

Techcon Systems TS6500 CIM Automatic Techkit Mixer

User Guide
English



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CONTENTS

Page Number

| | |
|---|-------|
| 1. Safety | 3 |
| 2. Description | 4 |
| 3. Symbol Definition | 4 |
| 4. Specifications | 5 |
| 5. Features and Function | |
| 5.1 Features | 6-8 |
| 5.2 Operation Function | 9-10 |
| 6. Setup and Operation | |
| 6.1 Fuse Installation and Voltage Selection | 11 |
| 6.2 Turn on the Unit | 12 |
| 6.3 Cartridge Kit Preparation | 13 |
| 6.4 Loading the Cartridge Kit | 14 |
| 6.5 Spindle Extension Installation | 15 |
| 6.6 Mix Cycle Program Setup | 16 |
| 6.7 Start the Unit | 16 |
| 6.8 Unloading the Cartridge Kit | 16 |
| 6.9 Manual Mode | 16 |
| 7. Speed Control | |
| 7.1 For Main Cylinder | 17 |
| 7.2 For Injection Rod | 17 |
| 8. Emergency Stop | 17 |
| 9. Troubleshooting | 18 |
| 10. Program Selection | 19 |
| 11. Cycle Counter Reset | 19 |
| 12. Cartridge Holder Installation | 19 |
| 13. Maintenance | 21 |
| 14. Warranty | 21 |
| 15. Appendix | |
| 15.1 Spare Parts and Accessories | 22-24 |
| 15.2 Techkit Part Number Chart | 25 |

1 SAFETY

1.1 Intended Use:

WARNING: Use of this equipment in ways other than those described in this User Guide may result in injury to persons or damage to property. Use this equipment only as described in this User Guide.

OK International cannot be responsible for injuries or damages resulting from unintended applications of its equipment. Unintended uses may result from taking the following actions:

- Making changes to equipment that has not been recommended in the User Guide
- Using incompatible or damaged replacement parts. Using unapproved accessories or auxiliary equipment

1.2 Safety Precautions:

- Do not operate this unit in excess of maximum ratings/settings
- Always wear appropriate personal protective clothing or apparel
- Care must be taken to prevent the ingress of corrosive or flammable fluid back into the Refer to Material Safety Data Sheet for proper handling and safety precautions
- Do not smoke or use open flame when flammable materials are being dispensed
- This equipment is for indoor use only.

2 DESCRIPTION

The TS6500CIM Series Automatic Techkit Mixer provides complete automatic mixing of two-component material package in cartridge kits. Equipped with a universal power supply, the TS6500 mixer is immediately usable anywhere in the world. The automatic fluid sensing device makes it very simple for operator to install and setup all cartridge kit sizes. The user friendly firmware provides up to 10 programmable mixing sequences with storage of 10 profiles.




The TS6500CIM Series is available in two versions:

- TS6500CIM-6 for 2.5 (74ml), 6.0 (177ml) and 8.0 oz. (237ml) Kit
- TS6500CIM-20 for 20 oz.(591ml) Kit

The following conversion kits are also available for your conveniences:

- CK6500-6 Conversion kit for 2.5 (74ml), 6.0 (177ml) and 8.0 oz. (237ml) Kit
- CK6500-10 Conversion kit for 1/10 gal.(325ml) Kit
- CK6500-20 Conversion kit for 20 oz.(591ml) Kit

3 SYMBOL DEFINITIONS

| Symbol | Definition |
|---|--------------|
|  | Power On/Off |
|  | Cycle Mode |
|  | Setup |

4 SPECIFICATIONS

| | |
|------------------------|--|
| Size | 15.7" (398mm) X 21.2"(538mm) X 40.6"(1032mm) |
| Weight | 80lbs (36kg) |
| Input Voltage | 120/230 VAC, 50/60 Hz |
| Rated Input Power | 200W |
| Rated Input Current | 2A @ 120 VAC / 1A@230 VAC |
| Motor Speed | 139 RPM |
| Motor Torque | 42 in-lb (4.7 Nm) |
| Indoor Use | Altitude up to 6,562ft (2,000m) |
| Operating Temperature | 32°F to 122°F (0°C to 50°C) |
| Storage Temperature | -10°C to 60°C (14°F to 140°F) |
| Max. Relative Humidity | 80% for temperature up to 87.8°F (31°C) Decreasing linearly to 50% relative humidity at 104°F (40°C) |
| Air Input | 50 to 100psi (3.5 – 6.9 Bar) |
| Display | LCD 20 X 4 display segments |

