

Owner's Manual: Red D Mix

Five-Gallon Gyro Mixer

05025 Models

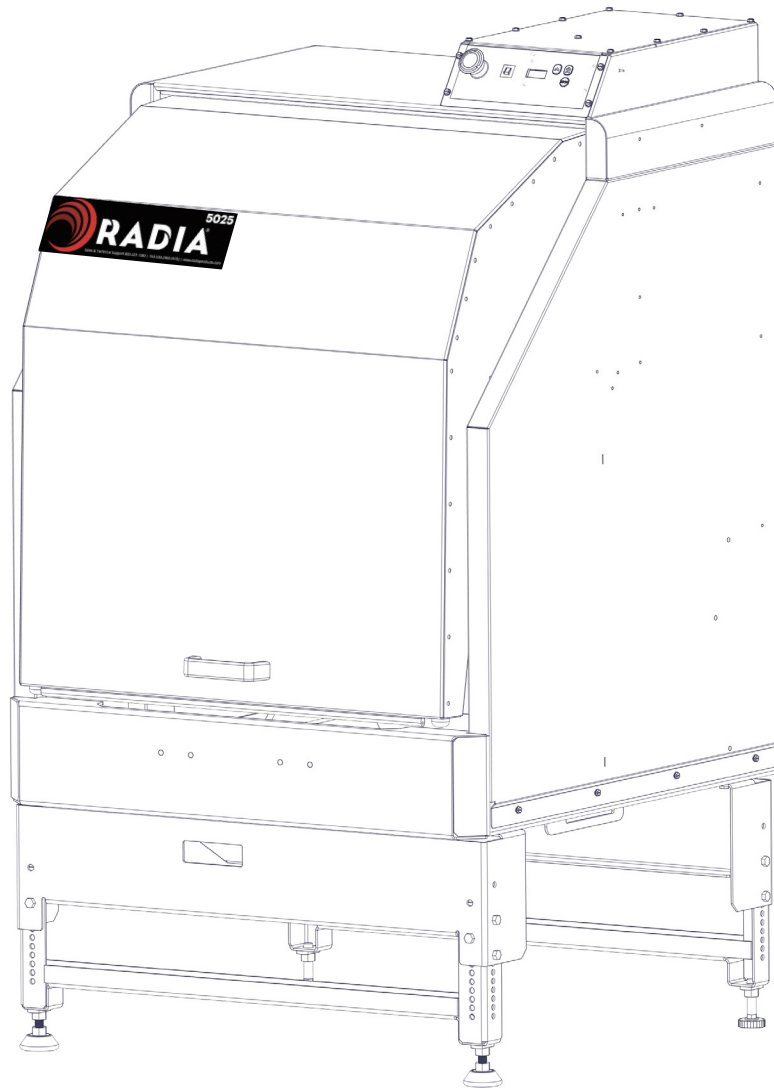


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1. Safety Information

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.

	"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.
	"CAUTION!" indicates a hazardous situation, which, if not avoided, could result in minor or moderate injury.
	"NOTICE" indicates practices that do not involve physical injury but may damage the machine.

1.1 Safety Precaution Labels



WARNING
ADVERTENCIA
AVERTISSEMENT

MOVING PARTS INSIDE
PARTES EN MOVIMIENTO
PIÈCES EN MOVEMENT

-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.

Part No. 1784963

NOTICE

DO NOT OVER-TIGHTEN!
Tighten clamp up to 1/2 turn
after contact with pail lid.

Part No. 1784462

Safety Information, Continued..

1.1 Safety Precaution labels



WARNING

ADVERTENCIA

CUIDADO

-This machine is not explosion proof rated.

-Review product label, Material Safety Data Sheet, and HMIS rating of materials and exposures prior to mixing to determine potential hazards.

-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.

-All containers must be properly sealed and void of leaks.

-Esta máquina no tiene la clasificación de prueba de explosión.

-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.

-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.

-Todos los contenedores deben estar bien sellados y sin fugas.

-Esta máquina não está classificada como sendo à prova de explosão.

-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.

-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.

-Todos os recipientes devem estar vedados corretamente para evitar vazamentos.

Part No. 1780899



WARNING

ADVERTENCIA

AVERTISSEMENT

-Machine must be properly grounded before use; improper grounding could cause electric shock and injury.

