

Legend:

RSPC = Recommended Spare Part Class		
RSPC	Description	Definition
A	Consumable part	A part that is not maintainable , consumed by the machine and /or the process and must be replaced/refilled after a certain quantity of products produced.
B	Wear and tear part	A part that is mostly not maintainable , it wears more or less proportional to the quantity of products produced and therefore needs to be replaced/reconditioned after a certain quantity of products produced.
C	Essential part	A part that is not maintainable within a reasonable time, with an “essential” function in the machine, which in case it fails, might cause a machine down situation.
D	Spare part	A part that might need replacement, due to unforeseen circumstances and therefore is made available.
E	Tooling part	A customized part, that means a part manufactured (customer and/or product specific) for a unique application.
<p>Note: The RSPC in this manual is indicative. GEA reserves the right to make changes without notices. Ask your local GEA sales representative for your customized Recommended Spare Part List.</p>		

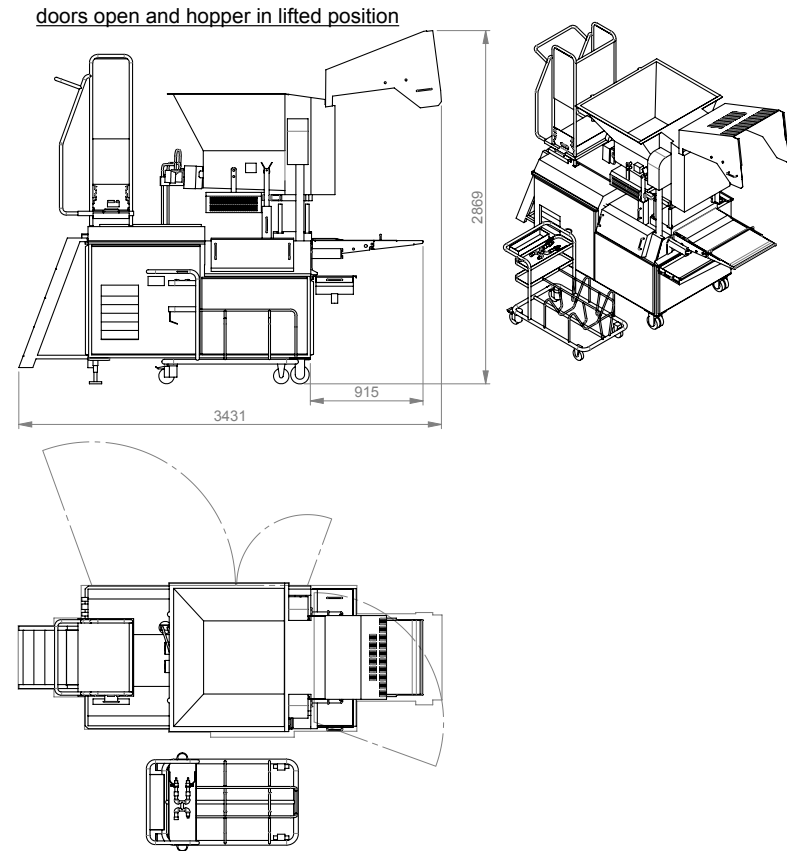
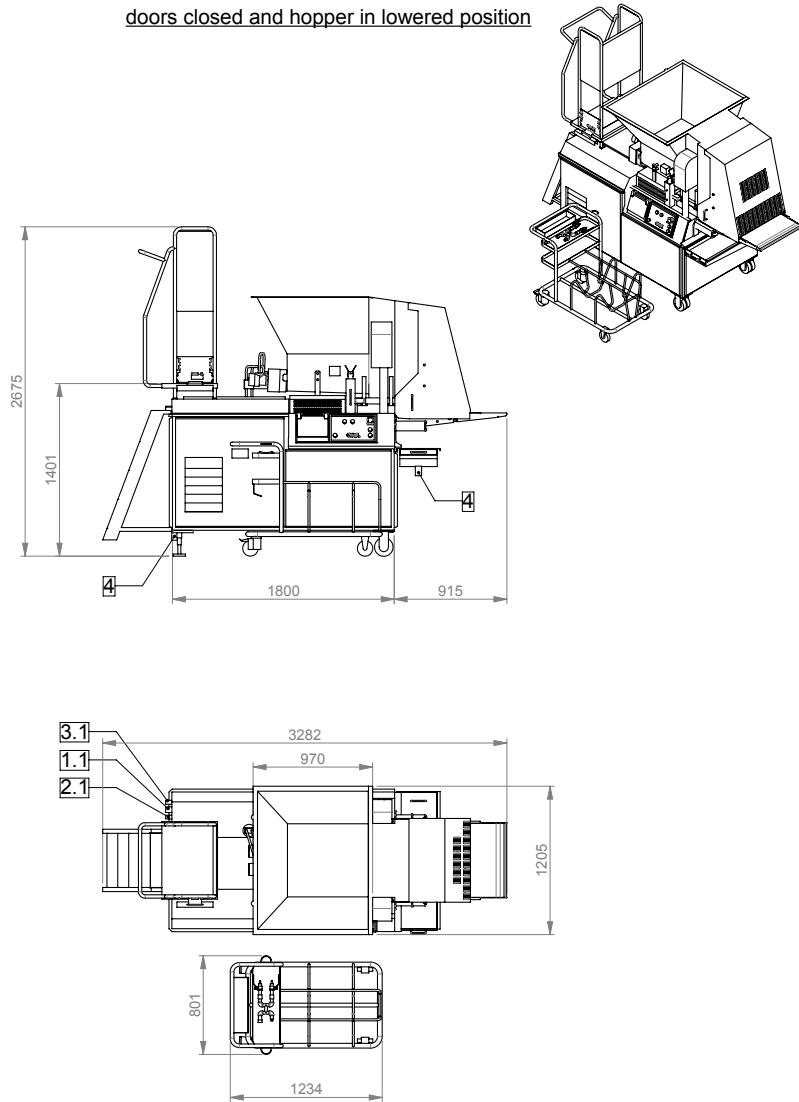
Item number	Item description (native)	Type	Pos	Sheet
1000422252	GEA MultiFormer	DOC		
1000422252	GEA MultiFormer	BOM		
1000424257	GEA MultiFormer	DOC	1	01
1000424255	document	DOC	2	-
1000384404	frame	DOC	10	01
1000384404	frame	BOM	10	
1000283735	part	DOC	20	01
1000283735	part	BOM	20	
1000294726	adjusting leg	DOC	20-1	01
1000294726	adjusting leg	BOM	20-1	
1000294727	adjusting leg	DOC	20-2	01
1000294727	adjusting leg	BOM	20-2	
4.133538	lever	DOC	20-5	01
4.133538	lever	BOM	20-5	
1000260047	cleaning device	DOC	20-9	01
1000260047	cleaning device	BOM	20-9	
F121706	auxiliary tool	DOC	20-10	01
F121706	auxiliary tool	BOM	20-10	
1000283889	hydraulic unit	DOC	30	01
1000283889	hydraulic unit	BOM	30	
H002229	hydraulic pump	DOC	30-4	10
1000372951	motor	DOC	40	01
1000372951	motor	BOM	40	
1000373481	oil cooler	DOC	50	01
1000373481	oil cooler	BOM	50	
1000430720	drive	DOC	60	01
1000430720	drive	BOM	60	
F109242	disc	DOC	60-14	01
F109242	disc	BOM	60-14	
1000283060	outfeed conveyor	DOC	70	01
1000283060	outfeed conveyor	BOM	70	
K013220	wire mesh belt	DOC	70-22-1	
1000286640	cowling	DOC	80	01
1000286640	cowling	BOM	80	
1000292239	lift	DOC	90	01

Item number	Item description (native)	Type	Pos	Sheet
1000292239	lift	BOM	90	
1000293334	lift	DOC	90-1	01
1000293334	lift	BOM	90-1	
1000286055	hopper	DOC	100	01
1000286055	hopper	BOM	100	
1000291963	gearbox	DOC	100-2	01
1000291963	gearbox	BOM	100-2	
1000291920	bearing block	DOC	100-2-1	
1000291920	bearing block	BOM	100-2-1	
1000289988	guide	DOC	100-10	01
1000289988	guide	BOM	100-10	
K019650	plate	DOC	100-12-1	
K019650	plate	DOC	100-13-1	
1000214613	piston	DOC	100-21-2	01
1000214613	piston	BOM	100-21-2	
1000257104	bushing	DOC	100-21-13	01
1000257104	bushing	BOM	100-21-13	
1000213043	throttle valve	DOC	100-21-17	01
1000213043	throttle valve	BOM	100-21-17	
1000282189	wear part kit	DOC	100-21-100	01
1000282189	wear part kit	BOM	100-21-100	
1000286915	air assisted knock out	DOC	100-27	01
1000286915	air assisted knock out	BOM	100-27	
F124109	female connector socket	DOC	100-31	01
F124109	female connector socket	BOM	100-31	
1000276422	stairs	DOC	110	01
1000276422	stairs	BOM	110	
1000282552	form plate guiding	DOC	120	01
1000282552	form plate guiding	BOM	120	
1000215899	clamping block	DOC	120-9	
1000215899	clamping block	BOM	120-9	
1000257081	piston	DOC	120-10-2	01
1000257081	piston	BOM	120-10-2	
1000257104	bushing	DOC	120-10-13	01
1000257104	bushing	BOM	120-10-13	

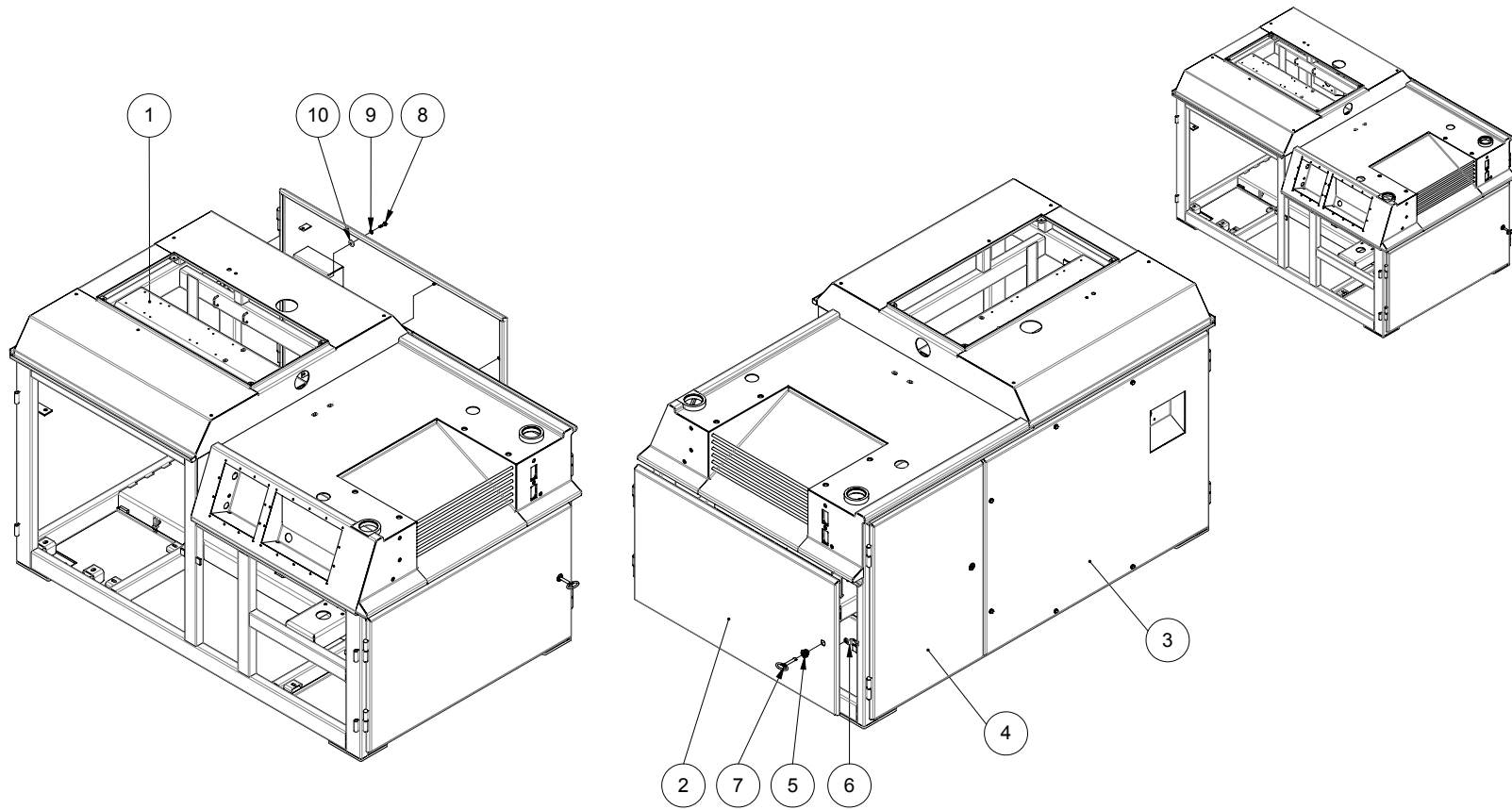
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1000213043	throttle valve	DOC	120-10-17	01
1000213043	throttle valve	BOM	120-10-17	
1000109733	foot	DOC	120-11	
1000109733	foot	BOM	120-11	
1000283887	pipework	DOC	130	01
1000283887	pipework	BOM	130	
F121215	clamp	DOC	130-2	01
F121215	clamp	BOM	130-2	
1000390154	hydraulic pipe	DOC	130-8	
1000390154	hydraulic pipe	BOM	130-8	
1000299327	hydraulic pipe	DOC	130-9	
1000299327	hydraulic pipe	BOM	130-9	
1000422242	hydraulic pipe	DOC	130-10	
1000422242	hydraulic pipe	BOM	130-10	
1000422244	hydraulic pipe	DOC	130-11	
1000422244	hydraulic pipe	BOM	130-11	
F121192	hydraulic pipe	DOC	130-12	
F121192	hydraulic pipe	BOM	130-12	
F121193	hydraulic pipe	DOC	130-13	
F121193	hydraulic pipe	BOM	130-13	
F121194	hydraulic pipe	DOC	130-14	
F121194	hydraulic pipe	BOM	130-14	
F121195	hydraulic pipe	DOC	130-15	
F121195	hydraulic pipe	BOM	130-15	
F121196	hydraulic pipe	DOC	130-16	
F121196	hydraulic pipe	BOM	130-16	
1000381926	hydraulic pipe	DOC	130-31	
1000381926	hydraulic pipe	BOM	130-31	
1000422248	hydraulic pipe	DOC	130-32	
1000422248	hydraulic pipe	BOM	130-32	
1000309741	door	DOC	160	01
1000309741	door	BOM	160	
3.038010	grate	DOC	160-3	01
3.038010	grate	BOM	160-3	
1000046978	grate	DOC	160-3-8	01
1000046978	grate	BOM	160-3-8	

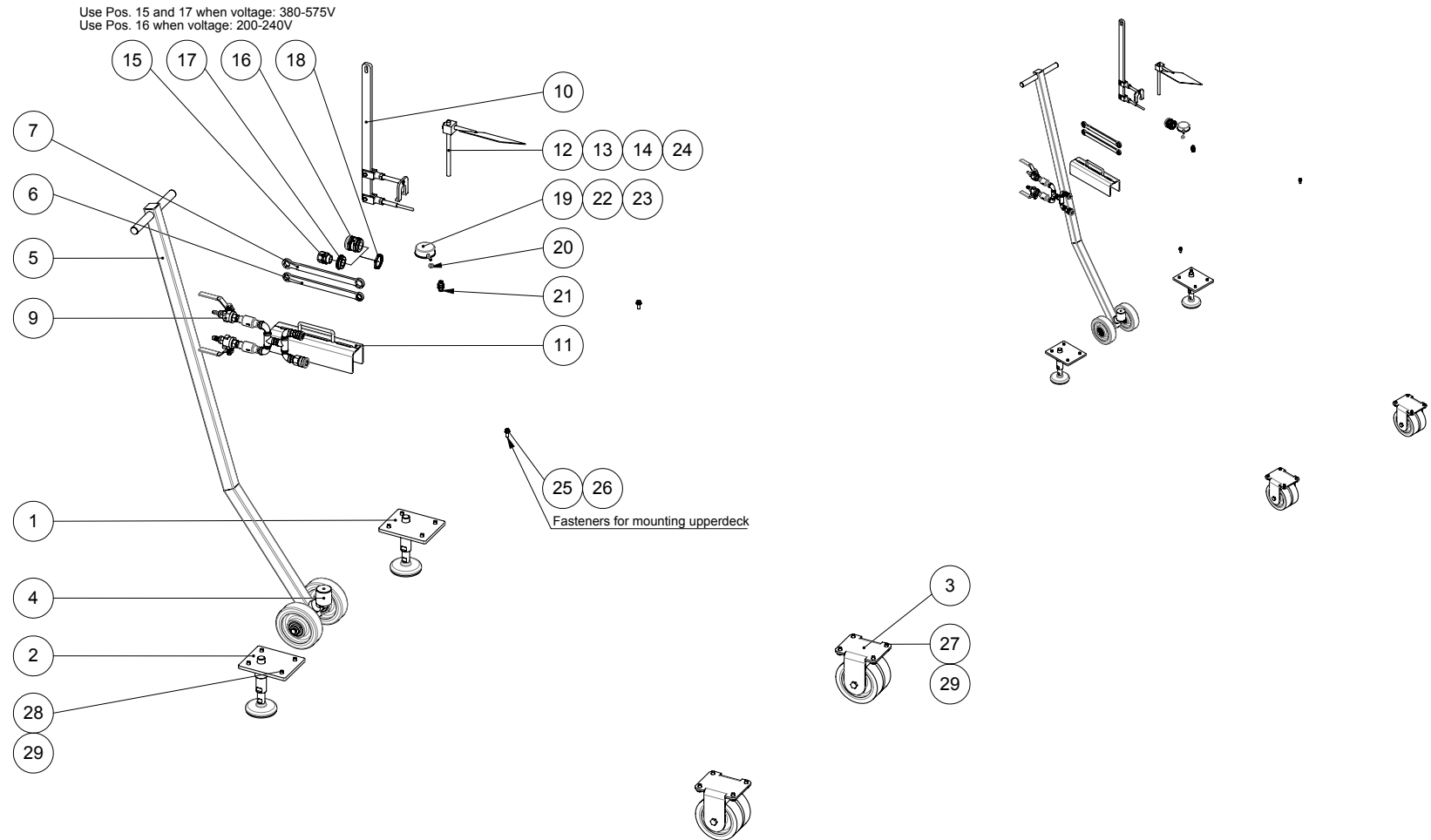
Item number	Item description (native)	Type	Pos	Sheet
1000309743	door	DOC	170	01
1000309743	door	BOM	170	
1000292314	water conduit	DOC	180	01
1000292314	water conduit	BOM	180	
1000300121	valve block	DOC	180-1	01
1000300121	valve block	BOM	180-1	
1000186955	Cleaning Cart	DOC	190	01
1000186955	Cleaning Cart	BOM	190	
1000307472	knock out	DOC	200	01
1000307472	knock out	BOM	200	
1000297146	knock out	DOC	200-2	01
1000297146	knock out	BOM	200-2	
1000012268	filling set	DOC	260	01
1000012268	filling set	BOM	260	
F121079	de-aeration set top	DOC	260-1	01
F121079	de-aeration set top	BOM	260-1	
1000287088	electrical cabinet	DOC	900	01
1000287088	electrical cabinet	BOM	900	
1000293223	control panel	DOC	910	01
1000293223	control panel	BOM	910	
1000292302	pneumatic diagram	DOC	970	01
1000306089	diagram	DOC	973	01
1000292304	hydraulic scheme	DOC	975	01
1000286991	pneumatic	DOC	980	01
1000286991	pneumatic	BOM	980	
1000297274	air-conditioning unit	DOC	980-1	01
1000297274	air-conditioning unit	BOM	980-1	
1000286950	valve block	DOC	980-4	01
1000286950	valve block	BOM	980-4	
F121097	de-aeration set top	DOC	1002	01
F121097	de-aeration set top	BOM	1002	
1000311522	support	DOC	1020	01
1000311522	support	BOM	1020	
1000297426	press block	DOC	1160	01
1000297426	press block	BOM	1160	
K019650	plate	DOC	1160-2-1	

Pos	Item number	Quantity	Unit	Item description (native)	Item description	Specification	RSPC	Detail
1	1000424257	1	pcs	GEA MultiFormer	GEA MultiFormer			
2	1000424255	1	pcs	document	document			
10	1000384404	1	pcs	frame	frame		E	
20	1000283735	1	pcs	part	part		D	
30	1000283889	1	pcs	hydraulic unit	hydraulic unit		D	
40	1000372951	1	pcs	motor	motor	Special Voltage - 575V 60Hz 22kW 4P IE3	C	
50	1000373481	1	pcs	oil cooler	oil cooler	Special Voltage - 575V 60Hz 1,3kW 2P IE3	C	
60	1000430720	1	pcs	drive	drive	Special Voltage-575V 60Hz 0,22kW 6P IE1	C	
70	1000283060	1	pcs	outfeed conveyor	outfeed conveyor		D	
80	1000286640	1	pcs	cowling	cowling		D	
90	1000292239	1	pcs	lift	lift		D	
100	1000286055	1	pcs	hopper	hopper		D	
110	1000276422	1	pcs	stairs	stairs		D	
120	1000282552	1	pcs	form plate guiding	form plate guiding		D	
130	1000283887	1	pcs	pipework	pipework		D	
160	1000309741	1	pcs	door	door		D	
170	1000309743	1	pcs	door	door		D	
180	1000292314	1	pcs	water conduit	water conduit		D	
190	1000186955	1	pcs	Cleaning Cart	Cleaning Cart			
200	1000307472	1	pcs	knock out	knock out		C	
260	1000012268	1	pcs	filling set	filling set		D	
900	1000287088	1	pcs	electrical cabinet	electrical cabinet		D	
910	1000293223	1	pcs	control panel	control panel		C	
970	1000292302	1	pcs	pneumatic diagram	pneumatic diagram			
973	1000306089	1	pcs	diagram	diagram		D	
975	1000292304	1	pcs	hydraulic scheme	hydraulic scheme			
980	1000286991	1	pcs	pneumatic	pneumatic	MultiFormer 600	C	
1002	F121097	1	pcs	de-aeration set top	de-aeration set top		D	
1020	1000311522	1	pcs	support	support		D	
1160	1000297426	1	pcs	press block	press block	35mm	D	

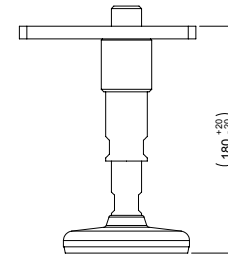
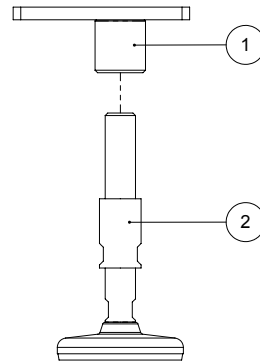
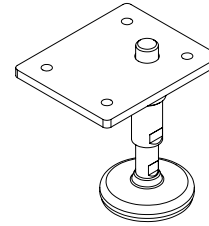


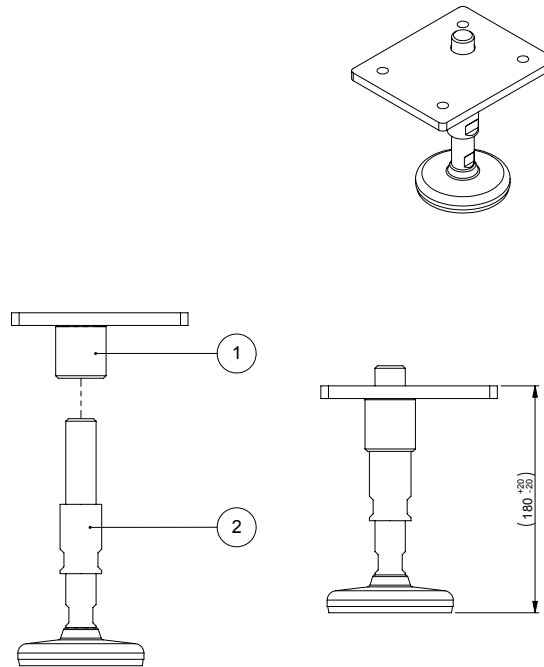
Position Nr.	GEA		Pos No. visible on machine layout
	Machine Utility Sheet MultiFormer 600		
	Product Engineer ==>		MvdM
1	Power supply		•
1.1	Connection		1(4x16mm ²)
	Total power	kW	23
	Voltage 3Ph - 50/60Hz	V	575
	Amperage (400 V)	A	33
2	Compressed Air (Unoiled, dry)		•
2.1	Connection		hose 12 mm
	Consumption	NI/min	300,0
	Minimum pressure	bar	4
	Maximum pressure	bar	6
3	Water		•
3.1	Connection	ø	hose 12 mm
	Flow	m3/hr	0,04
	Minimum pressure	bar	1
	Maximum pressure	bar	4
	Condition		cold consumable
	Temperature	°C	<7
4	Drains / overflows		n.a.
5	CO2 (as cooling medium)		n.a.
6	N2		n.a.
7	Ammonia		n.a.
8	Glycol		n.a.
9	Steam		n.a.
10	Exhaust		n.a.
11	Thermal oil		n.a.
12	CO2 (for fire extinction)		n.a.
13	Process Oil		n.a.
14	Brine		n.a.
15	Tempura		n.a.
16	Dry matter (Flour, crumbs, etc)		n.a.
17	Air filtering (Dust filter)		n.a.
18	Vacuum connection		n.a.
19	Ethernet connection		n.a.
20	Weight and floor load		•
	Total weight - empty	N	0,0
	Total weight - in production	N	0
	Weight per main leg - in production	N	0
	Floor load per disc - in production	N / mm ²	0
99	Options		
	Water Cooling	m3/hr	n.a.

