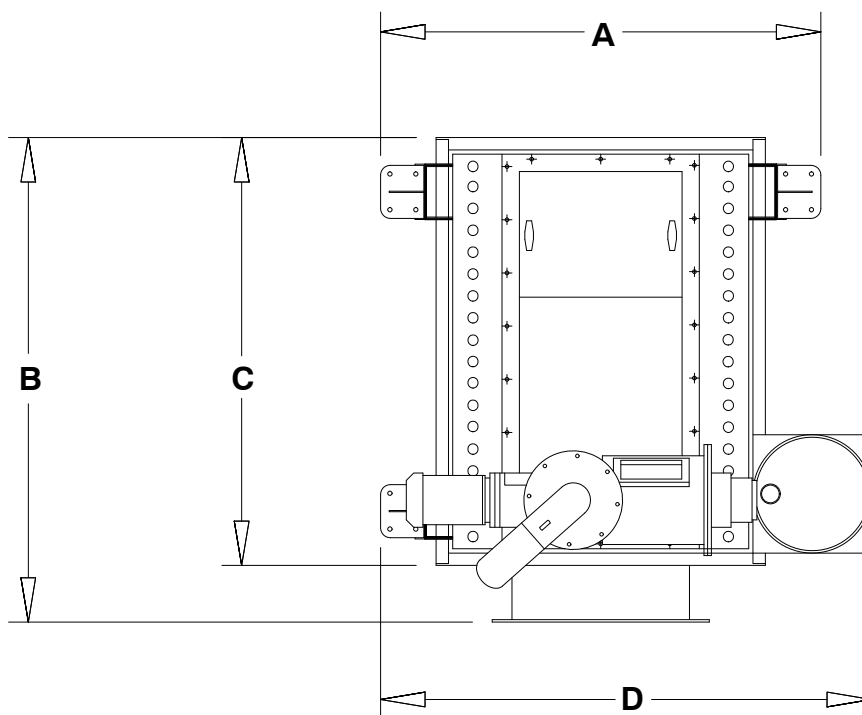


Figure 1 HTM Feed Hopper Dimensions (shown with HTM 36 with AZO sieve)

Table 1 HTM Hopper Dimensions and Capacity

Dimensions	Hopper			
	HTM 16	HTM 26	HTM 36	HTM 48
A	45 in. (114 cm)	45 in. (114 cm)	45 in. (114 cm)	57 in. (145 cm)
B	33 in. (84 cm)	39 in. (99 cm)	43.5 in. (110 cm)	52 in. (132 cm)
C	27 in. (69 cm)	33.5 in. (85 cm)	49 in. (124 cm)	59 in. (150 cm)
D	50 in. (127 cm)	49.5 in. (126 cm)	50 in. (127 cm)	62 in. (157 cm)
Approximate Capacity	200 lb (91 kg)	300 lb (136 kg)	400 lb (181 kg)	550 lb (249 kg)

## Feed Hopper Fluidizing Plate Replacement



**WARNING:** Allow only qualified personnel to perform the following tasks. Follow the safety instructions in this document and all other related documentation.

### *Preparation*

1. Pump as much powder as you can from the feed hopper. Disconnect the powder feed hoses, transfer hoses, accumulator vent hose, and 10-tube quick-disconnects from the feed hopper, powder pumps, and accumulator.
2. Rotate the level sensor and pull it from its mounting in the side of the feed hopper.
3. Unplug the sieve power cords (electrically driven sieves only). Disconnect the feed-hopper ground wire.
4. Remove the feed hopper from the color module and roll it to a clean work area.
5. Remove the powder from the hopper and thoroughly clean the hopper, accumulator, and sieve.

### *Replacement*

1. See Figure 2. Block up the plenum (5) so the plenum and feed hopper flanges will not bend when you start removing the clamping channels (3).
2. Loosen screws (4) about 6–10 mm (0.25–0.375 in.) to clear the gasket (2). Remove the clamping channels.
3. Remove the plenum and the fluidizing plate (1) from under the feed hopper.
4. Clean the plenum interior and the plenum and feed hopper flanges.
5. Position the new fluidizing plate and gasket on the plenum.
6. Slide the plenum and fluidizing plate under the hopper. Align the edges of the feed hopper flange, gasket, and plenum flange evenly on all sides. Block the plenum to hold it in position.
7. Install the clamping channels over the plenum and hopper flanges. Tighten the clamping-channel screws with a torque wrench to 2.8 N•m (25 in.-lb) in a criss-cross pattern. This prevents flange distortion and fluidizing plate damage.
8. Attach the feed hopper to the color module. Connect the hoses, quick-disconnects, power cords, and ground wires. Install the level sensor in its mounting.