-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.

-Review Owner's Manual before installing or operating.

-La maquinaria debe ser apoyada correctamente en el suelo antes de usar, el no apoyarla puede causar choque eléctrico y daños.

-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.

-Revise el manual del usuario antes de instalar u operar.

-La machine doit é'tre correctement mis a' la terre avant de les utiliser mise a' la terre incorrecte peut provoquer un choc é'lectrique et de blessure.

-De'branchez le cordon d'alimentation avant de procé'der a' l'entretien, le nettoyage ou le retrait des capots; suivez la procé'dure d'isolation/consignation procé'dures dans le manuel de l'opérateur;

E'chec de de'brancher la source d'alimentation peut provoquer shockand é'lectrique blessures.

-Re'examiner le fonctionnement manuel avant l'installation.

Part No. 1781570

NOTICE

BEFORE RUNNING MACHINE, DID YOU...

- 1. POSITION CONTAINER PROPERLY?**
- 2. ATTACH THE BAIL SPRING?**
- 3. TIGHTEN CLAMP SECURELY?**

Part No. 1784000

Safety Information, Continued..

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 procedures 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 and 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 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.
-  Clamp the can carefully to ensure that it is held securely during the mixing cycle.
-  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 05025 Gyro Mixer. This machine is designed to accommodate standard five-gallon plastic or metal pails weighing up to 125 lb. (45.3 kg).

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.

An optional Riser Leg Kit is available for additional height adjustments. This kit is included with the 05025-U and 05025-C models. This kit can be purchased for use with other 05025 models. Please see section 9, Ordering, for additional information.

Keep this manual for future reference.

Always follow all safety instructions!

2.2 Specifications

Unit Size: **W** 32.5 in (82.5 cm) **D** 34 in. (86.4cm)
H 47 in (119.3 cm)

Weight: 440 lb.

Electric Service: 110 V 60 Hz

Machines rated at 110 V, 60 Hz are for use on a nominal 120 V circuit.

Note: P3 models can not be run with a GFI outlet.

Capacity: 125 lb. (45.3 kg)

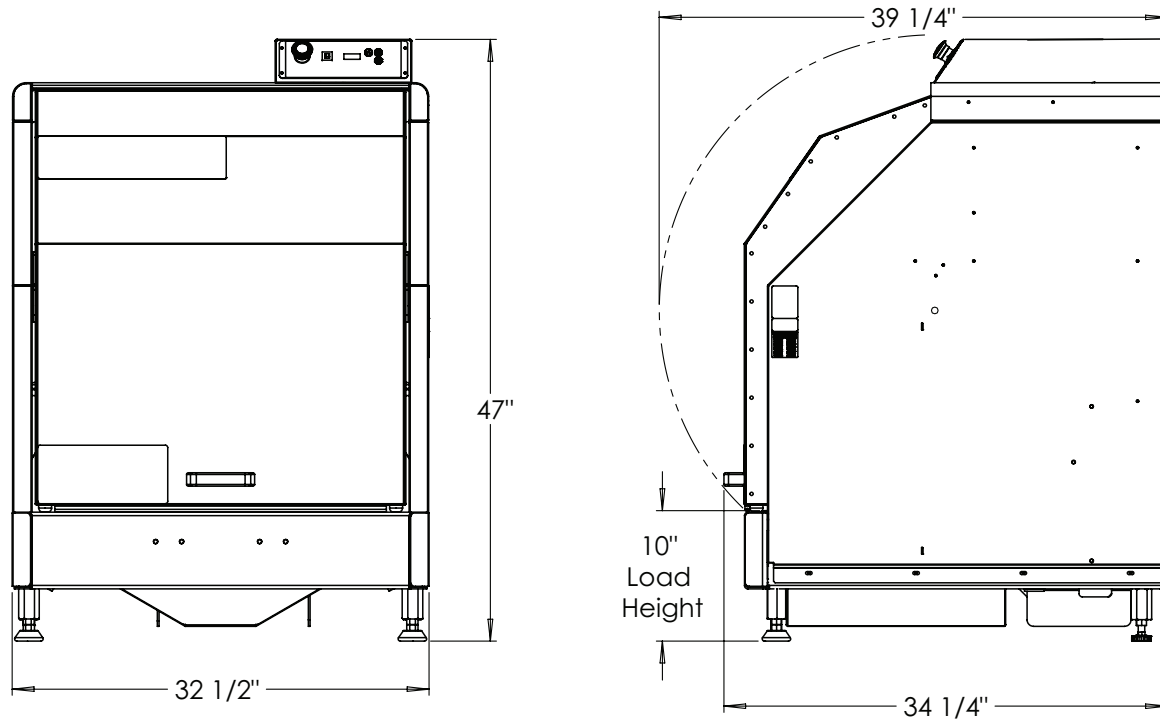
Sizes Mixed: 5 gal. (19 L), 13 in. (33 cm) to 16 in. (41 cm) H