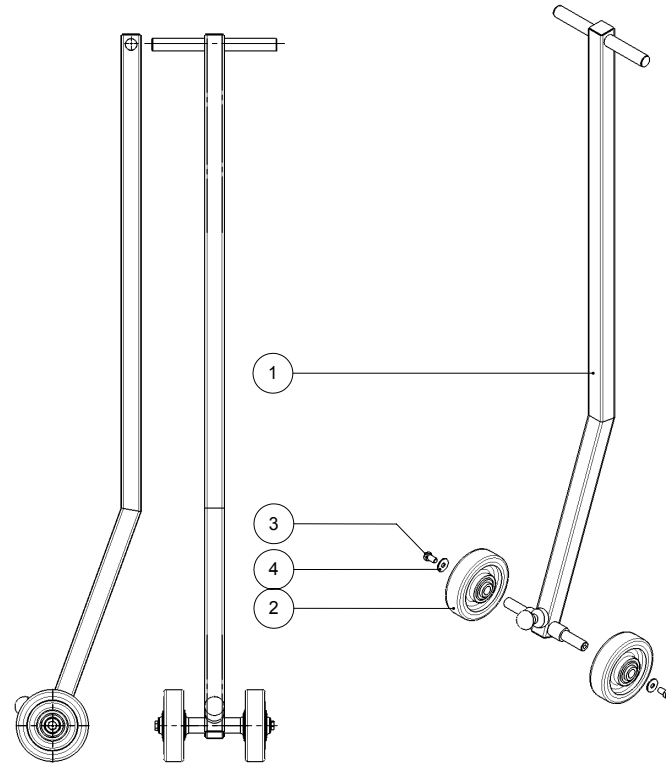


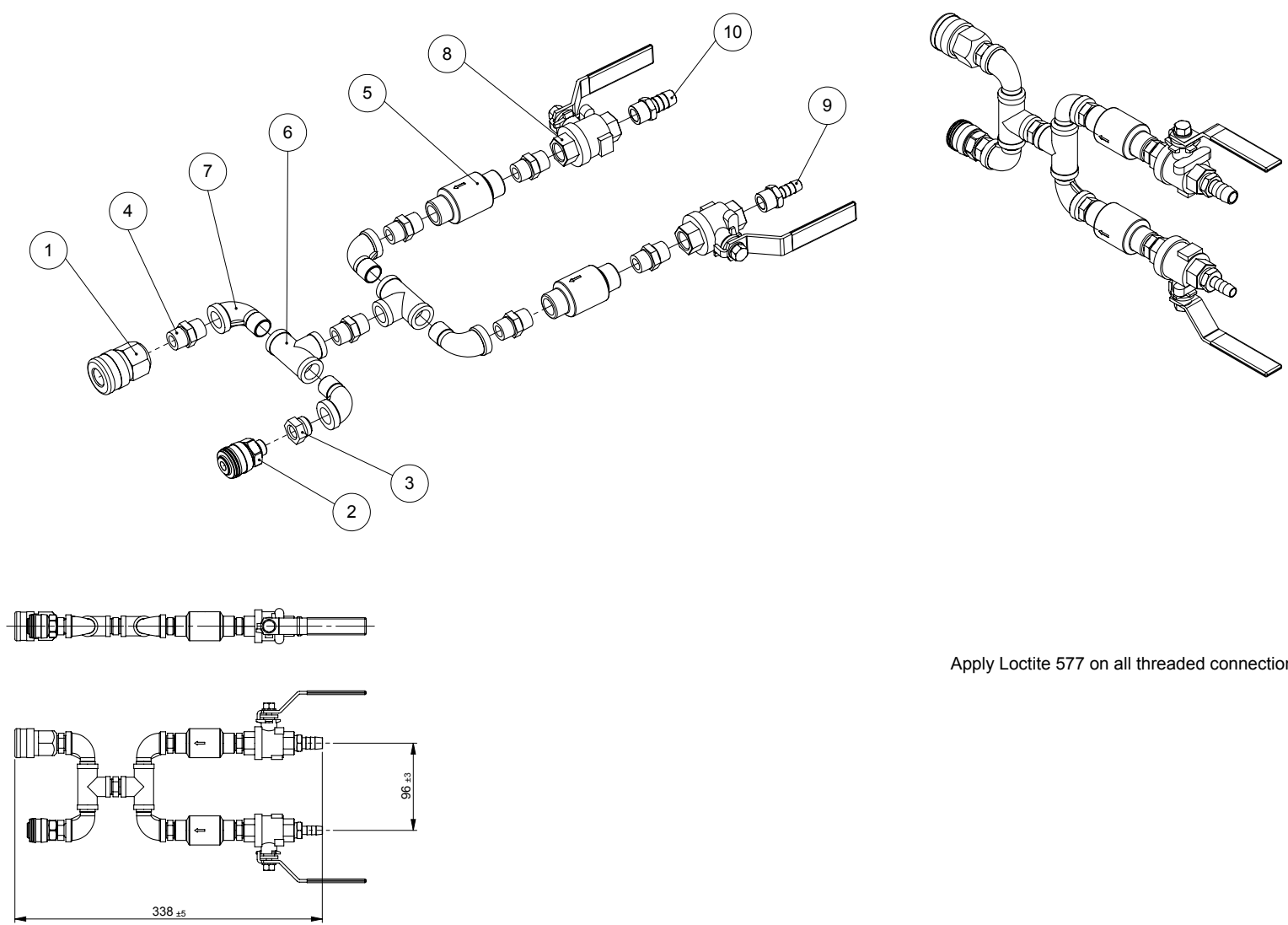


Pos	Item number	Quantity	Unit	Item description (native)	Item description	Specification	RSPC	Detail
1	1000294726	1	pcs	adjusting leg	adjusting leg		D	
2	1000294727	1	pcs	adjusting leg	adjusting leg	GEA MultiFormer 600	D	
3	K012436	2	pcs	fixed caster	fixed caster		D	
4	F119082	1	pcs	housing	housing		D	
5	4.133538	1	pcs	lever	lever		D	y
6	1000359940	1	pcs	wrench	wrench		D	
7	1000359941	1	pcs	wrench	wrench		D	
9	1000260047	1	pcs	cleaning device	cleaning device		D	
10	F121706	1	pcs	auxiliary tool	auxiliary tool		D	
11	1000328626	1	pcs	support	support		D	
12	9.009580	1	pcs	round material	round material			
13	F121103	1	pcs	mirror	mirror		D	
14	F121140	1	pcs	strip	strip		D	
15	E065020	1	pcs	gland	gland	M25x1,5 brass, thread 8mm	D	
16	E065028	1	pcs	gland	gland	M40x1,5 brass, thread 9mm	D	
17	E065607	1	pcs	ring	ring		D	
18	E065310	1	pcs	connecting nut	connecting nut	M40x1,5 brass	D	
19	E045010	1	pcs	pedal	pedal		C	
20	E003364	1	pcs	grommet	grommet		D	
21	1000290228	1	pcs	bulkhead connector	bulkhead connector			
22	K001139	6	pcs	hexagonal screw	hexagonal screw		D	
23	K001120	2	pcs	washer	washer		D	
24	K001930	2	pcs	hexagonal screw	hexagonal screw		D	
25	K002330	2	pcs	hexagonal screw	hexagonal screw		D	
26	K002150	2	pcs	washer	washer		D	
27	K002680	8	pcs	hexagonal screw	hexagonal screw		D	
28	K002690	8	pcs	hexagonal screw	hexagonal screw		D	
29	K002620	16	pcs	washer	washer	10	D	

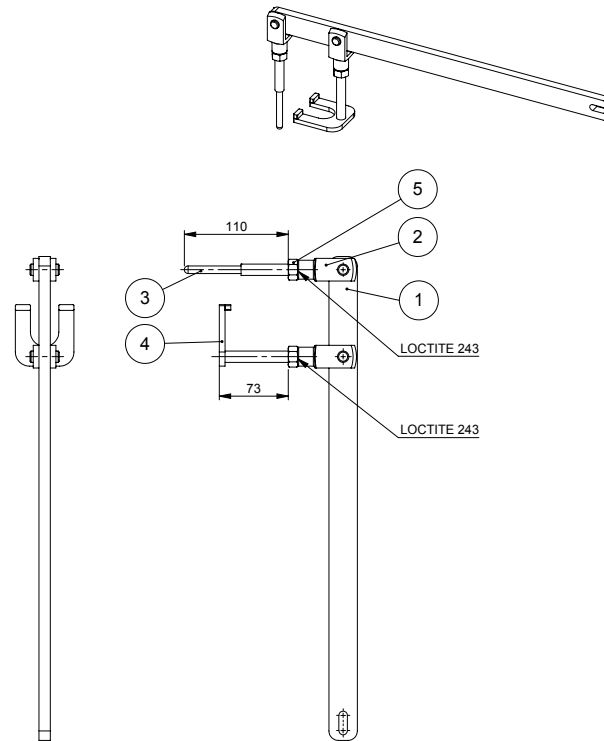


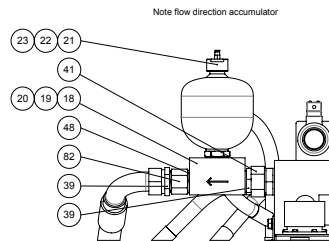
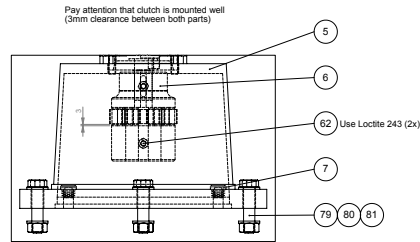
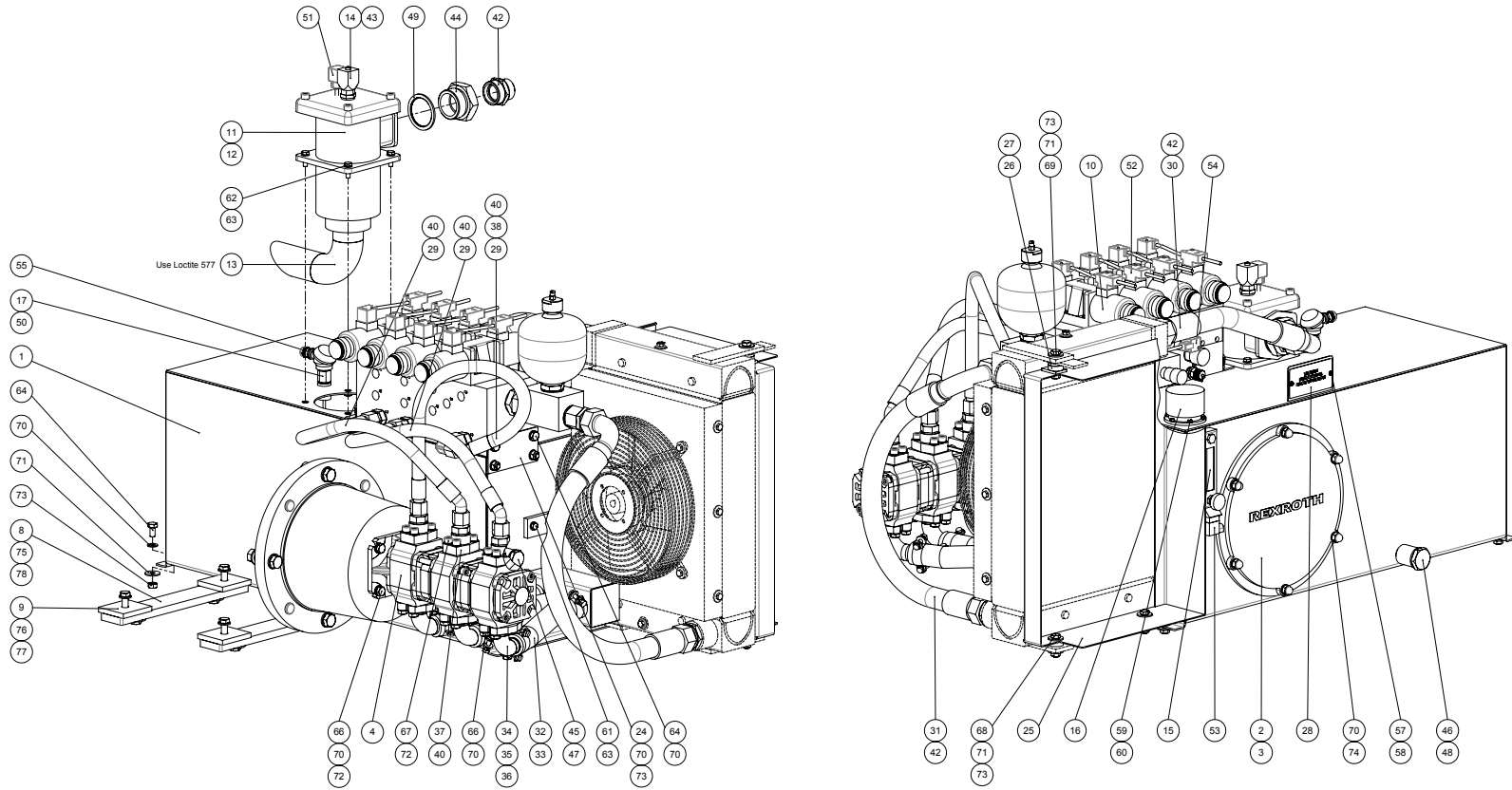






Apply Loctite 577 on all threaded connections.

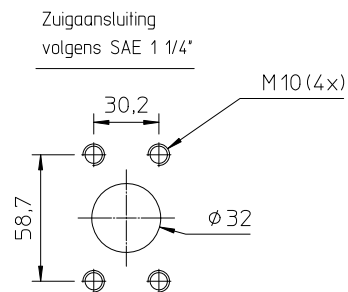
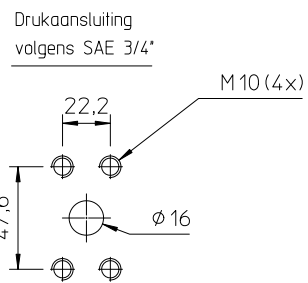
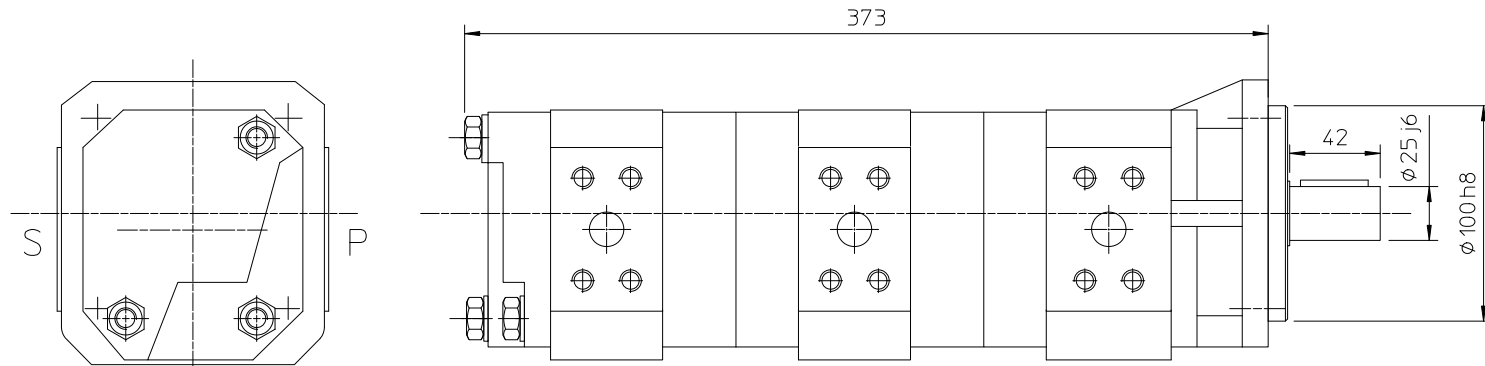




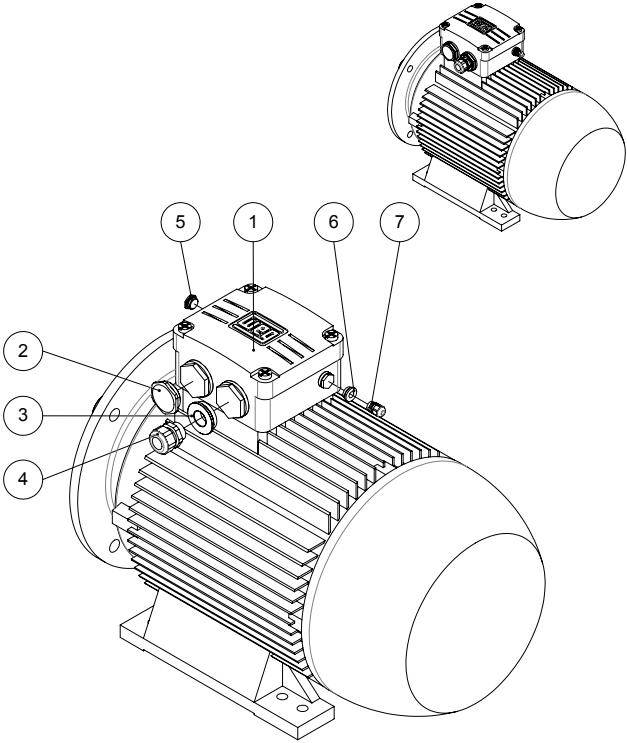
Put silicon sealant between Pos. 2 and 3 and the oil-storage tank
Mount Pos. 45 and 46 with Loctite 577

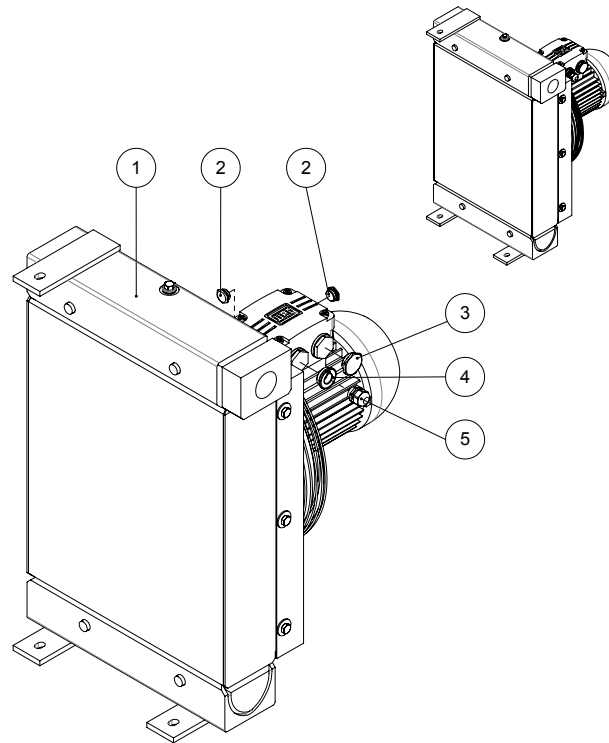
Pos	Item number	Quantity	Unit	Item description (native)	Item description	Specification	RSPC	Detail
1	1000289262	1	pcs	tank	tank		D	
2	H008000	1	pcs	lid	lid		D	
3	H008005	1	pcs	shaft sealing ring	shaft sealing ring		B	
4	H002229	1	pcs	hydraulic pump	hydraulic pump		C	
5	H002235	1	pcs	lantarn ring	lantarn ring		D	
6	H002236	1	pcs	clutch	clutch		D	
7	K008265	4	pcs	cap	cap		D	
8	F124121	2	pcs	strip	strip		D	
9	F124122	4	pcs	rubber	rubber		A	
10	1000203458	1	pcs	control block	control block	According to document HS-024-B594	B	
11	H002086	1	pcs	filter	filter		D	
12	H002087	1	pcs	filter	filter		B	
13	4.783491	1	pcs	pipe	pipe			
14	H002702	1	pcs	indicator	indicator		C	
15	H002253	1	pcs	level regulator	level regulator		D	
16	H002056	1	pcs	cap	cap		D	
17	Z006423	1	pcs	temperature sensor	temperature sensor		C	
18	1000314622	1	pcs	connection piece	connection piece		D	
19	1000314623	1	pcs	seal	seal	with SC (Self-Centralising)	B	
20	1000312575	1	pcs	accumulator	accumulator		C	
21	4.161326	1	pcs	gasket	gasket		C	
22	4.159922	1	pcs	plug	plug		C	
23	Z015363	1	pcs	check valve	check valve		D	
24	F124120	1	pcs	plate	plate		D	
25	4.133633	1	pcs	seal plate	seal plate		D	
26	F121784	3	pcs	spacer bushing	spacer bushing		D	
27	F601810	1	pcs	ring	ring		C	
28	1000171351	1	pcs	text plate	text plate		D	
29	Z007760	3	pcs	hydraulic hose	hydraulic hose		D	
30	Z008195	1	pcs	hydraulic hose	hydraulic hose		D	
31	Z013570	1	pcs	hydraulic hose	hydraulic hose		D	
32	Z006877	3	pcs	hydraulic hose	hydraulic hose		C	
33	K048550	6	pcs	hose clip	hose clip		D	
34	4.781502	3	pcs	hose connector	hose connector		D	
35	K008751	3	pcs	o-ring	o-ring		B	