4.1 Outside Dimensions

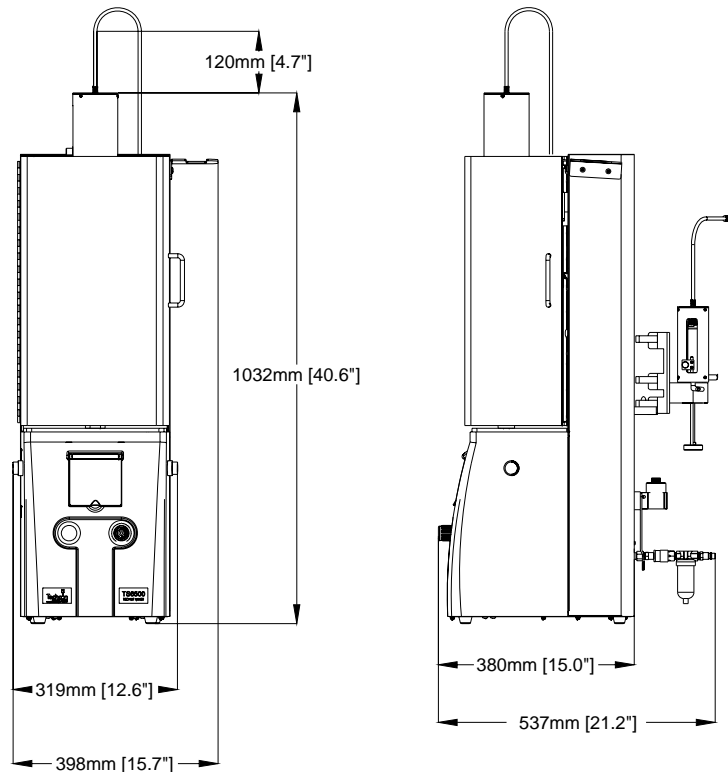


Figure 1.0 Dimensions

5 FEATURES AND FUNCTIONS

5.1 Features

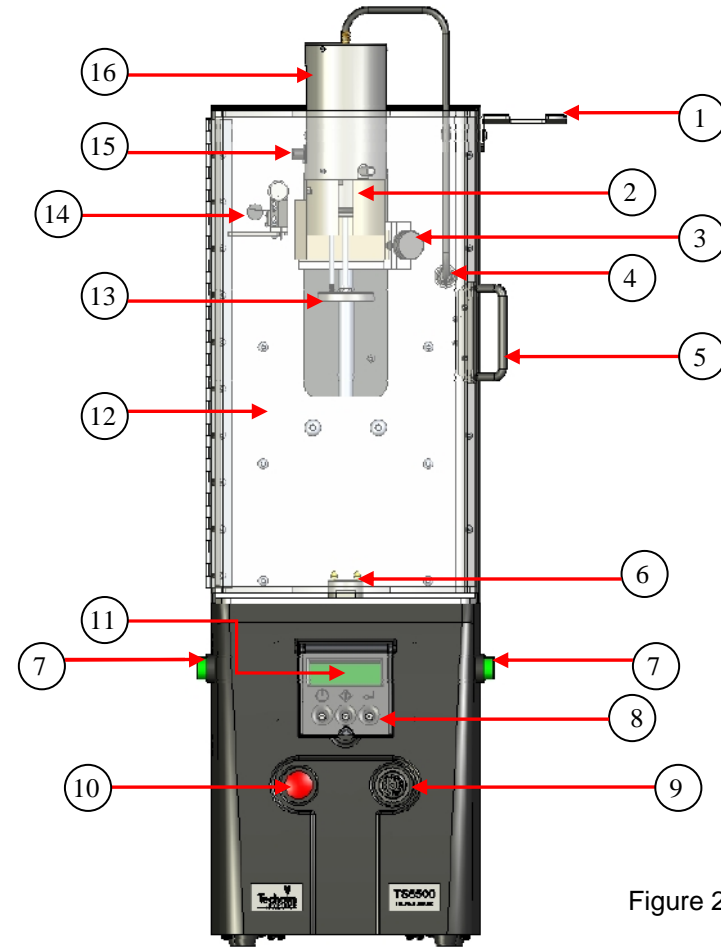


Figure 2.0 Front View

| ITEM | DESCRIPTION | ITEM | DESCRIPTION |
|------|----------------------------------|------|---------------------------|
| 1 | Plunger Bracket | 9 | Air Regulator |
| 2 | Cartridge Holder | 10 | E-Stop Button |
| 3 | Guide Block | 11 | LCD Display |
| 4 | Plunger Air Inlet | 12 | Safety Cover |
| 5 | Door Handle | 13 | Plunger Disk |
| 6 | Drive Spindle with Injection Rod | 14 | Fluid Level Sensor |
| 7 | Start Buttons | 15 | Fluid Level Sensor Magnet |
| 8 | Control Buttons | 16 | Plunger |

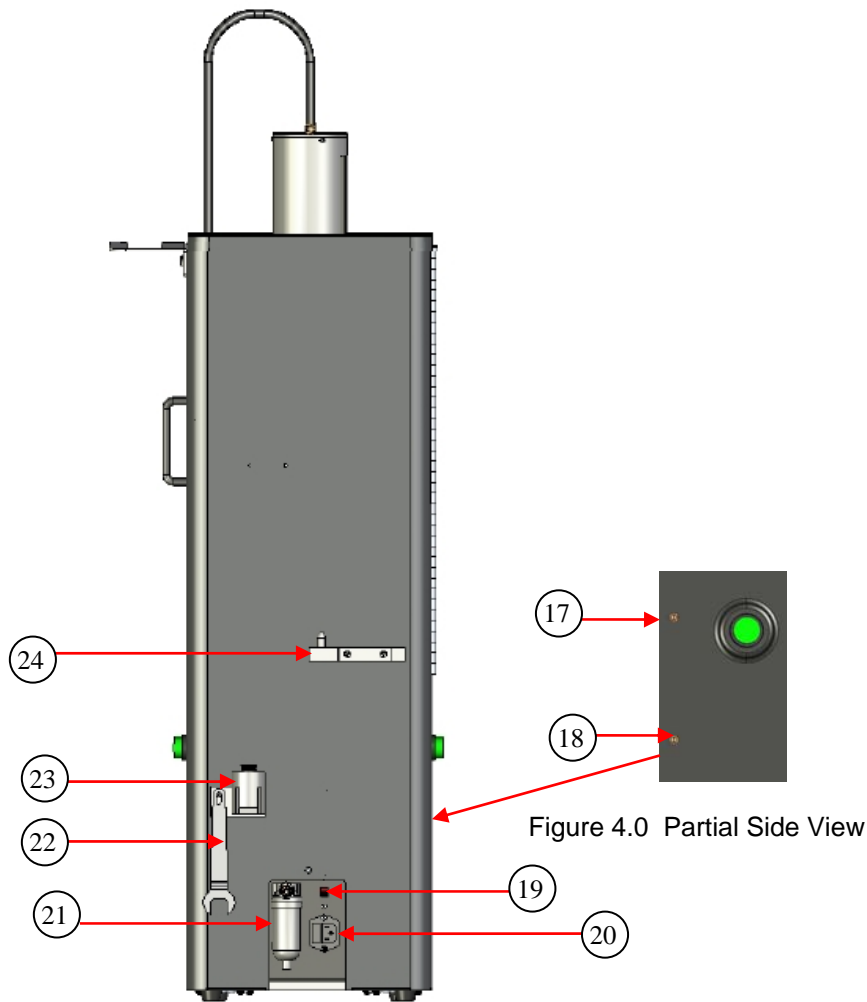


Figure 3. Back View

Figure 4.0 Partial Side View

| ITEM | DESCRIPTION | ITEM | DESCRIPTION |
|------|----------------------------------|------|--------------------------|
| 17 | Flow Control, Main Cylinder | 21 | Air Filter |
| 18 | Flow Control, Injection Rod | 22 | Wrench |
| 19 | Voltage Select Switch | 23 | Accessories Bracket |
| 20 | Power Input Socket with Fuse box | 24 | Cartridge Holder Bracket |