Load Height: 10 in. (25.4 cm)

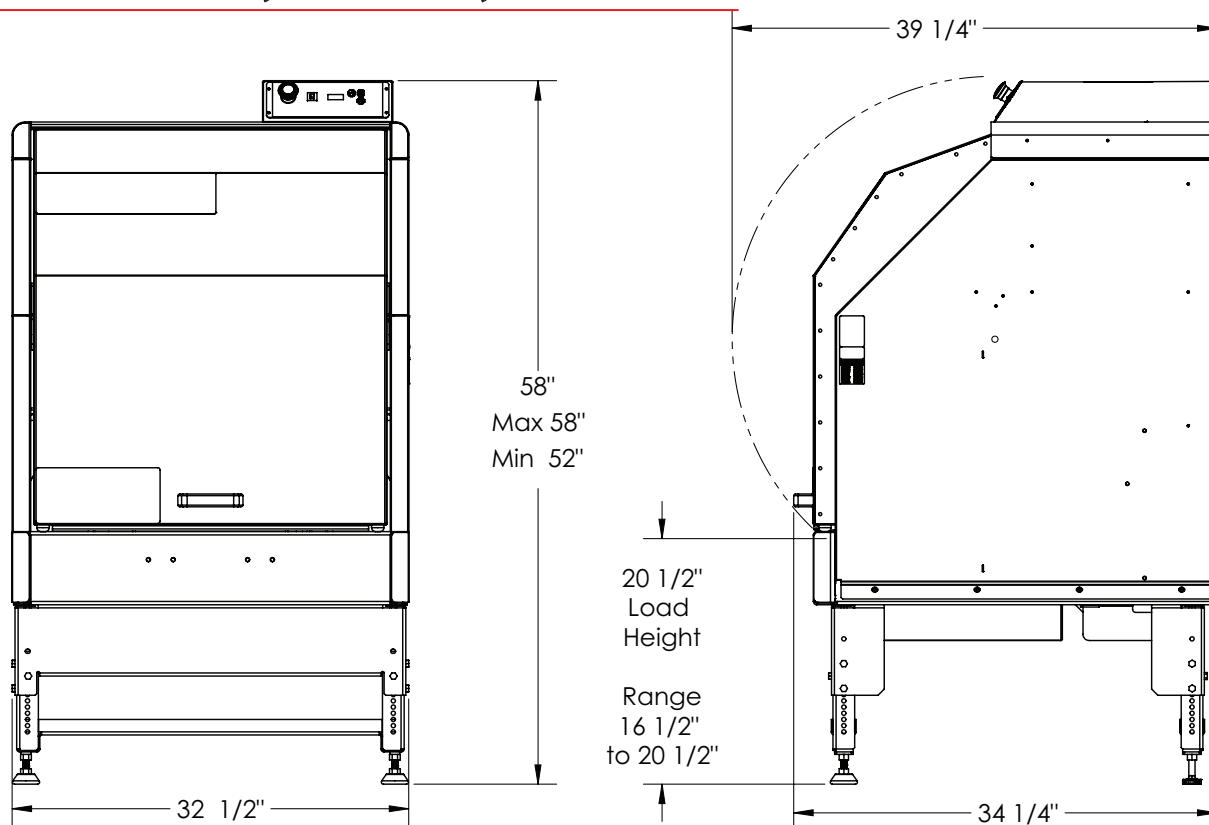
Timer: Digital Display Timer

3. Installation

MODEL 5025P3



MODEL 5025UP3, 5025U2P3, & 5025UP3DL



3.1 Prepare for Use

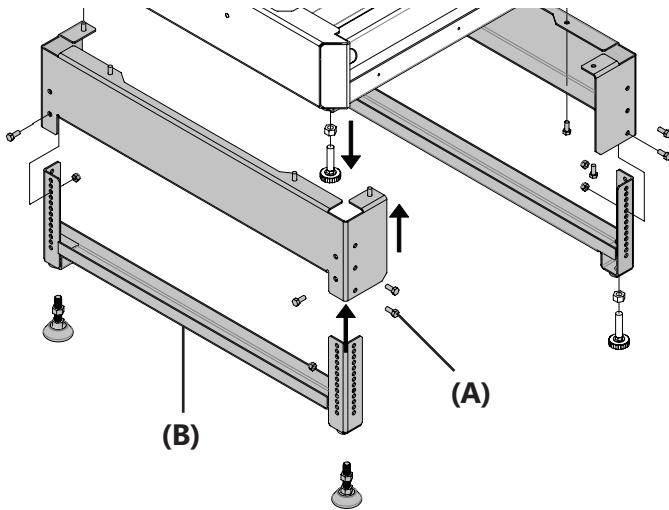