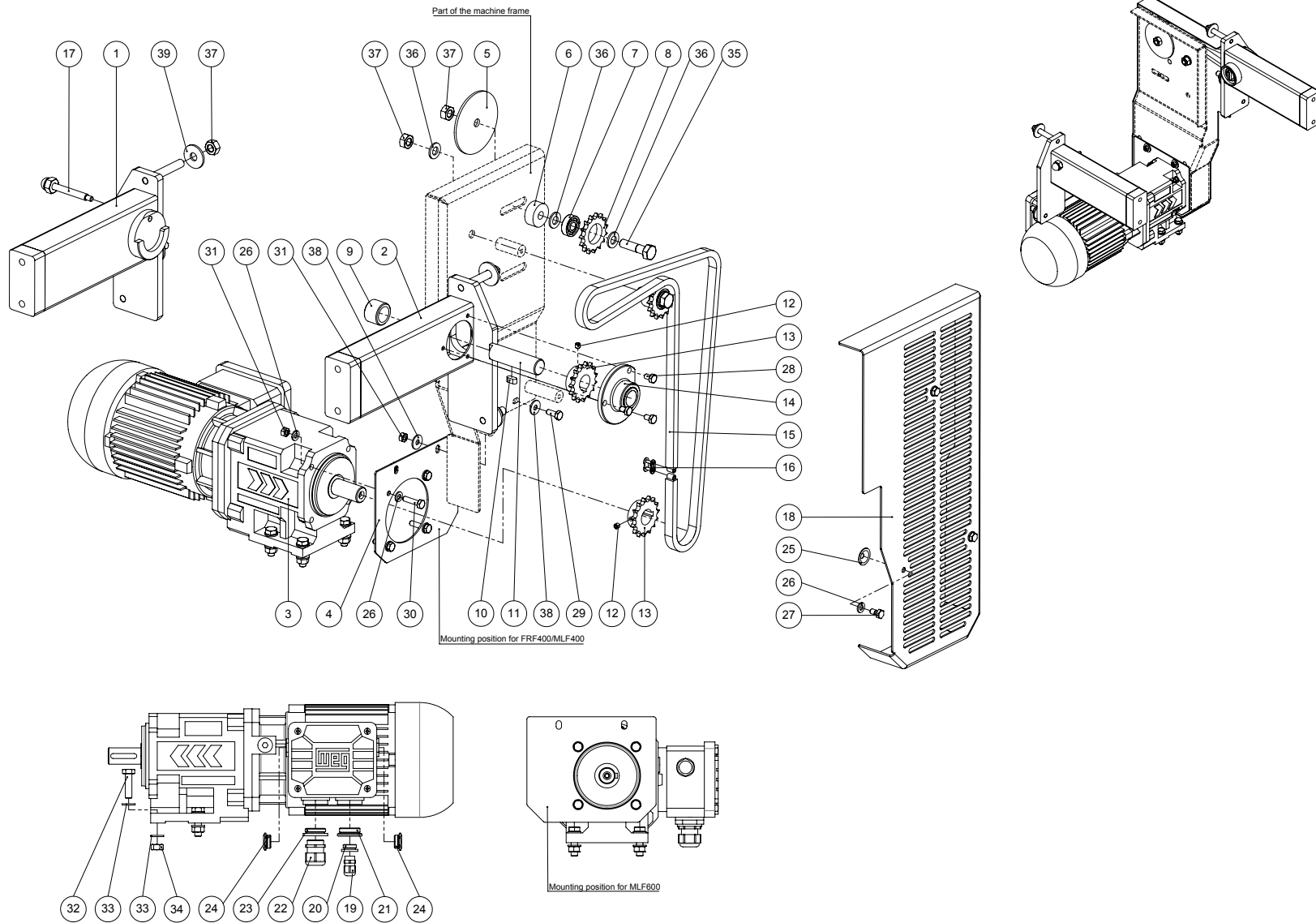
Pos	Item number	Quantity	Unit	Item description (native)	Item description	Specification	RSPC	Detail
36	Z006892	3	pcs	flange	flange		D	
37	Z007757	3	pcs	flange	flange	3/4"	D	
38	K046370	1	pcs	coupling	coupling		D	
39	K046730	2	pcs	coupling	coupling		D	
40	K046770	6	pcs	coupling	coupling		D	
41	K047140	1	pcs	coupling	coupling		D	
42	Z007129	3	pcs	coupling	coupling		D	
43	F121803	1	pcs	reducing piece	reducing piece		E	
44	Z008626	1	pcs	reducing piece	reducing piece		D	
45	K010916	1	pcs	blind plug	blind plug	DN20, 3/4" BSP	D	
46	K010925	1	pcs	blind plug	blind plug	DN25, 1" BSP	D	
47	K009682	1	pcs	seal	seal	with SC (Self-Centralising), St/NBR	B	
48	K009683	2	pcs	seal	seal	with SC (Self-Centralising), St/NBR	D	
49	K048640	1	pcs	seal	seal	with SC (Self-Centralising), St/NBR	B	
50	Z009209	1	pcs	sealing ring	sealing ring	DIN7603-21x26x1,5	C	
51	Z008363	1	pcs	plug	plug		C	
52	Z014968	4	pcs	plug	plug		C	
53	P021413	1	pcs	plug	plug		C	
54	E093000	1	pcs	plug	plug	with cable PVC-JZ 3x0,75 grey 3m, IP67	C	
55	E065204	1	pcs	gland	gland	M16x1,5 EMC, brass, thread 7mm	D	
57	K001145	2	pcs	cheese-head screw	cheese-head screw		D	
58	K001120	2	pcs	washer	washer		D	
59	K001330	6	pcs	cheese-head screw	cheese-head screw		D	
60	K001510	6	pcs	washer	washer		D	
61	K002270	2	pcs	hexagonal screw	hexagonal screw		D	
62	K002350	6	pcs	hexagonal screw	hexagonal screw		D	
63	K002150	6	pcs	washer	washer		D	
64	K002690	8	pcs	hexagonal screw	hexagonal screw		D	
66	K002720	16	pcs	hexagonal screw	hexagonal screw		D	
67	K002583	12	pcs	cheese-head screw	cheese-head screw		D	
68	K002760	2	pcs	hexagonal screw	hexagonal screw		D	
69	K002780	1	pcs	hexagonal screw	hexagonal screw		D	
70	K002620	32	pcs	washer	washer	10	D	
71	K002630	10	pcs	washer	washer	10	D	
72	K002625	16	pcs	spring ring	spring ring	M10	D	
73	K002660	9	pcs	hexagon nut	hexagon nut	M10	D	



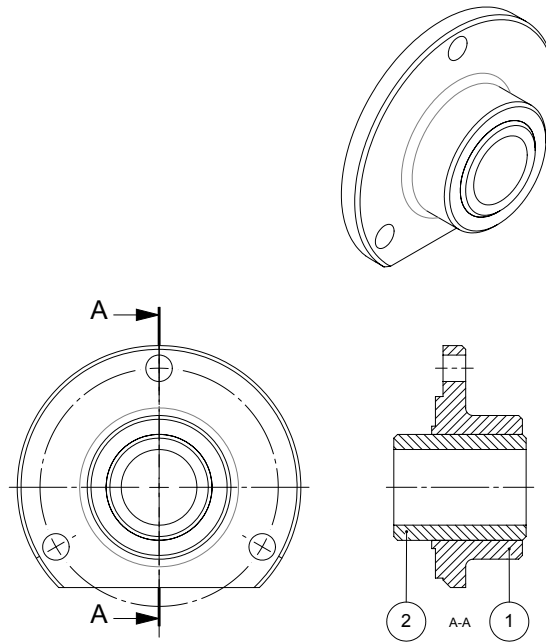
1PF2GF3-3X/025RH07VE4 +
1PF2GF3-3X/020RL07VM +
1PF2GF3-3X/020RL07VM

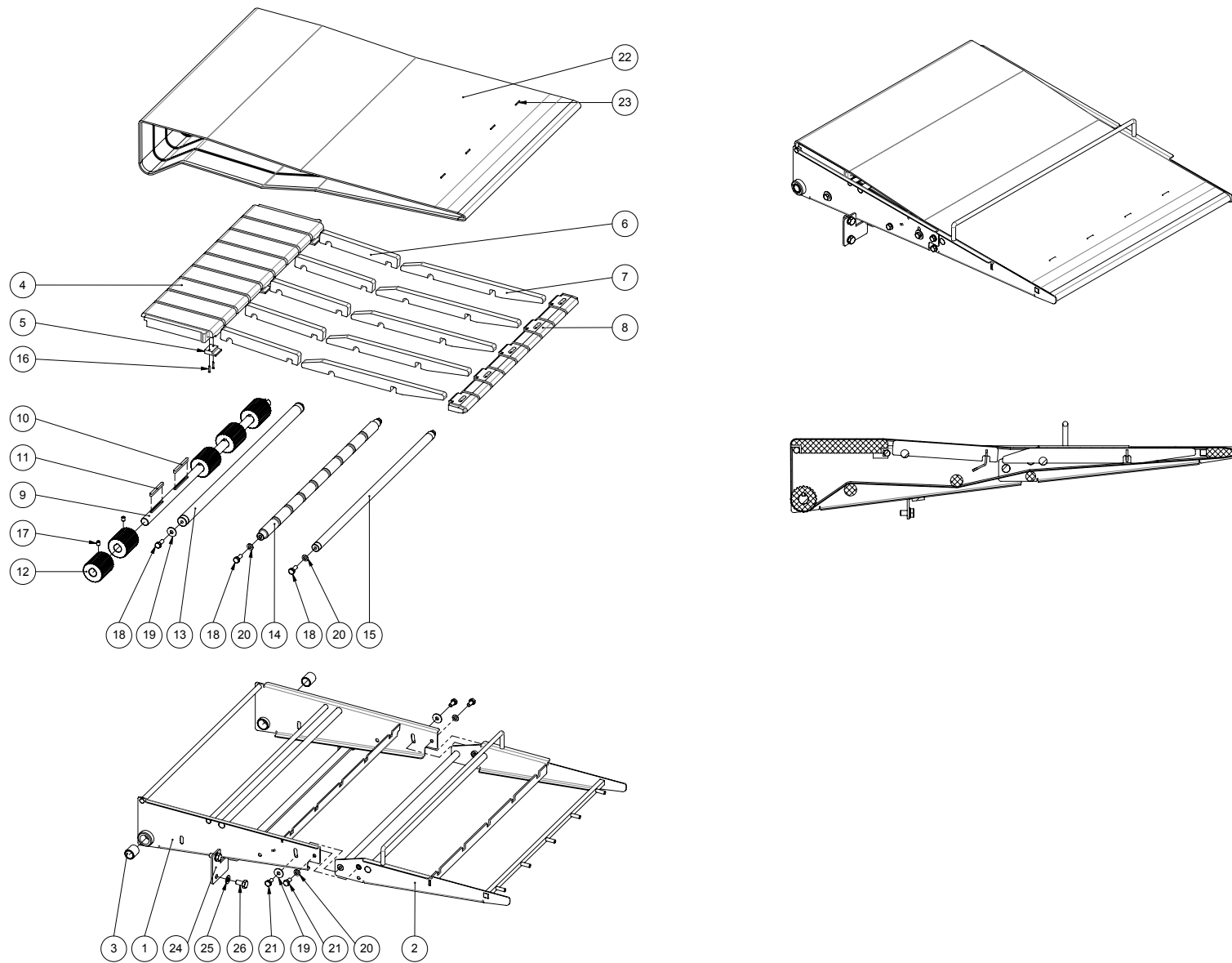


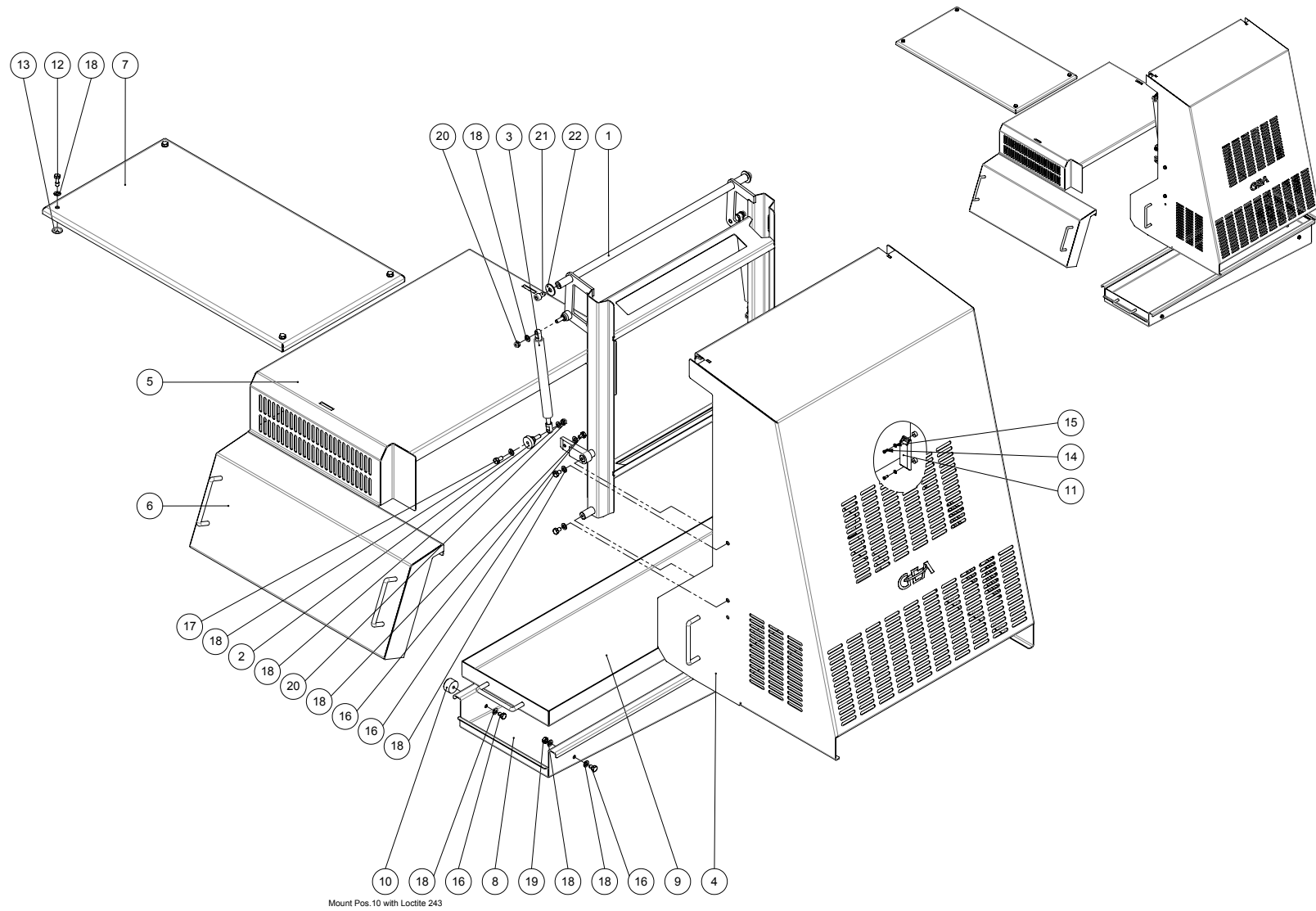


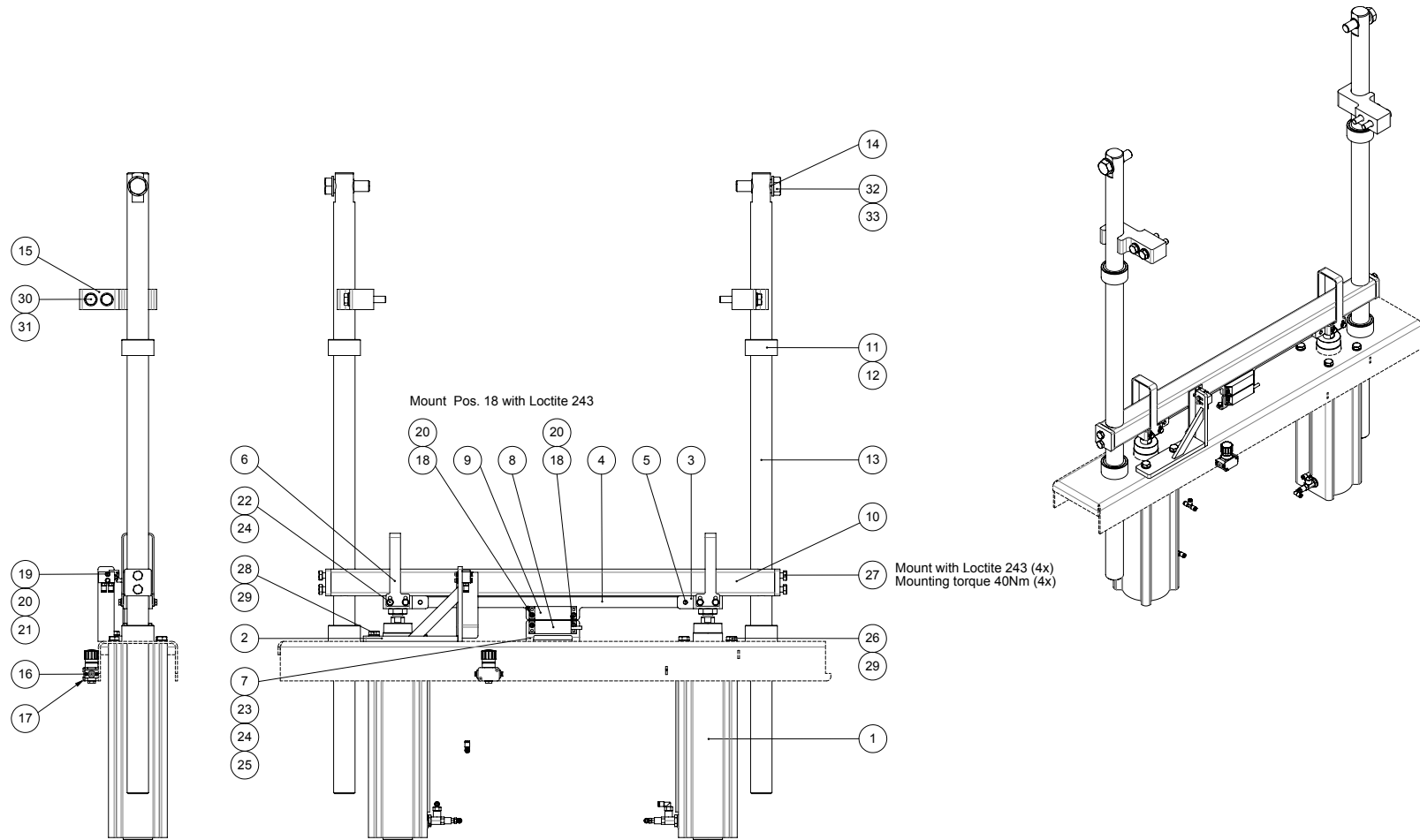


Pos	Item number	Quantity	Unit	Item description (native)	Item description	Specification	RSPC	Detail
1	1000041428	1	pcs	support	support		D	
2	1000041429	1	pcs	support	support		D	
3	1000430719	1	pcs	geared motor	geared motor	Special Voltage-575V 60Hz 0,22kW 6P IE1	C	
4	1000300529	1	pcs	plate	plate		D	
5	1000299950	1	pcs	plate	plate		D	
6	F104334	2	pcs	spacer ring	spacer ring		D	
7	Z012647	2	pcs	grooved ball bearing	grooved ball bearing	10x26x8	B	
8	F102150	2	pcs	chain sprocket	chain sprocket		B	
9	K007890	1	pcs	bushing	bushing	20x28x20	B	
10	K005215	1	pcs	feather key	feather key		D	
11	F101701	1	pcs	drive shaft	drive shaft		B	
12	K001905	2	pcs	adjusting screw	adjusting screw	M6x6	D	
13	F102149	2	pcs	chain sprocket	chain sprocket		B	
14	F109242	1	pcs	disc	disc		D	
15	1000287927	1	pcs	chain	chain		B	
16	K012921	1	pcs	link	link		B	
17	F121044	1	pcs	pin	pin		D	
18	1000300708	1	pcs	protection	protection		E	
19	E065000	1	pcs	gland	gland	M12x1,5 brass, thread 6,5mm, 3-7mm	D	
20	E065600	1	pcs	ring	ring		D	
21	E065603	1	pcs	ring	ring		D	
22	E065208	1	pcs	gland	gland	M20x1,5 EMC, brass, thread 8mm	D	
23	E065604	1	pcs	ring	ring		D	
24	E065502	2	pcs	cap	cap		D	
25	1000244077	3	pcs	washer	washer			
26	K001890	11	pcs	washer	washer	DIN125-M6-A2	D	
27	1000301792	3	pcs	bolt	bolt			
28	K001930	3	pcs	hexagonal screw	hexagonal screw		D	
29	K001970	2	pcs	hexagonal screw	hexagonal screw		D	
30	K001990	4	pcs	hexagonal screw	hexagonal screw		D	
31	K002030	6	pcs	hexagon nut	hexagon nut	M6	D	
32	K002370	4	pcs	hexagonal screw	hexagonal screw		D	
33	K002150	8	pcs	washer	washer		D	
34	K002250	4	pcs	hexagon nut	hexagon nut	M8	D	
35	K002761	2	pcs	hexagonal screw	hexagonal screw		D	