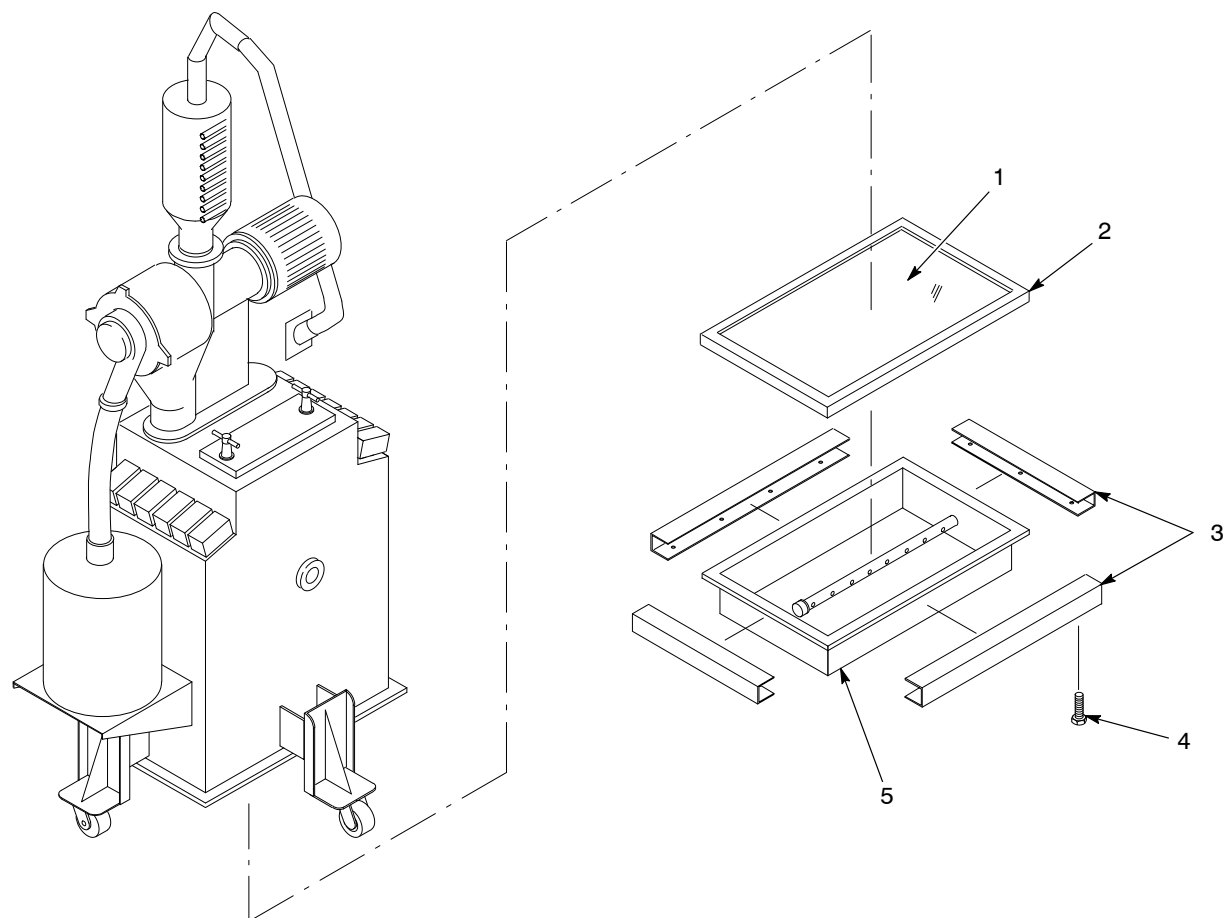


Figure 2 Feed Hopper Fluidizing Plate Replacement

- |                     |                      |           |
|---------------------|----------------------|-----------|
| 1. Fluidizing plate | 3. Clamping channels | 5. Plenum |
| 2. Gasket           | 4. Screws            |           |

## Parts

See Figure 3 and the following parts list.