IMPORTANT: Before attempting to operate the machine:

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 (if needed)

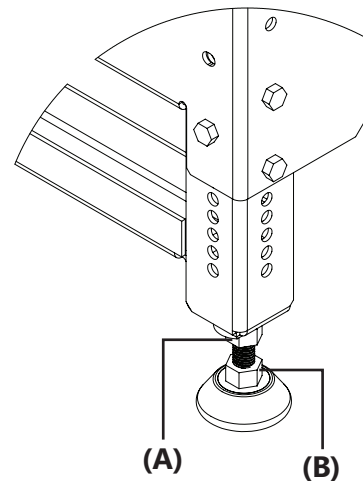
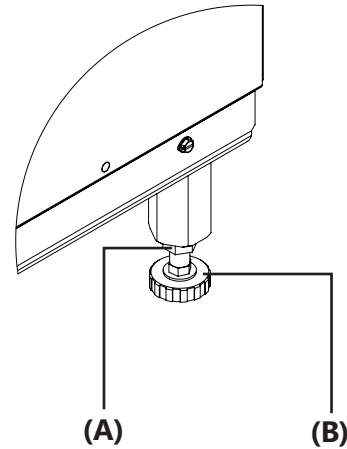
⚠ Avoid personal injury! Be sure the machine is stable.