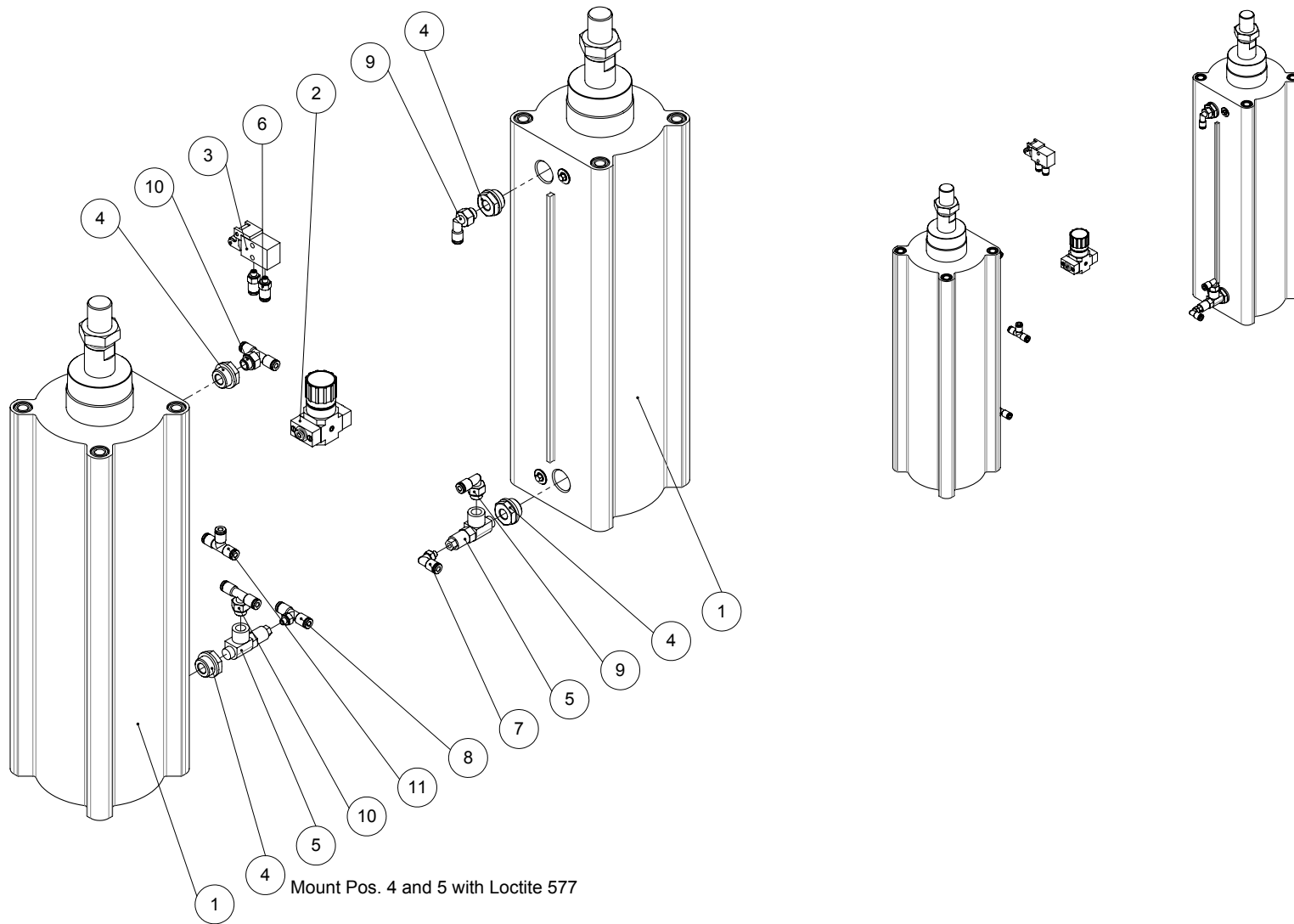


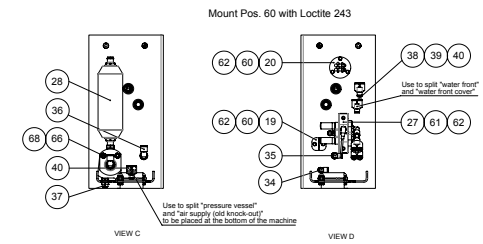
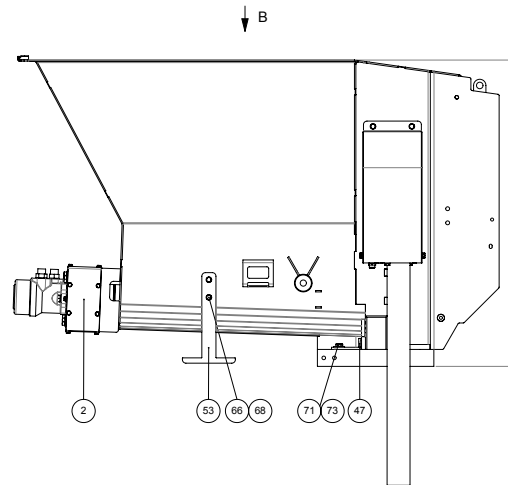
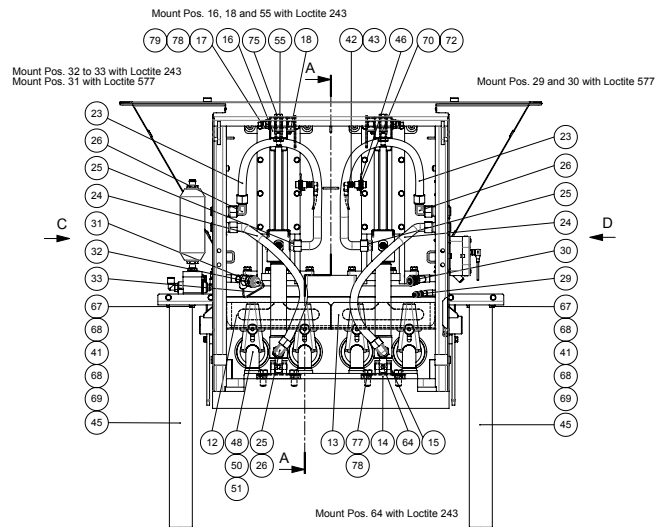
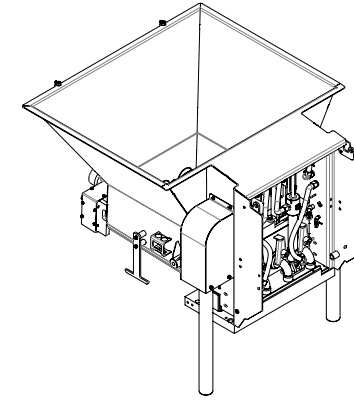
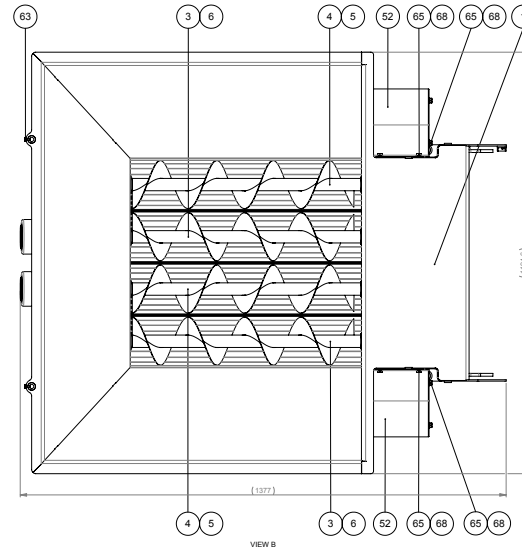
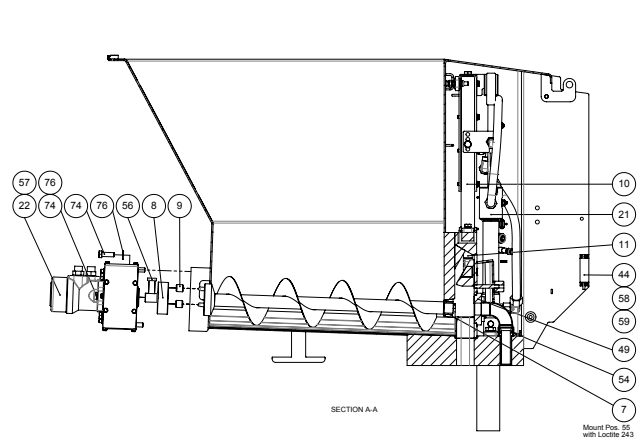






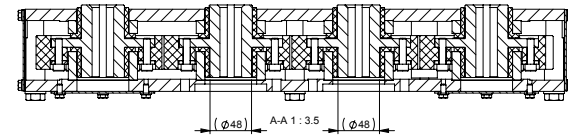
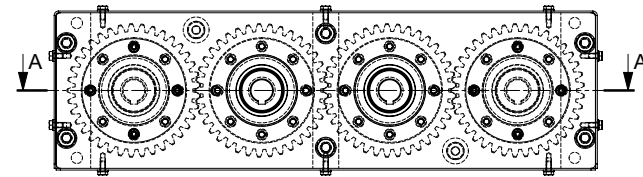
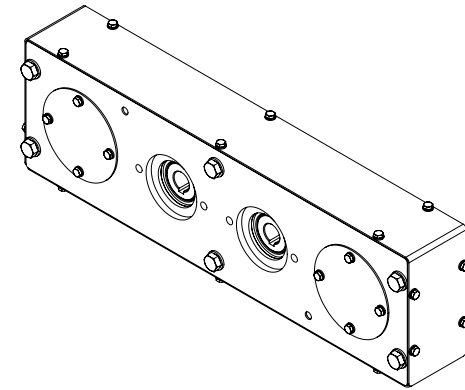
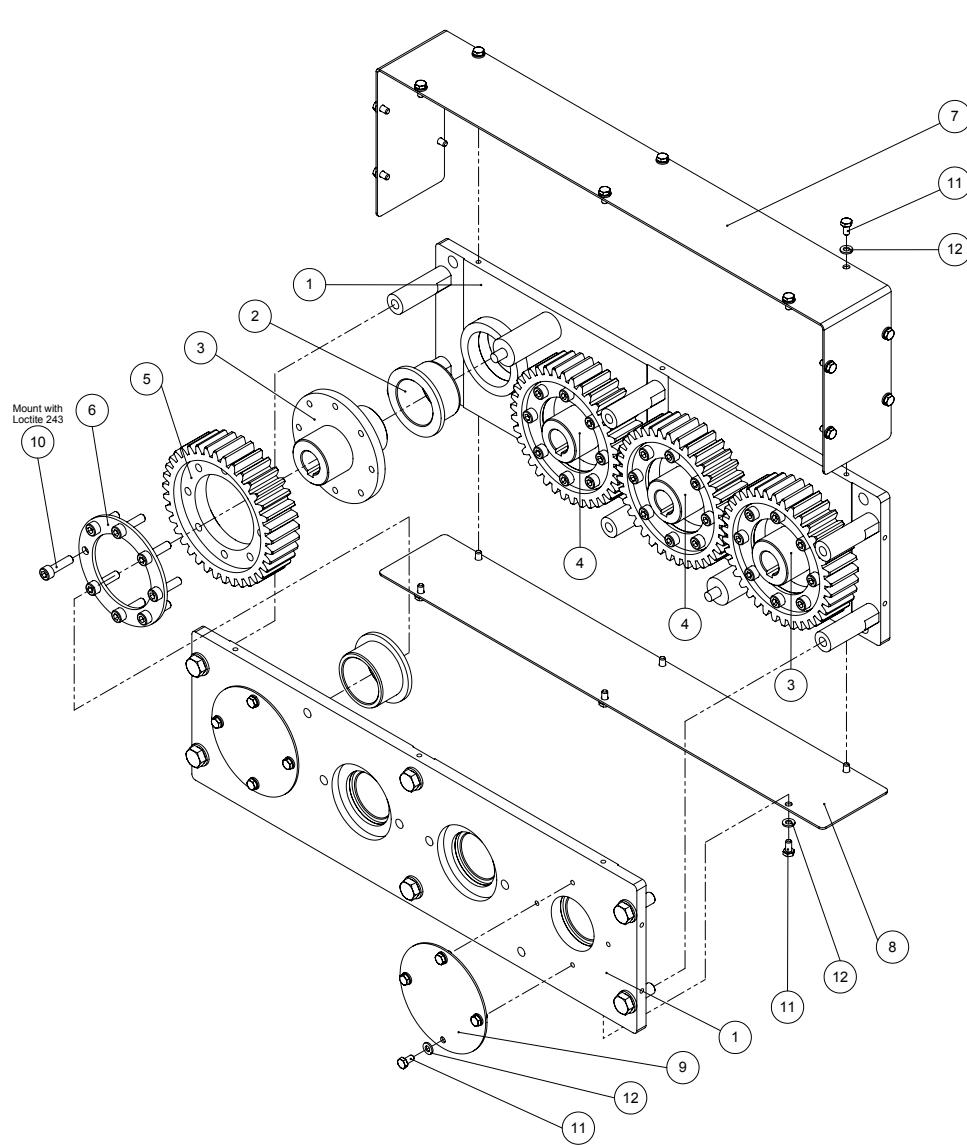
Pos	Item number	Quantity	Unit	Item description (native)	Item description	Specification	RSPC	Detail
1	1000293334	1	pcs	lift	lift		D	
2	1000096023	1	pcs	bracket	bracket		D	
3	1000296352	2	pcs	support	support		D	
4	1000296357	1	pcs	support plate	support plate		D	
5	2003920136	2	pcs	fitted bolt	fitted bolt		D	
6	1000296361	2	pcs	bracket	bracket		D	
7	1000296358	1	pcs	bracket	bracket		D	
8	E045520	1	pcs	sensor	sensor		C	
9	E045530	1	pcs	magnet	magnet		C	
10	F121163	1	pcs	box beam	box beam		D	
11	F121549	4	pcs	bushing	bush		D	
12	F119080	4	pcs	bushing	bushing		B	
13	1000296946	2	pcs	shaft	shaft		B	
14	F124110	2	pcs	bushing	bush		B	
15	1000318121	2	pcs	block	block		D	
16	1000070021	1	pcs	plate	plate		D	
17	K001050	2	pcs	cheese-head screw	cheese-head screw		D	
18	K001155	4	pcs	cheese-head screw	cheese-head screw		D	
19	K001236	2	pcs	hexagonal screw	hexagonal screw		D	
20	K001120	8	pcs	washer	washer		D	
21	K001135	2	pcs	lock nut	lock nut	M4	D	
22	K001931	8	pcs	hexagonal screw	hexagonal screw		D	
23	K001970	2	pcs	hexagonal screw	hexagonal screw		D	
24	K001890	12	pcs	washer	washer	DIN125-M6-A2	D	
25	K002030	2	pcs	hexagon nut	hexagon nut	M6	D	
26	K002690	6	pcs	hexagonal screw	hexagonal screw		D	
27	K002700	4	pcs	hexagonal screw	hexagonal screw		D	
28	K002720	2	pcs	hexagonal screw	hexagonal screw		D	
29	K002620	8	pcs	washer	washer	10	D	
30	K003065	4	pcs	hexagonal screw	hexagonal screw		D	
31	K002910	4	pcs	washer	washer		D	
32	K003470	2	pcs	hexagonal screw	hexagonal screw		D	
33	K003422	2	pcs	washer	washer		D	



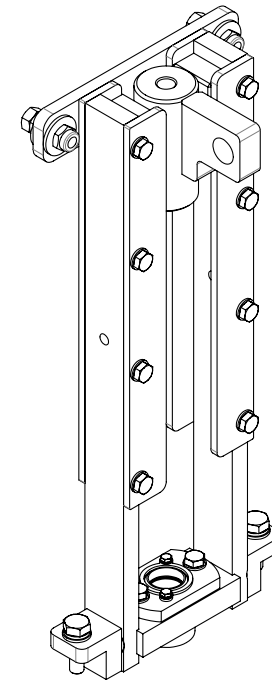
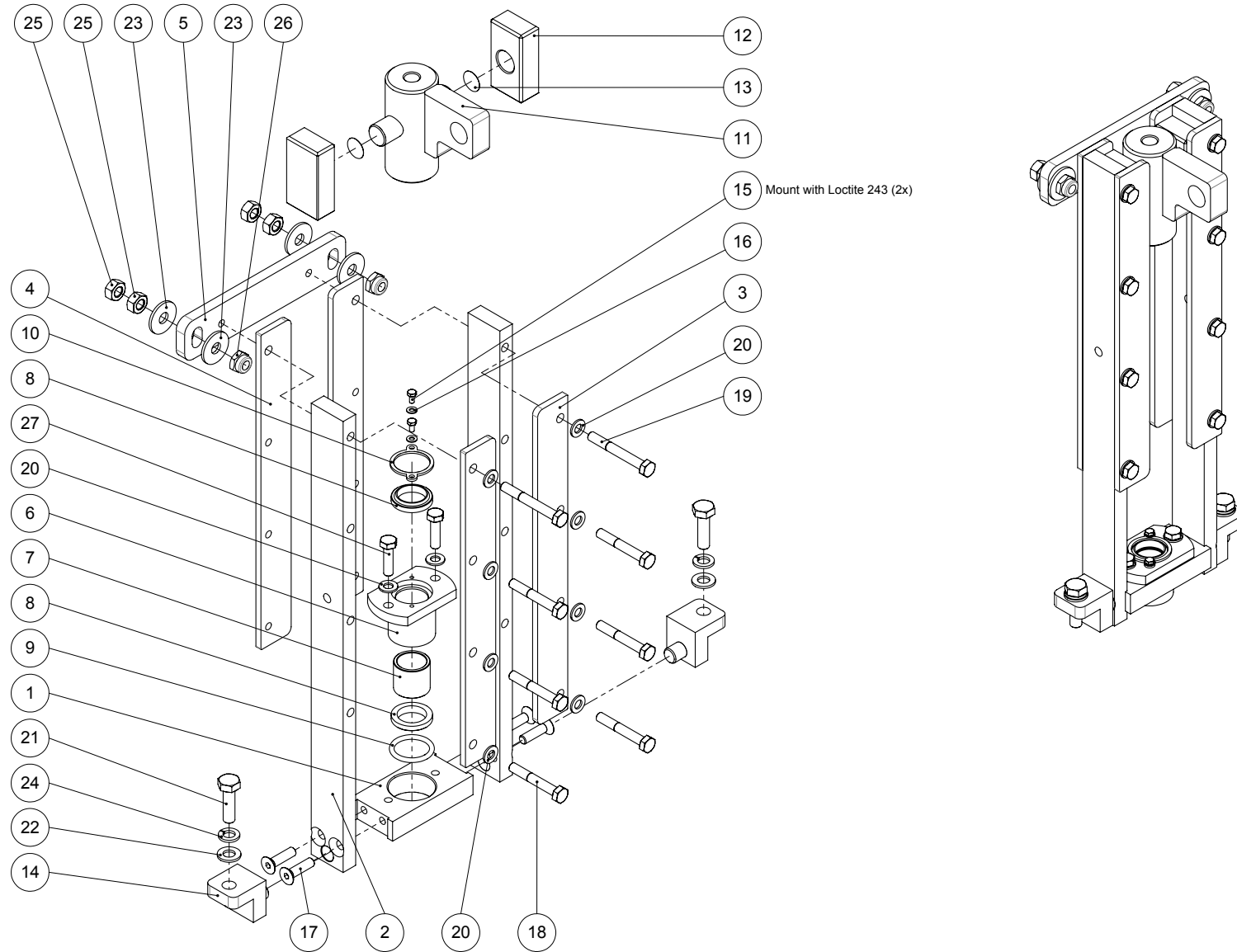


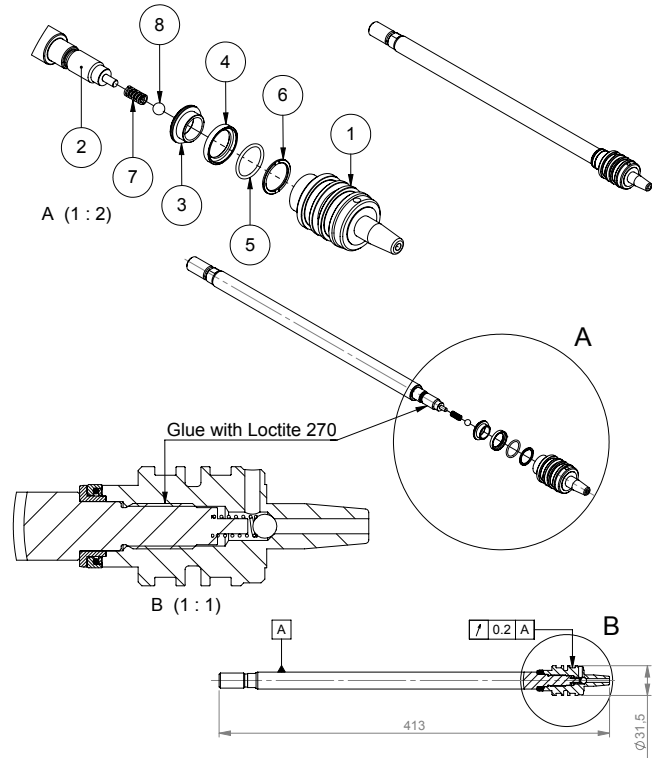
Pos	Item number	Quantity	Unit	Item description (native)	Item description	Specification	RSPC	Detail
1	1000286061	1	pcs	hopper	hopper	MultiFormer 600	D	
2	1000291963	1	pcs	gearbox	gearbox	GEA MultiFormer 600	C	
3	F121172	2	pcs	auger	auger		D	
4	F121173	2	pcs	auger	auger		D	
5	F121609	2	pcs	journal	journal		D	
6	F121610	2	pcs	journal	journal		D	
7	F121118	4	pcs	flanged bushing	flanged bushing		B	
8	F121114	4	pcs	connection piece	connection piece		D	
9	F121115	12	pcs	hose	hose		B	
10	1000289988	2	pcs	guide	guide		C	
11	1000293620	2	pcs	press block bar	press block bar		D	
12	1000293625	1	pcs	press block	press block		D	
13	1000293626	1	pcs	press block	press block		D	
14	1000293937	2	pcs	hinge	hinge		D	
15	F121090	2	pcs	hinged part	hinged part		D	
16	1000292531	2	pcs	clevis	clevis		C	
17	1000006566	2	pcs	shaft	shaft		B	
18	1000327887	2	pcs	cam	cam		B	
19	1000183820	2	pcs	seal plate	seal plate		D	
20	1000297275	1	pcs	seal plate	seal plate		D	
21	1000214617	2	pcs	hydraulic cylinder	hydraulic cylinder	according to drawing	B	
22	1000381675	2	pcs	hydraulic motor	hydraulic motor	chemical nickel plated, ZC	C	
23	Z009963	2	pcs	hydraulic hose	hydraulic hose		D	
24	Z009964	2	pcs	hydraulic hose	hydraulic hose		D	
25	Z009609	4	pcs	coupling	coupling		D	
26	Z009961	4	pcs	coupling	coupling		D	
27	1000286915	1	pcs	air assisted knock out	air assisted knock out		D	
28	1000297573	1	pcs	pressure vessel	pressure vessel		D	
29	P021040	1	pcs	coupling	coupling		D	
30	P021060	1	pcs	coupling	coupling		D	
31	F124109	1	pcs	female connector socket	female connector socket		D	
32	F121126	1	pcs	stop	stop		D	
33	4.140620	1	pcs	chain	chain		B	
34	1000293019	1	pcs	swivel elbow	swivel elbow		D	
35	1000283166	1	pcs	swivel elbow	swivel elbow		D	

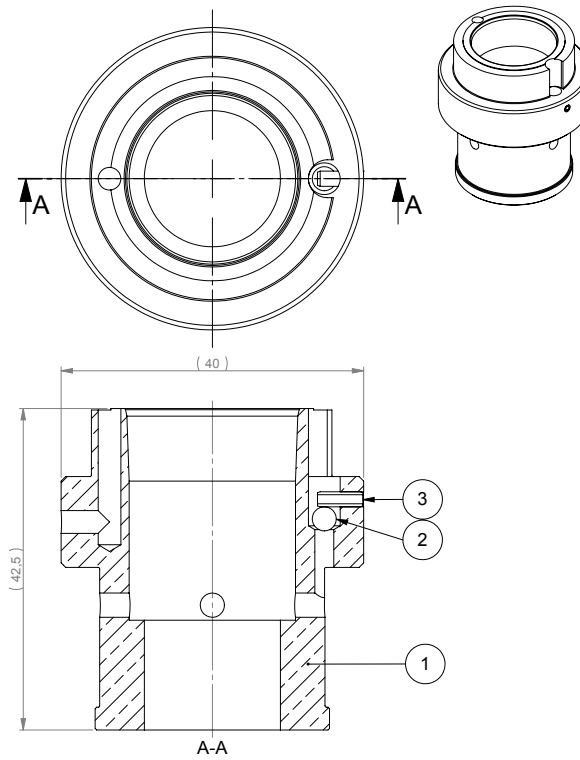
Pos	Item number	Quantity	Unit	Item description (native)	Item description	Specification	RSPC	Detail
36	1000293036	1	pcs	swivel elbow	swivel elbow		D	
37	1000291286	1	pcs	bulkhead connector	bulkhead connector		D	
38	1000293099	1	pcs	equal straight connector	equal straight connector		D	
39	1000293051	1	pcs	y-connector	y-connector		D	
40	1000293046	2	pcs	y-connector	y-connector		D	
41	E003366	4	pcs	grommet	grommet		D	
42	E021220	2	pcs	connector	connector		D	
43	E021270	2	pcs	proximity switch	proximity sensor		C	
44	E045520	1	pcs	sensor	sensor		C	
45	1000289631	2	pcs	duct	duct	GEA FreshFormer 400		
46	F121718	2	pcs	support	support		D	
47	F121121	2	pcs	stop	stop		D	
48	F109984	4	pcs	pipe	pipe		D	
49	F121157	4	pcs	sealing disk	sealing disk		B	
50	F121208	4	pcs	clamp plate	clamp plate		D	
51	F109204	4	pcs	nut	nut		D	
52	F121831	2	pcs	cover	cover		D	
53	1000322179	2	pcs	plate	plate		D	
54	1000315401	4	pcs	o-ring	o-ring		B	
55	K003315	2	pcs	hexagon nut	hexagon nut		D	
56	K005310	4	pcs	feather key	feather key		D	
57	K005320	2	pcs	feather key	feather key		D	
58	K001150	2	pcs	cheese-head screw	cheese-head screw		D	
59	K001120	2	pcs	washer	washer		D	
60	K001541	5	pcs	hexagonal screw	hexagonal screw		D	
61	K001543	2	pcs	hexagonal screw	hexagonal screw		D	
62	K001510	7	pcs	washer	washer		D	
63	K001931	2	pcs	hexagonal screw	hexagonal screw		D	
64	K001970	2	pcs	hexagonal screw	hexagonal screw		D	
65	K002310	12	pcs	hexagonal screw	hexagonal screw		D	
66	K002330	6	pcs	hexagonal screw	hexagonal screw		D	
67	K002350	4	pcs	hexagonal screw	hexagonal screw		D	
68	K002150	26	pcs	washer	washer		D	
69	K002260	4	pcs	lock nut	lock nut	M8	D	
70	K002680	2	pcs	hexagonal screw	hexagonal screw		D	
71	K002690	2	pcs	hexagonal screw	hexagonal screw		D	

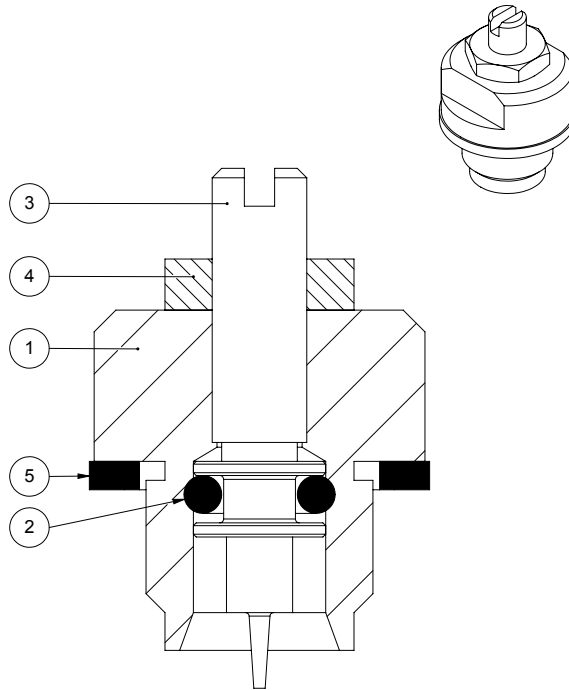


- REMARKS:
- Axial clearance between connection piece and bearing nom. $1\text{mm} \pm 0.5$.
 - Radial clearance of two gears to each other nom. $0.45^\circ \pm 0.1^\circ$.
 - Moving part grease with fat.
 - Keyways all in the same position.