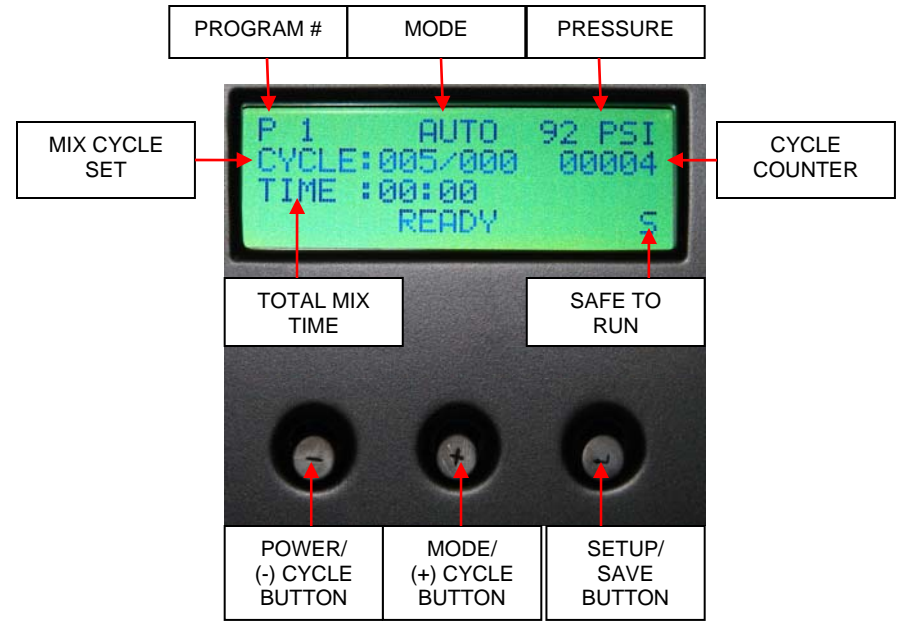


Figure 5.0 Buttons and Screen Identification

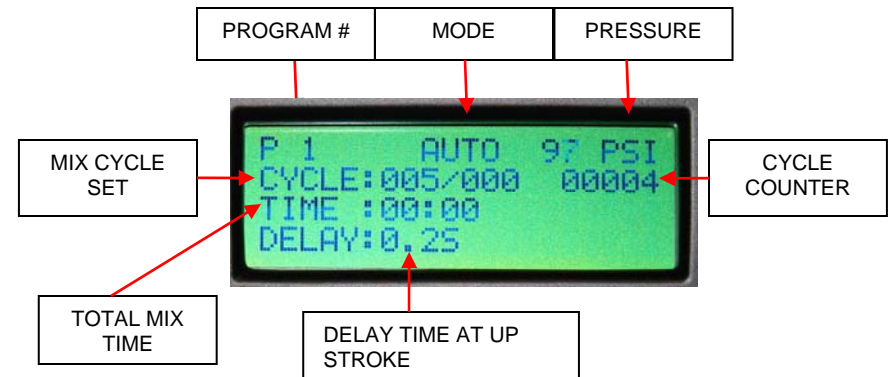


Figure 6.0 Setup Screen Identification

5.2 Operation Function

| | DESCRIPTION | FUNCTION |
|----|----------------------------------|--|
| 1 | Plunger Bracket | <ul style="list-style-type: none"> • Holds plunger assembly when not in use |
| 2 | Cartridge Holder | <ul style="list-style-type: none"> • Holds cartridge kit • Operates with the plunger assembly and guide block to drive the cartridge up and down for mixing |
| 3 | Guide Block | <ul style="list-style-type: none"> • Operates with the plunger assembly and cartridge holder to drive the cartridge up and down for mixing |
| 4 | Air Plunger Inlet | <ul style="list-style-type: none"> • Provides air to plunger |
| 5 | Door Handle | <ul style="list-style-type: none"> • Secures cover and disengages door |
| 6 | Drive Spindle with Injection Rod | <ul style="list-style-type: none"> • Rotates mix rods during mix cycle • Injects the hardener into the resin |
| 7 | Start Buttons (Green) | <ul style="list-style-type: none"> • Starts the unit • Press green buttons simultaneously to start |
| 8 | Control Buttons | <ul style="list-style-type: none"> • Input buttons (see Fig. 5) |
| 9 | Air Regulator | <ul style="list-style-type: none"> • Regulate the air pressure to the unit |
| 10 | Emergency Stop button (Red) | <ul style="list-style-type: none"> • Stops the Unit in an Emergency • Press to Engage • "E-Stop!" will be displayed, • To reset, rotate the E-Stop knob a quarter turn clockwise |
| 11 | LCD Display | <ul style="list-style-type: none"> • Displays unit status, operation and error messages. |
| 12 | Protective (Safety) Cover | <ul style="list-style-type: none"> • Protect operators when machine in use |
| 13 | Plunger Disk | <ul style="list-style-type: none"> • Part of Plunger Assembly |
| 14 | Fluid Level Sensor | <ul style="list-style-type: none"> • Senses the fluid level at the top of the cartridge |

| | | |
|----|----------------------------------|---|
| 15 | Fluid Level Magnet | <ul style="list-style-type: none"> • Work with Fluid Level Sensor |
| 16 | Plunger Assembly | <ul style="list-style-type: none"> • Locks cartridge in place • Applies steady pressure to prevent air entrapment |
| 17 | Flow Control; Main Cylinder | <ul style="list-style-type: none"> • Controls the speed of the Main Cylinder • Rotate the flow control screw clockwise to increase the speed. • Rotate the flow control screw counterclockwise to decrease the speed |
| 18 | Flow Control; Injection Rod | <ul style="list-style-type: none"> • Controls the speed of the injection rod • Rotate the flow control screw clockwise to increase the speed. • Rotate the flow control screw counterclockwise to decrease the speed |
| 19 | Voltage Select Switch | <ul style="list-style-type: none"> • Select 115V or 230V |
| 20 | Power Input Socket with Fuse Box | <ul style="list-style-type: none"> • Input power connection |
| 21 | Air Filter | <ul style="list-style-type: none"> • Provide air filtration |
| 22 | Wrench | <ul style="list-style-type: none"> • Use to install Air filter assembly and Drive spindle assembly |
| 23 | Accessories Bracket | <ul style="list-style-type: none"> • To hold wrench or other accessories |
| 24 | Cartridge Holder Bracket | <ul style="list-style-type: none"> • To hold extra Cartridge Holder |

6 SETUP AND OPERATION

NOTE: To ensure proper voltage setting, units shipped from the factory will not have the fuse installed. Refer to Section 6.1 to install proper fuse and select proper voltage.