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

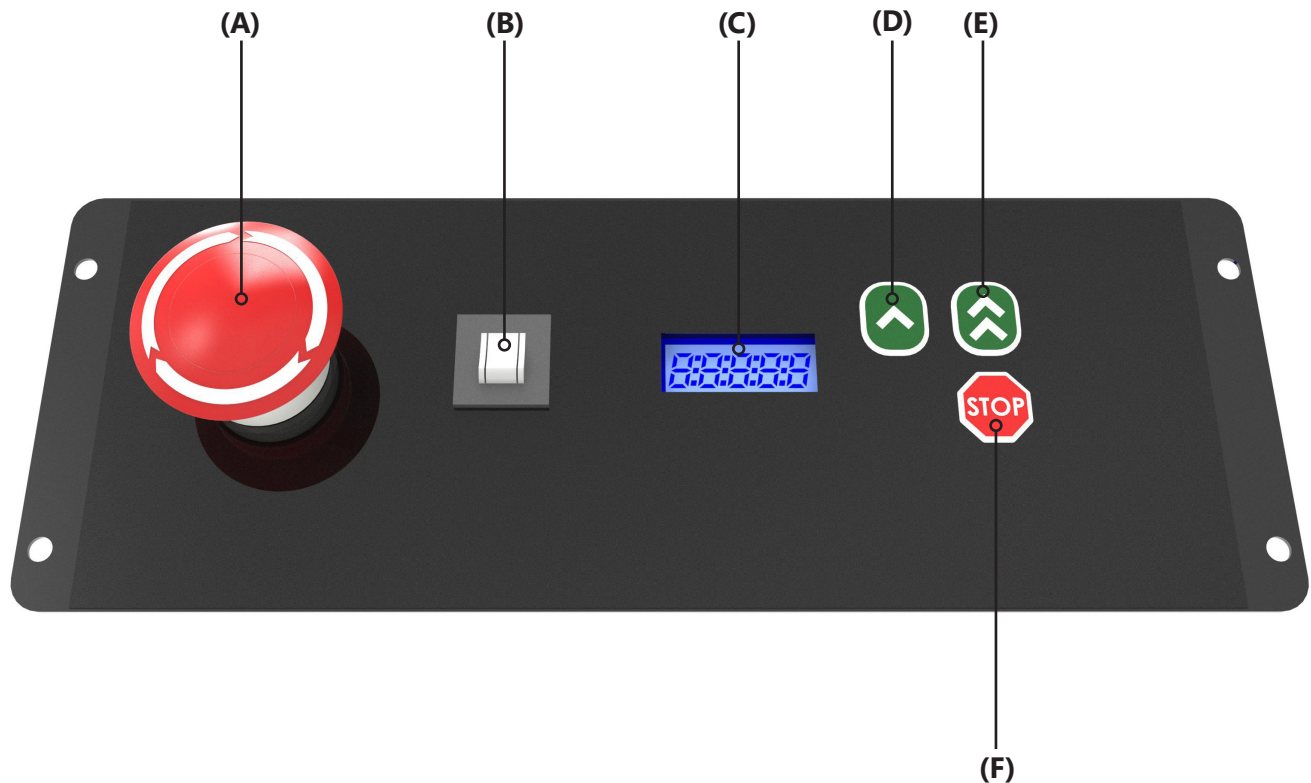
1. Clamp a 5-gallon pail in the machine as per the instructions in Section 4.2, install a Pail and Mix.
2. Turn the timer to start the machine.
3. Adjust any feet under which a piece of paper can fit.
 - A. Loosen the upper jam nut **(A)**.
 - B. Turn the foot **(B)** to adjust.
 - C. Tighten the jam nut **(A)** when the feet make full contact with the floor.
4. Repeat with any additional feet that may still need adjustment.



4. Operation

4.1 Control Panel

- **E-Stop Push Button (A):** Only use to immediately cut the power to the machine.
- **Breaker Switch, 20-Amp (B):** Turn off the power and push the switch if the breaker trips.
- **Digital Display (C):** View programming revision, Cycle count, and cycle time remaining.
- **Two-Minute Cycle (D):** Push to set a two-minute cycle, and to increase a cycle in two minute increments.
- **Three-Minute Cycle (E):** Push to set a three-minute cycle, and to increase a cycle in three minute increments.
- **Stop (F):** Push to stop the cycle. Any remaining cycle time will be deleted.



..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.
Pull the red ratchet lever **(A)** toward you and the handle on top of clamp **(B)** counterclockwise to raise the plate.
2. Slide the pail under the clamping (top) plate **(C)**.
3. Position the pail in the grooves on the bottom plate **(D)**. The grooves on the plate keep the pail in place during mixing.
4. Lower the clamping plate (B) by turning the handle clockwise. Once the plate makes contact with the pail, tighten another 1/4 turn.
5. Secure the bail spring.
6. Close the door and start the machine.

NOTICE

A Safety interlock interrupts machine operation if the door is open.

NOTICE

If the bail spring wasn't properly secured, press the **EMERGENCY STOP** button on the control panel.

REMOVAL:

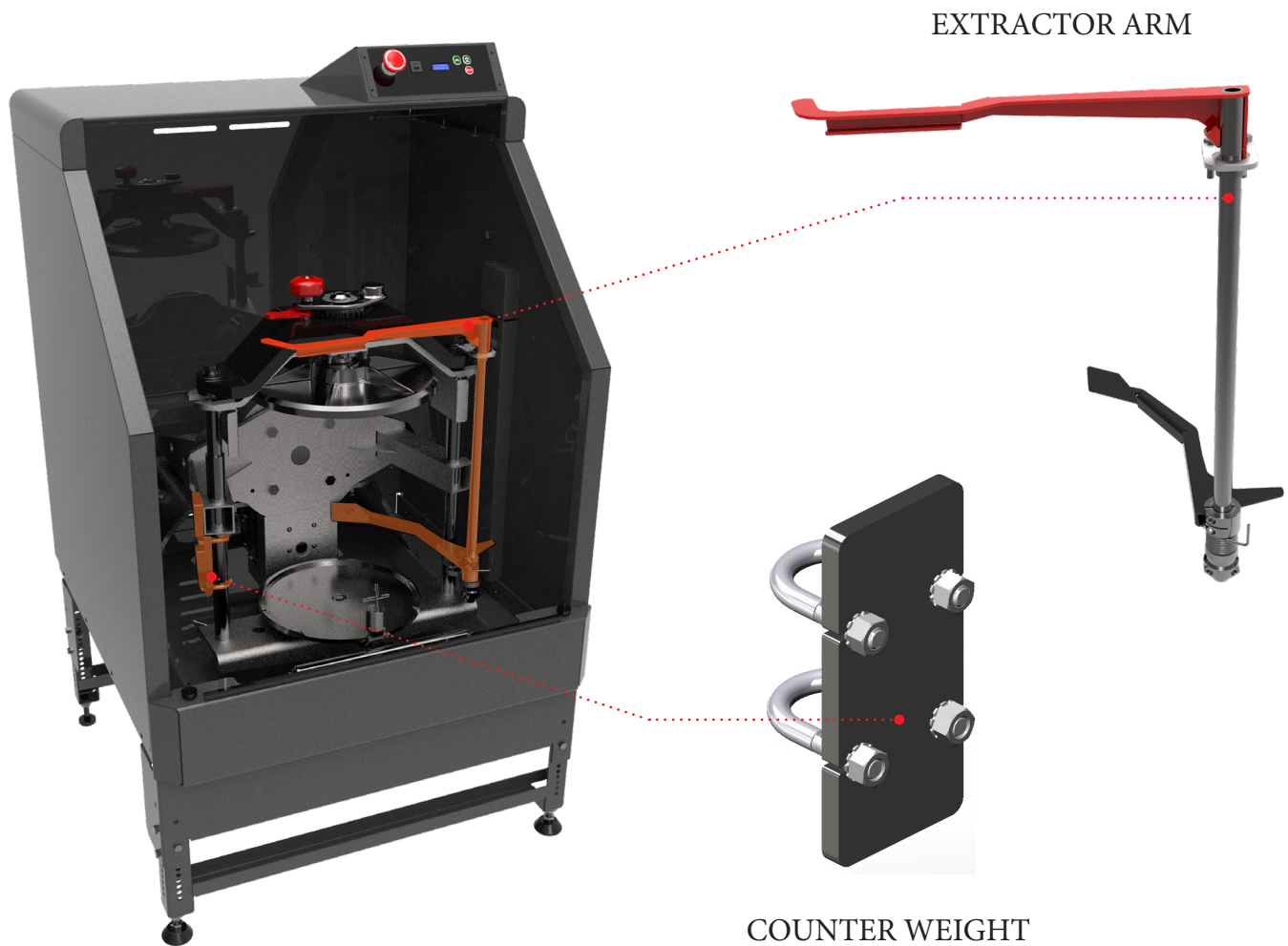
 **WARNING:** Avoid serious personal injury!
Do not open the door until the machine comes to a complete stop.

1. Raise the clamp all the way to the top by holding the ratchet lever open while turning the crank handle counter-clockwise.
2. Unfasten the bail spring.
3. Remove the pail by hand or with extractor option.



4.3 Pail Extractor Options

5025 Universal-Legs with Extractor



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

Lubrication:

1. Speed Reducer: Maintenance is not required. If an oil change is necessary due to debris build-up:

A. Remove the oil drain plug on the bottom side of the machine and drain the oil from the gearbox.

B. Remove the oil level plug and fill only up to that level: with Mobil SHC 634 Synthetic oil. Do not overfill or underfill.