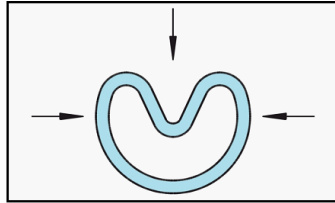


General installation instructions:

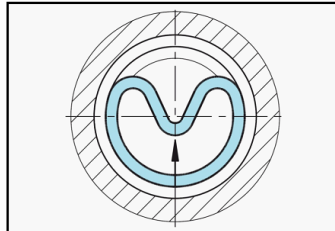
- Remove residues such as dirt and other foreign particles and carefully clean all parts.
- The seals can be installed more easily if the rod/piston and the seals are greased or oiled. Attention must be paid to the compatibility of the seal materials with these lubricants. Use only grease without solid additives (e.g. molybdenum disulphide or zinc sulphide).
- Make sure that the rod seals and scraper are assembled with the correct side towards the pressure side.
- Do not use tools with sharp edges.

Installation of rod seals (pos. 7, 8 and 9):

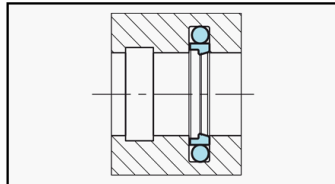
- Place the o-rings into the grooves.
- Compress the seals into a kidney shape while avoiding sharp bends.



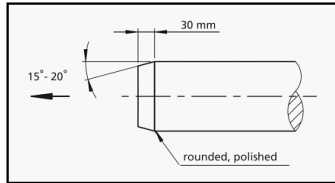
- Place the seal ring in compressed form into the groove and push against the o-ring in the direction of the arrow.



- After placing the seal ring into the groove, form the seal into a ring again in the groove by hand.

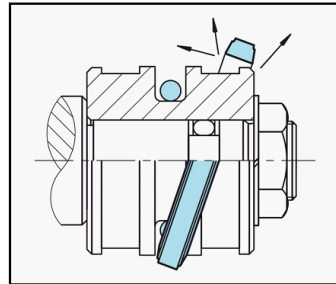


- Finally size the seal ring using a mandrel (ø18,0) which should have a chamfer of 15° to 20° over a length of approx. 30mm.

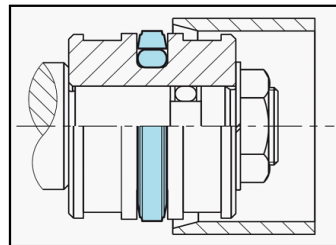
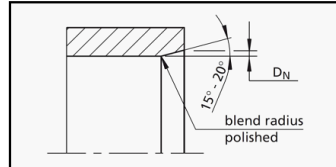


Installation of piston seal (pos. 3):

- Place the o-ring into the groove.
- The seal can be installed more easily by heating in oil, water or using a hot air fan to approx. 80 °C to 100 °C (expanding and then shrinking back to the original form).



- Sizing of the seal ring is achieved with a separate sizing sleeve (ø32,0) which should have a lead-in chamfer of 15° to 20° and DN is minimal 1mm or with the cylinder tube.



Installation of piston guide element (pos. 4):

- Place the guiding elements into the grooves.

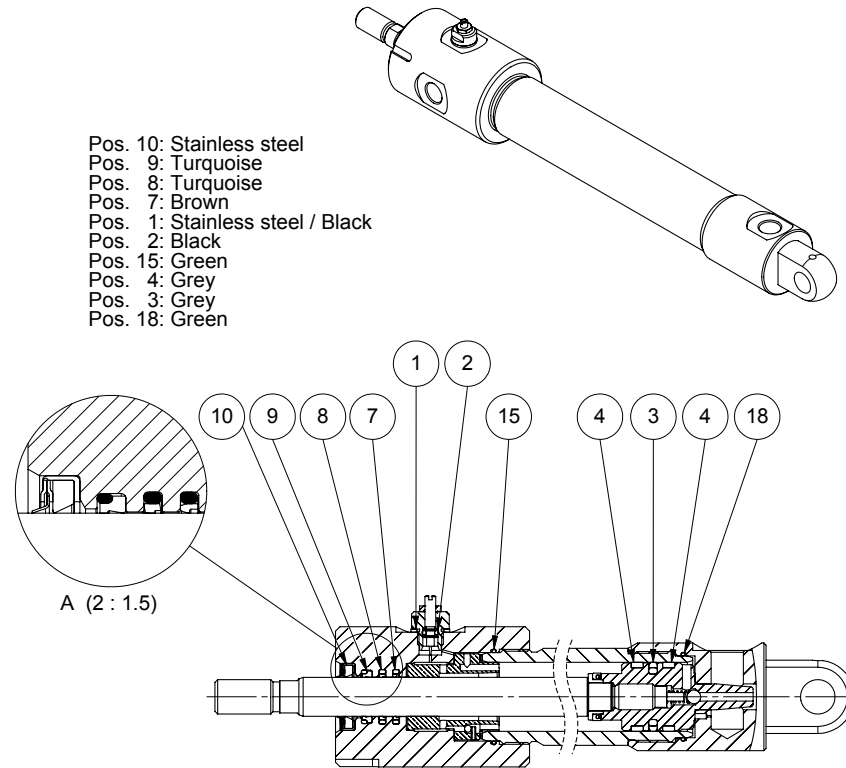
Installation of metal scraper (pos. 10):

- A press or "no-rebound" hammer and a distance bushing are used to press/hammer the scraper in place. Do not scratch or break the scraper.

Installation of o-rings (pos. 15 and 18):

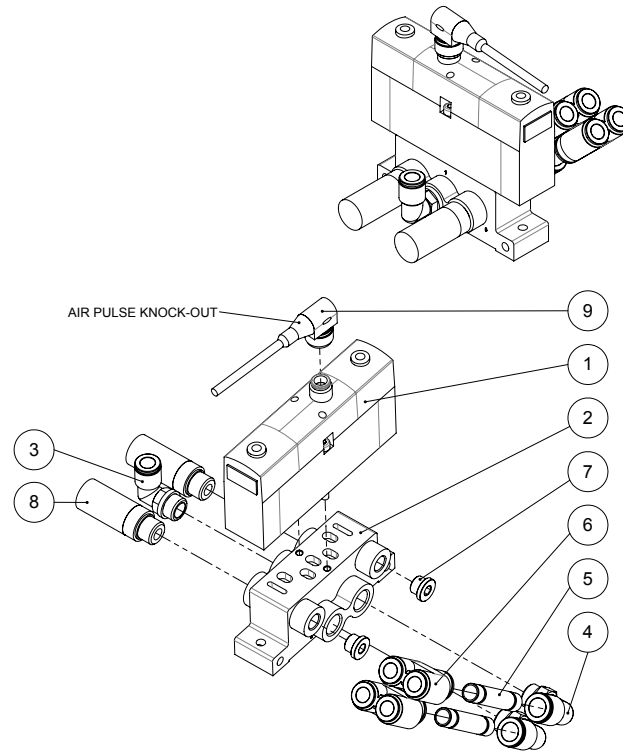
- Finally place the o-ring between the cylinder head and the cylinder pipe.

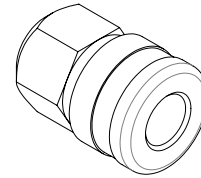
- Pos. 10: Stainless steel
- Pos. 9: Turquoise
- Pos. 8: Turquoise
- Pos. 7: Brown
- Pos. 1: Stainless steel / Black
- Pos. 2: Black
- Pos. 15: Green
- Pos. 4: Grey
- Pos. 3: Grey
- Pos. 18: Green



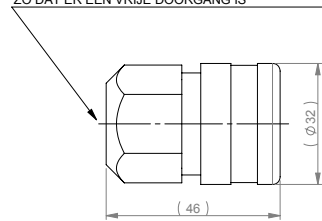
A (2 : 1.5)

Mounting torque cylinder head: 125Nm

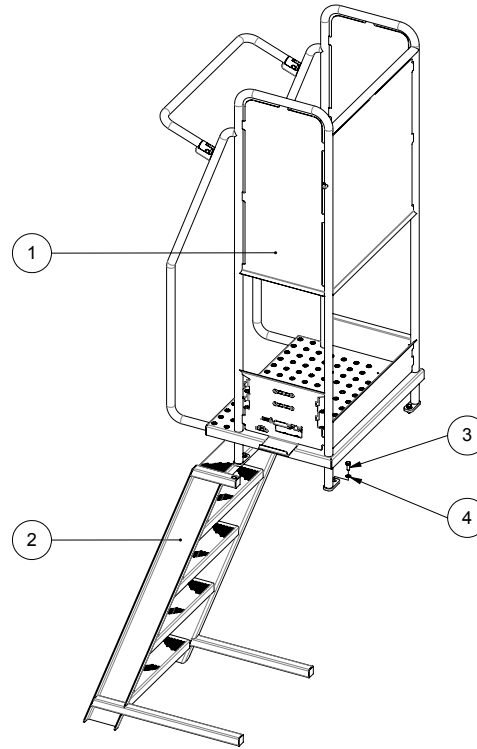


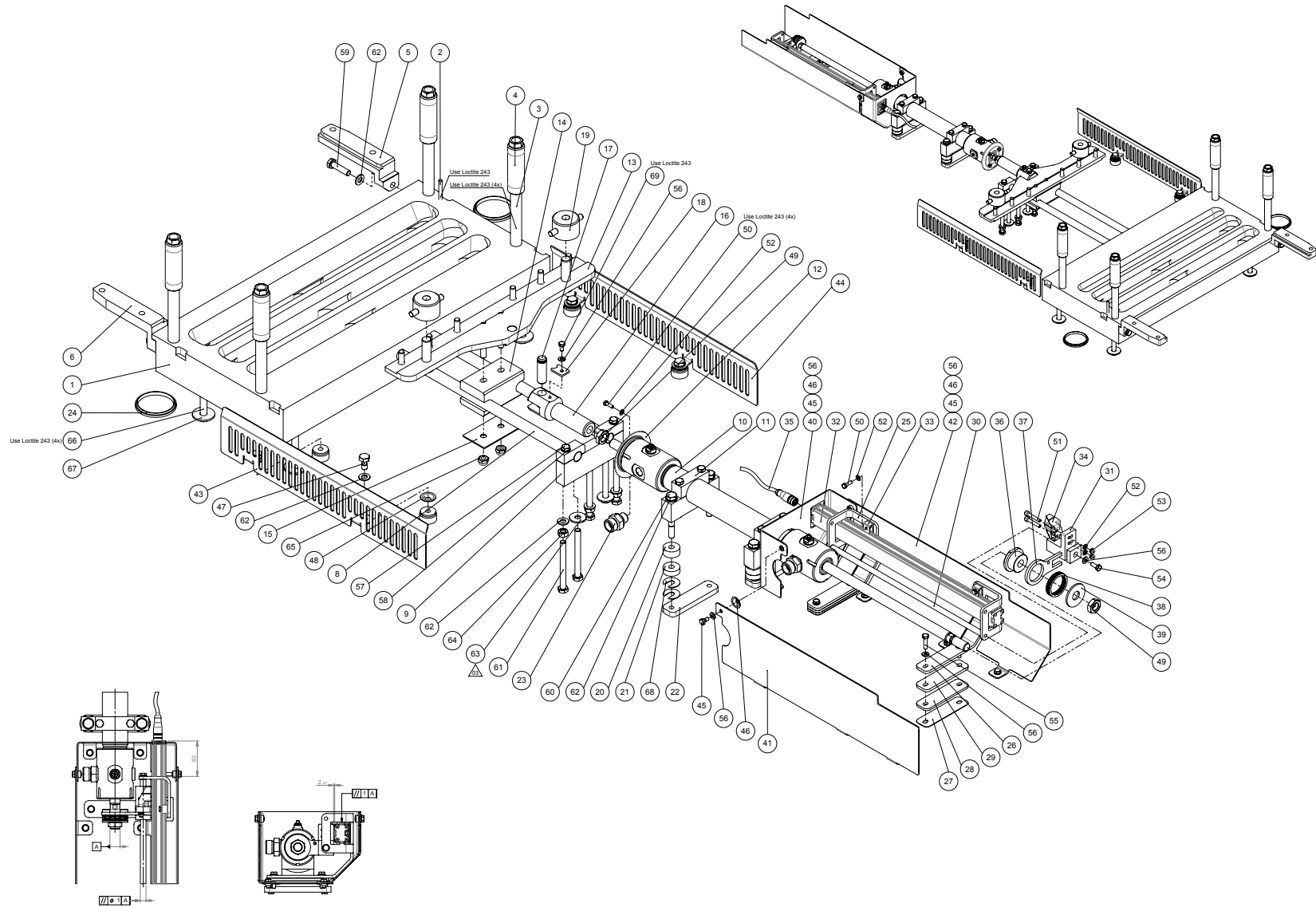


REMOVE SPRING AND ONE-WAY VALVE COMPLETELY
SO THAT THERE IS A FREE PASS
VERWIJDER VEER EN EEN-WEG KLEP VOLLEDIG
ZO DAT ER EEN VRIJE DOORGANG IS



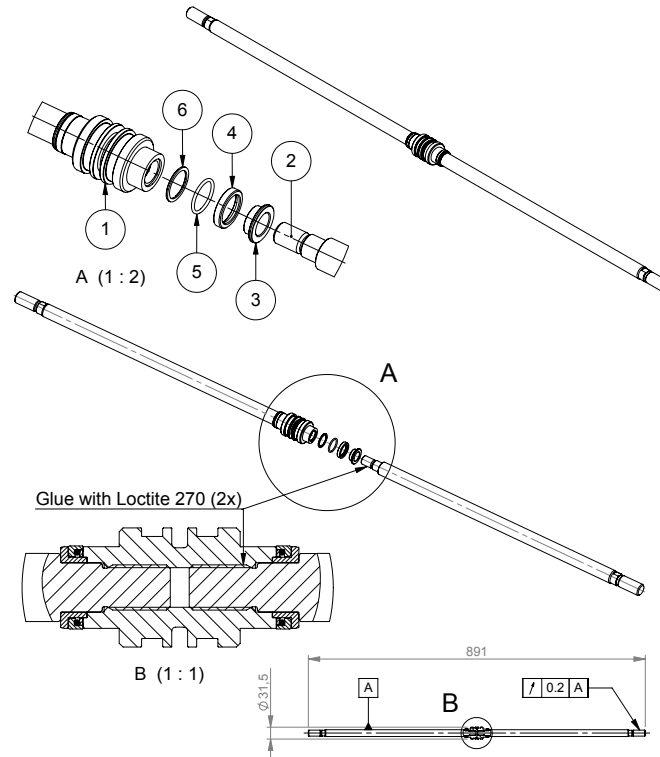
connection 3/8"
verbinding 3/8"

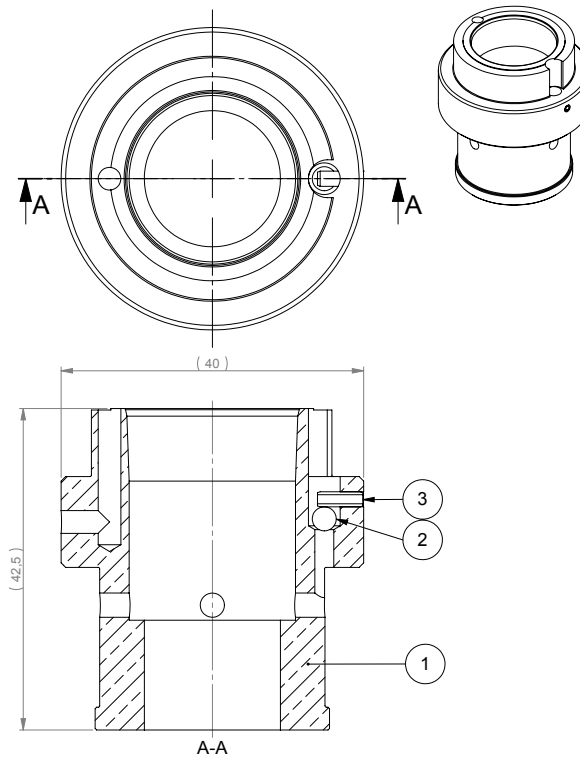


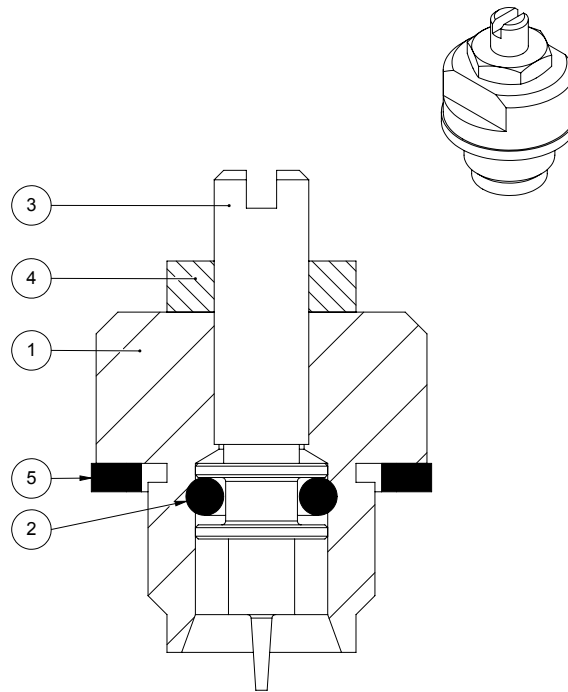


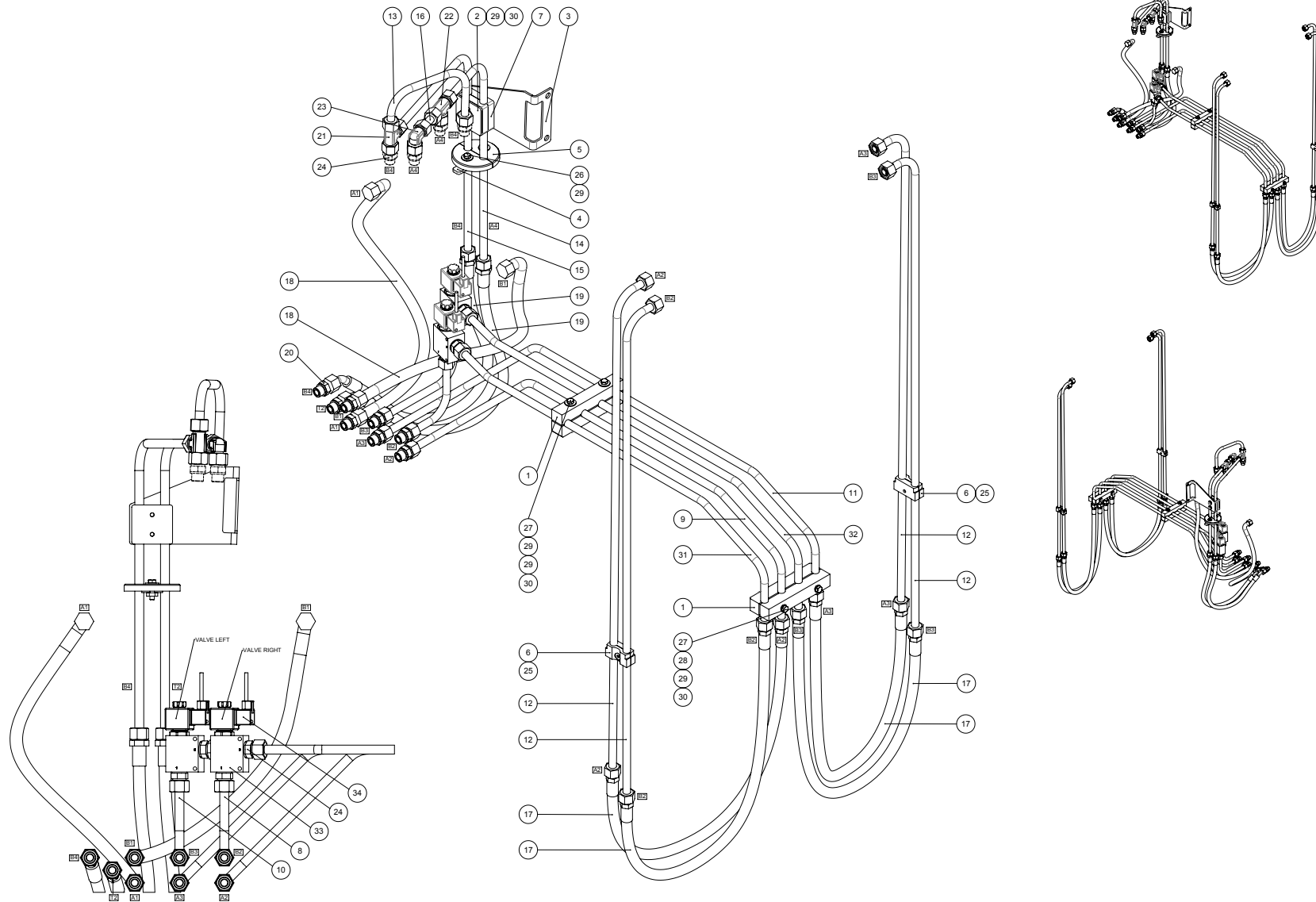
Pos	Item number	Quantity	Unit	Item description (native)	Item description	Specification	RSPC	Detail
1	F121065	1	pcs	base plate	base plate		D	
2	F109968	1	pcs	threaded piece	threaded piece		D	
3	1000302168	4	pcs	threaded piece	threaded piece		D	
4	F121016	4	pcs	threaded bush	threaded bush		D	
5	1000316461	1	pcs	support	support		D	
6	1000316462	1	pcs	support	support		D	
7	1000311791	4	pcs	threaded bush	threaded bush		D	
8	F121018	2	pcs	shaft	shaft		B	
9	1000215899	1	pcs	clamping block	clamping block		D	
10	1000213702	1	pcs	hydraulic cylinder	hydraulic cylinder	according to drawing	B	
11	1000109733	2	pcs	foot	foot		D	y
12	1000214253	1	pcs	disc	disc		D	
13	1000009289	1	pcs	form plate	form plate		B	
14	F121137	1	pcs	block	block		D	
15	F124099	1	pcs	plate	plate		D	
16	1000286394	1	pcs	connection piece	connection piece		D	
17	F121134	1	pcs	pin	pin		D	
18	F124100	1	pcs	flat material	flat material		D	
19	1000007430	2	pcs	nut	nut		D	
20	F104334	4	pcs	spacer ring	spacer ring		D	
21	F121774	4	pcs	spacer ring	spacer ring		D	
22	1000379332	2	pcs	threaded piece	threaded piece		D	
23	K046866	2	pcs	coupling	coupling	without nut, without cutting ring	D	
24	K010100	2	pcs	scraper	scraper		B	
25	1000268096	1	pcs	support	support		D	
26	1000268482	1	pcs	support	support		D	
27	1000261927	2	pcs	plate	plate		D	
28	1000301759	2	pcs	plate	plate		D	
29	1000261926	2	pcs	plate	plate		D	
30	1000262557	1	pcs	round	round		D	
31	1000268516	1	pcs	guide piece	guide piece		B	
32	1000227298	1	pcs	sensor	sensor	15...30 VDC 4-draads, N.O./N.C., PNP/N		
33	1000227650	2	pcs	bracket	bracket	Material: aluminium		
34	1000261873	1	pcs	positioning module	positioning module		D	
35	1000342968	1	pcs	connector	connector	M12x1-straight-female-5x0,34mm ² -IP67-5m	D	