6.1 Fuse Installation/Voltage Selection

1. Remove the fuse holder by using a flat head screw driver to pry it open.
2. Insert proper fuse into the fuse box, refer to table below

| Voltage Range | Voltage Setting | Fuse Rating |
|---------------|-----------------|---------------|
| 100V – 120V | 115V | 2 Amp, Type F |
| 220V – 240V | 230V | 1 Amp, Type F |

3. Re-install the fuse holder into the unit
4. Select the proper voltage by sliding the voltage switch up or down.

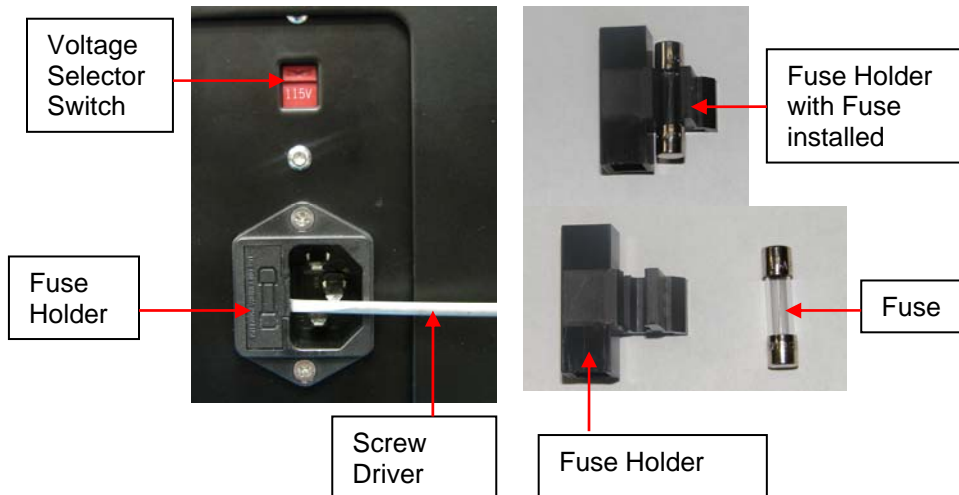


Figure 7.0 Fuse Installation

6.2 Turn On the Unit

1. Insert the power cord to the power socket (Fig. 3, 20).

Caution: Make sure the proper fuse has been installed and correct voltage has been set. Refer to section 6.1 for instructions.

2. Connect the air filter assembly to the air inlet (Fig. 3, 21).
3. Connect the air hose to the air filter assembly

Caution: The air filter assembly (7091-9080), supplied with the unit, must be installed to ensure proper air filtration.

4. Set the air Pressure to 80 psi (5.5 bars) minimum
 - Rotate the Air Pressure regulator knob (Fig. 1, 9) clockwise to increase the Air Pressure.
 - Rotate the Air Pressure regulator knob counterclockwise to decrease the Air Pressure.
5. The desired Air Pressure will be displayed on the screen.
6. Turn on the unit by pressing the power button (Fig. 5). The cartridge holder should move up to home position. If it does not move up, please check pressure connection.



Figure 8.0 Air and Power Connection

6.3 Cartridge Kit Preparation

Injection Kit: The TS6500 Mixer has an automatic injection device that will inject the hardener into the catalyst during the mixing operation. However the valve in the mix rod needs to be opened before placing the kit in the machine. Follow below instructions to open the valve.

1. Insert the ram rod into the mix rod
2. Push the ram rod to force the valve opened
3. Follow instructions in section 6.4 to mix the injection kit

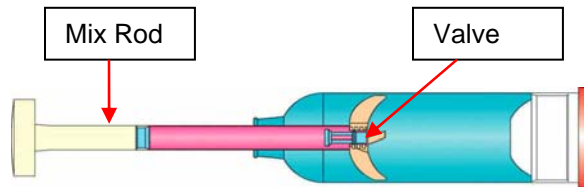


Figure 9.0 Injection Kit

Barrier Kit

1. Remove barrier tape from the kit
2. Pull the mix rod down to the fullest extend to remove the foil from the dasher.
3. Follow instructions in section 6.4 to mix the barrier kit

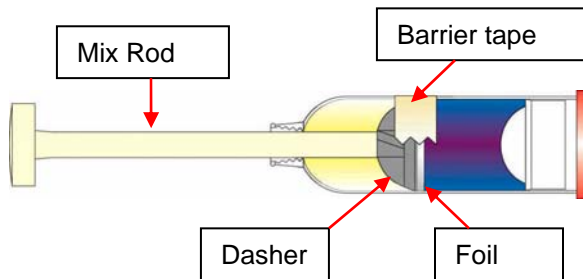


Figure 10.0 Barrier Kit

6.4 Loading the Cartridge Kit

Note:

- a. *The unit is setup to mix cartridge kit with 8"(203mm) mix rod. To mix cartridge kit with 6"(152mm) mix rod, the spindle extension needs to be installed. Refer to section 6.5 for instructions.*
- b. *The TS6500CIM-6 is setup to mix 6 oz. (177ml) cartridge kit. To mix 2.5 oz. (74ml) or 8.0 oz.(237ml) kit, Refer to section 12. for instructions.*

1. Open the safety cover (Fig. 2, 12).
2. Load the cartridge kit into the cartridge holder (Fig. 2, 2).
3. Pull the mix rod to the fullest extend then align the two through holes of the rod to the drive spindle (Fig. 2, 6).
4. Insert the plunger assembly (Fig.2,16) into the cartridge holder with the plunger sit properly inside the cartridge.
5. Align the dowel pins of the plunger assembly with the bayonet slots in the cartridge holder and turn counterclockwise until it locked in.
6. Connect the air hose into the plunger air inlet (Fig. 2, 4).
7. Close the safety cover.

