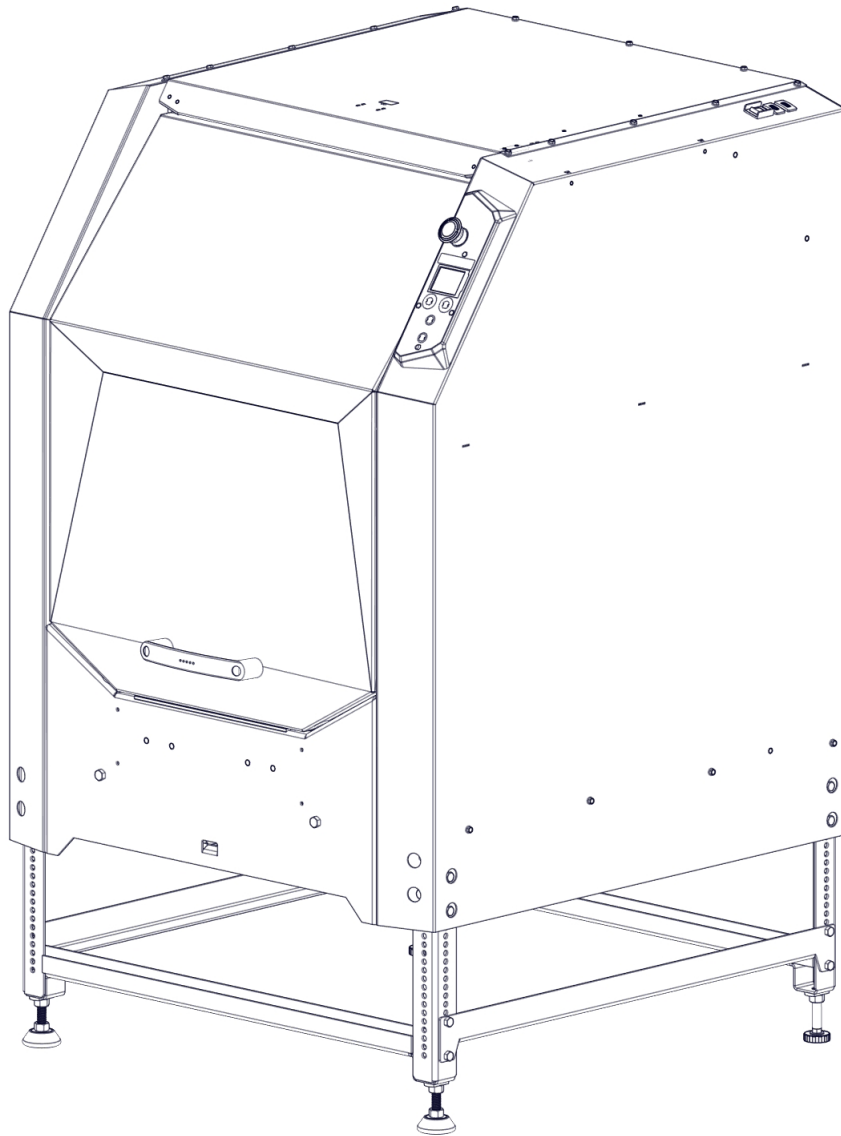


Owner's Manual: Autogyro

Auto Gyro Mixer

09025 Models



RADIA®




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1. Safety Information

Review this owner's manual and read all warning labels on the machine prior to use.

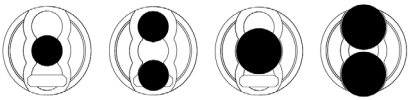
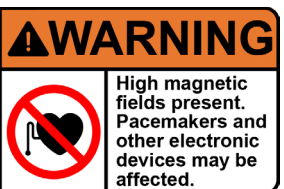
The three main safety notifications used in this manual and on the warning labels are **WARNING**, **CAUTION** and **NOTICE**. They have specific meanings and indicate the potential dangers from misuse of the machine.

	<p>"WARNING!" indicates a hazardous situation, which, if not avoided, could result in death or serious injury. These serious injuries could include permanent loss of function or significant disfigurement, disability, considerable pain and suffering, amputations, severe burns, and loss or impairment of vision or hearing. Take all necessary precautions to avoid unnecessary injury.</p>
	<p>"CAUTION!" indicates a hazardous situation, which, if not avoided, could result in minor or moderate injury.</p>
	<p>"NOTICE" indicates practices that do not involve physical injury but may damage the machine.</p>

1.1 Safety Precaution Labels

	<p>MOVING PARTS INSIDE PARTES EN MOVIMIENTO PIE'CES EN MOVEMENT</p>
<p>-Do not open door until machine comes to complete stop; moving parts inside could cause serious injury. -No abra la puerta hasta que la maquina se detenga completamente, las partes internas en movimiento pueden causar heridas graves. - Ne pas ouvrir la porte avant que la machine ne s'arrête complètement. Pièces en mouvement à l'intérieur pourraient provoquer des blessures graves.</p>	


Part No. 1784963

 <p>1 Quart 2 Quarts 1 Gallon 2 Gallons</p>	
---	---

Part No. 1788787

Safety Information, Continued..

1.1 Safety Precaution labels

 WARNING ADVERTENCIA CUIDADO
<p>-This machine is not explosion proof rated.</p> <p>-Review product label, Material Safety Data Sheet, and HMIS rating of materials and exposures prior to mixing to determine potential hazards.</p> <p>-Use in dry and well-ventilated environment where dust and flammable vapors are not present; risk of physical injury exists if used in hazardous environment.</p> <p>-All containers must be properly sealed and void of leaks.</p> <p>-Esta máquina no tiene la clasificación de prueba de explosión.</p> <p>- Revise la etiqueta del producto, la hoja informativa de datos de seguridad, su clasificación HMIS antes de mezclar y exposiciones de materiales peligrosos para determinar los peligros potenciales.</p> <p>-Use en un ambiente seco y bien ventilado donde polvo y vapores inflamables no estén presentes; Riesgo de daño físico existe si es utilizado en un ambiente peligrosos.</p> <p>-Todos los contenedores deben estar bien sellados y sin fugas.</p> <p>-Esta máquina não está classificada como sendo à prova de explosão.</p> <p>-Ler o rótulo do produto, a ficha de informações de segurança do produto e a classificação HMIS dos materiais antes de misturar para determinar os riscos potenciais.</p> <p>-Usar em ambiente seco e bem ventilado onde não existam poeira e vapores inflamáveis presentes; existe risco de ferimento físico se for usada em ambientes perigosos.</p> <p>-Todos os recipientes devem estar vedados corretamente para evitar vazamentos.</p>

Part No. 1780899















 WARNING ADVERTENCIA AVERTISSEMENT
<p>-Machine must be properly grounded before use; improper grounding could cause electric shock and injury.</p> <p>-Disconnect power cord before servicing, cleaning, or removing any covers, and follow lockout/tagout procedures in owner's manual; failure to disconnect power could cause electric shock and injury.</p> <p>-Review Owner's Manual before installing or operating.</p> <p>-La maquinaria debe ser apoyada correctamente en el suelo antes de usar, el no apoyarla puede causar choque eléctrico y daños.</p> <p>-Desconecte la energía antes de dar mantenimiento, limpiar o quitar cualquier cubierta, y siga los procedimientos de bloqueo/etiquetado del manual, Fallar en desconectar puede causar choque eléctrico y daños.</p> <p>-Revise el manual del usuario antes de instalar u operar.</p> <p>-La machine doit être correctement mise à la terre avant de les utiliser mise à la terre incorrecte peut provoquer un choc électrique et de blessure.</p> <p>-De'branchez le cordon d'alimentation avant de procéder à l'entretien, le nettoyage ou le retrait des capots; suivez la procédure d'isolation/consignation procédures dans le manuel de l'opérateur; E'chec de de'brancher la source d'alimentation peut provoquer shockand électrique blessures.</p> <p>-Re'examiner le fonctionnement manuel avant l'installation.</p>

Part No. 1781570






Safety Information, Continued..

1.2 Safety Precaution Summary


WARNING!

-  Review this owner's manuals before installing or operating.
-  The machine must be properly grounded prior to use. In case of electrical short circuit grounding reduces the risk of electric shock by providing an escape wire for the electric current.
-  If you must repair or replace the power cord or plug, **DO NOT** connect the grounding wire to either flat-blade terminal. The wire with insulating having an outer surface that is green (with or without yellow stripes) is the grounding wire.
-  Check with a qualified electrician if you don't completely understand these grounding instructions, or if you are not sure whether the machine is properly grounded. **DO NOT** Modify the plug provided; if it won't fit in the outlet, have a proper outlet installed by a qualified electrician.
-  Disconnect the power cord before servicing, cleaning, or removing and covers.
-  Follow the lockout/tagout producers of your company.
-  Do not use the machine in a damp or wet environment. Keep the work area well lit.
-  Do not open the door until the machine comes to a complete stop.
-  To avoid electric shock, don't get the timer, control panel, or wiring wet.
-  This machine is not explosion proof rated.
-  All containers must be properly sealed and void of leaks.
-  Review product label, Material Safety Data Sheet, and HMIS rating of material prior to mixing to determine potential hazards.
-  Do not use solvent-based cleaners or thinners
-  Use in a dry and well-ventilated environment where dust ad flammable vapor are not present.

CAUTION!

-  Keep the work area free of clutter and electrical cords.
-  Avoid extension cords. To minimize the risk of improper electrical grounding, extension cords are not recommended. If an extension cords are not recommended. If an extension cord is unavoidable, consult a qualified electrician to determine what type of extension cord will satisfy the grounding, current capacity, and other requirements of the particular situation.
-  Use the proper power source. Refer to the machine data plate on the right side panel or the section 2.1 Specifications in this manual.
-  Keep customers away from the work area. This machine should be used only by properly trained individuals.
-  Do not operate the machine without a can installed.

Product safety labels should be inspected and cleaned periodically to maintain good legibility. Replace any labels that are no longer legible.

 **WARNING: This product may expose you to chemicals including DEHP, which is known to the State of California to cause cancer. For more information, go to www.P65Warnings.ca.gov**

2. Introduction

2.1 Application

Congratulations on your purchase of the 09025 Auto Gyro Mixer. This machine is designed to accommodate standard five-gallon plastic or metal pails weighing up to 120 lb. (54.4 kg), one gallon cans, quart cans, and containers up to 18" tall.

Understand your machine's features and proper operation to take full advantage of its capabilities.

Read this entire manual completely before operating the machine. Practice installing and removing a pail before mixing for the first time.

Keep this manual for future reference.

Always follow all safety instructions!

NOTE: This equipment has been tested and found to comply with the limits for a Class A digital device, pursuant to part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference when the equipment is operated in a commercial environment. This equipment generates, uses, and can radiate radio frequency energy and, if not installed and used in accordance with the instruction manual, may cause harmful interference to radio communications. Operation of this equipment in a residential area may cause harmful interference in which case the user will be required to correct the interference at his own expense."

Contains Transmitter Module FCC ID: MCQ-XB3M1 & Canadian ID: IC:1846A-XB3M1

2.2 Specifications

Model 09025 (Standard)

Model 09025A (Automation)

Unit Size: **W** 34 in. (86 cm) **D** 44.4 in. (112.8 cm)

H Adjustable 48 in. (122 cm) - 53.7 in. (136 cm)

Weight: 460 lb.

Electric Service: 90-264 V 50-60 Hz

Capacity: 120 lb. (54.4 kg)

Sizes Mixed:

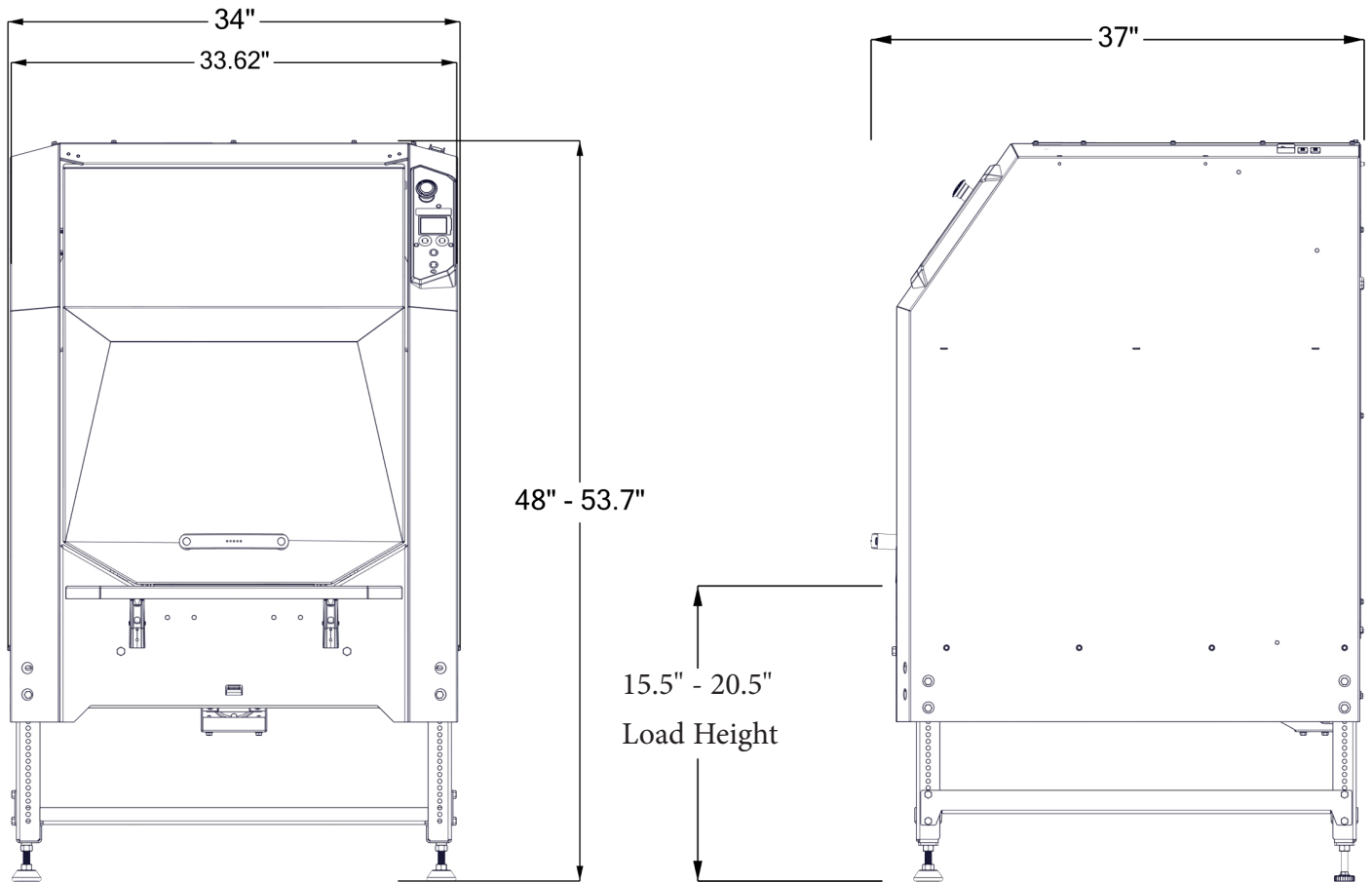
- 1 or 2 quart cans at a time
- 1 or 2 one gallon cans at a time
- 1 5 gallon plastic or metal can
- Maximum can height 18" – to handle metric cans up to 27 liter.

Note: must have standard diameter can bottoms.

Load Height: Adjustable 15.5 in. (39.4 cm) - 20.5 in. (52.1 cm)

3. Installation

MODEL 9025



3.1 Prepare for Use

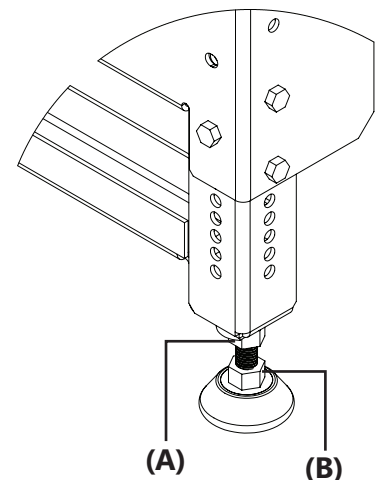
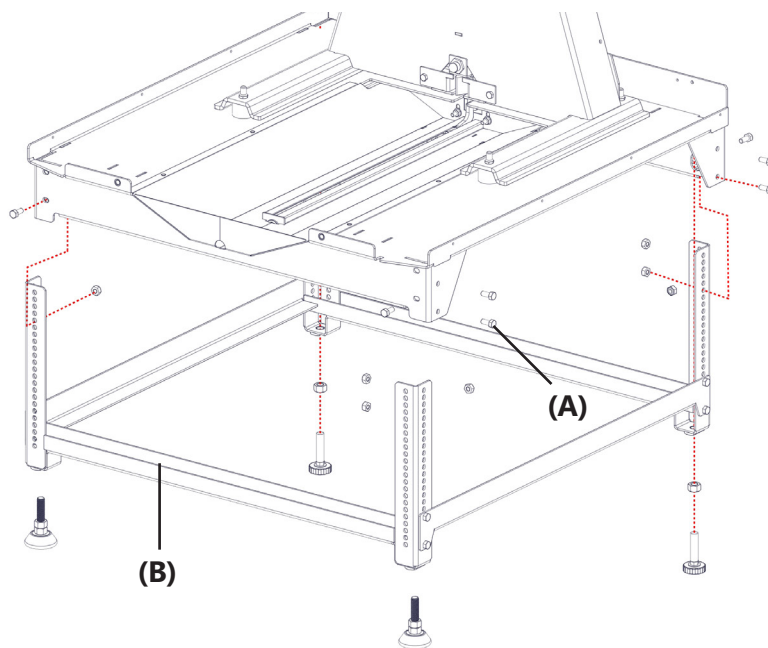
IMPORTANT: Before attempting to operate the machine:

1. Remove all packaging material.
2. Position the machine on a firm, level surface.
3. Follow the electrical connection instructions described above.

3.2 Adjust the Risers (overall height)

⚠ Avoid personal injury! Be sure the machine is stable.

1. Loosen the screws **(A)**.
2. Adjust the crossbar **(B)** to the appropriate height.
3. Retighten the screws.



3.3 Verify the Machine is Level

Adjust any feet under which a piece of paper can fit.

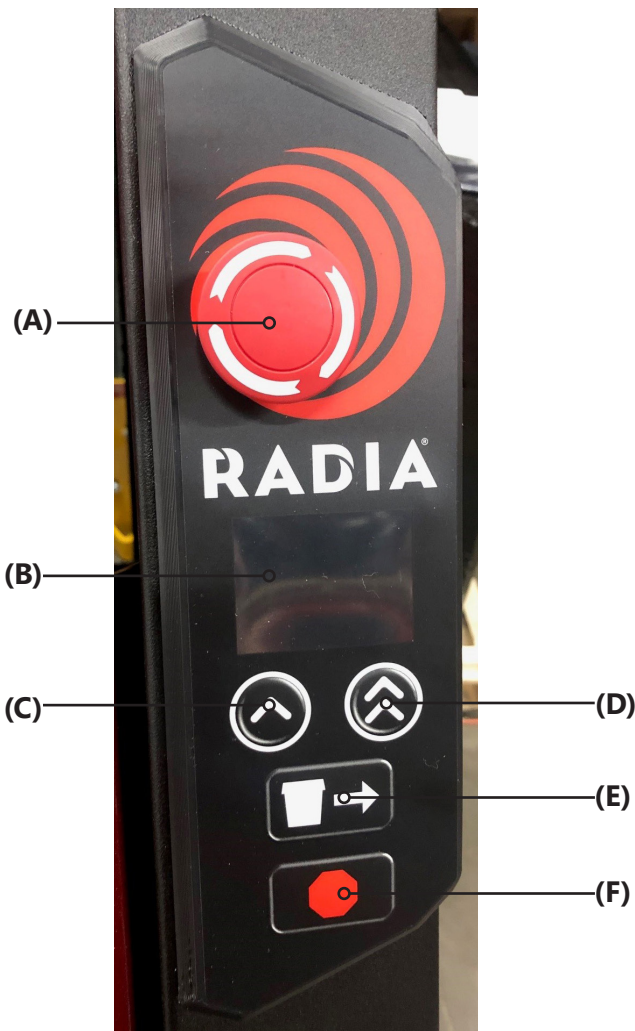
- A.** Loosen the upper jam nut **(A)**
- B.** Turn the foot **(B)** to adjust.
- C.** Tighten the jam nut **(A)** when the feet make full contact with the floor

Repeat with any additional feet that may still need to be adjusted.

4. Operation

4.1 Control Panel

- **E-Stop Push Button (A):** Immediately cuts power to the machine, and Cycles Power.
- **Display (B):** View programming revision, Cycle count, and cycle time remaining.
- **Two-Minute Cycle (C):** Push to set a two-minute cycle, and to increase a cycle in 30 second increments. Note: Can be set to 90 seconds.
- **Three-Minute Cycle (D):** Push to set a three-minute cycle, and to increase a cycle in one minute increments. Note: Can be set to 2 minutes.
- **Extract (E):** Push to extract only 5 Gallon buckets after mixing is complete.
- **Stop (F):** Push to stop the cycle. Any remaining cycle time will be deleted.



On-Off Switch



..Operation, Continued

4.2 Install and Remove Pail

INSTALL:

Warning!


Avoid serious personal injury. Do not mix flammable or combustible materials in this mixer.

1. Open the machine door.
2. Slide the pail under the clamping (top) plate.
3. Position the pail in the grooves on the bottom plate. The grooves on the plate keep the pail in place during mixing.
4. Close the door and start the machine.

NOTICE

The door is locked during mixing.

REMOVAL:

 **WARNING:** Avoid serious personal injury! Do not attempt to override the door lock.

The Door Lock will prevent opening the door while the machine is mixing.

Remove the pail(s) by hand or by pressing the Extract button (only for 5 gallon buckets).



5. Care and Maintenance

⚠ WARNING! Avoid serious personal injury. Always unplug the power cord before performing maintenance tasks.

5.1 Cleaning

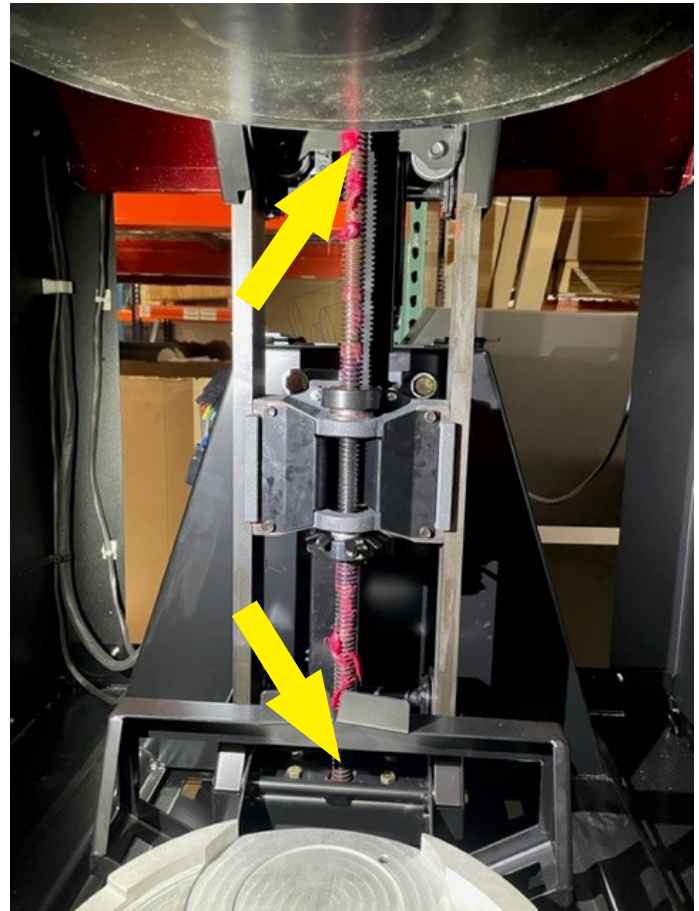
⚠ Avoid serious personal injury. Do not use solvent-based cleaners or thinners, or other combustible cleaners.

- Keeping the machine clean is important for reliable operation.
- Remove water-based/glycol colorants or base paints spilled on machine surfaces using lukewarm water and mild detergent.
- To preserve the appearance of the machine, do not use abrasives to clean machine surfaces.

5.2 Maintenance

1) Lubricate the clamp screw and Extractor screw every 6 months or as needed with 7784193 Synthetic Grease. This is available in kit #6789740.