Pos	Item number	Quantity	Unit	Item description (native)	Item description	Specification	RSPC	Detail
36	1000232612	1	pcs	bushing	bushing		B	
37	1000268057	1	pcs	guide part	guide part		D	
38	1000238203	1	pcs	spring	spring	Multiwave spring, shims no.: 2x	D	
39	1000233105	1	pcs	ring	ring		C	
40	1000301791	1	pcs	protection	protection		E	
41	1000301788	1	pcs	protection	protection		E	
42	1000301789	1	pcs	protection	protection		E	
43	1000311456	1	pcs	protection	protection		E	
44	1000311455	1	pcs	protection	protection		E	
45	1000301792	10	pcs	bolt	bolt			
46	1000244077	10	pcs	washer	washer			
47	1000310852	4	pcs	bolt	bolt		D	
48	1000310853	4	pcs	washer	washer		D	
49	K003315	2	pcs	hexagon nut	hexagon nut		D	
50	K001542	8	pcs	hexagonal screw	hexagonal screw		D	
51	K001430	2	pcs	cheese-head screw	cheese-head screw		D	
52	K001510	10	pcs	washer	washer		D	
53	K001575	2	pcs	lock nut	lock nut	M5	D	
54	K001970	2	pcs	hexagonal screw	hexagonal screw		D	
55	K001990	4	pcs	hexagonal screw	hexagonal screw		D	
56	K001890	17	pcs	washer	washer	DIN125-M6-A2	D	
57	K002370	2	pcs	hexagonal screw	hexagonal screw		D	
58	K002150	2	pcs	washer	washer		D	
59	K002760	2	pcs	hexagonal screw	hexagonal screw		D	
60	K002795	4	pcs	hexagonal screw	hexagonal screw		D	
61	K002800	5	pcs	hexagonal screw	hexagonal screw		D	
62	K002620	13	pcs	washer	washer	10	D	
63	K002630	2	pcs	washer	washer	10	D	
64	K002660	3	pcs	hexagon nut	hexagon nut	M10	D	
65	K002560	2	pcs	lock nut	lock nut	M10	D	
66	K003082	4	pcs	hexagonal screw	hexagonal screw		D	
67	K002920	4	pcs	washer	washer	12	D	
68	1000379341	8	pcs	ring	ring		C	
69	K001931	1	pcs	hexagonal screw	hexagonal screw		D	

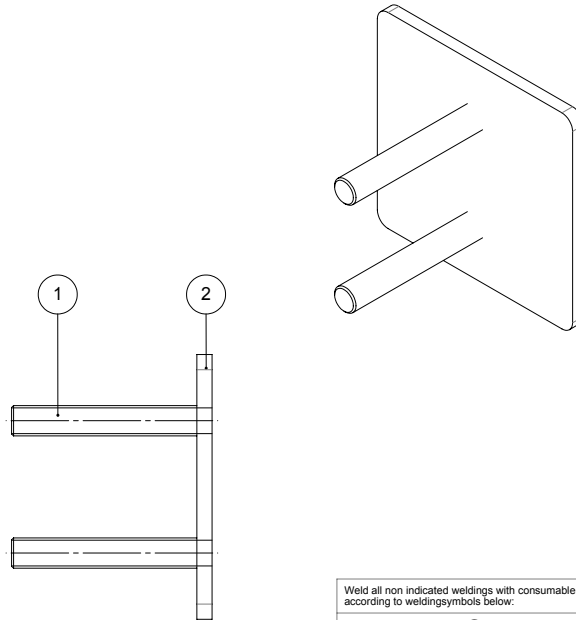








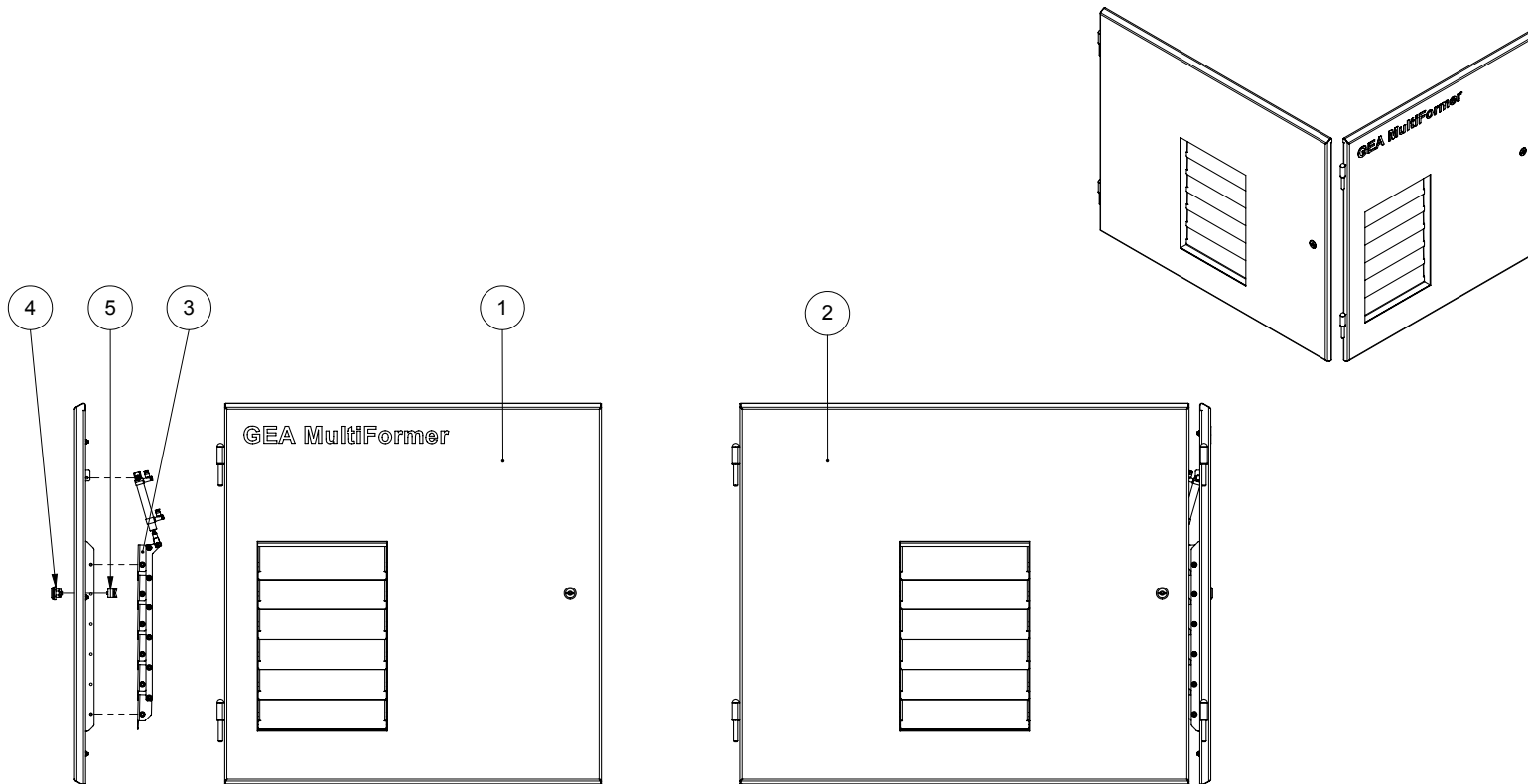
Pos	Item number	Quantity	Unit	Item description (native)	Item description	Specification	RSPC	Detail
1	F121171	2	pcs	clamping plate	clamping plate		D	
2	F121215	1	pcs	clamp	clamp		D	
3	1000328245	1	pcs	support	support		D	
4	F121584	1	pcs	strip	strip		D	
5	F121585	1	pcs	clamping plate	clamping plate		D	
6	F121586	2	pcs	clamping block	clamping block		D	
7	F121789	1	pcs	clamping block	clamping block		D	
8	1000390154	1	pcs	hydraulic pipe	hydraulic pipe		D	
9	1000299327	1	pcs	hydraulic pipe	hydraulic pipe		D	
10	1000422242	1	pcs	hydraulic pipe	hydraulic pipe		D	
11	1000422244	1	pcs	hydraulic pipe	hydraulic pipe		D	
12	F121192	4	pcs	hydraulic pipe	hydraulic pipe		D	
13	F121193	1	pcs	hydraulic pipe	hydraulic pipe		D	
14	F121194	1	pcs	hydraulic pipe	hydraulic pipe		D	
15	F121195	1	pcs	hydraulic pipe	hydraulic pipe		D	
16	F121196	1	pcs	hydraulic pipe	hydraulic pipe		D	
17	H003360	4	pcs	hydraulic hose	hydraulic hose		D	
18	H003421	2	pcs	hydraulic hose	hydraulic hose		D	
19	Z007759	2	pcs	hydraulic hose	hydraulic hose		D	
20	K046766	8	pcs	coupling	coupling		D	
21	Z009959	1	pcs	coupling	coupling		D	
22	Z009960	1	pcs	coupling	coupling		D	
23	Z009961	1	pcs	coupling	coupling		D	
24	Z009962	4	pcs	coupling	coupling		D	
25	K002470	2	pcs	countersunk screw	countersunk screw	M8x16	D	
26	K002370	2	pcs	hexagonal screw	hexagonal screw		D	
27	K002426	4	pcs	hexagonal screw	hexagonal screw		D	
28	K002150	2	pcs	washer	washer		D	
29	K002160	10	pcs	washer	washer	8	D	
30	K002260	6	pcs	lock nut	lock nut	M8	D	
31	1000381926	1	pcs	hydraulic pipe	hydraulic pipe		D	
32	1000422248	1	pcs	hydraulic pipe	hydraulic pipe		D	
33	1000432543	2	pcs	valve	valve		C	
34	E093000	2	pcs	plug	plug	with cable PVC-JZ 3x0,75 grey 3m, IP67	D	

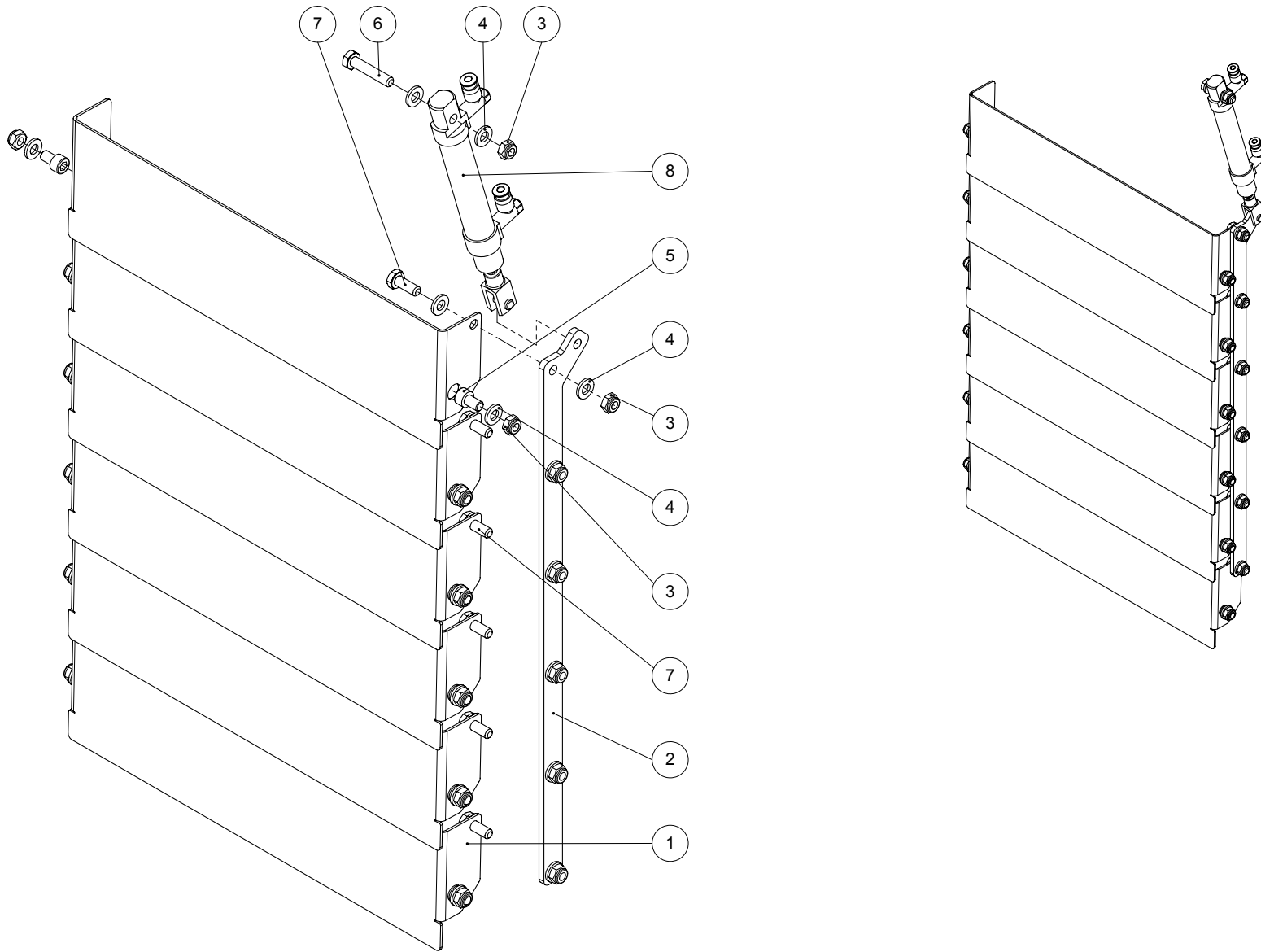


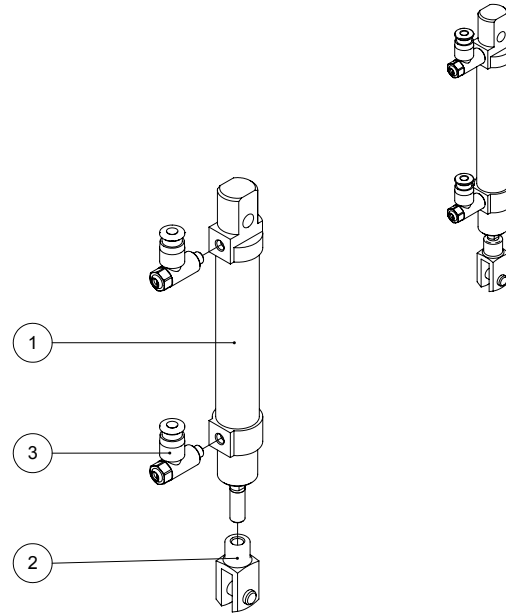
Weld all non indicated weldings with consumable according to weldingsymbols below:

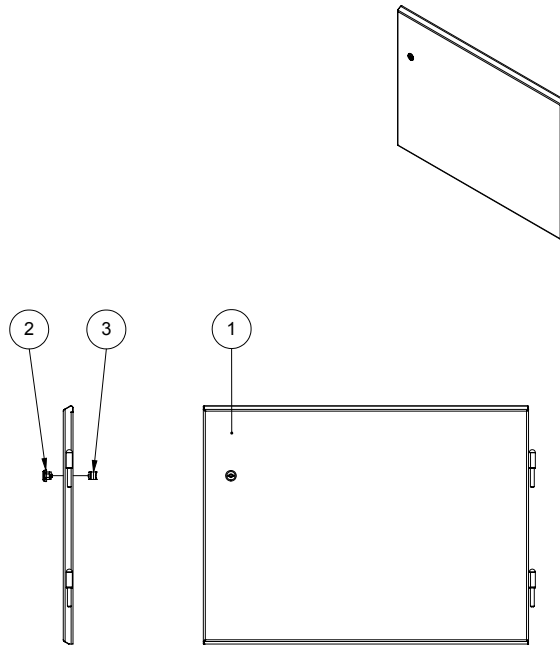
ISO 4063 (process)	ISO 14343 (consumable)
T1 141 (TIG)	W19 12 3 LSi (316 LSi)
T2 142 (TIG)	-
M 135 (MAG)	W19 9 L (304 L)
general tolerances	DIN EN ISO 13920 - BF
assessment class	ISO 5817 - B

Blasting	Welds only	Ra 1.6
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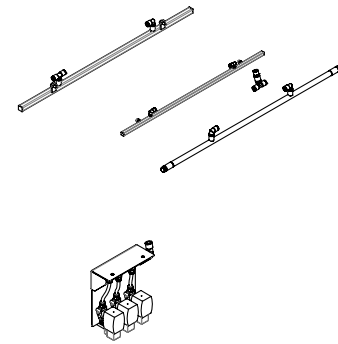
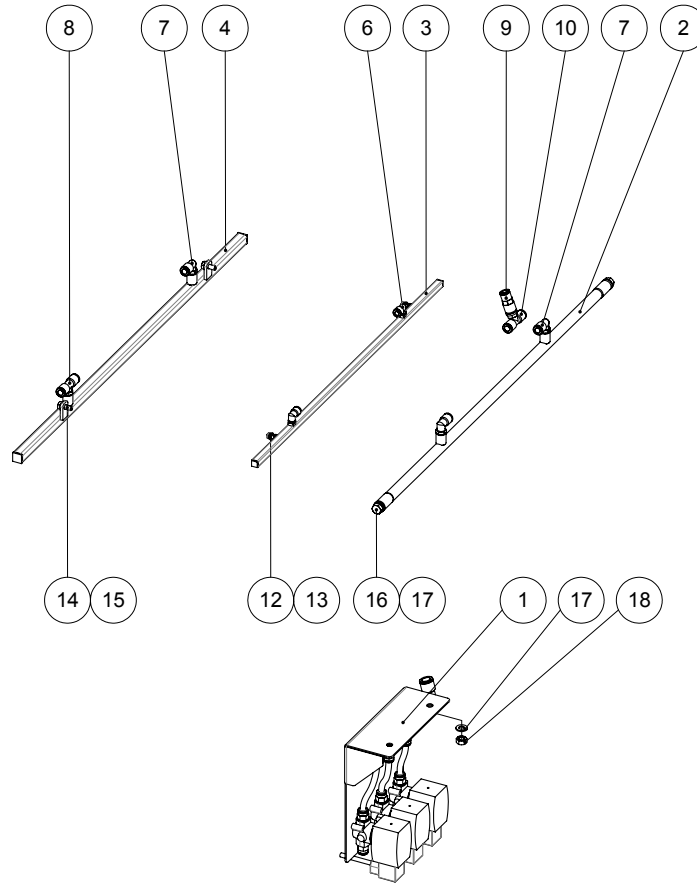
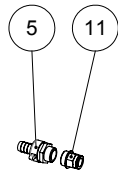