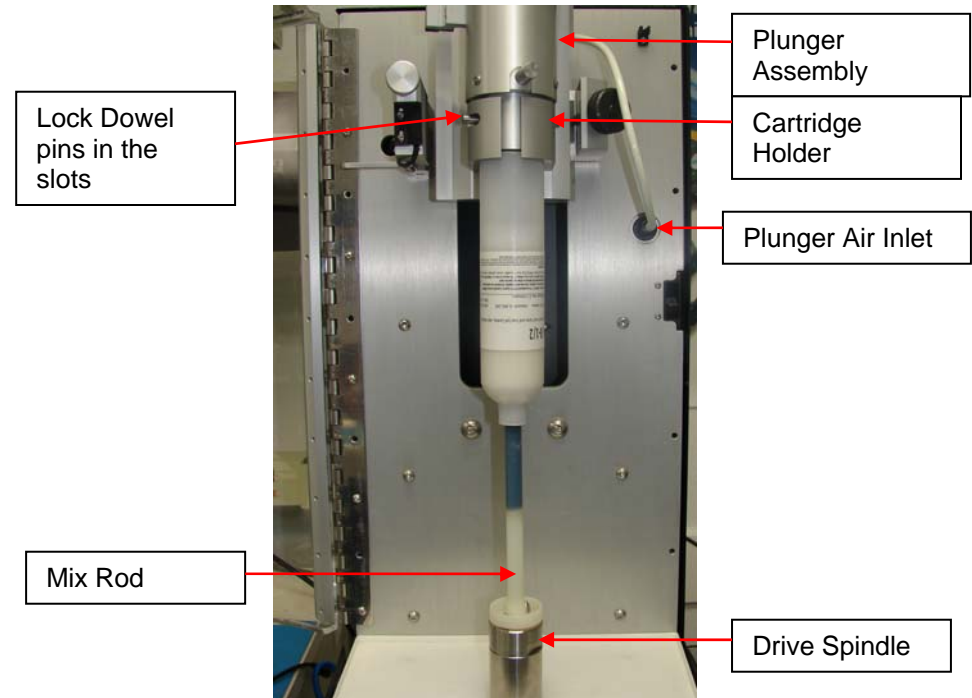


Figure 11.0 Loading the Cartridge Kit

6.5 Spindle Extension Installation

Refer to Fig. 12 and Fig. 13

1. Place the wrench on the motor shaft (beneath the spindle).
2. Place a screw driver between the two locking pins of the spindle.
3. Hold the wrench and turn the screw driver counter clockwise to unscrew the spindle assembly.
4. Remove the spindle assembly from the motor shaft
5. Install the spindle extension on the motor shaft by turning it clockwise
6. Install the spindle assembly on the spindle extension by turning it clockwise

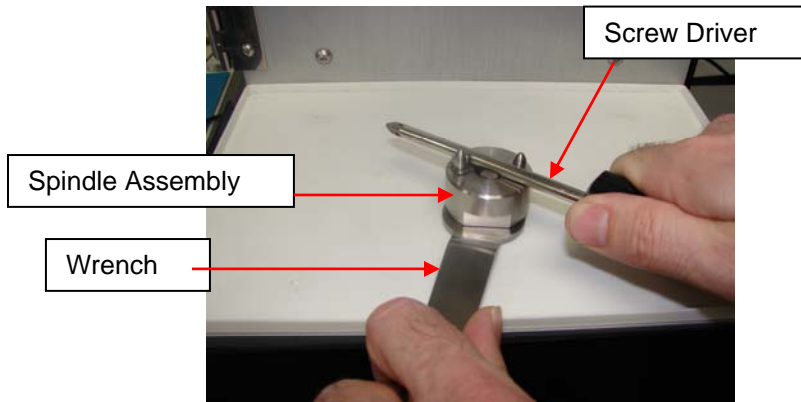


Figure 12.0. Remove Spindle Assembly

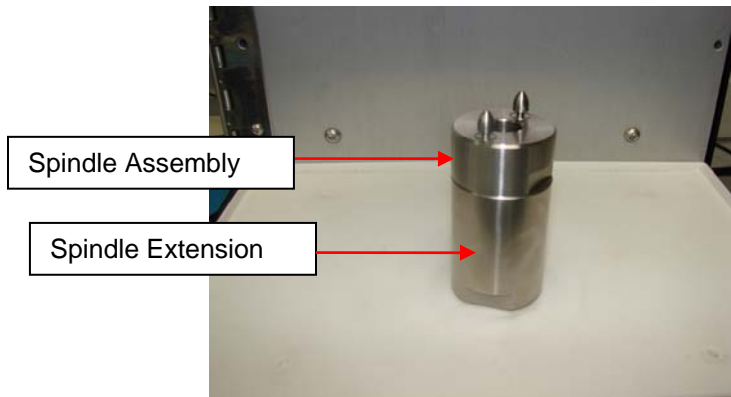


Figure 13.0. Spindle Assembly with Extension

6.6 Mixed Cycle Program Setup:

Refer to Fig. 5 and Fig 6

1. Press the Mode button (Fig. 5) to select Auto mode.
2. Press and hold the Setup button (Fig. 5) for 3 seconds to enter setup screen.
3. Press the Setup button (Fig. 5) to move the cursor to the "CYCLE" indicator.
4. Press the (+) and (-) button (Fig. 5) to set number of mixed cycle required
5. If delay time is required, press the Setup button to move the cursor to the "DELAY" indicator then press the (+) and (-) button to adjust delay time
6. Press and hold the Setup button for 3 seconds to save data. The unit is now ready to run.

6.7 Start the unit

1. Ensure the unit is in the Automatic Mode and the desired profile has been selected.
2. Press and release the Start buttons (Green) (Fig 2, 7) simultaneously.
3. The unit will run the selected profile. The cycle count and elapsed time will be displayed on the LED screen.

6.8 Unloading The Cartridge Kit

1. The machine will automatically stop once the mixing cycles are completed.
2. Open the protective cover (Fig. 2, 12)
3. Remove the retaining collar plunger assembly (Fig.2, 16) by turning it clockwise.
4. Place the retaining collar plunger assembly on the side bracket
5. Turn the cartridge kit clockwise to remove it from the drive spindle
6. Pull the cartridge kit out of the cartridge holder

6.9 Manual Mode

While in the manual mode, the injection rod, main cylinder and drive spindle motor may be controlled independently. Note: while in manual mode any errors will not halt the operation of the motors. Refer to Fig. 14

1. Press and hold the Mode button for 3 seconds to select Manual mode
2. Press the Power (-) button to activate the injection rod (the injection rod will move up)
3. Press the Mode button (+) to activate the motor (the drive spindle will rotate)

- Press the Setup button (↵) to activate the main cylinder (the cartridge holder will move up and down)