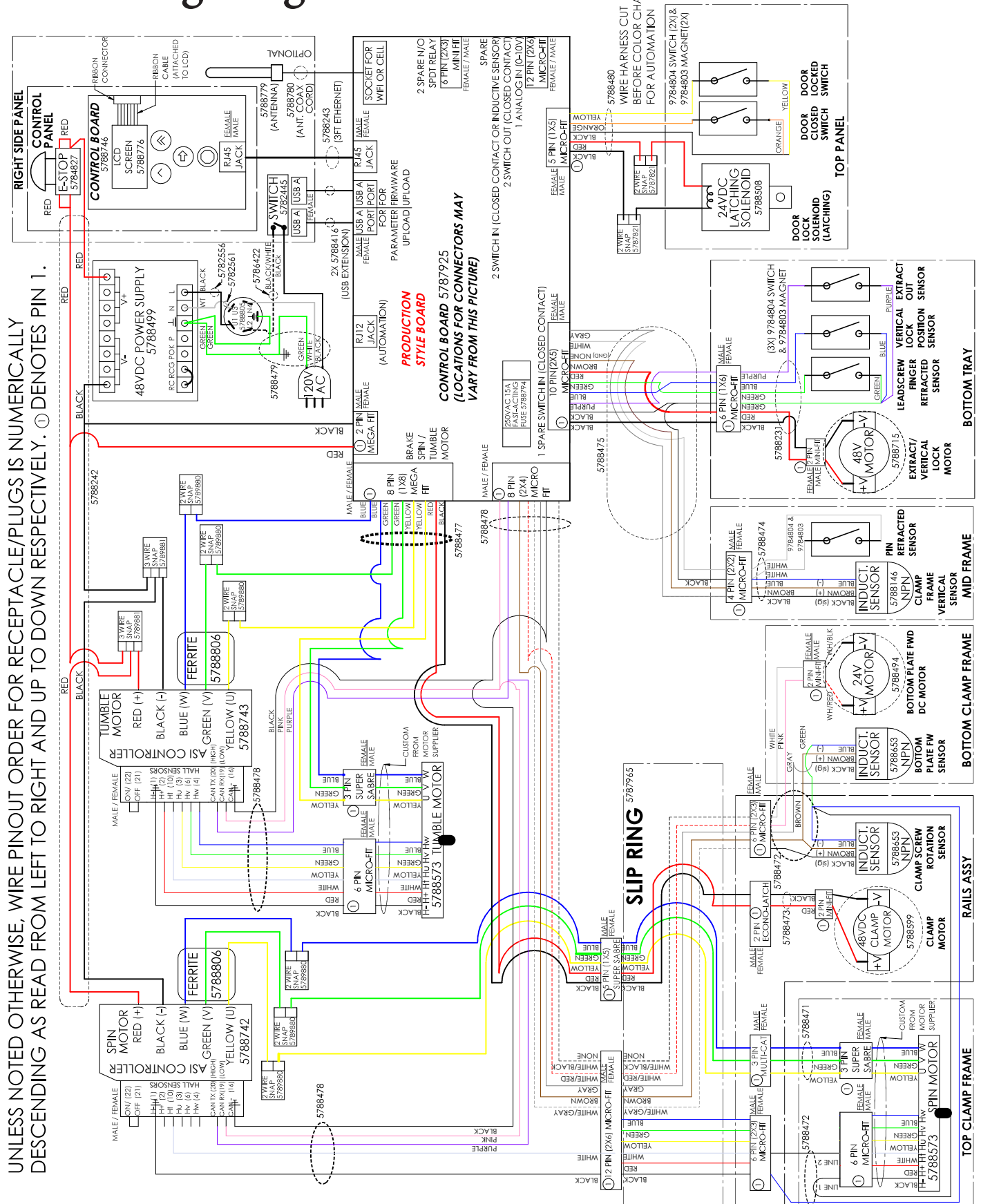
After applying grease, run the machine with a one gallon can to help spread the grease evenly over the entire clamp screw.



6. Troubleshooting

PROBLEM	CAUSE	REMEDY
Machine won't operate	Not connected to power source	Connect to power source
	Emergency E-STOP push button is activated	Turn switch knob 1/4-turn clockwise to disengage
	Machine door does not make contact with limit switch	Adjust switch to make contact with limit switch screw when door is closed
Pail won't fit properly into clamping plates	Pail damaged	Fix or replace pail
Error message	See message displayed	Press the Stop button and turn the machine off/on to clear errors

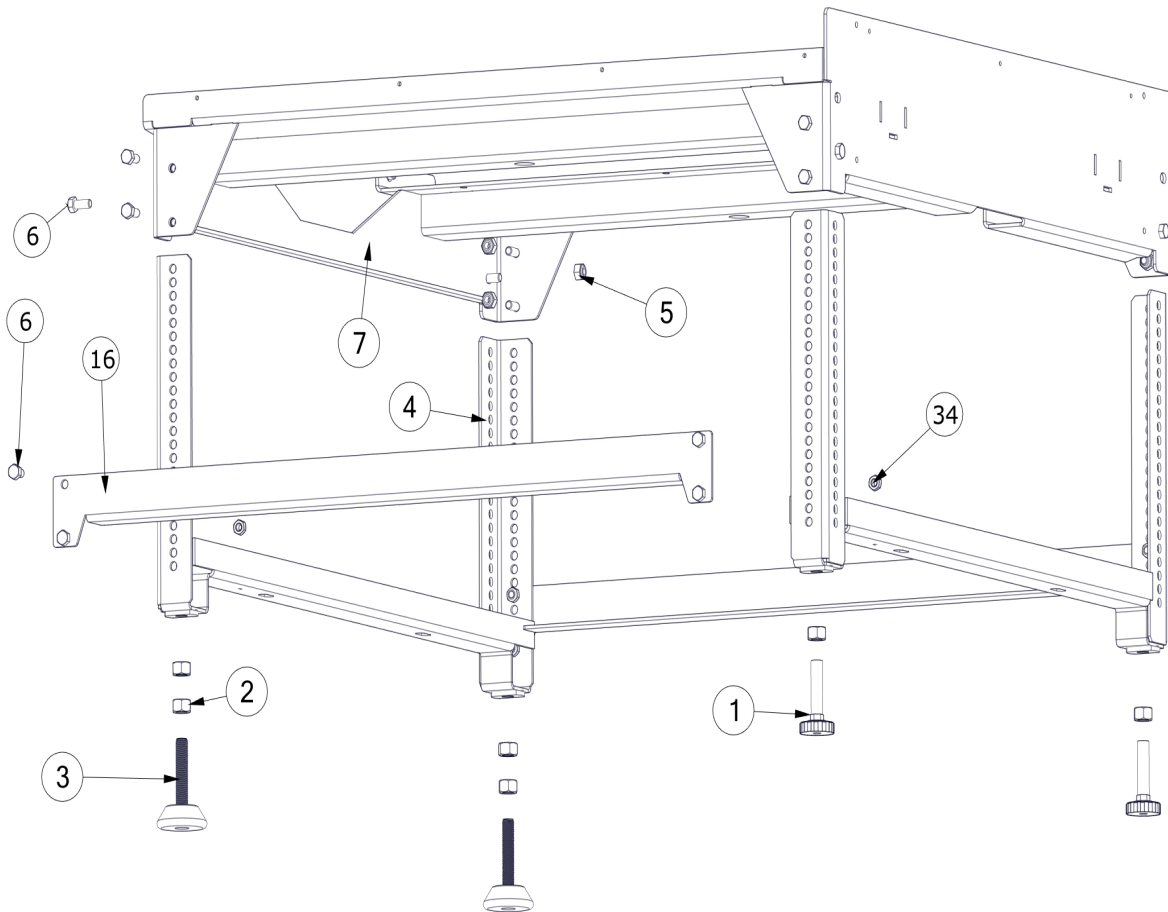
7.1 Wiring Diagram 9025



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8. Exploded Views

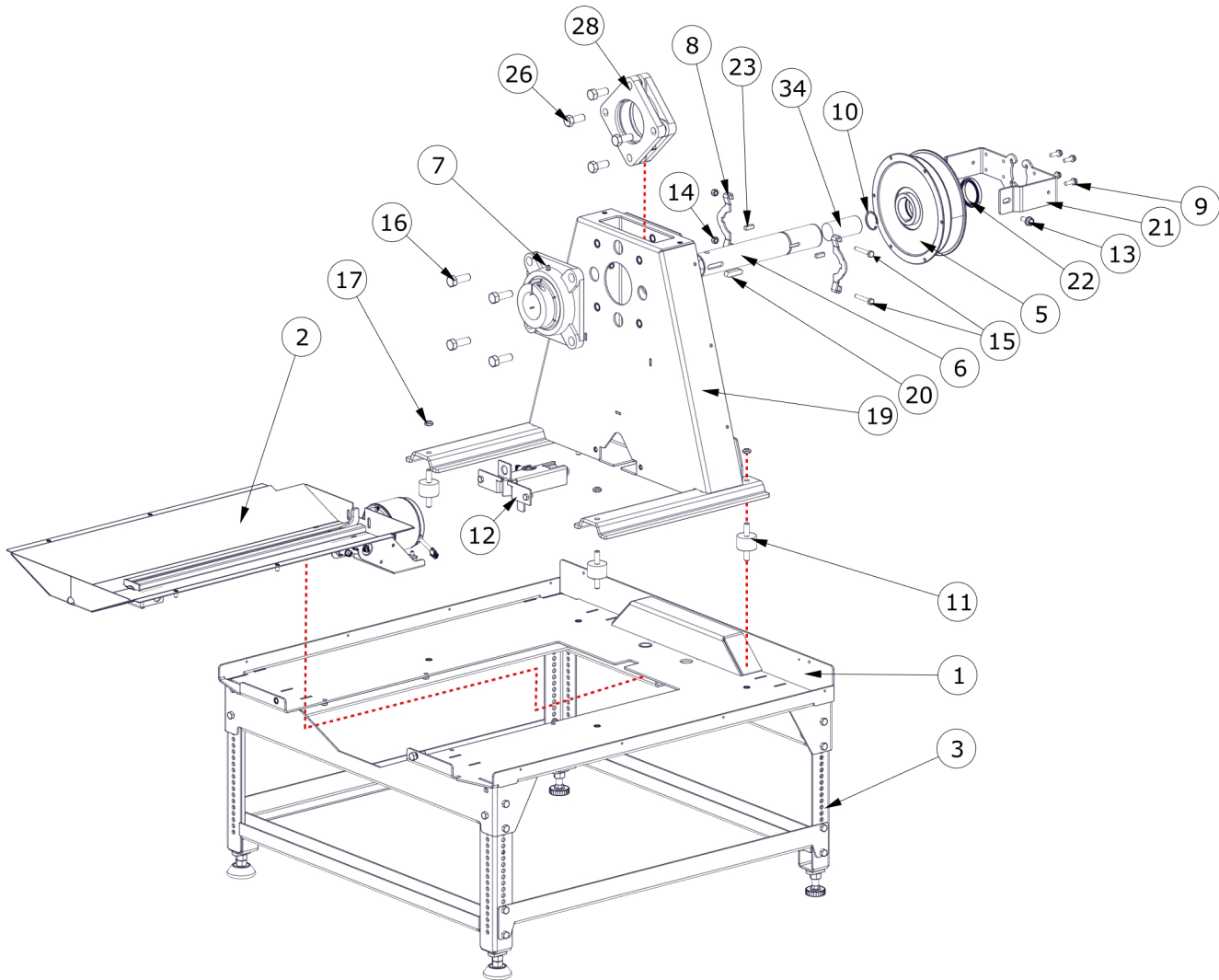
8.1 Riser Legs



BOM ID	Description
1	9785721 FOOT, GLIDER
2	9781711 NUT, HEX 1/2-13
3	9785722 FOOT, NON SKID, LEVELING
4	9788069 LEG WELDMENT
5	9780182 NUT, NYLOCK 5/16-18 ZINC
6	9788084 SCREW HEX HEAD 5/16-18 X 0.75 GR8 ZP PATCH
7	9788632 WELDMENT, BASE, AUTOCLAMP GYRO
16	9788890 LEG, SIDE CROSS, 9025
34	9781493 9781493 NUT, NYLON JAM 5/16-18