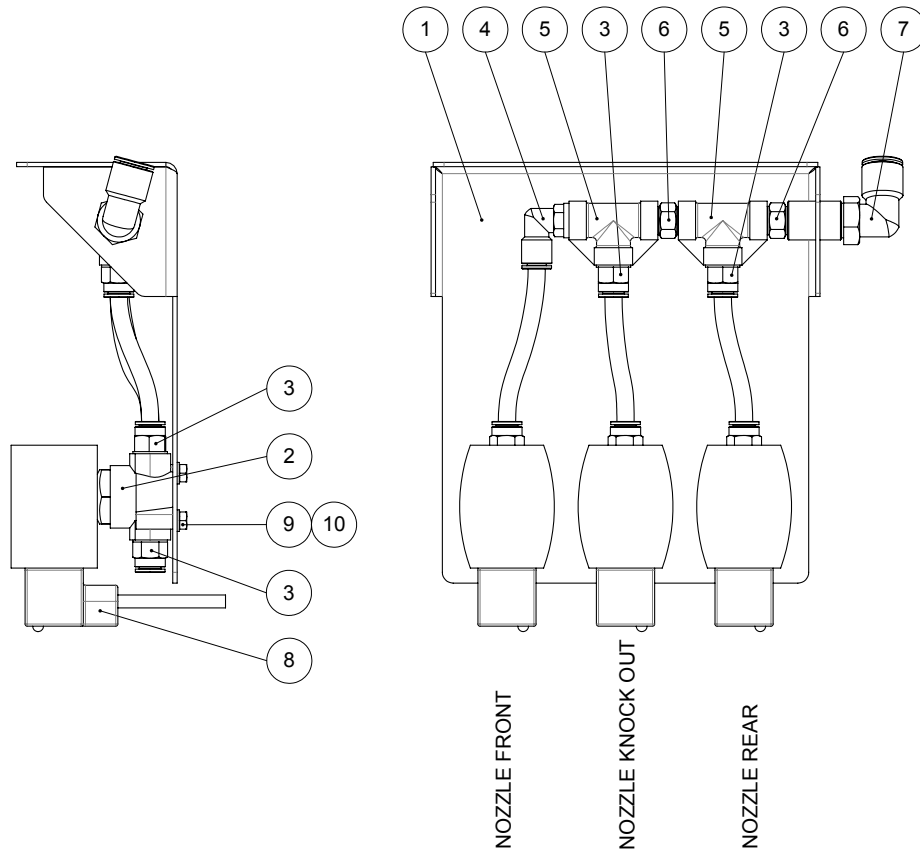




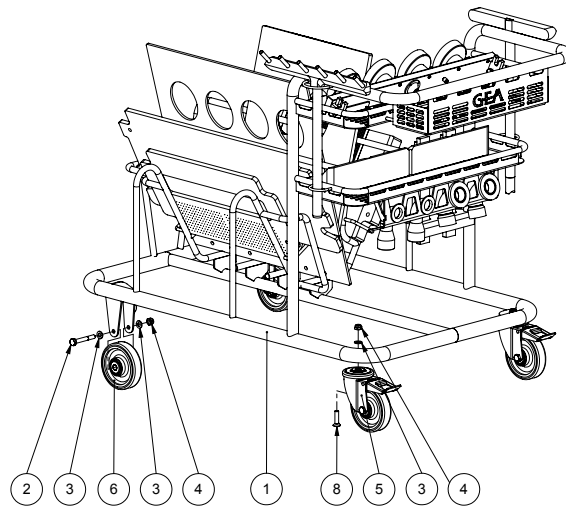
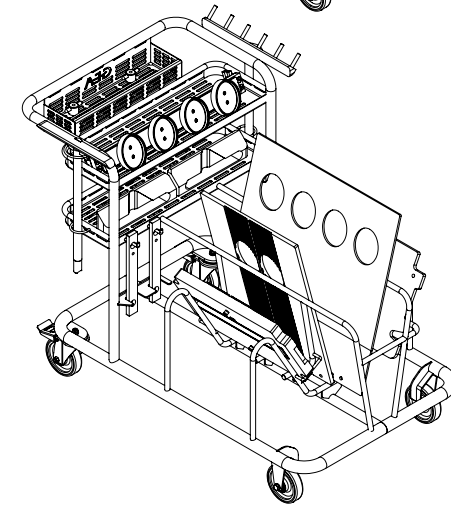
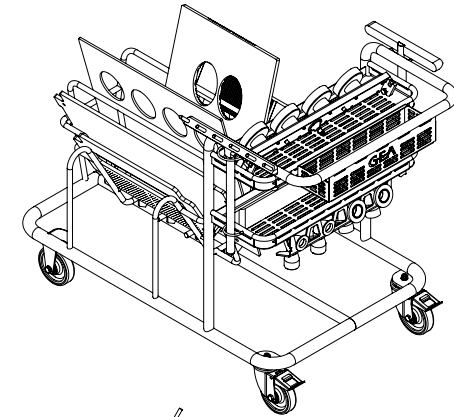
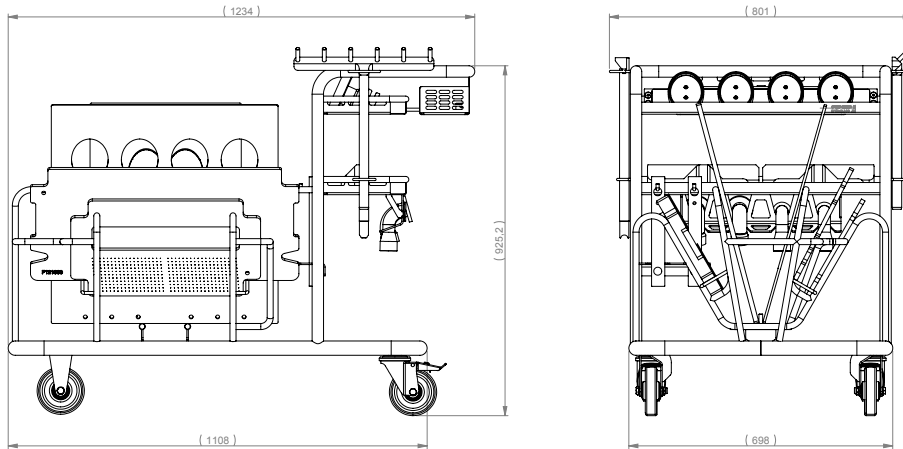


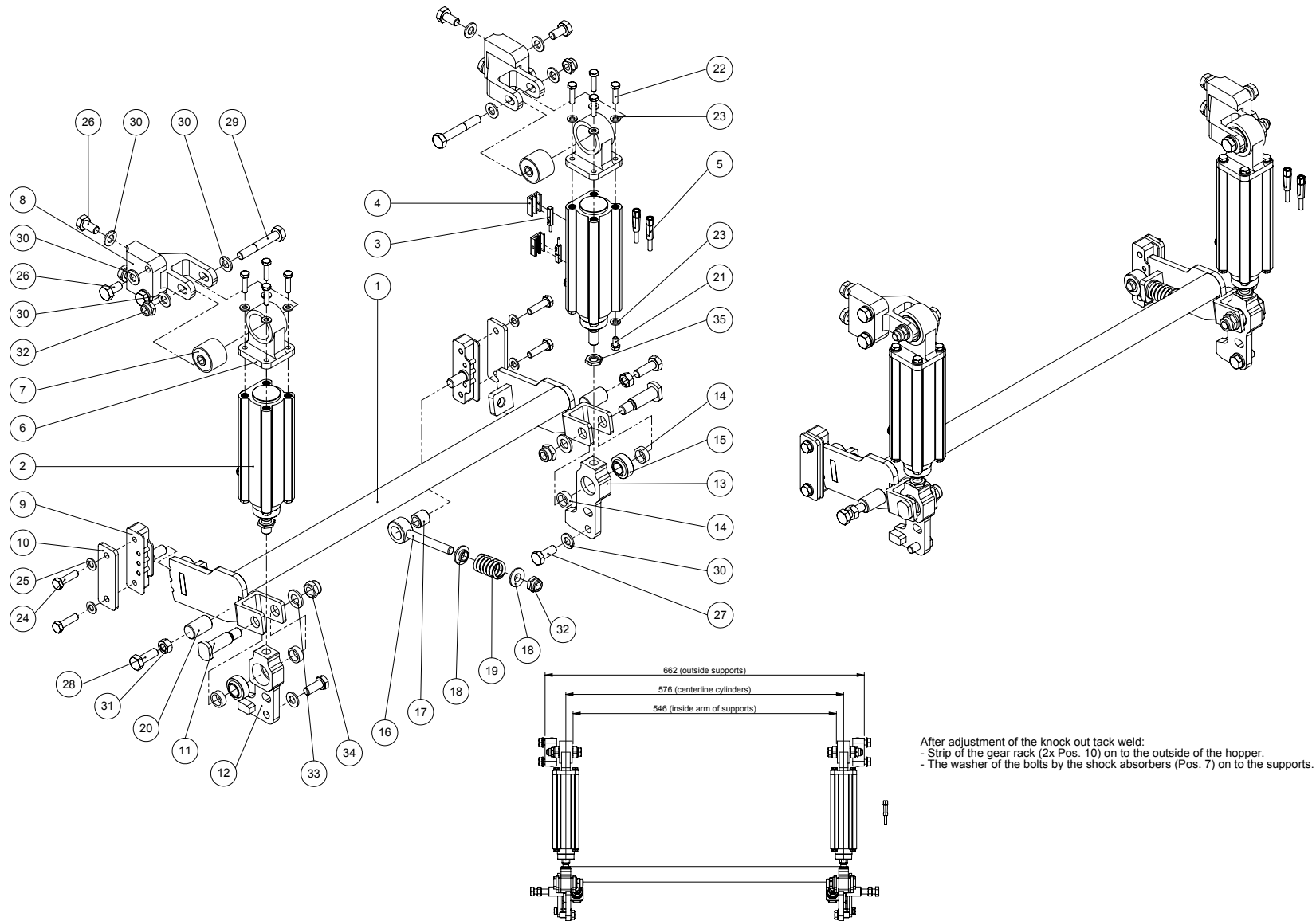
Mount Pos. 5 with Loctite 577



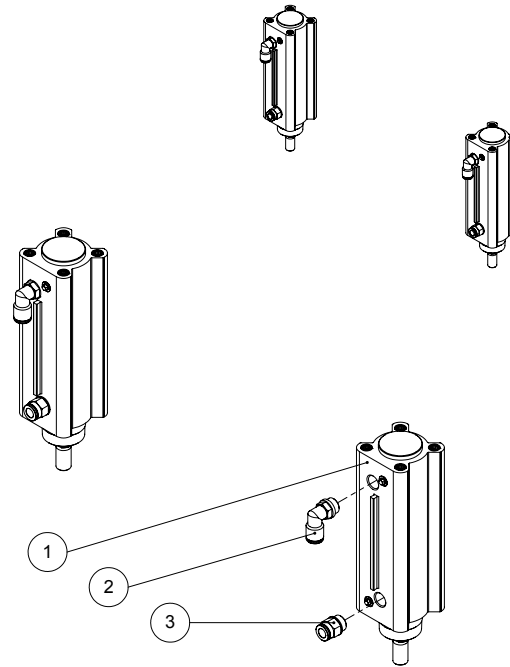


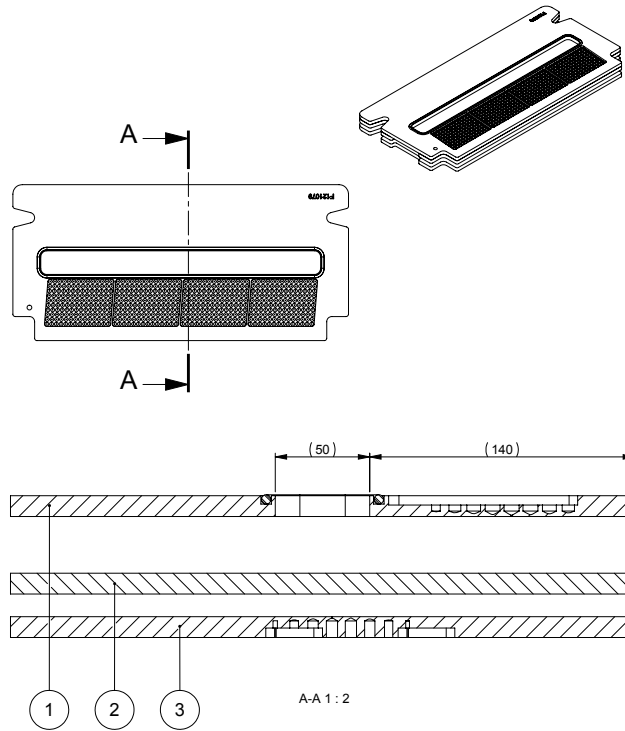
Apply Loctite 577 to Pos. 6.

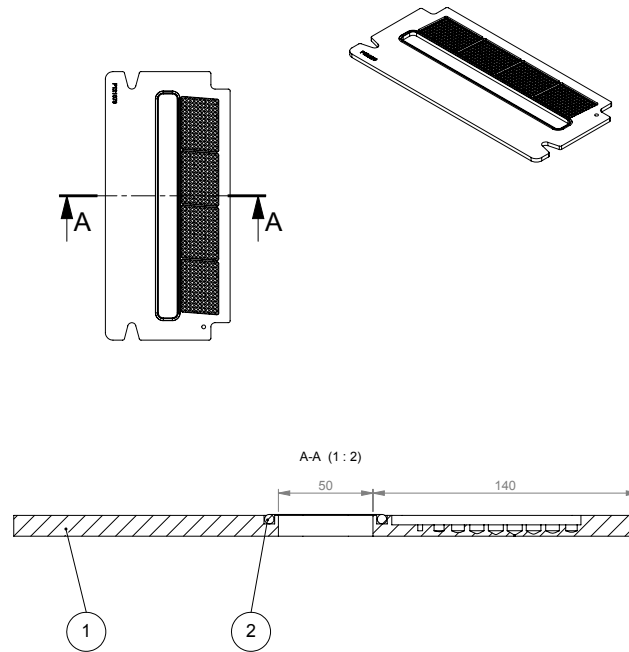


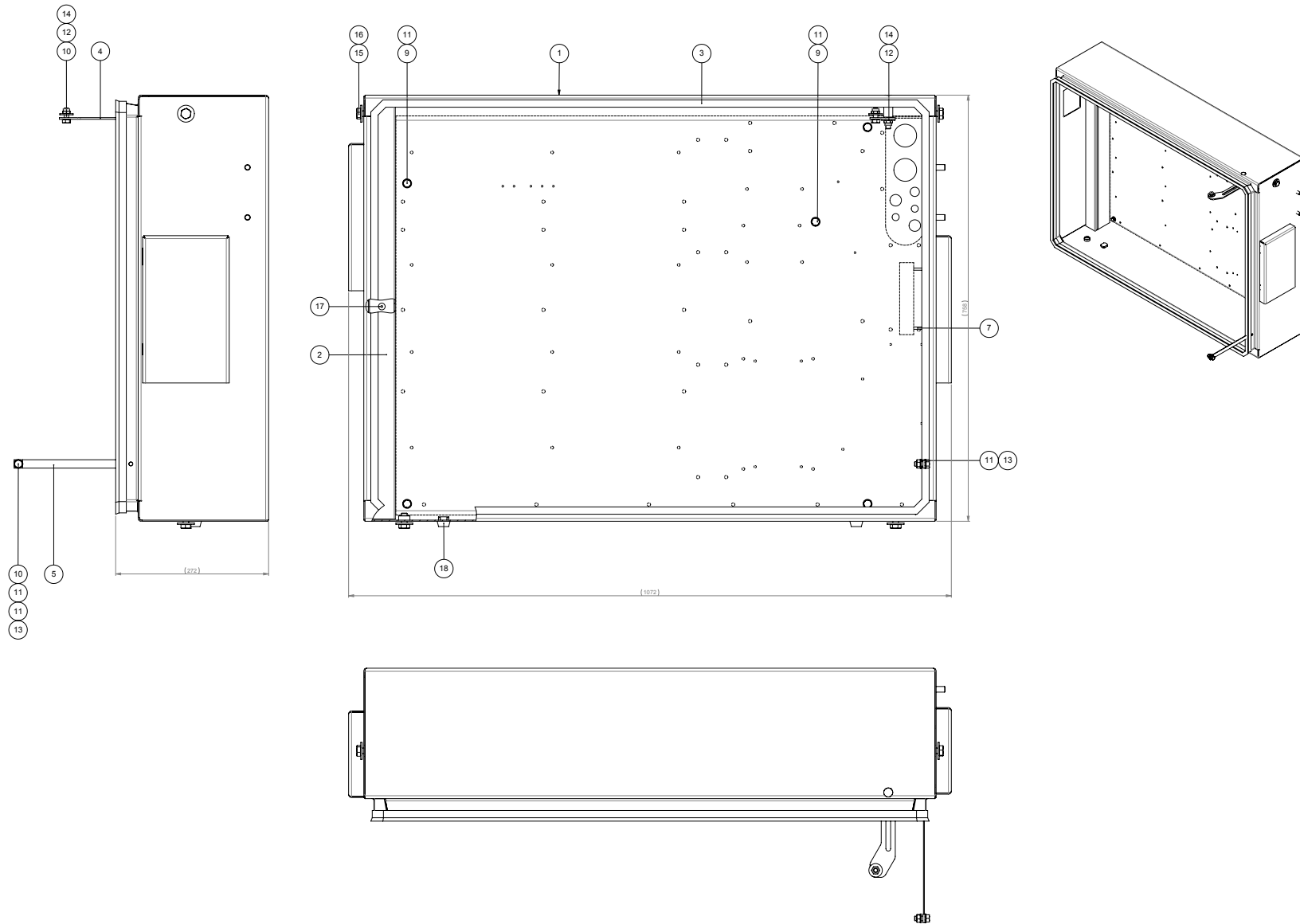


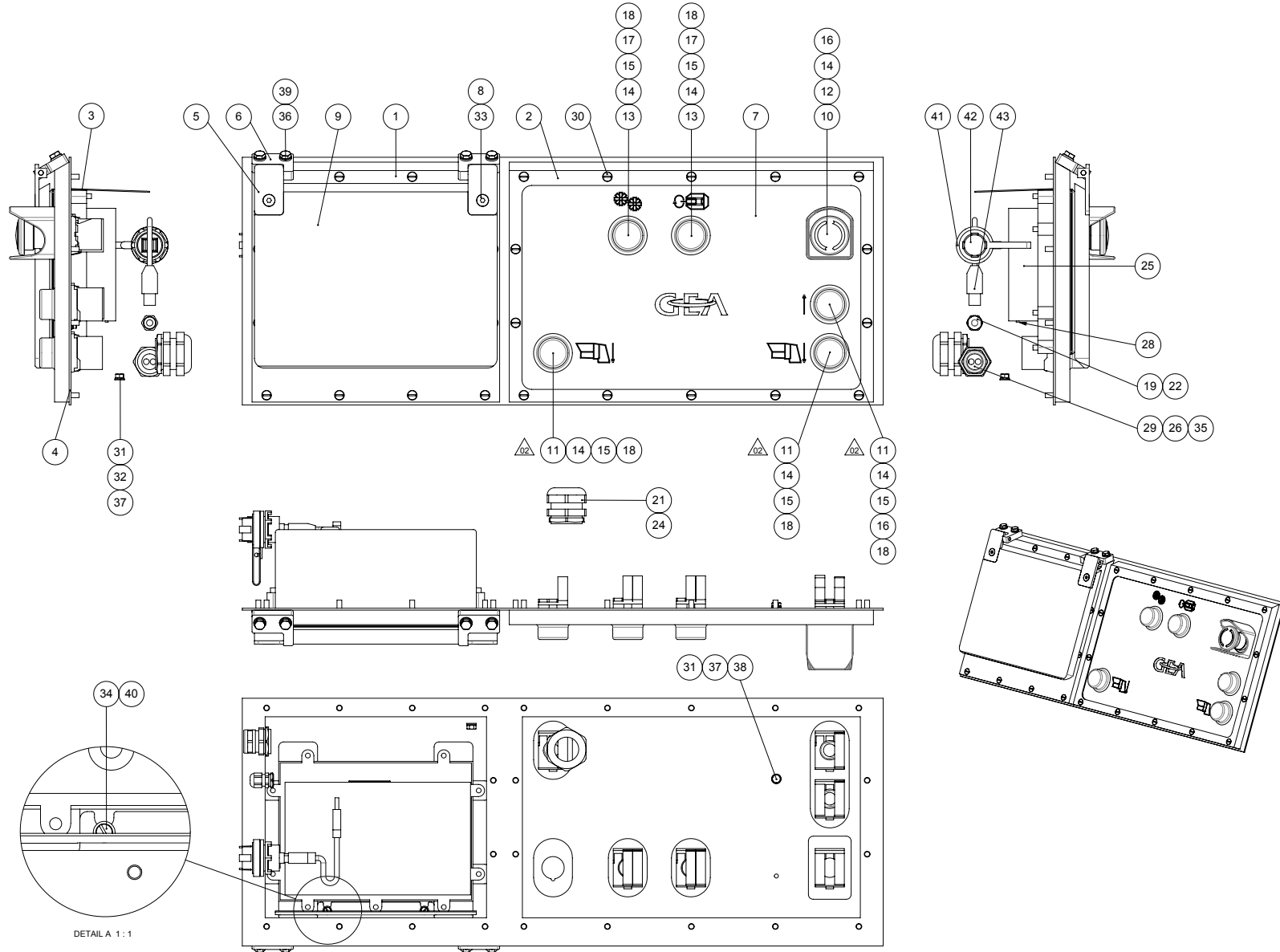
Pos	Item number	Quantity	Unit	Item description (native)	Item description	Specification	RSPC	Detail
1	F121785	1	pcs	arm	arm		C	
2	1000297146	1	pcs	knock out	knock out		C	
3	1000295530	2	pcs	proximity switch	proximity switch		C	
4	1000295531	2	pcs	bracket	bracket		D	
5	1000295533	2	pcs	connector	connector		D	
6	1000194334	2	pcs	support	support		D	
7	1000191029	2	pcs	shock absorber	shock absorber	According to drawing	B	
8	1000237265	2	pcs	support	support		D	
9	F121128	2	pcs	gear rack	gear rack		D	
10	F121676	2	pcs	strip	strip		D	
11	F121130	2	pcs	bolt	bolt		D	
12	F121084	1	pcs	strip	strip		D	
13	F121083	1	pcs	strip	strip		D	
14	F121131	4	pcs	bushing	bush		D	
15	1000184645	2	pcs	rodeye	rodeye		D	
16	F121129	2	pcs	tensioner	tensioner		D	
17	F121786	2	pcs	bushing	bushing		B	
18	F121091	4	pcs	ring	ring		D	
19	K027002	2	pcs	compression spring	compression spring		B	
20	F119040	2	pcs	blind plug	blind plug		D	
21	K001931	8	pcs	hexagonal screw	hexagonal screw		D	
22	K001990	8	pcs	hexagonal screw	hexagonal screw		D	
23	K001890	16	pcs	washer	washer	DIN125-M6-A2	D	
24	K002370	4	pcs	hexagonal screw	hexagonal screw		D	
25	K002150	4	pcs	washer	washer		D	
26	K002690	8	pcs	hexagonal screw	hexagonal screw		D	
27	K002700	2	pcs	hexagonal screw	hexagonal screw		D	
28	K002720	2	pcs	hexagonal screw	hexagonal screw		D	
29	K002791	2	pcs	hexagonal screw	hexagonal screw		D	
30	K002620	14	pcs	washer	washer	10	D	
31	K002660	2	pcs	hexagon nut	hexagon nut	M10	D	
32	K002560	4	pcs	lock nut	lock nut	M10	D	
33	K002910	2	pcs	washer	washer		D	
34	K002980	2	pcs	lock nut	lock nut	M12	D	
35	Z007556	2	pcs	hexagon nut	hexagon nut		D	



