

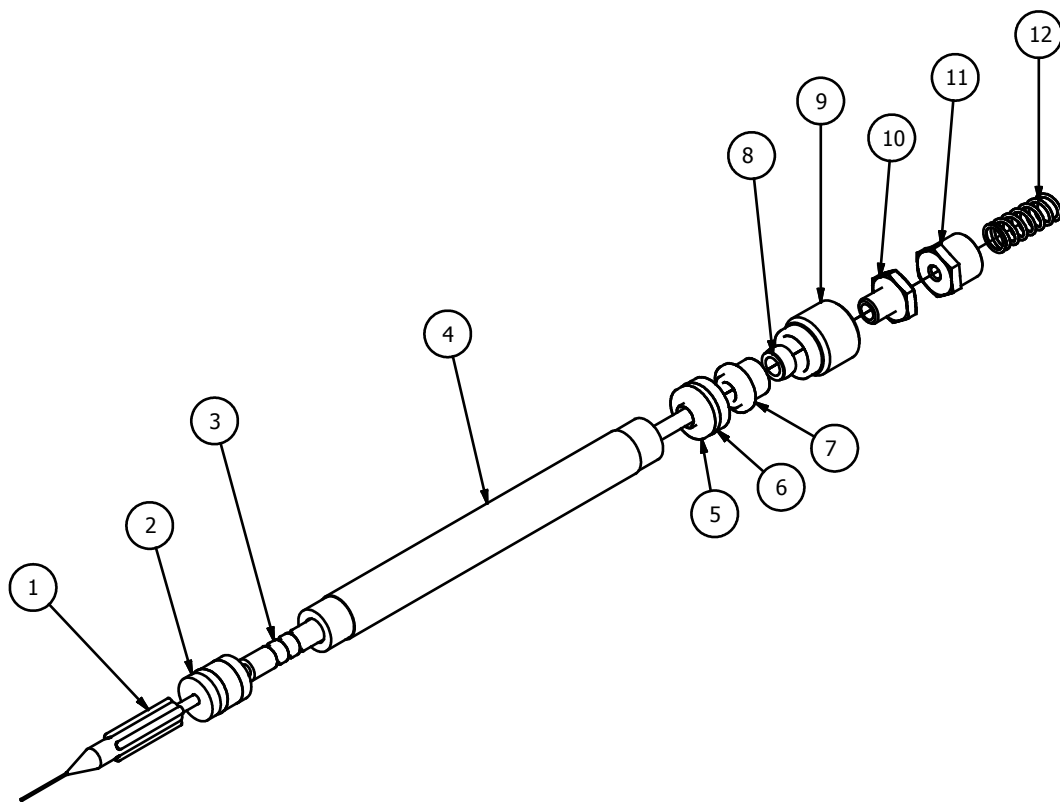
## **VECTOR™ R90/70 - NEEDLE SHAFT ASSEMBLY**

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1. Prior to installing the non-adjustable cartridge seal, fill the internal bore with dielectric grease. Then place the cartridge seal onto the front of the needle shaft and **SCREW IT ON AND OVER THE EXTERNAL THREADS**. Once both internal o-rings have cleared the threads, slide it onto the sealing area.
  - **DO NOT PUSH THE CARTRIDGE SEAL STRAIGHT OVER THE SHAFT THREADS. THE THREADS WILL DAMAGE THE INTERNAL O-RINGS AND CAUSE FLUID LEAKS.**
2. Screw the needle electrode onto the front of the needle shaft and hand tighten.
3. Fill the inner diameter of the packing tube with dielectric grease and insert the needle shaft, rear section first. Rotate the needle shaft while moving it back and forth inside the packing tube until fully inserted.
4. With your finger, wipe the excess grease from both ends of the packing tube. Using the excess grease, apply a thin film to the outer surface of the packing tube and to the external o-rings.
5. Insert the spring loaded u-cup into the seal retainer (with the concave side facing outward). Use the short end of the spacer to seat the seal.
6. While holding the rear seal retainer subassembly and spacer together, place these components (with the spacer rearward) onto the rear of the needle shaft and slide them over the sealing area.
7. Place the packing nut (large bore first) on the rear needle shaft section.
8. Screw the trigger adjustment nut onto the rear needle shaft section with the hexagon rearward and the spring retainer with the hexagon forward. Do not lock the hexagon nuts in place.
9. Install the needle shaft subassembly into the barrel chamber. Tighten the packing nut until it bottoms. Adjust the hexagon components according to your service manual.
  - **DO NOT OVER TIGHTEN THE HEXAGON ADJUSTMENT NUTS OR DAMAGE MAY OCCUR TO THE PLASTIC THREADS OR THE NEEDLE SHAFT MAY BREAK. FINGER TIGHT IS TYPICALLY SUFFICIENT. (MAXIMUM TORQUE OF 18-24 OZ•IN)**

## R90/70 CLASSIC NEEDLE SHAFT - PARTS LIST

Item #	Part #	Description	Qty
	78628-11	Shaft Assembly, R90 (Includes all parts)	
	78628-12	Shaft Assembly, R70 (Includes all parts)	
1	70430-01	Electrode, High Flex	1
2	78626-00	Seal Cartridge Non-Adj., Assembly	1
3	78627-04	Shaft Assembly, 2-Piece Needle, R90	1
	78627-05	Shaft Assembly, 2-Piece Needle, R70	1
4	18842-01	Tube, Packing, R90	1
	18842-02	Tube, Packing, R70	1
5	78629-00	Retainer, Needle Seal, Rear	1
6	79001-06	O-Ring, Solvent Proof	1
7	78630-00	Spacer, Seal	1
8	10051-05	Cup Seal, Spring Loaded	1
9	78631-00	Nut, Packing	1
10	78632-00	Nut, Locking Trigger Adjustment	1
11	78633-00	Spring, Retainer, Needle Shaft	1
12	78636-00	Spring	1



Ransburg Technical/Service Assistance  
 800/ 233-3366  
[www.ransburg.com](http://www.ransburg.com)

(Technical Support Representative will direct you to the appropriate telephone number for ordering Spare Parts.)



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