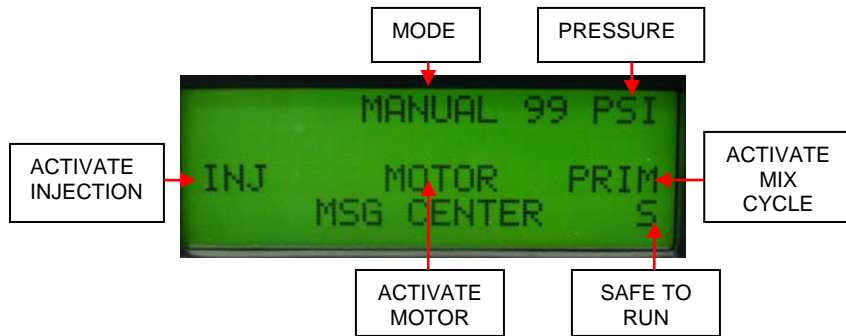


Figure 14.0 Manual Mode Screen

7 SPEED CONTROL

7.1 For main air cylinder

The main air cylinder drives cartridge kit up and down. The stroke speed of the main air cylinder can be adjusted by rotating the flow control screw (Fig. 15) clockwise to increase the speed and counterclockwise to decrease the speed

7.2 For injection rod

The injection rod air cylinder drives the injection rod up and down. The injection speed can be adjusted by rotating the flow control screw (Fig. 15) clockwise to increase the speed and counterclockwise to decrease the speed

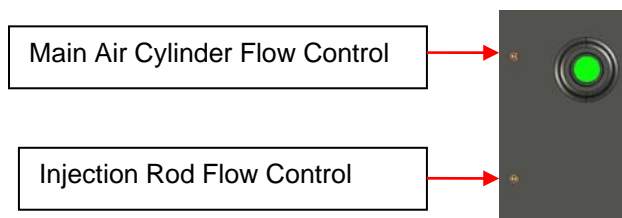


Figure 15.0 Side View

8 EMERGENCY STOP

In case of an emergency, the mixing operation can be stopped at any time by pressing the EMERGENCY STOP BUTTON, (Fig 2, 10). After problems have been fixed, the machine can be restart by pulling and turning the emergency button counter clockwise. The mix cycle will start from the beginning.

9 TROUBLESHOOTING

| PROBLEM | POSSIBLE CAUSE | CORRECTION |
|---|--|--|
| Unit fail to start | <ul style="list-style-type: none"> No power input Emergency button is pressed Safety door is not fully closed | <ul style="list-style-type: none"> Check power cord connections Turn Emergency button clockwise to release Closed safety door |
| LCD does not light | <ul style="list-style-type: none"> No power input | <ul style="list-style-type: none"> Check power cord connections Check Fuse Turn on power |
| Air Cylinder does not move | <ul style="list-style-type: none"> Insufficient air pressure Air hoses not plugged in Regulator defective | <ul style="list-style-type: none"> Increase air supply pressure to 80 psi Check air connection Replace regulator |
| The hardener is not completely injected | <ul style="list-style-type: none"> Air cylinder is damaged | <ul style="list-style-type: none"> Replace air cylinder |
| The injection rod does not retract | <ul style="list-style-type: none"> Injection rod is dirty Injection rod is bent | <ul style="list-style-type: none"> Clean rod Replace rod |
| Material is not completely mixed | <ul style="list-style-type: none"> Not enough mixing cycle Insufficient air pressure | <ul style="list-style-type: none"> Increase number of cycles Increase air pressure to 80 psi |
| Cartridge holder is not in "Home" position | <ul style="list-style-type: none"> Insufficient air pressure Air hoses not plugged in | <ul style="list-style-type: none"> Increase air supply pressure to 80 psi Check air connection |
| Mixing rod does not reach spindle | <ul style="list-style-type: none"> Extension spindle is not installed for 6" rod Mixing rod in not fully extend | <ul style="list-style-type: none"> Install extension spindle for 6" rod Extend mixing rod |
| No pressure on plunger | <ul style="list-style-type: none"> Plunger air hose is not connected | <ul style="list-style-type: none"> Connect plunger air hose |
| Plunger disk does not fit inside cartridge | <ul style="list-style-type: none"> Wrong plunger disk size | <ul style="list-style-type: none"> Use correct plunger disk size |
| Cartridge holder remains in the down position during mixing cycle | <ul style="list-style-type: none"> Sensor and magnet is not aligned | <ul style="list-style-type: none"> Turn off unit and adjust sensor / magnet alignment |
| Motor is not running | <ul style="list-style-type: none"> No power to motor Motor burned out | <ul style="list-style-type: none"> Check motor connection Replace motor |

10 PROGRAM SELECTION

Up to 10 programs can be stored in the TS6500 Mixer.

1. Press the Set button (Fig. 5) to highlight the program number selection.
2. Press the (+) or (-) buttons to select desired program.
3. Press the Set button to exit.

11 CYCLE COUNTER RESET

The cycle counter can record up to 99999 mix cycle. To reset the cycle counter follow below instructions:

1. Press and hold Setup button for 3 seconds to enter setup mode.
2. Once the setup mode is displayed, press and hold Setup button again until the cycle counter reset to "00000"

12 CARTRIDGE HOLDER INSTALLATION

Refer to Figure 16 and 17

The TS6500CIM-6 is setup to mix the 6.0 oz.(177ml) kit. To mix the 2.5 (74ml) or 8.0 oz.(237ml) kit the cartridge holder needs to be re-install at different mounting locations as shown in Fig. 10.

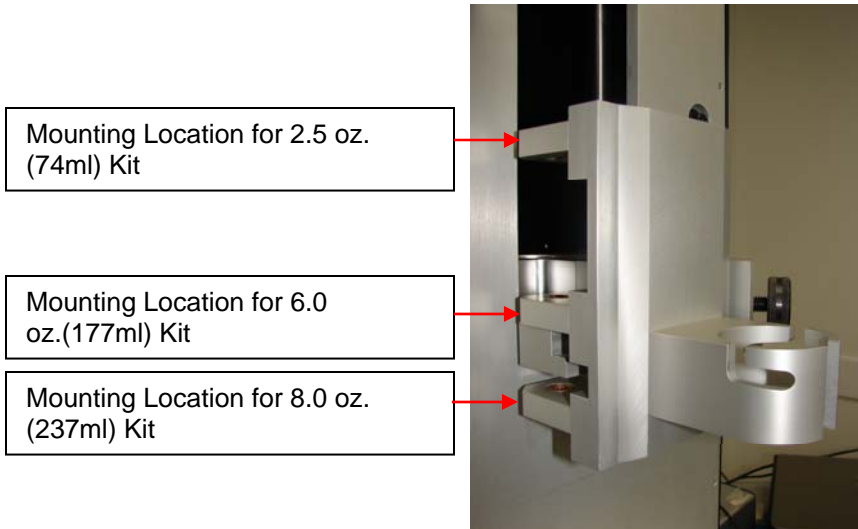


Figure 16.0 Mounting Location

The cartridge holder can be installed in a few simple steps

1. Pull the release knob and push the Fluid level sensor assembly to the left
2. Loosen the locking screw by turning it counter clockwise.
3. Rotate the cartridge holder outward and pull it up to remove from the machine
4. Install new cartridge holder in reverse order
5. Pull release knob to rotate fluid level sensor assembly back into position.