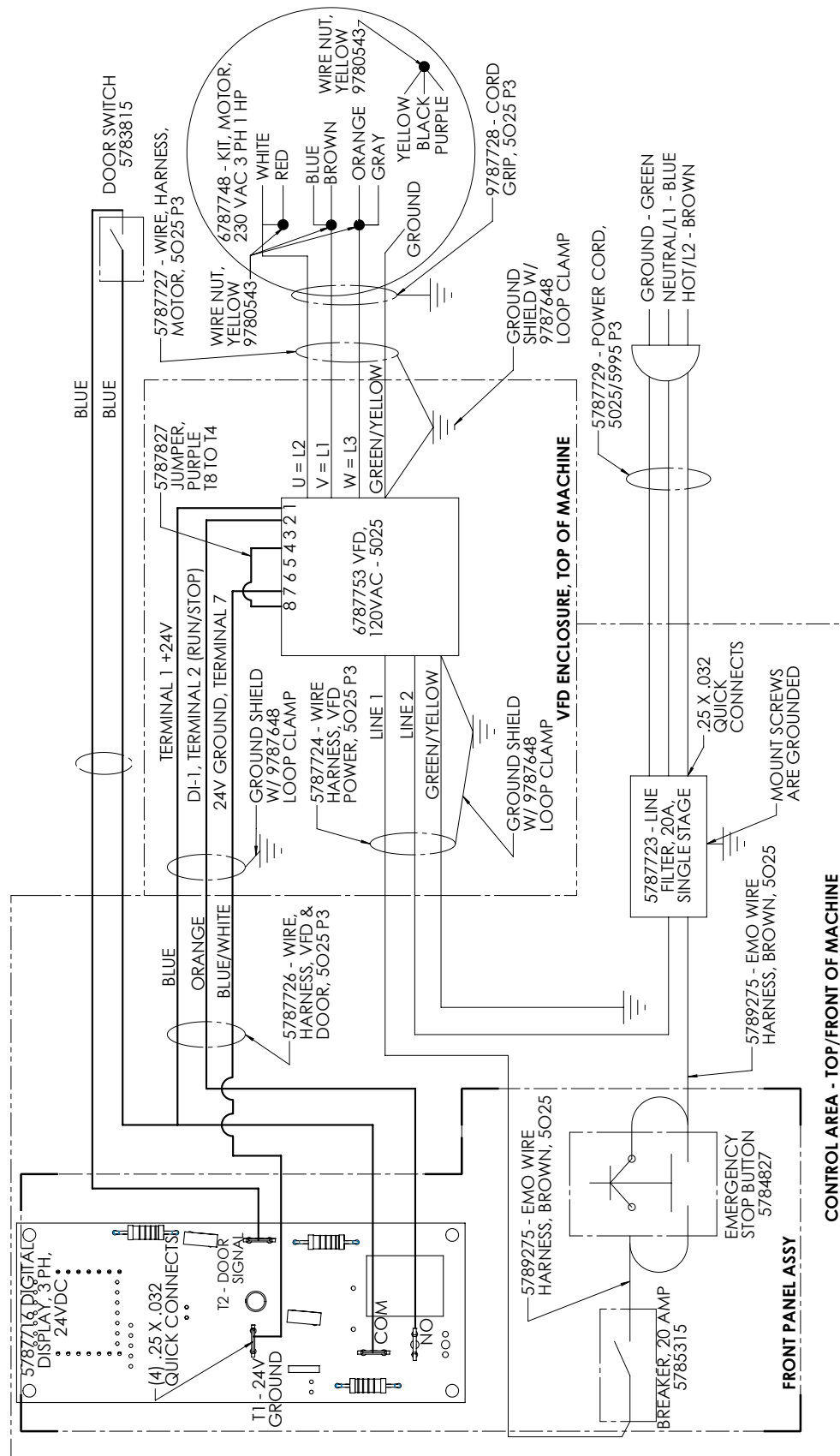
2. Clamp: Lubricate the clamping screw threads and thrust bearing as needed.