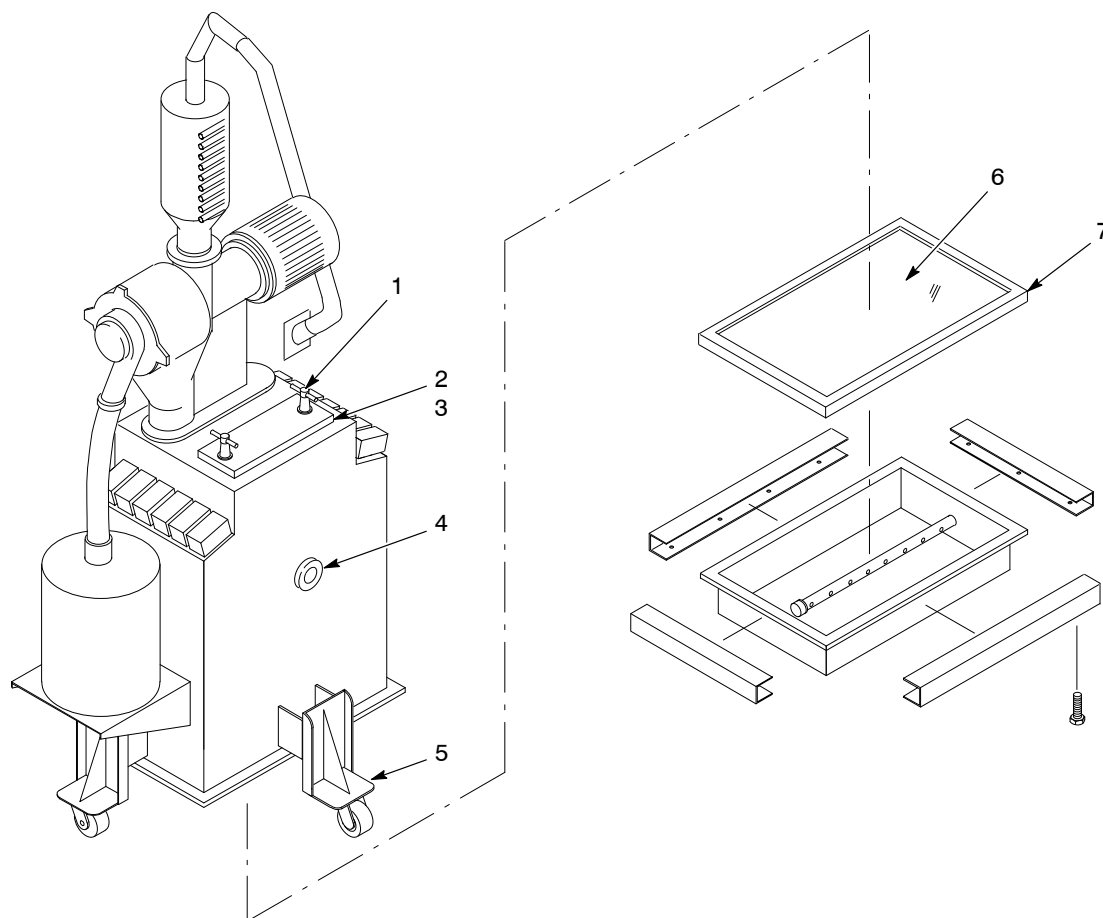


Figure 3 Feed Hopper Parts

Item	Hopper	Part	Description	Quantity	Note
1	All HTM	235049	LATCH, with gasket, black	AR	
2	HTM 16/26/ 36	235052	DOOR, access, assembly, 5–3/4 in. x 16–1/4 in.	1	F
3		235047	GASKET, access door, 17 in. X 6.25 in.	1	F
2	HTM 48	-----	DOOR, access, 11–3/4 in. x 15–3/4 in.	1	D
3		-----	GASKET, access door	1	D
4	All HTM	339425	KIT, retro, level sensor	1	A
		339344	• KIT, retrofit, level sensor control	1	B
		1601144	• • TIMER, relay	1	
		237199	• SENSOR, level, N/C, quick disconnect	1	
		310740	• CABLE, 3 pin, micro AC connection	1	
		933326	• CONNECTOR, conduit, ½ NPTX 0.437 grip	1	
		174607	• KIT, well, level sensor mounted	1	C
5	All HTM	174600	CASTER, 6 in., swivel	AR	E
		174545	CASTER, 4 in., swivel	AR	E
6	HTM 16	176311	PLATE, fluidizing, 0.50 TH x 20.50 x 32.50 in.	1	
7		176335	GASKET, fluid plate, 29.00 x 19.00 in.	1	
6	HTM 26	179059	PLATE, fluidizing, 0.50 TH x 32.50 x 32.50 in.	1	
7		1020586	GASKET, 25.50 x 25.50 in.	1	
6	HTM 36	176312	PLATE, fluidizing, 0.50 TH x 32.50 x 42.50	1	
7		176330	GASKET, fluid plate, 31.5 x 41.5	1	
6	HTM 48	179072	PLATE, fluidizing, 0.50 TH x 44.75 x 50.75	1	
7		179080	GASKET, plate, fluidizing, HF2TM hopper	1	
NOTE A: Complete kit to add a level sensor to an existing system, including the sensor and connections, well to mount to the hopper, and electrical components to add to the control panel.					
B: Contains only the parts required to modify the control panel.					
C: Contains only the components required to install the level sensor to the hopper. It does not include the sensor.					
D: Contact Nordson representative to order.					
E: Check castors currently installed to determine castor size required.					
F: Measure existing component to confirm correct part needed. If using HTM 36 with 650 AZO lid, contact Nordson representative for ordering.					
AR: As Required					
NS: Not Shown					

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