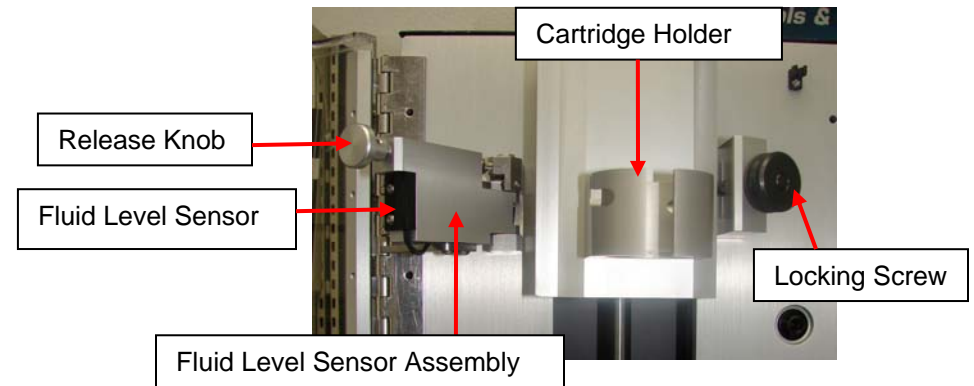


Figure 17.0 Cartridge Holder

13 MAINTENANCE

The TS6500 Mixer is designed and built to be relatively maintenance free. To assure trouble free operation, the following recommendations should be followed:

1. Make certain the air supply is clean and dry.
2. Avoid connecting the unit to excessive moisture or solvent saturation.
3. Use only Amyl Alcohol to clean outside surface of the main housing.
4. Use only soft cloth to clean the LCD.
5. Clean the injection rod regularly with cleaning solvent
6. Clean the tray regularly with cleaning solvent

14 LIMITED WARRANTY

OK International warrants this product to the original purchaser for a period of one (1) year from date of purchase to be free from material and workmanship defects but not normal wear-and-tear, abuse and faulty installation. Defective product or subassembly and components under warranty will be repaired or replaced (at OK International's option) free of charge. Customer with defective product under warranty must contact the nearest OK International office or distributor to secure a return authorization prior to shipping the product to the assigned OK International authorized service center. For nearest OK International office or distributor contact information, please visit www.okinternational.com. OK International reserves the right to make engineering product changes without notice.

15 APPENDIX

15.1 Spare Parts List

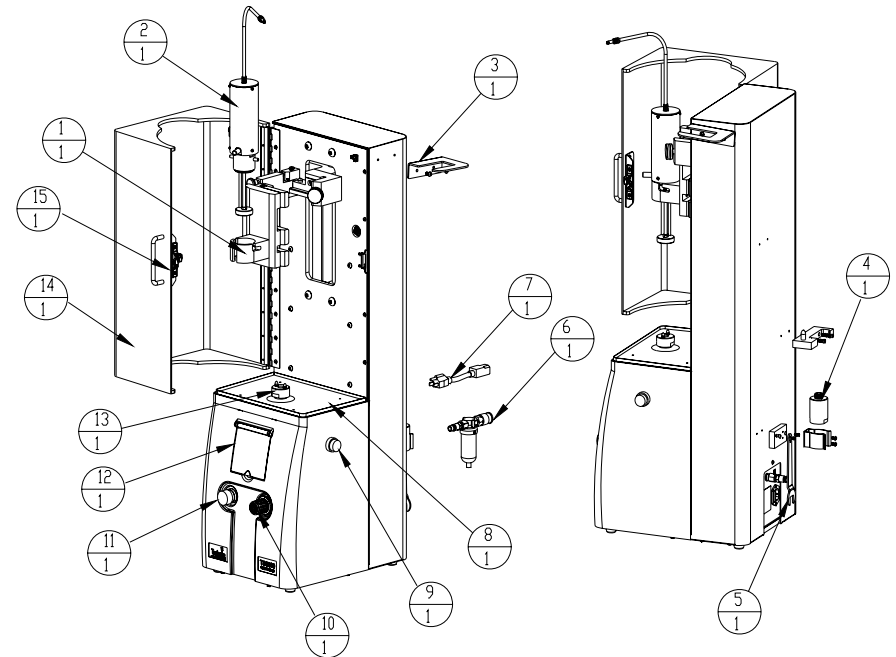


Figure 18.0 Main Assembly

| ITEM | PART NUMBER | DESCRIPTION | QTY |
|------|-------------|--|-----|
| 1 | 7091-9010 | CARTRIDGE HOLDER ASSEMBLY, 2.5oz/6oz/8oz | 1 |
| | 7091-9030 | CARTRIDGE HOLDER ASSEMBLY, 20 oz | 1 |
| 2 | 7091-9040 | PLUNGER ASSEMBLY, 2.5oz/6oz/8oz | 1 |
| | 7091-9060 | PLUNGER ASSEMBLY, 20 oz | 1 |
| 3 | 7091-0420 | HOLDER, PLUNGER ASSEMBLY | 1 |
| 4 | 7091-0120 | SPINDLE EXTENSION | 1 |
| 5 | 7091-0530 | WRENCH, THIN HEAD, 19mm | 1 |
| 6 | 7091-9080 | AIR FILER ASSEMBLY (Filter only = TSD800-6) | 1 |
| 7 | 6002-0703 | POWER CORD | 1 |
| 8 | 7091-0430 | TRAY | 1 |
| 9 | 5100-0079 | START PUSH BUTTON | 1 |
| 10 | TSD500-29 | AIR REGULATOR | 1 |
| 11 | 5100-0078 | E-STOP SWITCH | 1 |
| 12 | 7091-0510 | LCD COVER | 1 |
| 13 | 7091-9070 | SPINDLE ASSEMBLY | 1 |
| 14 | 7091-0430 | SAFTY DOOR | 1 |
| 15 | 5100-0077 | INTERLOCK SWITCH | 1 |

