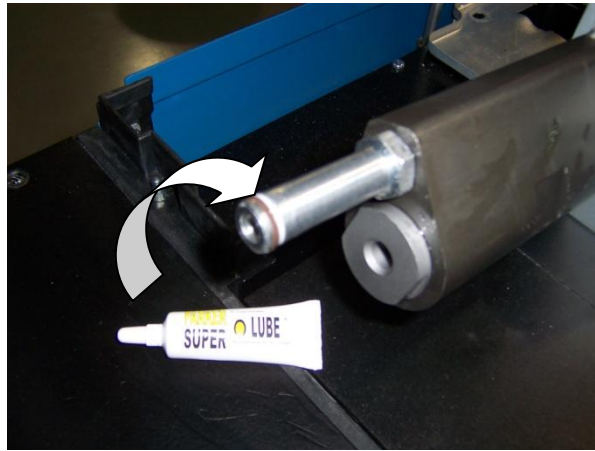




**Installation Instructions for Keystone Replacement Pump  
P/N K10035  
Fits Nordson® Model 3100, 3400, 3500, and 3700 14:1 Pumps**

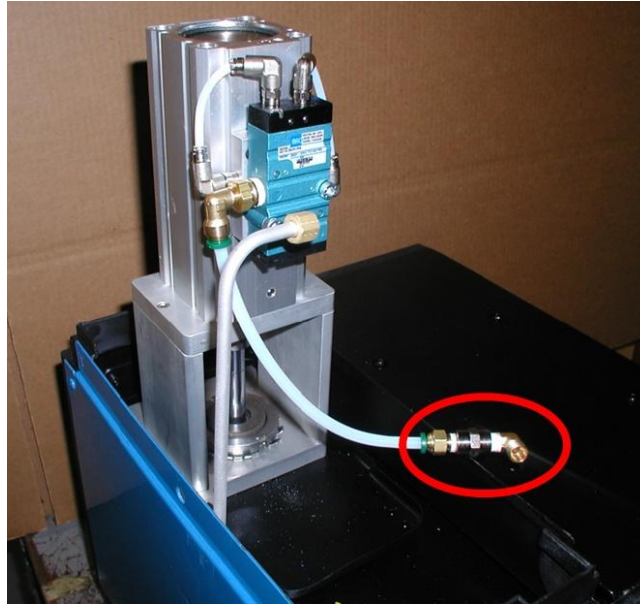
1. Follow the instruction in the Nordson® system manual for the removal of the pump.
2. Apply o-ring lube to the o-ring and the backup ring on the crossover tube of the new pump.



3. Install the new pump assembly into the tank and tighten it up with the 3 hex bolts that you removed from the old pump assembly.



4. Determine the appropriate air fitting (circled in red below).
- a. The replacement pump comes standard assembled with KHF0105 Elbow Fitting (small) and is typical to Models 3100, 3400, 3500.
  - b. KHF0106 Elbow fitting (large) is typical of the Model 3700. If you are retrofitting a Model 3700, you will need to switch out the fitting circled below with the bigger elbow provided loose in the kit.
  - c. In cases where flexible tubing is already present on the melter, the hardware circled below and the Teflon tubing are not needed.



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5. Install the hardware end of the assembly (circled in the picture immediately above) to the air tube on the unit as shown below. **Do Not Allow the Teflon Tube to Kink.**



6. Tighten the nut to the fitting.



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7. In some cases the melter may Teflon tubing connected to the pump rather than rigid piping. If this is the case, you need only remove the tubing and fitting that came with the replacement pump (shown laying to the right below), and connect the tubing on the melter directly to the pump as shown below.



8. Pump is ready to run when the system is up to operating temperature. The air pressure may have to be readjusted to obtain desired glue pressure.

**(Note: Minimum air pressure is 10 psi and the Maximum is 75 psi)**

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