...Exploded Views, Continued

8.2 Base

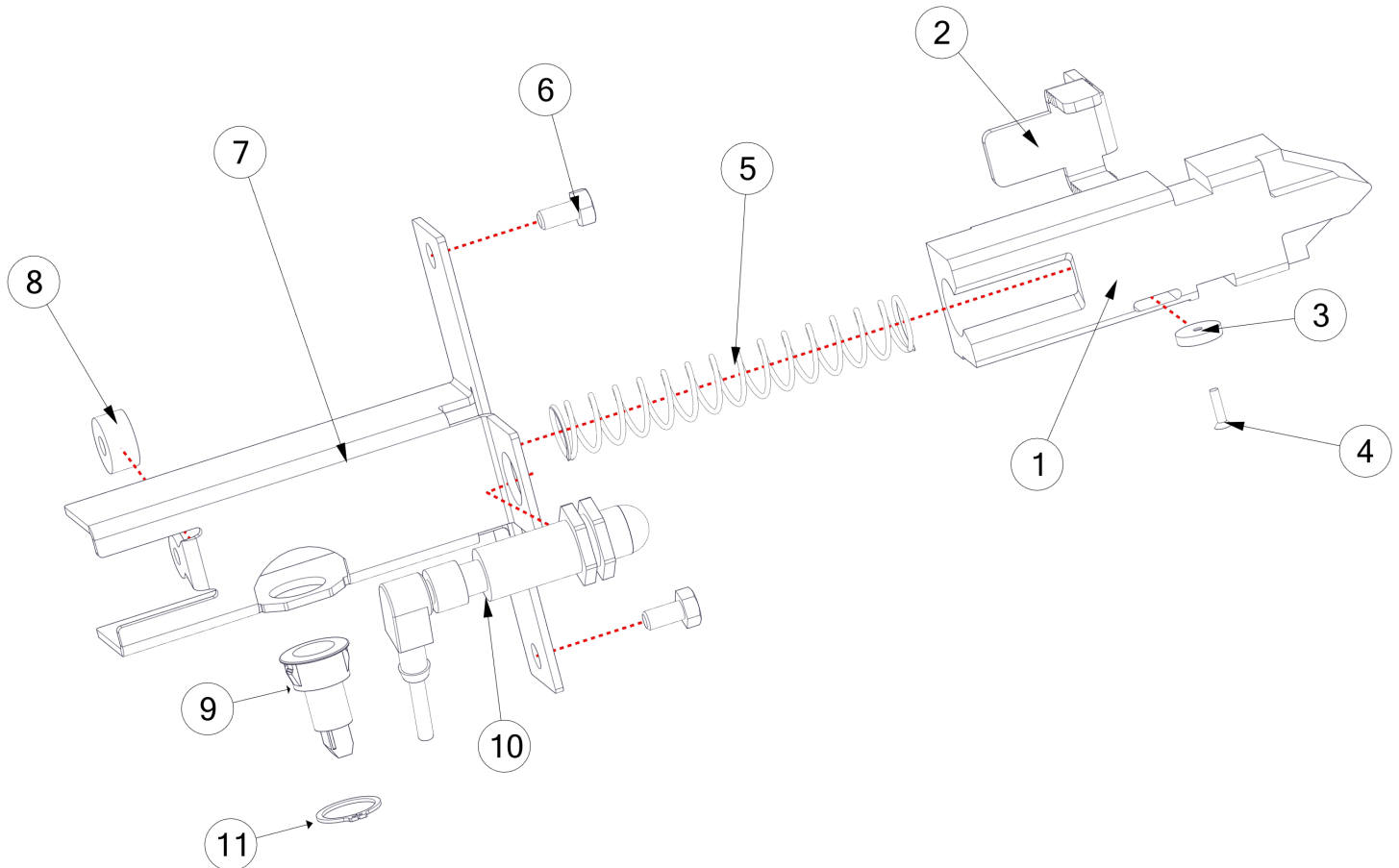


BOM ID	PART #	DESCRIPTION	BOM ID	PART #	DESCRIPTION
1	9788632	WELDMENT, BASE, AUTOCLAMP GYRO	15	9781620	SCREW, HEX HD 1/4-20X13/4 GR5 ZINC
2		EXTRACTOR BOTTOM SEE 8.4	16	9782154	SCREW, HEX HD 1/2-13X11/2 GR8 ZINC
3		RISER ASSEMBLY SEE 8.1	17	9783951	NUT, NYLOCK 3/8-16 ZINC, SHORT
5	5788573	MOTOR, DRIVE, AUTOGYRO (use kit for replacement)	19	9788694	WELDMENT, MID FRAME, AUTOGYRO
6	9787983	SHAFT, MAIN, AUTOGYRO	20	9788451	3/8 X 3/8 X 1.5 ROUND END KEY
7	9789800	BEARING, FLANGED, 2.1875 ID	21	9788862	MOUNT, MOTOR, SIDES, 9025
8	9788553	THIN CLAMP COLLAR, AUTOGYRO	22	9788147	BEARING, 6809, 45MM ID
9	9788697	SCREW, SFHH 1/4-20X3/4 GR5 ZINC	23	9788642	KEY, 1/4 X 1/4 X .625
10	9788682	RETAINING RING, INTERNAL, 35MM	26	9788042	SCREW HEX HD 1/2-13 X 1.25 GR5 ZP PATCH
11	9788503	ISOLATOR, STUD- STUD, 1.50 DIA X 1.00 TALL	28	9788535	BEARING, FLANGE, 45MM ID
12		VERTICAL LOCK ASSEMBLY SEE 8.3	34	5787965	SLIP RING, CUSTOM
13	9788708	SCREW, SFHH 5/16-18 X .75		6789703	TUMBLE MOTOR KIT (INCLUDES 5, 9, 13, 22, 23, wire tie wraps(not shown))
14	9780343	NUT, NYLOCK 1/4-20, ZINC			

PART NUMBERS LISTED MAY ONLY BE AVAILABLE IN KIT FORM OR AS AN ASSEMBLY
 Exploded Views, Continued...

...Exploded Views, Continued

8.3 Vertical Lock



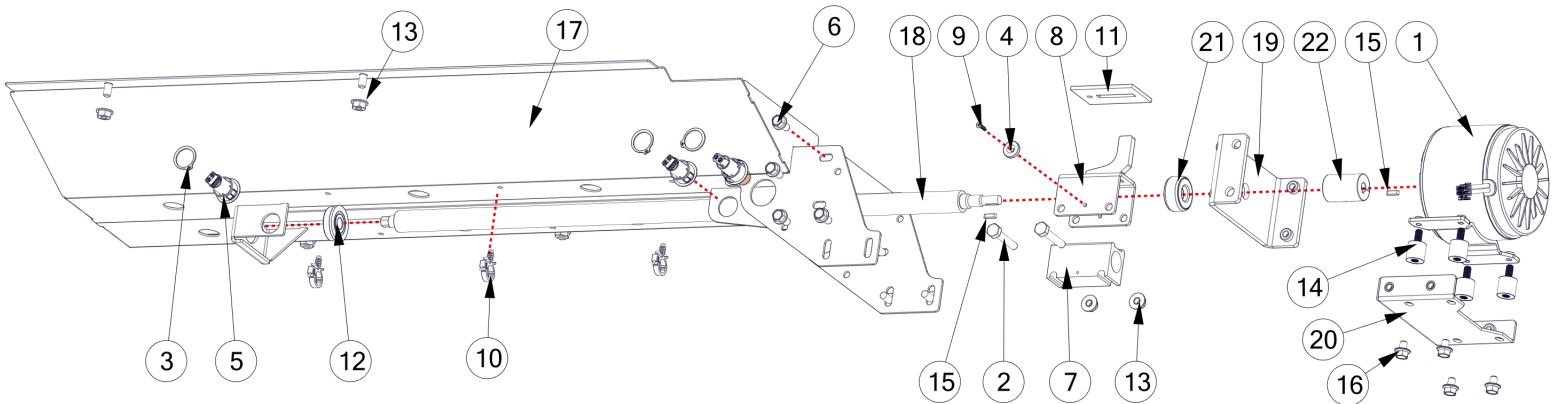
BOM ID	Description
1	9788640 LATCH, VERTICAL LOCK, BASE, MALE
2	9788662 RETRACTOR, VERTICAL LOCK
3	9784803 SWITCH, MAGNET
4	9789459 SCREW, FL HD, #4 X .375, PLASTIC TAPPING - FOR #44 HOLE
5	9788664 SPRING, VERT LATCH
6	9788087 SCREW HEX HD 5/16-18 X 0.50 -PATCH
7	9788660 BRACKET, LATCH, BASE
8	9788663 SPACER, .75 OD, LDPE
9	9784804 SWITCH, MAGNETIC
10	5788146 SENSOR, 18MM X 8MM SENSING
11	9784416 3/4 EXTERNAL RETAINING RING

PART NUMBERS LISTED MAY ONLY BE AVAILABLE IN KIT FORM OR AS AN ASSEMBLY

Exploded Views, Continued...

...Exploded Views, Continued

8.4 Bottom Tray



BOM ID	Part Number	Description
1	5788715	EXTRACTOR MOTOR, AUTOGYRO
2	9780353	SCREW, HEX HD 1/4-20 X 1 1/2 GR5 ZINC
3	9784416	3/4 EXTERNAL RETAINING RING
4	9784803	Switch Magnet
5	9784804	SWITCH, MAGNETIC
6	9785779	SCREW, SFHH 1/4-20X1/2 GR5 ZINC
7	9788614	NUT, ACME, RH, EXTRACTOR, 3/4-8
8	9788615	EXTRACTOR ARM
9	9788680	SCREW, FL HD, #4 X .5, PLASTIC TAPPING - FOR #44 HOLE
10	9788691	CABLE CLAMP, PUSH IN, .5 DIA
11	9788723	WEAR PAD, EXTRACTOR
12	9788726	BEARING, FLANGED

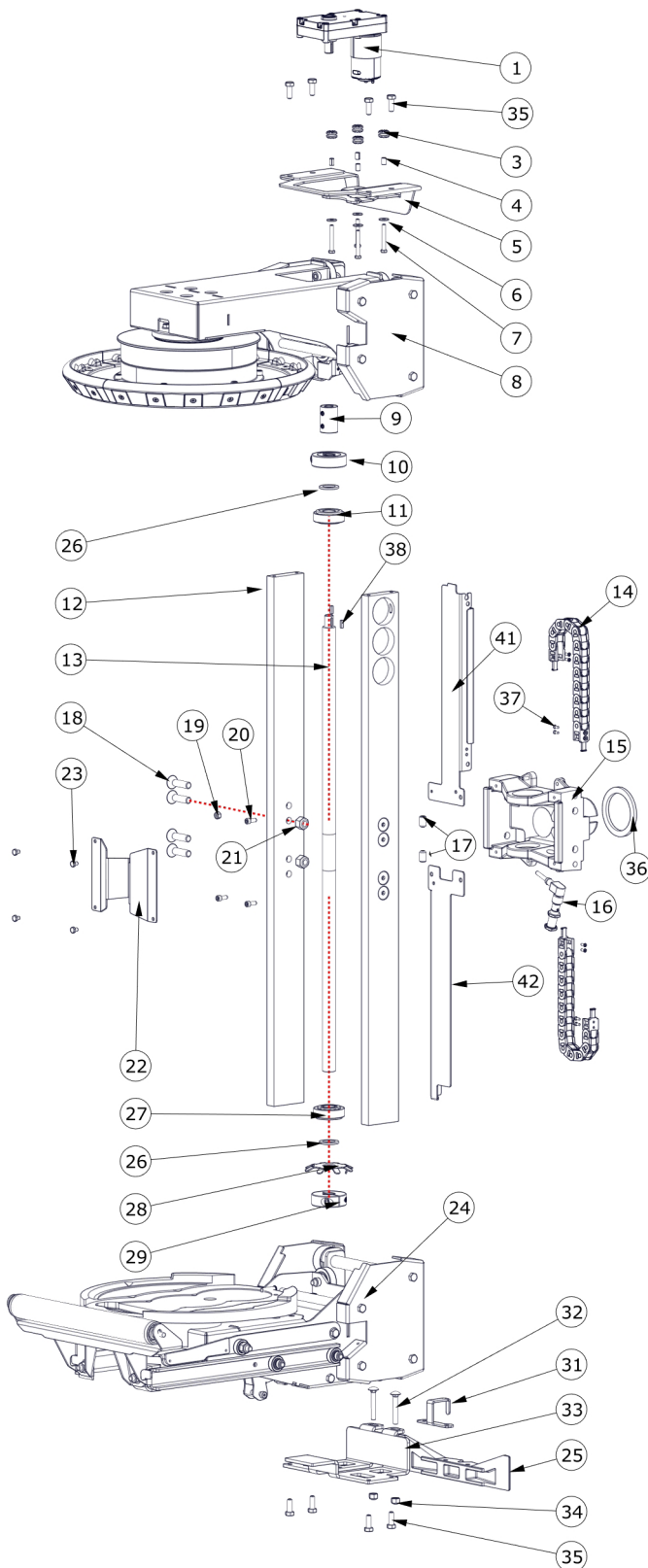
BOM ID	Part Number	Description
13	9788741	NUT, HEX, FLANGED SERRATED 1/4-20, GR 5
14	9788724	ISOLATOR, .625OD X .625, M6
15	9788749	KEY, 3mm SQUARE
16	9788785	SCREW, HEX HD, FLANGED, M6-1.0 X 8mm
17	9788821	TRAY, BOTTOM, AUTOGYRO
18	9788825	SHAFT, ACME, EXTRACTOR, DUAL START
19	9788826	BRACKET, BEARING, EXTRACTOR
20	9788831	MOTOR MOUNT, EXTRACTOR
21	9788834	BEARING, THRUST, .500 ID
22	9788837	COUPLING, 8MM, KEYED CLAMP-ON

PART NUMBERS LISTED MAY ONLY BE AVAILABLE IN KIT FORM OR AS AN ASSEMBLY

Exploded Views, Continued...