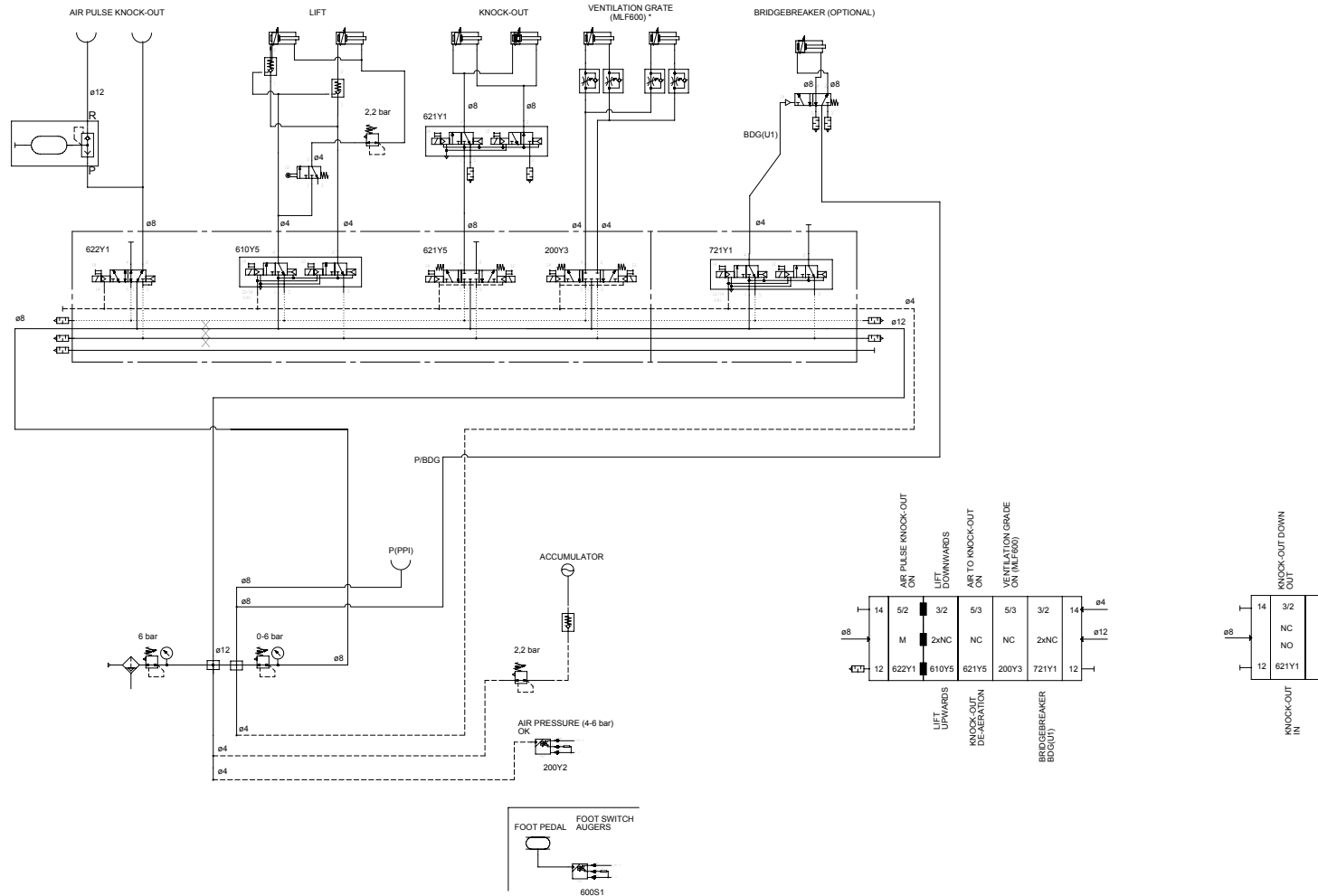






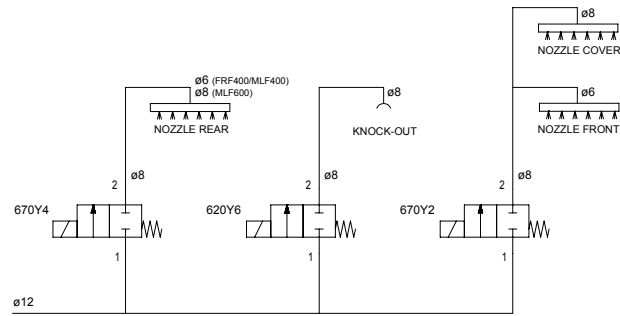


Pos	Item number	Quantity	Unit	Item description (native)	Item description	Specification	RSPC	Detail
1	1000180660	1	pcs	control panel	control panel		C	
2	F121814	1	pcs	control panel	control panel		C	
3	1000099645	1	pcs	plate	plate		D	
4	F121817	1	pcs	gasket	gasket		C	
5	F121727	2	pcs	strip	strip		D	
6	1000180662	2	pcs	hinge	hinge		D	
7	1000293222	1	pcs	sticker	sticker		D	
8	F104020	2	pcs	blind plug	blind plug		D	
9	F121210	1	pcs	cover sheet	cover sheet		D	
10	1000022490	1	pcs	emergency stop	emergency stop		C	
11	1000268040	3	pcs	push button	push button	heads only, IP66, UL/CSA	D	
12	1000277649	1	pcs	cover	cover		D	
13	1000022467	2	pcs	push button	push button		C	
14	1000022514	6	pcs	adapter	adapter		C	
15	1000022510	5	pcs	connection element	connection element		C	
16	1000022511	3	pcs	connection element	connection element		C	
17	1000022533	2	pcs	led	led		C	
18	1000022519	5	pcs	membrane	membrane		B	
19	E065000	1	pcs	gland	gland	M12x1,5 brass, thread 6,5mm, 3-7mm	D	
21	E065024	1	pcs	gland	gland	M32x1,5 brass, thread 9mm	D	
22	E065300	1	pcs	connecting nut	connecting nut	M12x1,5 brass	D	
24	E065308	1	pcs	connecting nut	connecting nut	M32x1,5 brass	D	
25	3000342363	1	pcs	input unit	input unit		C	
26	B000503	1	pcs	gland	gland		D	
28	4016085196	1	pcs	memorycard	memorycard		C	
29	B000500	1	pcs	insert	insert		D	
30	K001490	26	pcs	countersunk screw	countersunk screw		D	
31	K001510	2	pcs	washer	washer		D	
32	K001570	1	pcs	hexagon nut	hexagon nut	M5	D	
33	K002065	2	pcs	countersunk screw	countersunk screw		D	
34	K001145	2	pcs	cheese-head screw	cheese-head screw		D	
35	E065306	1	pcs	connecting nut	connecting nut	M25x1,5 brass	D	
36	K001890	4	pcs	washer	washer	DIN125-M6-A2	D	
37	K001525	2	pcs	spring ring	spring ring	M5	D	
38	K001530	1	pcs	hexagonal screw	hexagonal screw		D	

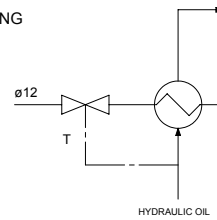


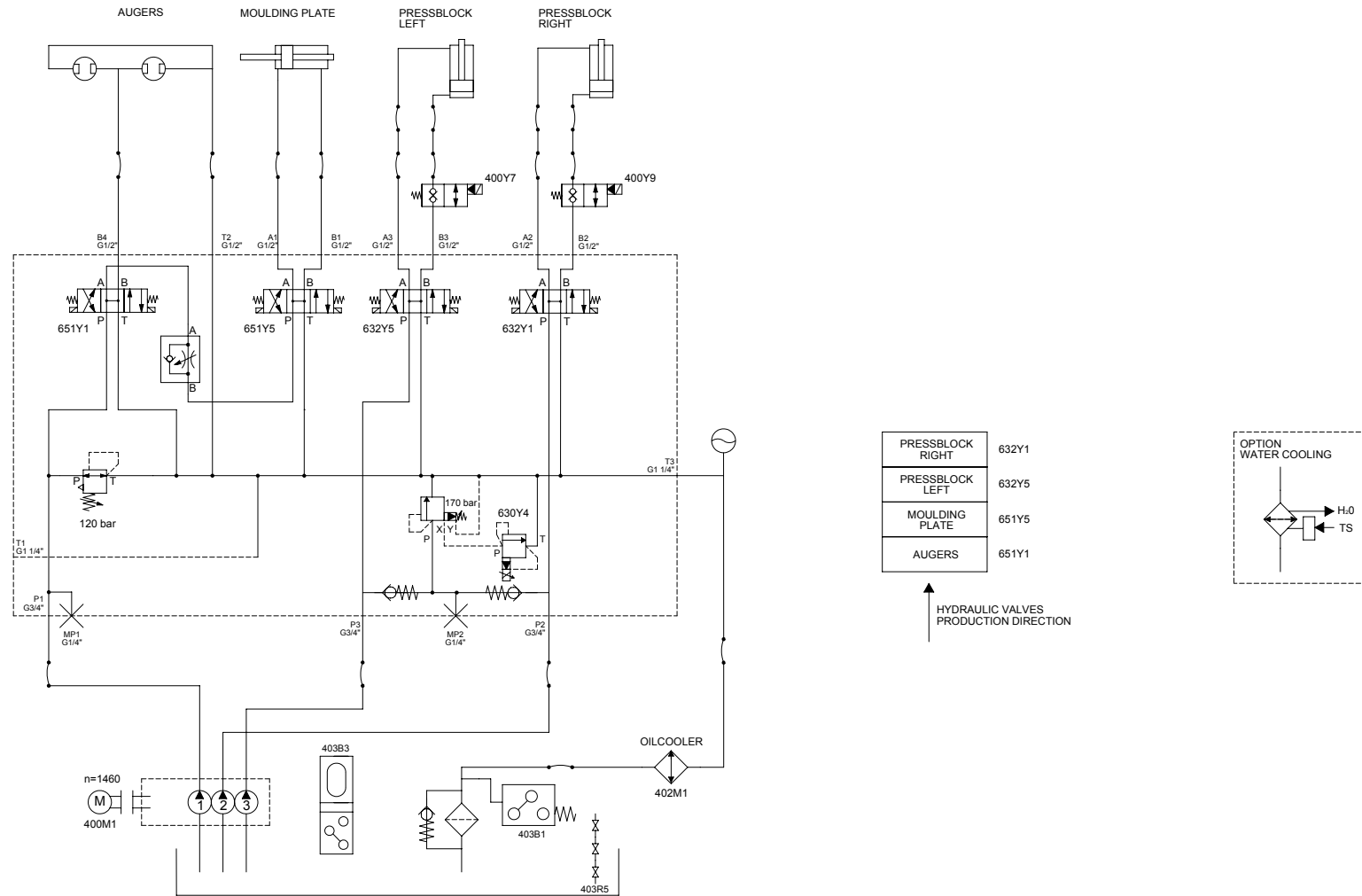
* When option water cooling port 2 and 4 on valve are plugged up

WATER DIAGRAM
STANDARD

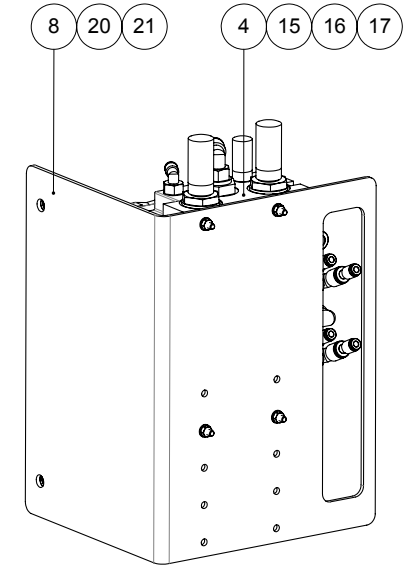
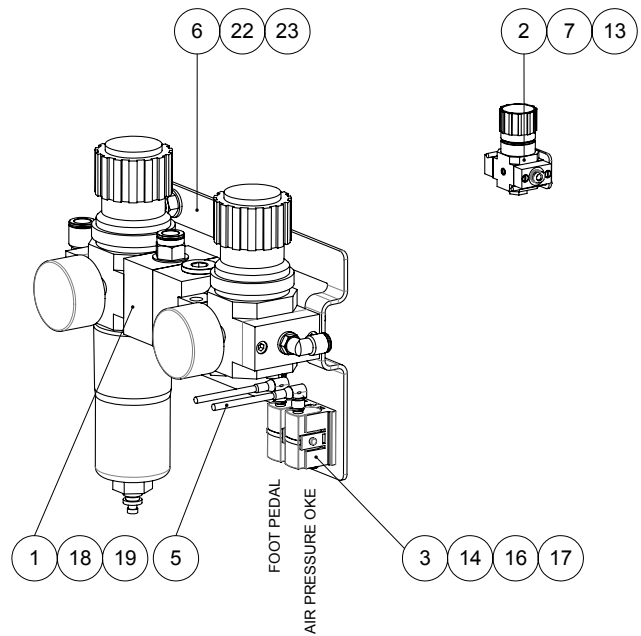
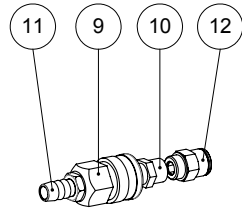


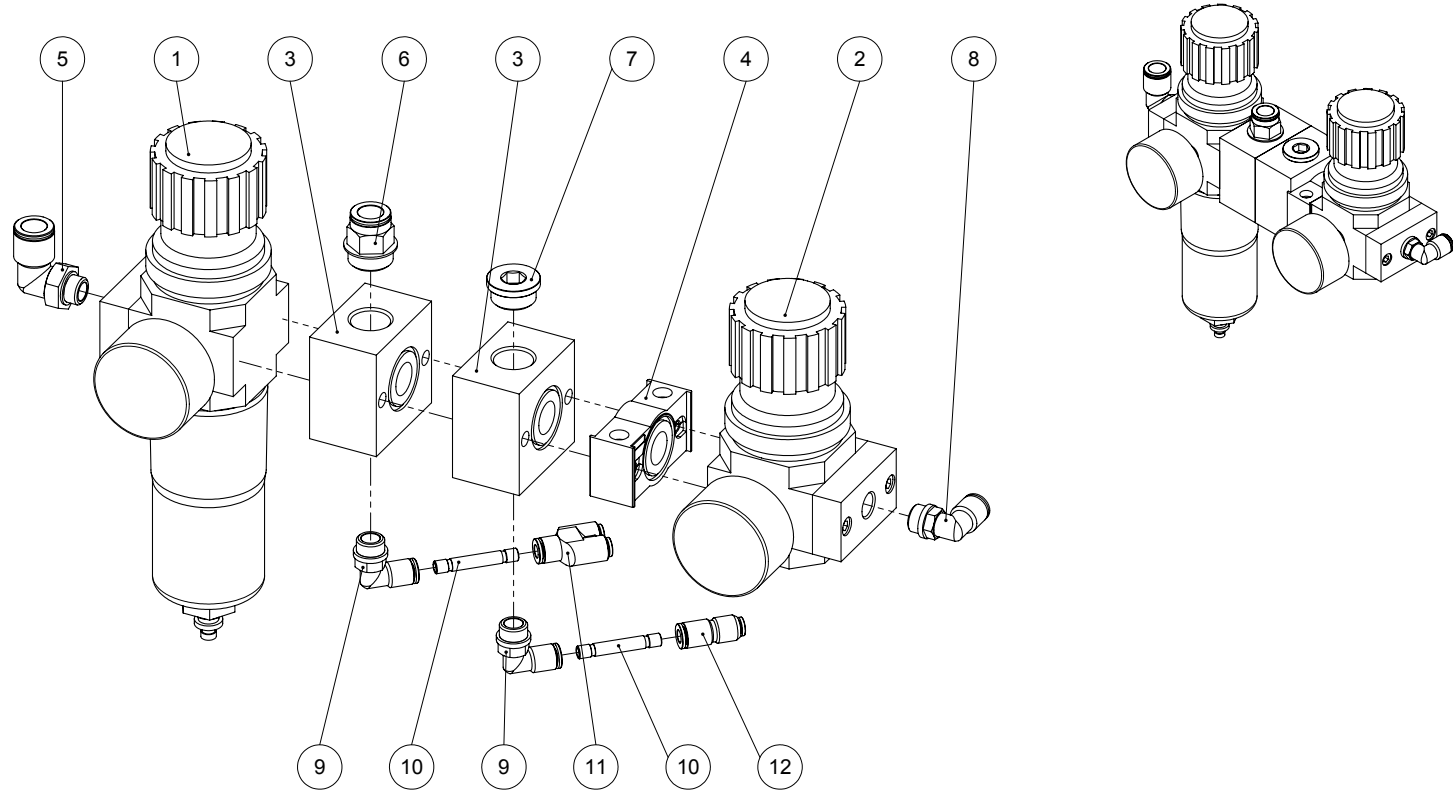
WATER COOLING
OPTIONAL

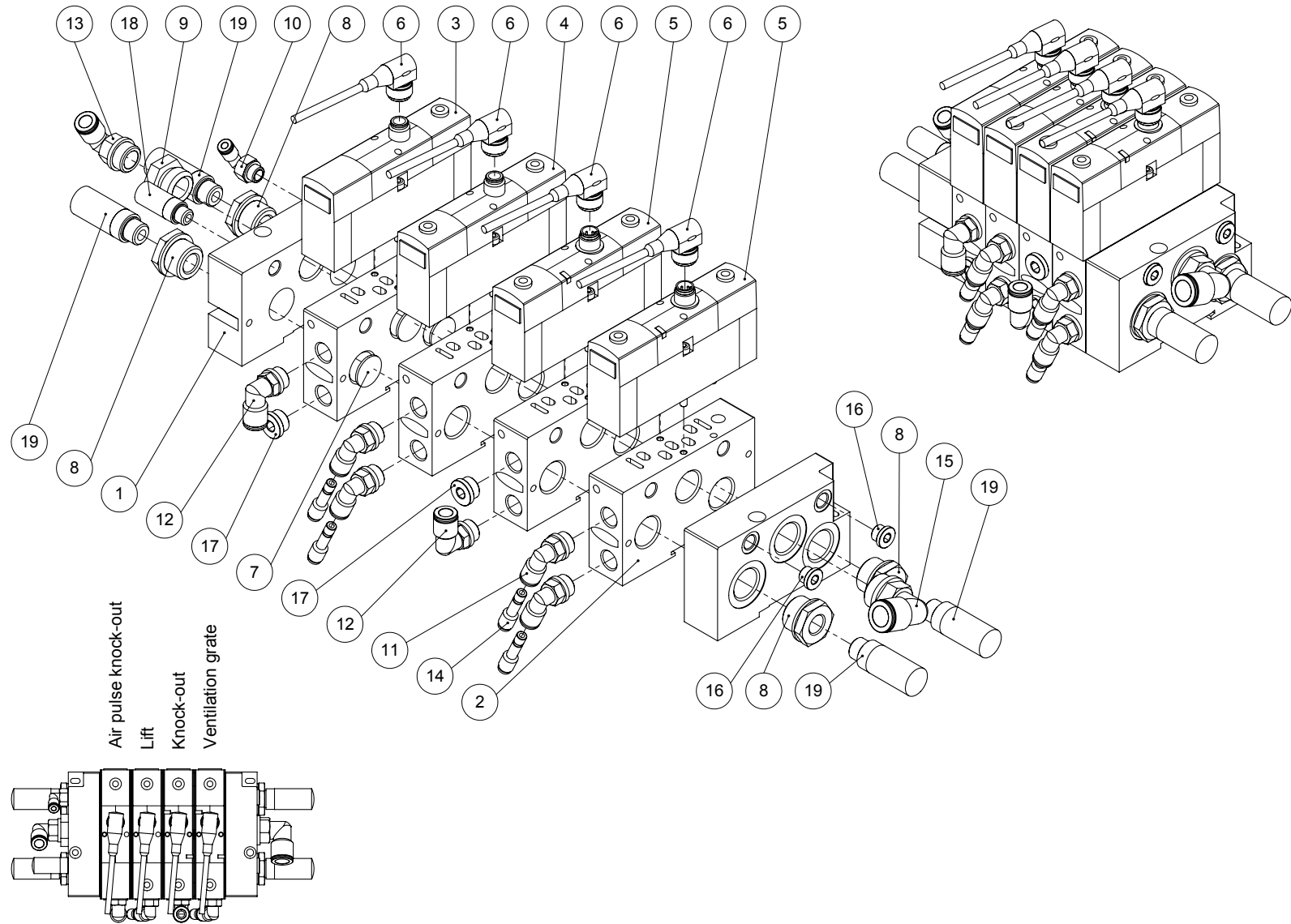


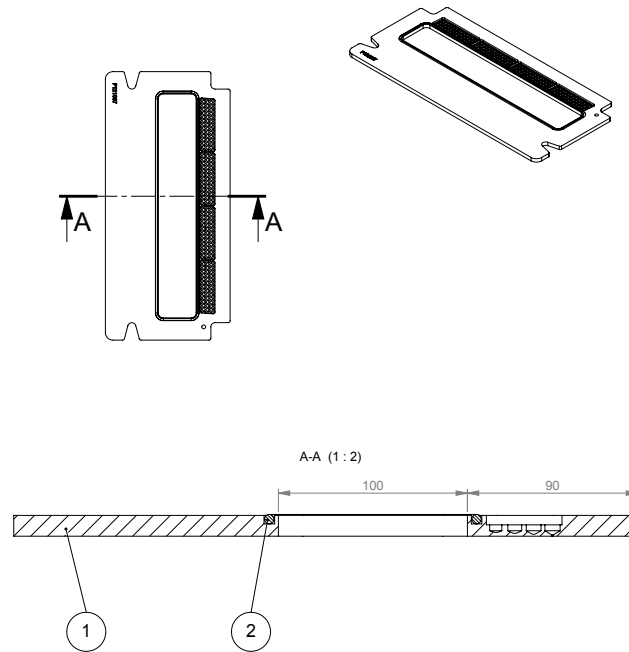


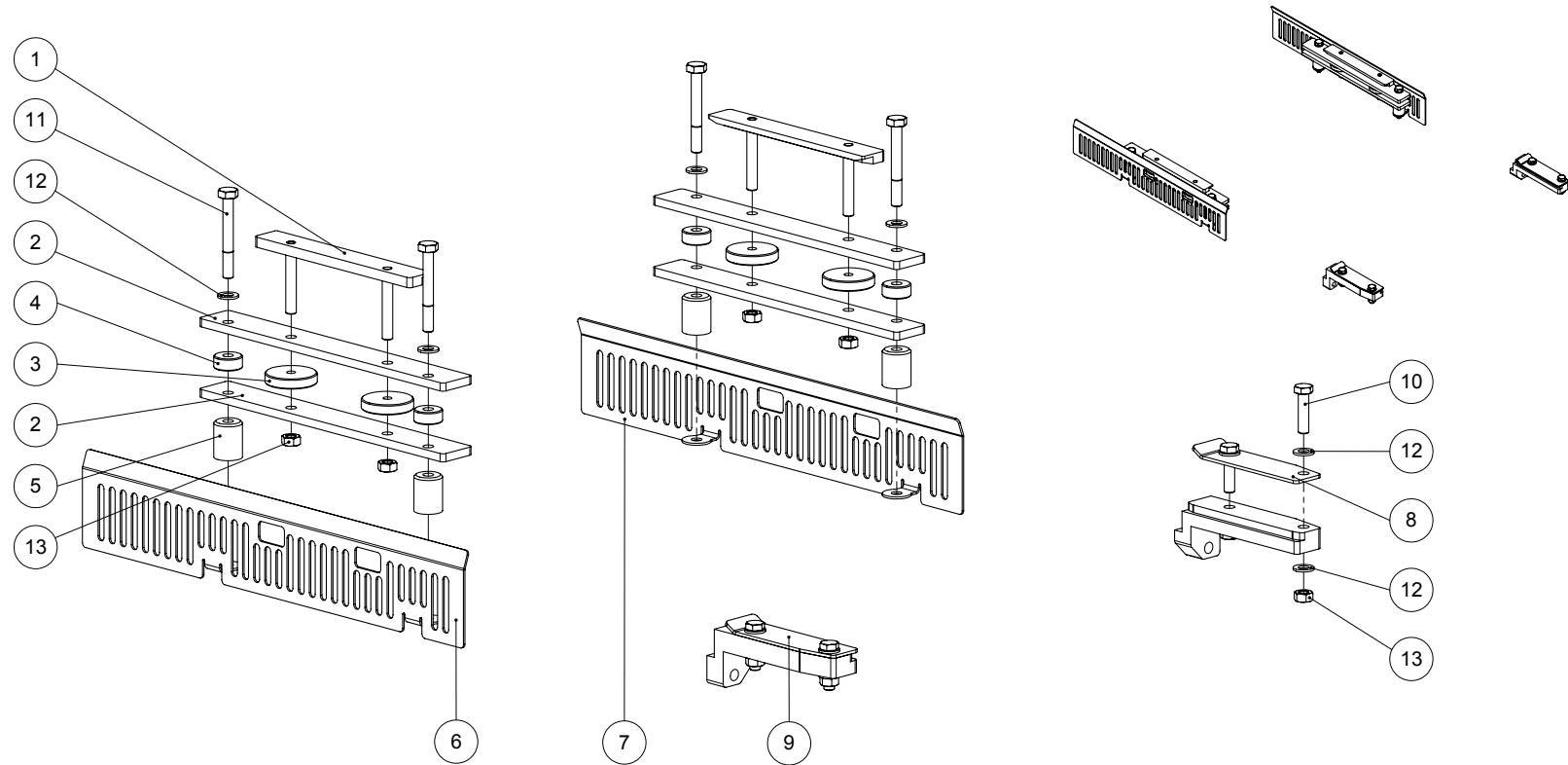
11 9 10 12
Mount Pos. 9, 10 and 11
with Loctite 577











Use filling rings Pos. 14-17 between Pos. 5 and 6/7 to adjust the height.