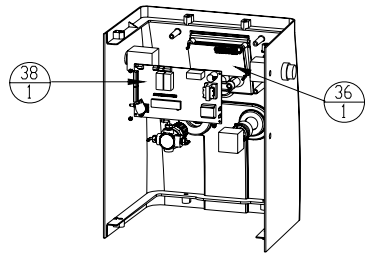


Figure 19.0 Inside Front Cover Assembly

| ITEM | PART NUMBER | DESCRIPTION | QTY |
|------|-------------|---------------------|-----|
| 36 | 2900-0015 | LCD | 1 |
| 38 | 7091-9000 | PCBA, TECHKIT MIXER | 1 |

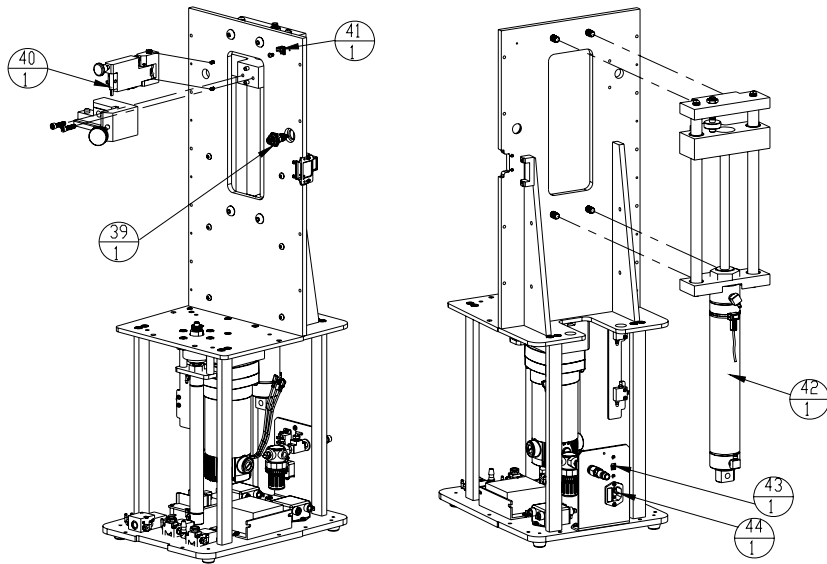


Figure 18.0 Inside Assembly Level One

| ITEM | PART NUMBER | DESCRIPTION | QTY |
|------|-------------|-----------------------------|-----|
| 39 | 535 | PLUNGER AIR INLET | 1 |
| 40 | 5500-0008 | FLUID LEVEL SENSOR | 1 |
| 41 | 3300-0408 | TUBE HOLDER, 1/4" TUBE DIA. | 1 |
| 42 | 7091-9140 | MAIN AIR CYLINDER | 1 |
| 43 | 5100-0060 | VOLTAGE SELECT SWITCH | 1 |
| 44 | 2100-0372 | POWER CONNECTOR | 1 |

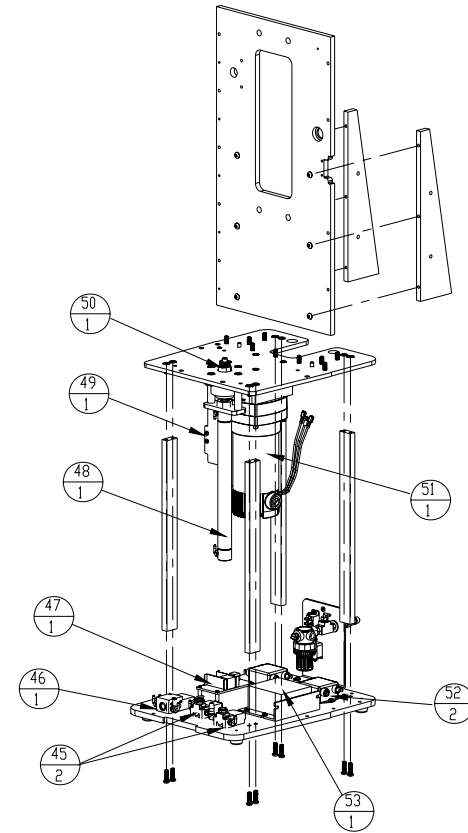


Figure 19.0 Inside Assembly Level 2

| ITEM | PART NUMBER | DESCRIPTION | QTY |
|------|-------------|--|-----|
| 45 | TSD650-21 | SOLENOID VALVE | 2 |
| 46 | 2600-0132 | SOLENOID VALVE, 4-WAY | 1 |
| 47 | 1700-0027 | DC POWER SUPPLY | 1 |
| 48 | 7091-9150 | AIR CYLINER, INJECTION ROD | 1 |
| 49 | TSD210-6 | FLOW CONTROL | 1 |
| 50 | 7091-9130 | SPINDLE SHAFT ASSY /BEARING SLEEVE | 1 |
| 51 | 7091-9160 | MOTOR ASSEMBLY | 1 |
| 52 | 2700-0046 | FILTER, EMI, 115/250 VAC, 3A, 50-60 Hz | 2 |
| 53 | 7091-9120 | MOTOR DRIVER | 1 |

15.2 TECHKIT PART NUMBER CHART

| SIZE | PART NUMBER | ROD LENGTH | KIT TYPE |
|---------------------|-------------|------------|---------------|
| 2.5 oz. (74ml) | 250-61T | 6" (152mm) | Taped Barrier |
| | 250-81T | 8" (203mm) | Taped Barrier |
| | 250-60 | 6" (152mm) | Injection |
| | 250-80 | 8" (203mm) | Injection |
| 6.0 oz. (177ml) | 600-61T | 6" (152mm) | Taped Barrier |
| | 600-81T | 8" (203mm) | Taped Barrier |
| | 600-60 | 6" (152mm) | Injection |
| | 600-80 | 8" (203mm) | Injection |
| 8.0 oz. (237ml) | 800-61T | 6" (152mm) | Taped Barrier |
| | 800-81T | 8" (203mm) | Taped Barrier |
| | 800-60 | 6" (152mm) | Injection |
| | 800-80 | 8" (203mm) | Injection |
| 20 oz. (591ml) | 200-81T | 8" (203mm) | Taped Barrier |
| | 200-80 | 8" (203mm) | Injection |
| 1/10 gal (325ml) | 110-81T | 8" (203mm) | Taped Barrier |
| | 110-80 | 8" (203mm) | Injection |



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