...Exploded Views, Continued

8.5 Clamp Frame



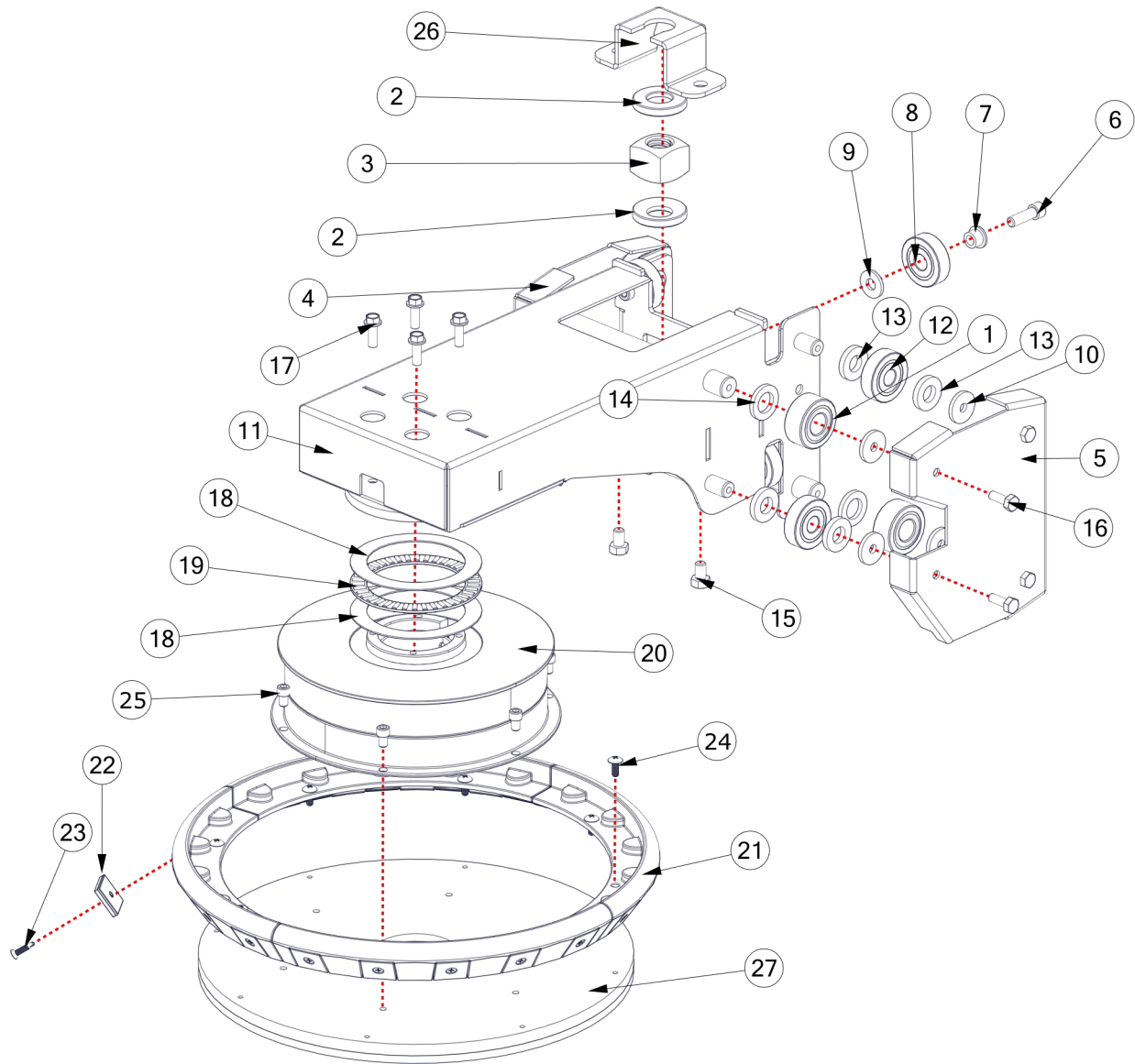
BOM ID	PART #	DESCRIPTION
1	5788599	MOTOR, CLAMP, 200 RPM
3	9788656	GROMMET, .28ID, .12 TH PLATE
4	9788657	SPACER, #10, .25OD, .375 LG
5	9788645	SUPPORT, MOTOR, AUTOGYRO
6	9780749	WASHER, FLAT #10 USS ZINC
7	9788328	SCREW, HEX HD 10-32X1.5
8	See section 8.6	See section 8.6
9	9788262	COUPLING, .50 SHAFT, SOLID
10	9788014	ACME CLAMP-ON COLLAR, LH
11	9788097	BEARING, TAPER ROLLER, .75 ID
12	9788603	GUIDE BAR, CLAMP FRAME, AUTOGYRO
13	9788010	CLAMP SCREW, .75-6, AUTOGYRO
14	9788030	CABLE TRAY, FEXIBLE
15	8788643	SUPPORT, MAIN, CLAMP FRAME, AUTOGYRO
16	5788653	SENSOR, INDUCTIVE, M12 BODY, M12 CONN, 4MM RANGE
17	9788469	SCREW, SET 3/8-16 X 5/8 CUP PT, PATCH
18	9788559	SCREW, FL HD, SOC, 3/8-16 X 1 1/2
19	9785126	NUT, NYLOCK 8-32 ZINC
20	9784861	SCREW, TORX HD 10/32 X 1/2
21	9780193	NUT, NYLOCK 3/8-16 ZINC
22	9788650	WIRE GUARD
23	9788517	SCREW, HEX HD, FLANGED, 10-32 X 0.5, BLACK
24	See section 8.7 or 8.8	See section 8.7 or 8.8
25	9789685	LATCH, VERTICAL LOCK, CLAMP FRAME, FEMALE
26	9788098	WASHER, FLAT .75ID X 1.125OD X .093THK
27	9788097	BEARING, TAPER ROLLER, .75 ID
28	9788649	BRACKET, FINGERS
29	9788013	ACME CLAMP-ON COLLAR, .75, RH
31	9788678	VERT LOCK SENSOR PROX FINGER
32	9788677	BOLT, CARR, 1/4-20 X 1.75, ZINC
33	9788719	SUPPORT, BOTTOM RAILS
34	9780343	NUT, NYLOCK 1/4-20, ZINC
35	9788088	SCREW HEX HD GR8 1/4-20 X 0.75 -PATCH
36	9789799	SPACER, 2.210 ID X .188 THICK
37	9788739	SCREW, FL HD #4 - 40 X .313
38	9788018	KEY, SQUARE .125 X .438
41	9788637	GUARD, UPPER, AUTOGYRO
42	9788611	GUARD, LOWER, AUTOGYRO
	6789704	Clamp Motor Kit (includes 1, 3, 4, 5, 6, 7, 9, 35, 38)

PART NUMBERS LISTED MAY ONLY BE AVAILABLE IN KIT FORM OR AS AN ASSEMBLY

Exploded Views, Continued...

...Exploded Views, Continued

8.6 Clamp Frame, Top Clamp



BOM ID	PART #	DESCRIPTION
1	9787991	BEARING, DOUBLE ROW, 3203
2	9788095	WASHER, SELF ALIGNING, 3_4IN SCREW, FEMALE
3	9788011	NUT, ACME, RH, RECTANGLE, AUTOGYRO
4	9788607	COVER, WHEELS, RIGHT, AUTOGYRO
5	9788606	COVER, WHEELS, LEFT, AUTOGYRO
6	9784282	SCREW, SOCKET HD 5/16-18 X 1 1/4
7	9788634	BUSHING, BRONZE, FLANGED, .312ID X .50 OD X .38LG
8	9788621	BEARING, BALL, SIDE TIP, AUTOGYRO
9	9100023	WASHER, FLAT 5/16 USS ZINC 4400/50 LBS----3520/40 L
10	9788519	WASHER, .281 ID X 1.00 OD X .120,.130 TH
11	9788602	MACHINED WELDMENT, TOP CLAMP
12	9788621	BEARING, BALL, SIDE TIP, AUTOGYRO
13	9788631	WASHER, THICK, .53 ID
14	9788630	WASHER, 17mm ID

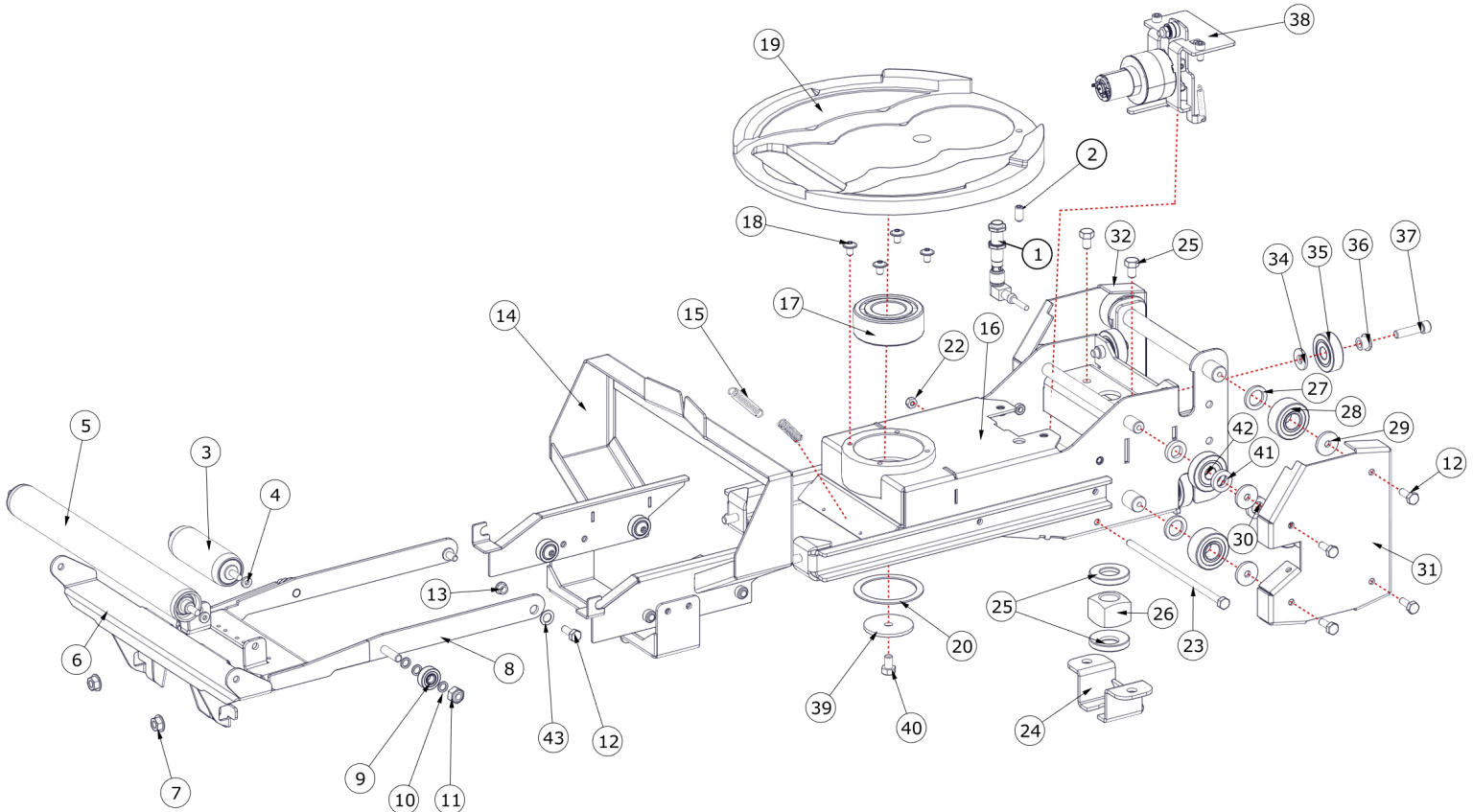
BOM ID	PART #	DESCRIPTION
15	9788087	SCREW HEX HD 5/16-18 X 0.50 -PATCH
16	9788088	SCREW HEX HD GR8 1/4-20 X 0.75 -PATCH
17	9788697	SCREW, SFHH 1/4-20X3/4 GR5 ZINC
18	9788121	WASHER, HARDENED, 75MM ID, 1MM THICK
19	9788111	BEARING, THRUST, NEEDLE, 75MM ID
20	5788573	MOTOR, DRIVE, AUTOGYRO
21	9788579	MAGNET HOLDER
22	9788699	ASSY MAGNET
23	9788675	SCREW, FH, #8 TAPPING 3/4" LG
24	9788545	SCREW, TRUSS HD 10-24 X 1/2 PHILLIPS
25	9788363	SCREW, SOCKET HD 1/4-20X3/8
26	9788577	NUT HOLDER
27	9788745	ASSY, TOP PLATE, 9025
	6789702	Spin Motor kit (includes 17, 18, 19, 20, 25)

PART NUMBERS LISTED MAY ONLY BE AVAILABLE IN KIT FORM OR AS AN ASSEMBLY

Exploded Views, Continued...

...Exploded Views, Continued

8.7 Clamp Frame, Bottom Clamp



BOM ID	PART #	DESCRIPTION
1	5788653	SENSOR, INDUCTIVE, M12 BODY, M12 CONN, 4MM RANGE
2	9788706	SCREW, SET, 5/16-18 X .625, FLAT TIP
3	9788136	MINI ROLLER, AUTOGYRO
4	9785537	Washer, Rubber, .195 ID x 7/16 OD .093THK
5	9782520	ROLLER
6	9788627	ROLLER SUPPORT, ROTATING AUTOGYRO
7	9788740	NUT, HEX, FLANGED SERRATED 5/16-18, GR 5
8	9788628	EXTRACTOR LIFT, ASSY
9	9788213	BALL BEARING 1605-2RS 5/16 ID .906 OD 5/16 THK
10	9788308	SHIM WASHER, 5/16 ID 7/16 OD .062 THK
11	9780182	NUT, NYLOCK 5/16-18 ZINC
12	9788088	SCREW HEX HD 1/4-20 X 0.75 -PATCH
13	9788654	BEARING, BRONZE, FLANGED 1/4 ID 3/8 OD X 1/4 LG
14	9788644	EXTRACTOR, AUTOGYRO
15	9786604	SPRING, EXTENSION, TC15
16	9788601	MACHINED WELDMENT, BOTTOM CLAMP, AUTOGYRO
17	9787872	BEARING, BALL, DUAL ROW, 35MM X 72MM
18	9788497	SCREW, BUTTON HD, FLANGED 1/4-20 X .375
19	9788135	BOTTOM PLATE MACHINED CASTING
20	9788889	WASHER, SPACER, BOT. PLATE, 9025
22	9780343	NUT, NYLOCK 1/4-20, ZINC

