

Technical Bulletin

Bulletin No	10	2014-01	Issued: 021914	Revised:	Page 1 of 1
Equipment	1-Gallon Bail-O-Matic				
Topic	Updated Can Escapement Assemblies				

Issues: **Excess wear of escapement assemblies, causing poor operation, resulting in can and label damage.**

1. The escapement cylinder rod bushing wears out prematurely due to a lack of cylinder rod guiding, and the cylinder fails to operate adequately.
2. The escapement arm becomes wobbly, and causes damage to cans and labels, from rough operation.
The escapement arm pivot shoulder screw thread becomes loose and worn, from wobbly arm.
The shoulder screw cannot remain tight once the tapped hole is damaged.
3. A missing or damaged Needle Valve, can prevent proper speed control.

Remedy: **Replace the entire Escapement Assembly with an updated version, to correct all issues. (Recommended)**
(Assy. # 10.003.001 for Model D, Assy. # 10.003.002 for Model DS)

Or

Install individual parts as described below, to repair as needed.

1. Install Guide and Nose on a new Escapement Cylinder. The guide and nose prevent wear to the cylinder rod bushing.
2. Install the hardened Shaft, updated Escapement Arm, 2 Needle Bearings, 2 bronze Thrust Washers, and Clamp Collar. If threaded hole is damaged, repair, or replace the Escapement Bracket (Base).
The updated arm with needle bearings, hardened pivot shaft, etc., provides smoother pivoting control.
3. The Needle Valve is key to controlling the speed at which the arm actuates and returns. If missing or damaged, replace.

Setup Criteria

1. Mount the Nose on the cylinder rod end, until the cylinder rod bottoms out against the roll pin in the nose.
2. Install the bronze Guide over the cylinder's neck-mount thread, until it bottoms out, and tightens against the end of the thread.
3. Replace the older shoulder screw with the hardened stud. Position one bronze thrust washer below, and one above the escapement pivot arm. Install the clamp collar to retain the washers, and arm. Position the collar so there is very minimal vertical play of the pivot arm, and it pivots freely.

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Escapement Model D

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	00419	AIR CYLINDER	1
2	00814	STRIKER PAD	1
3	00819A	AIR TRIGGER ASSEMBLY	1
4	00830	BUMPER	1
5	01911-02	ESCAPEMENT ARM	1
6	01919	ESCAPEMENT BRACKET	1
7	00121	ROLLER	2
8	00922-01	BEARING-NEEDLE	1
9	00922-02	BEARING-NEEDLE	1
10	01106	GUIDE	1
11	01107	NOSE	1
12	01154	SHAFT	1
13	20697	THRUST WASHER	2
14	25145	COLLAR - 1 PC CLAMP	1
15	01010+	SPRING-EXTENSION	1
16	02040	VALVE NEEDLE	1

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Escapement Model DS

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	00419	AIR CYLINDER	1
2	00814	STRIKER PAD	1
3	00830	BUMPER	1
4	01911-02	ESCAPEMENT ARM	1
5	01919	ESCAPEMENT BRACKET	1
6	00121	ROLLER	2
7	00922-01	BEARING-NEEDLE	1
8	00922-02	BEARING-NEEDLE	1
9	01106	GUIDE	1
10	01107	NOSE	1
11	01154	SHAFT	1
12	20697	THRUST WASHER	2
13	25145	COLLAR - 1 PC CLAMP	1
14	01010+	SPRING-EXTENSION	1
15	02040	VALVE NEEDLE	1

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