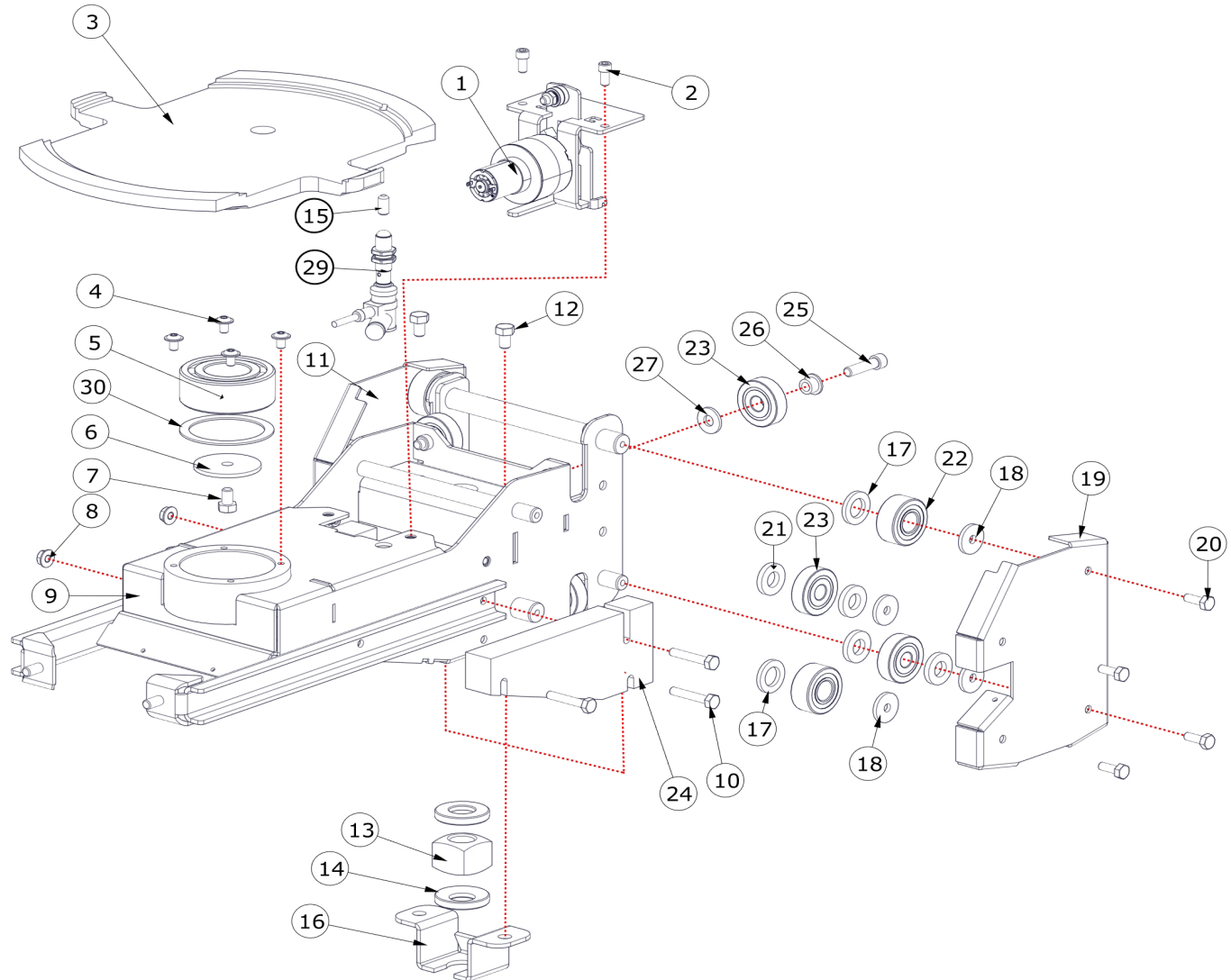
BOM ID	PART #	DESCRIPTION
23	9788652	SCREW, HEX HD 1/4-20 X 7
24	9788577	NUT HOLDER
25	9788095	LEVELING WASHER, .781 ID
26	9788012	NUT, ACME, LH, RECTANGLE, AUTOGYRO
27	9788630	SPACER, CUSTOM, 17MM
28	9787991	BEARING, DOUBLE ROW, 3203
29	9788519	WASHER, .281 ID X 1.00 OD X .120,.130 TH
30	9788631	SPACER, CUSTOM, .53 ID
31	9788607	COVER, WHEELS, RIGHT, AUTOGYRO
32	9788606	COVER, WHEELS, LEFT, AUTOGYRO
34	9100023	WASHER, FLAT HD 5/16 USS ZINC 4400/50 LBS---- 3520/40 L
35	9788621	BEARING, BALL, SIDE TIP, AUTOGYRO
36	9788634	BUSHING, BRONZE, FLANGED, .312ID X .50 OD X .38LG
37	9784282	SCREW, SOCKET HD 5/16-18 X 1 1/4
38	6789221	KIT, FWD LOCK ASSY 9025(See 8.10 for details)
39	9788452	WASHER, FENDER .344 ID X 2 OD X .125 THK
40	9788087	SCREW HEX HD 5/16-18 X 0.50 -PATCH
41	9788631	SPACER, CUSTOM, .53 ID
42	9788621	BEARING, BALL, SIDE TIP, AUTOGYRO
43	9788655	WASHER, SHIM .39" ID .625" OD .035 THK

PART NUMBERS LISTED MAY ONLY BE AVAILABLE IN KIT FORM OR AS AN ASSEMBLY

Exploded Views, Continued...

...Exploded Views, Continued

8.8 Clamp Frame, Automation Bottom Clamp



BOM ID	PART #	DESCRIPTION
1	6789221	KIT, FWD LOCK ASSY 9025 (See 8.10 for details)
2	9788026	SCREW SOCKET HD 1/4-20 X 0.50 - PATCH
3	9788751	BOTTOM PLATE, AUTOMATION, AUTOGYRO
4	9788497	SCREW, BUTTON HD, FLANGED 1/4-20 X .375
5	9787872	BEARING, BALL, DUAL ROW, 35MM X 72MM
6	9788452	WASHER, FENDER .344 ID X 2 OD X .125 THK
7	9788087	SCREW HEX HD 5/16-18 X 0.50 -PATCH
8	9788741	NUT, HEX FLANGED SERRATED 1/4 - 20
9	9788601	MACHINED WELDMNT, BOTTOM CLAMP, AUTOGYRO
10	9780353	SCREW, HEX HD 1/4-20 X 1 1/2 GR5 ZINC
11	9788606	COVER, WHEELS, LEFT, AUTOGYRO
12	9788087	SCREW HEX HD 5/16-18 X 0.50 -PATCH
13	9788012	NUT, ACME, LH, RECTANGLE, AUTOGYRO
14	9788095	WASHER, SELF ALIGNING, 3_4IN SCREW, FEMALE
15	9788706	SCREW, SET, 5/16-18 X .625, FLAT TIP

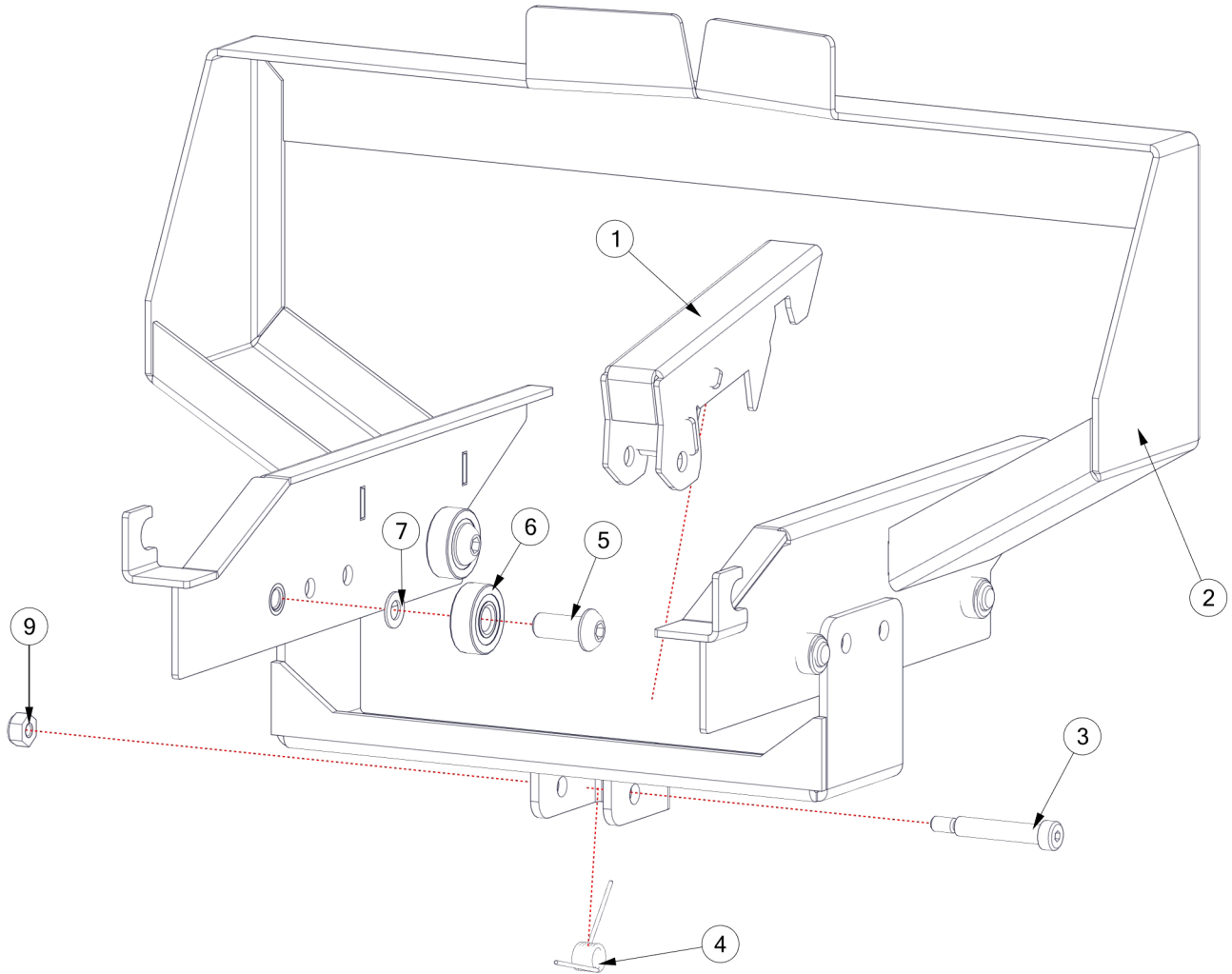
BOM ID	PART #	DESCRIPTION
16	9788577	NUT HOLDER
17	9788630	SPACER, CUSTOM, 17MM
18	9788519	WASHER, .281 ID X 1.00 OD X .120,.130 TH
19	9788607	COVER, WHEELS, RIGHT, AUTOGYRO
20	9788088	SCREW HEX HD 1/4-20 X 0.75 -PATCH
21	9788631	SPACER, CUSTOM, .53 ID
22	9787991	BEARING, DOUBLE ROW, 3203
23	9788621	BEARING, BALL, SIDE TIP, AUTOGYRO
24	9788783	2-PART COUNTERWEIGHT - 9025 AUTO
25	9784282	SCREW, SOCKET HD 5/16-18 X 1 1/4
26	9788634	BUSHING, BRONZE, FLANGED, .312ID X .50 OD X .38LG
27	9100023	WASHER, FLAT 5/16 USS ZINC 4400/50 LBS---- 3520/40 L
29	5788653	SENSOR, INDUCTIVE, M12 BODY, M12 CONN, 4MM RANGE
30	9788889	WASHER, SPACER, BOT. PLATE, 9025

PART NUMBERS LISTED MAY ONLY BE AVAILABLE IN KIT FORM OR AS AN ASSEMBLY

Exploded Views, Continued...

...Exploded Views, Continued

8.9 Bottom Clamp, Extractor Assembly

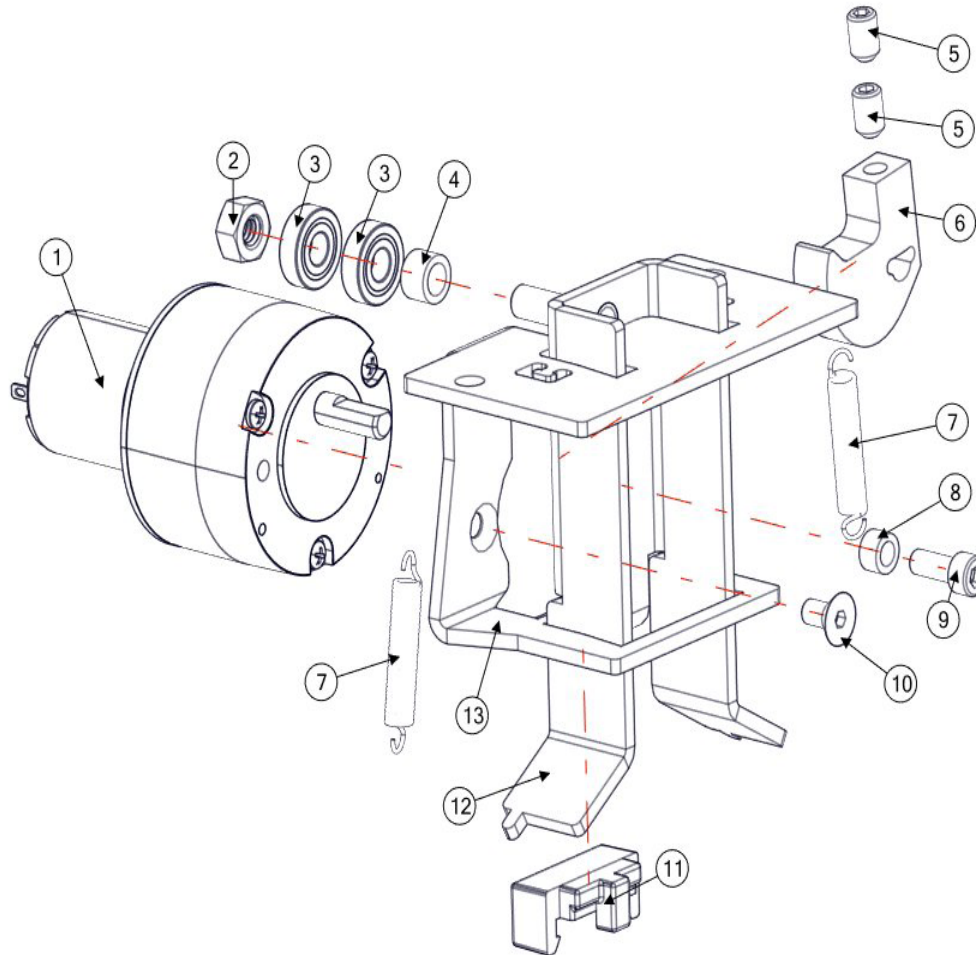


BOM ID	Description
1	9788651 LATCH, VERTICAL, AUTOGYRO
2	9788644 EXTRACTOR, AUTOGYRO
3	9788707 SCREW, SHOULDER 1/4X1.24, #10 THD
4	9788713 SPRING, .25 SHAFT, 120 DEG, LH
5	9782904 SCREW, BUTTON HD, SOC, 5/16-18 X 3/4
6	9788213 BALL BEARING, 5/16
7	9788295 WASHER, FLAT
9	9782004 NUT, NYLOCK 10-24 ZINC

Note: This assembly is not included in the Automation version

...Exploded Views, Continued

8.10 Bottom Clamp, Motor Assembly



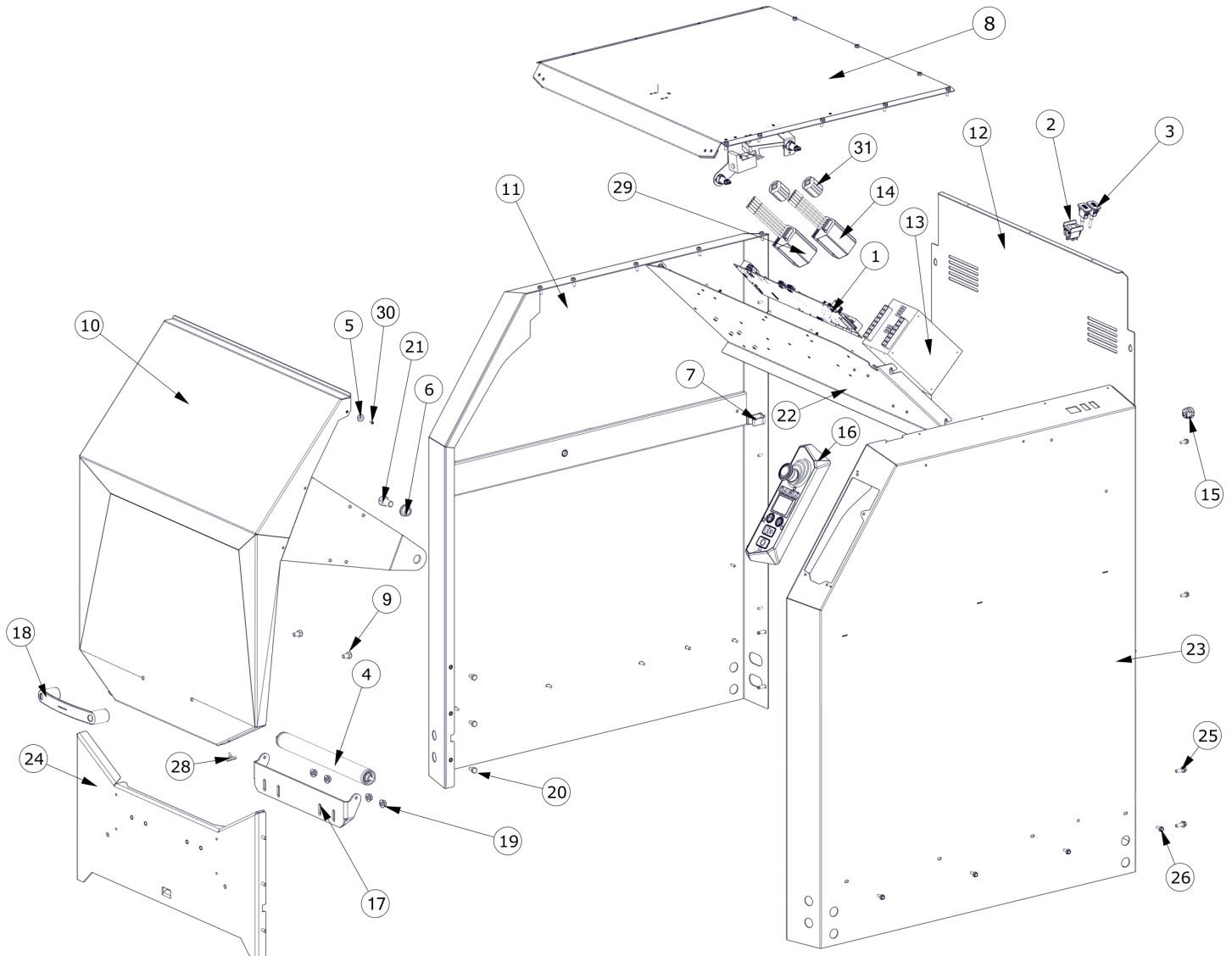
BOM ID	PART #	DESCRIPTION
1	5788494	MOTOR, SMALL FWD LOCK
2	9789764	NUT, HEX 1/4-20 DISTORTED THREAD
3	9788704	BEARING .25 ID, DUAL SEAL
4	9789679	BEARING, BRONZE, .25 ID X .25 LG
5	9788906	SET SCREW 1/4-28 X .375 FLAT, PATCH
6	9788639	CAM, FWD LOCK
7	9788483	SPRING, FORWARD HOLD
8	9788716	SPACER, #10 ID X .188 LG
9	9788798	SCREW, SOCKET HD #10-32 X 0.5
10	9788489	SCREW, FL HD SOC #10-32 X .375
11	9789729	WEAR PAD, CLIP ON
12	9789676	SLIDE, FWD LOCK
13	9789675	BASE PLATE, FWD LOCK
	6789221	KIT, FWD LOCK ASSY 9025 (includes everything displayed and 2x 9788026 to mount)

PART NUMBERS LISTED MAY ONLY BE AVAILABLE IN KIT FORM OR AS AN ASSEMBLY

Exploded Views, Continued...

...Exploded Views, Continued

8.11 Enclosure



BOM ID	Description
1	5787925 CONTROL PCB, AUTOGYRO
2	5782445 POWER SWITCH
3	5788416 USB-A FEMALE PANEL PUSH-IN TO MALE A
4	9782520 ROLLER
5	9784803 Switch Magnet
6	9786732 BEARING, BRONZE, FLANGED, .50 ID
7	9788695 CABLE CLAMP, PUSH IN, .88 X .7 FOR .25 HOLE
8	6788659 ASSEMBLY, TOP PANEL AND DOOR LOCK
9	9788087 SCREW HEX HD 5/16-18 X 0.50 GR5 ZINC -PATCH
10	9788551 DOOR, AUTOGYRO
11	9788605 PANEL, LEFT SIDE, AUTOGYRO
12	9788686 PANEL, BACK, AUTOGYRO
13	5788499 POWER SUPPLY, 48V 1008W
14	5788743 MOTOR CONTROLLER, TUMBLE, 9025
15	9784046 BUSHING, STRAIN RELIEF, FOR .875 DIA X .770 HOLE
16	9788583 PANEL, CONTROL

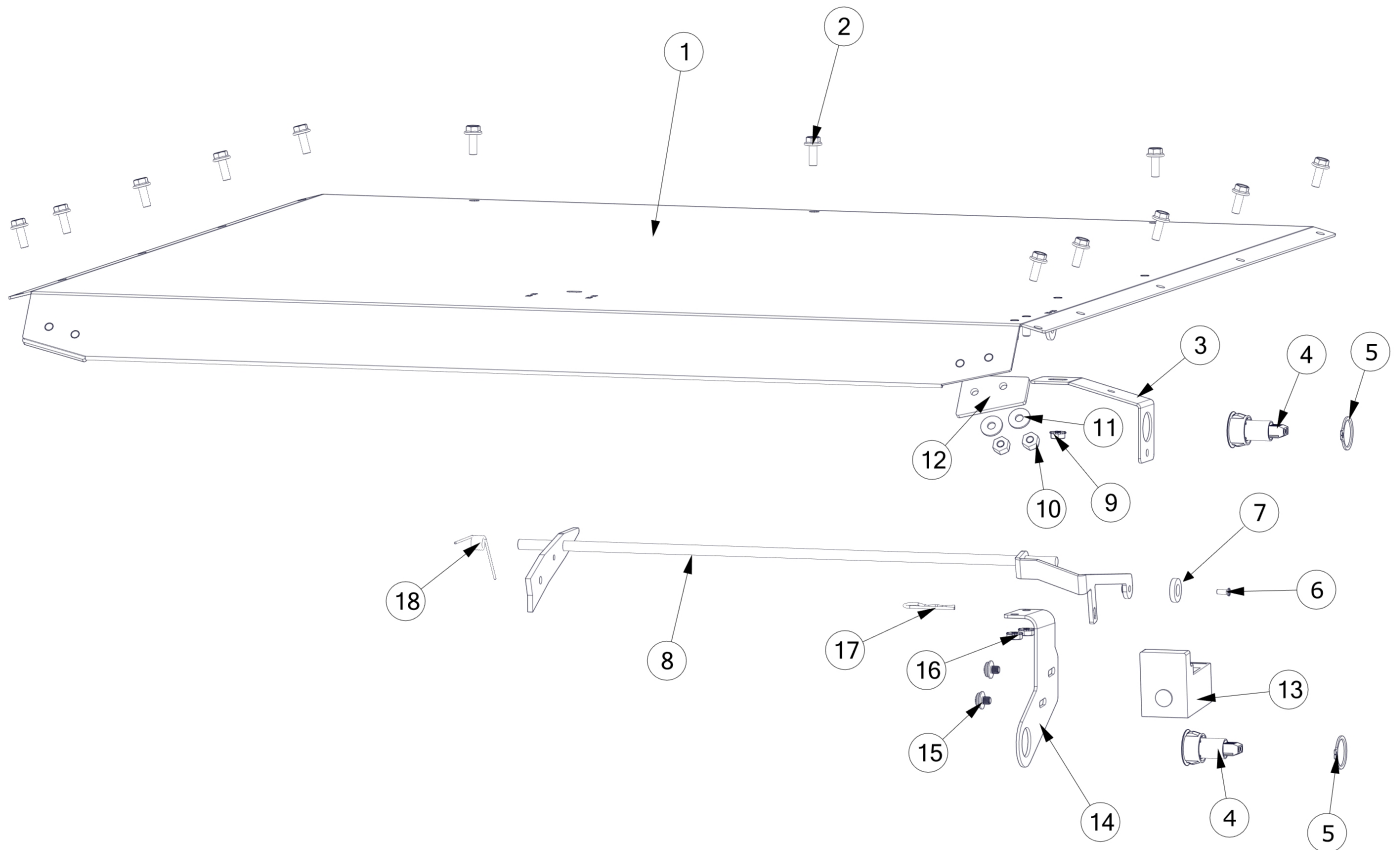
BOM ID	Description
17	9788522 ROLLER BRACKET
18	9788455 HANDLE, DOOR, AUTOGYRO
19	9788740 NUT, HEX, FLANGED SERRATED 5/16-18, GR 5
20	9788297 SCREW, HEX HD 1/4-20 X 1/2 GR5 ZINC
21	9788380 SCREW, HEX HD 1/2-13X.7/8 GR5 ZINC
22	9788358 ELECTRICAL ENCLOSURE
23	9788687 PANEL, RIGHT SIDE, AUTOGYRO
24	9788684 PANEL, FRONT BOTTOM, AUTOGYRO
25	9788717 SCREW, TAPPING 1/4 X 1/2 TYPE F
26	9788517 SCREW, HEX HD, FLANGED, 10-32 X 0.5, BLACK
28	9788364 BUMPER, TIGHT GRIP, 1/8 ID
29	5788742 MOTOR CONTROLLER, SPIN, 9025
30	9788739 SCREW, FL HD #4-40 X .313
31	5788806 FERRITE, 1/2" ID

PART NUMBERS LISTED MAY ONLY BE AVAILABLE IN KIT FORM OR AS AN ASSEMBLY

Exploded Views, Continued...

...Exploded Views, Continued

8.12 Top Panel and Door Lock



BOM ID	Description
1	9788351 PANEL, TOP, AUTOGYRO
2	9788517 SCREW, HEX HD, FLANGED, 10-32 X 0.5, BLACK
3	9788689 BRACKET, SENSOR, DOOR LOCK
4	9784804 SWITCH, MAGNETIC
5	9784416 3/4 EXTERNAL RETAINING RING
6	9788739 SCREW, FL HD #4-40 X .313
7	9784803 MAGNETIC SWITCH
8	9788507 LATCH ASSEMBLY
9	9783426 NUT, KEPS 10-32 ZINC
10	9781383 NUT, NYLOCK 10-32 ZINC
11	9785956 WASHER, FENDER #10 x .75 OD
12	9788588 DOOR BUMPER, AUTOGYRO
13	5788508 MAGNETIC LATCHING SOLENOID
14	9788587 BRACKET, DOOR LOCK, AUTOGYRO
15	9788714 SCREW, PAN HD, SEMS, 10-32 X .25 PHILLIPS
16	9781383 NUT, NYLOCK 10-32 ZINC
17	9787720 PIN, COTTER, .25-.50 DIA
18	9788713 SPRING, .25 SHAFT, 120 DEG, LH

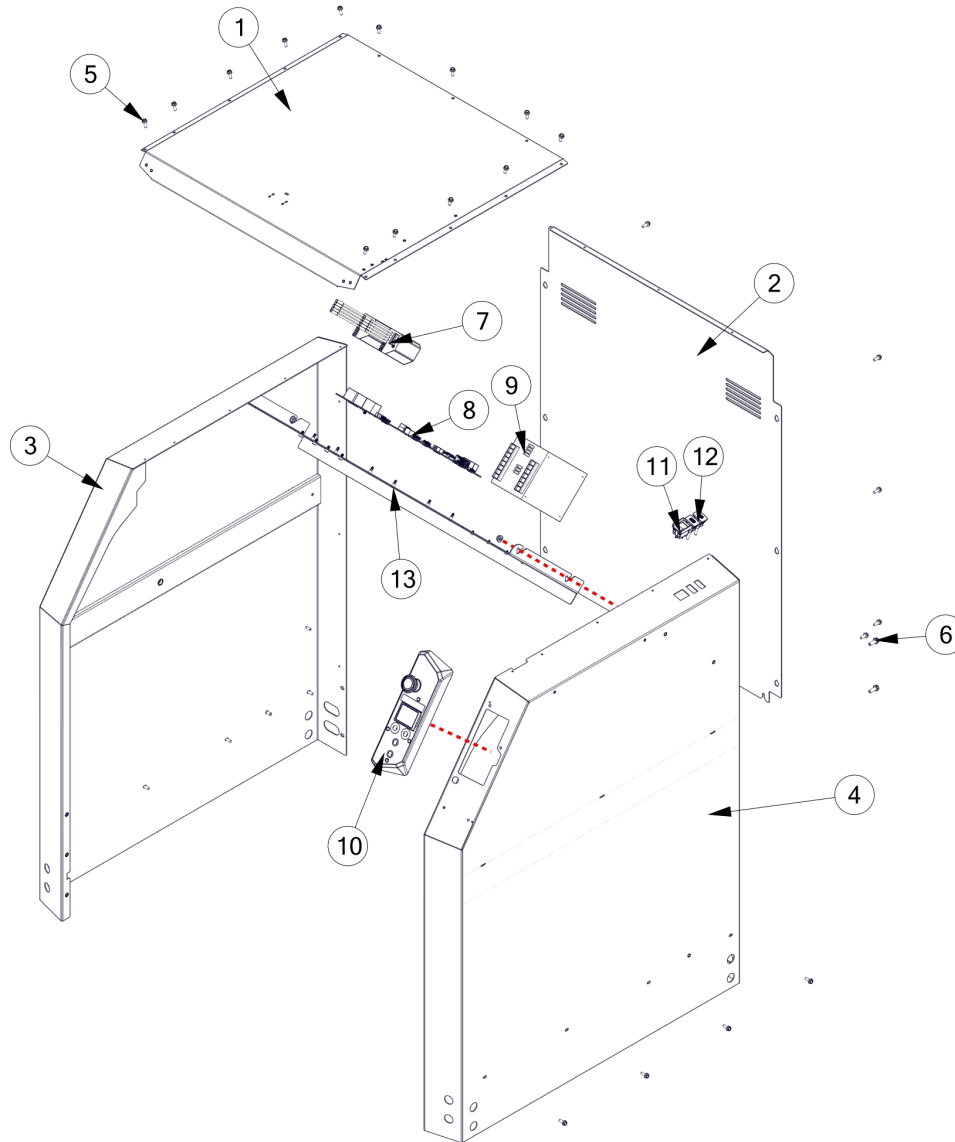
Note: Automation version only uses items 1 & 2.

PART NUMBERS LISTED MAY ONLY BE AVAILABLE IN KIT FORM OR AS AN ASSEMBLY

Exploded Views, Continued...

...Exploded Views, Continued

8.13 Automation Enclosure



BOM ID	Description
1	9788351 PANEL, TOP, AUTOGYRO
2	9788686 PANEL, BACK, AUTOGYRO
3	9788605 PANEL, LEFT SIDE, AUTOGYRO
4	9788687 PANEL, RIGHT SIDE, AUTOGYRO
5	9788517 SCREW, HEX HD, FLANGED, 10-32 X 0.5, BLACK
6	9788717 SCREW, TAPPING 1/4 X 1/2 TYPE F
7	5788743 MOTOR CONTROLLER, TUMBLE, 9025
8	5787925 CONTROL PCB - 9025
9	5788499 POWER SUPPLY, 48V 1008W
10	9788583 PANEL, CONTROL
11	5782445 POWER SWITCH
12	5788416 USB-A FEMALE PANEL PUSH-IN TO MALE A
13	9788358 ELECTRICAL ENCLOSURE

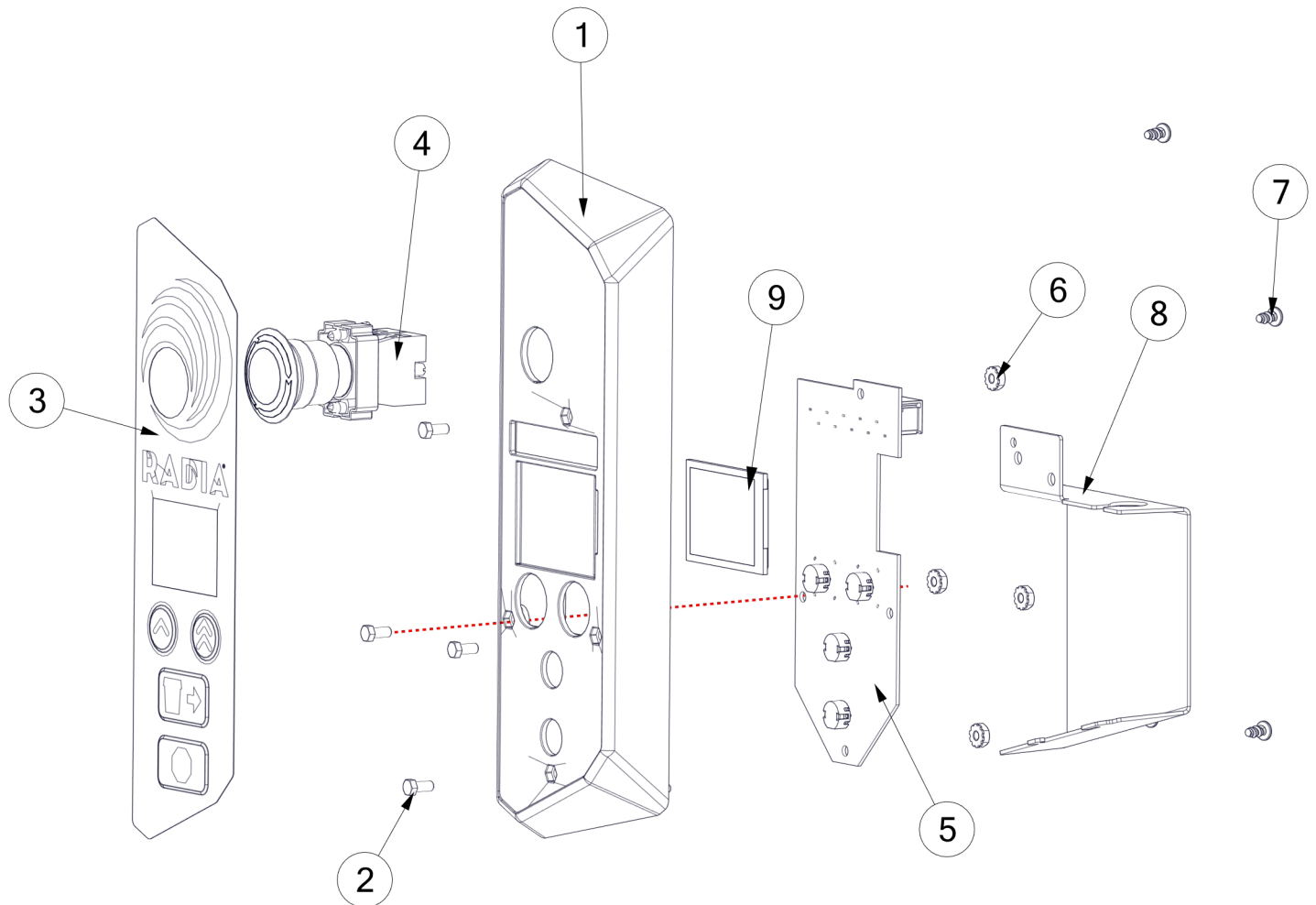
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PART NUMBERS LISTED MAY ONLY BE AVAILABLE IN KIT FORM OR AS AN ASSEMBLY

Exploded Views, Continued...

...Exploded Views, Continued

8.14 Control Panel



BOM ID	Description
1	9788583 PANEL, CONTROL - INJECTION MOLDED
2	9788327 SCREW, HEX HD 8-32 X .375
3	1788404 LABEL, CONTROL PANEL, AUTOGYRO
4	5784827 E-STOP SWITCH
5	5788746 PCB, LCD 9025
6	9781840 NUT, KEPS 8-32 ZINC
7	9788392 SCREW, PAN HD #10-16 X .375 THRD-FORMING
8	9788893 CTRL PANEL COVER, 9025
9	5788776 LCD, 2.4"

PART NUMBERS LISTED MAY ONLY BE AVAILABLE IN KIT FORM OR AS AN ASSEMBLY

Exploded Views, Continued...

9. Ordering

Replacement Parts

HOW TO ORDER REPLACEMENT PARTS

Replacement parts can be ordered from Red Devil Equipment Co. by telephone, fax, or email:

RADIA

800-221-1083
763-533-2969
763-533-0015 (FAX)
orders@radiaproducts.com

If you need help in determining the proper part(s) to order, please call Customer Care at 1-800-221-1083. Always indicate the Model and Serial numbers of the machine when ordering replacement parts.

GENERAL PARTS REPLACEMENT POLICIES

While your machine is under warranty, do not attempt on-site repair or parts replacement without first contacting RADIA to protect your warranty. After the warranty expires, replacement parts and recommendations for on-site servicing are available from RADIA. Please Customer Care for assistance.

RESTOCKING FEE

A restocking fee will be charged on all unused parts which are returned.



For instructional "How To" videos please visit:
www.radiaproducts.com



10. Warranty

Equipment Covered Under This Warranty

Models 09025

Warranty

Radia warrants equipment manufactured by it and bearing its name to be free from defects in material and workmanship.

EXCEPT FOR THE WARRANTY SET FORTH HEREIN, RADIA MAKES NO WARRANTY WHATSOEVER WITH RESPECT TO THE EQUIPMENT, INCLUDING ANY (a) WARRANTY OF MERCHANTABILITY; (b) WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE; OR (c) WARRANTY AGAINST INFRINGEMENT OF INTELLECTUAL PROPERTY RIGHTS OF A THIRD PARTY; WHETHER EXPRESS OR IMPLIED BY LAW, COURSE OF DEALING, COURSE OF PERFORMANCE, USAGE OF TRADE OR OTHERWISE.

This warranty applies only when the equipment is installed, operated and maintained in accordance with written Radia instructions as appearing in the owners' manuals.

This warranty does not cover, and Radia shall not be liable for, any malfunction, damage, or wear caused by faulty installation, misapplication, abrasion, corrosion, inadequate or improper maintenance, negligence, accident, tampering or substitution of non-Radia component parts, modification or use for non-intended purposes. Nor shall Radia be liable for malfunction, damage or wear caused by the incompatibility of Radia equipment with structures, accessories, equipment, or materials not supplied by Radia.

Subject to the limitations set forth above, Radia shall (i) repair or replace the equipment (or the defective part) or (ii) credit or refund the price of such equipment. Costs of labor and transportation for service of machines under this warranty will also be covered during the warranty period if Radia elects to repair or replace the equipment. Normal ground freight will be covered for replacement parts sent within the warranty period. For customers outside of the US and Canada, the warranty is for parts only. Ground or common carrier ground freight will be covered for the return of defective items only. In no case shall Radia's liability exceed the amount of the purchase price.

*All warranty repairs must be executed by a Radia Authorized Service Center or warranty will be voided.

THE REMEDIES SET FORTH HEREIN ARE PURCHASER'S SOLE AND EXCLUSIVE REMEDY and RADIA'S ENTIRE LIABILITY FOR ANY BREACH OF THE LIMITED WARRANTY SET FORTH HEREIN.

Please contact your Radia Relationship Manager at 800-221-1083 for specific questions regarding specific questions regarding warranty terms.

For sales or service, please contact

RADIA

Attn: Customer Service Department
14900 21st Ave N
Plymouth, Mn 55447
USA

U.S. Telephone: 800.211.1083

International Telephone: 763.533.2969

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E-mail: info@radiaproducts.com

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