3. Ratchet Lever: Lubricate the shaft as needed.

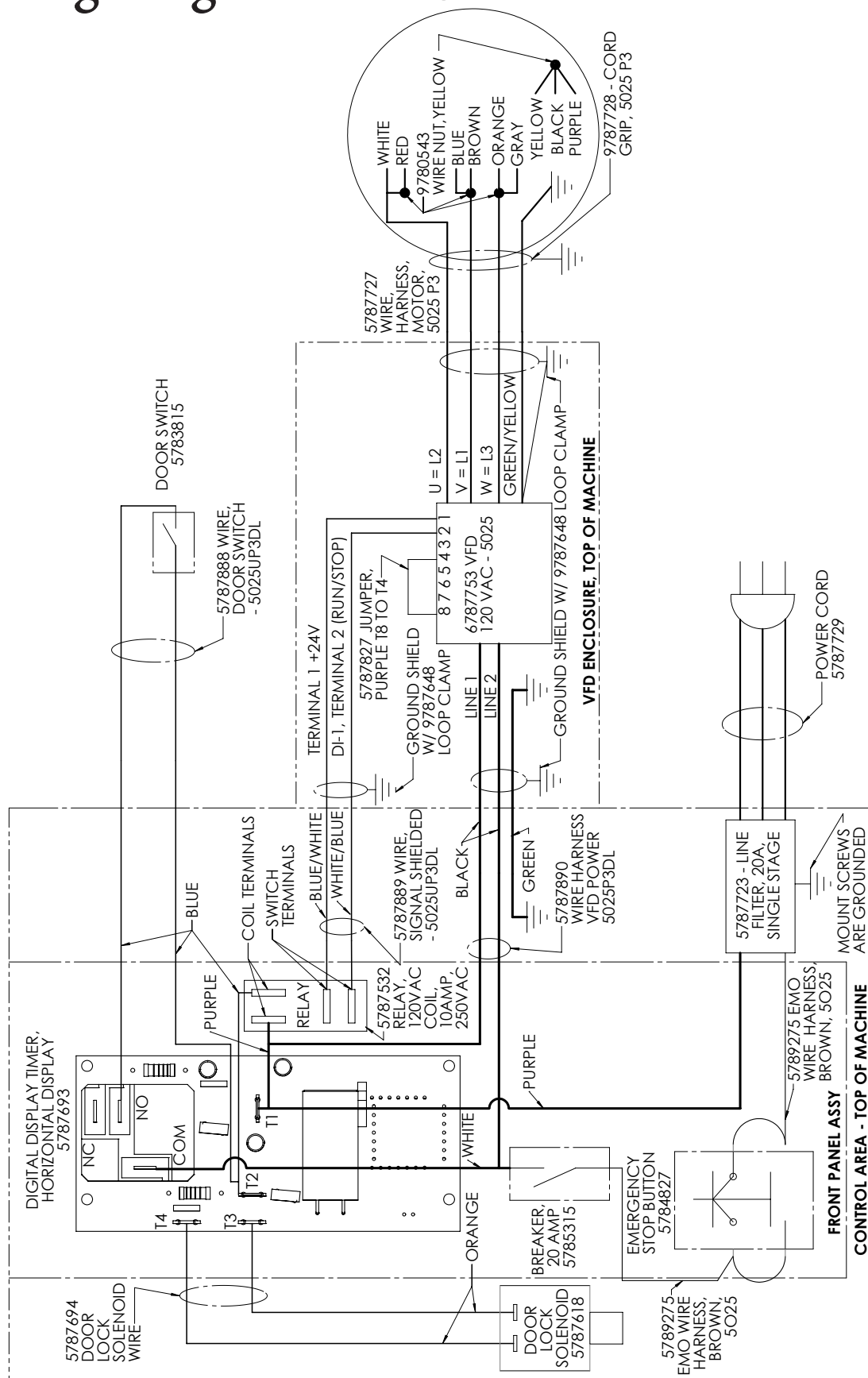
6. Troubleshooting

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
	Building circuit breaker or fuse blown	Reset breaker or replace fuse
	Machine door does not make contact with limit switch	Adjust switch to make contact with limit switch screw when door is closed
	Machine circuit breaker tripped	Reset by pressing circuit breaker back in
pail won't fit properly into clamping plates	Pail damaged	Fix or replace pail
Machine doesn't shut off at end of mixing cycle	Faulty controller	Contact Radia Customer Care
Machine doesn't shut off when door is opened	Faulty door limit switch	Contact Radia Customer Care
Increasing mechanical noise	Bearings worn or damaged	Contact Radia Customer Care
Pail rotates inside the clamping plates	Top clamp pad worn	Replace pad
	Top clamp not secure	Turn the crank handle down until top plate is snug on pail

7.1 Wiring Diagram 5025 P3

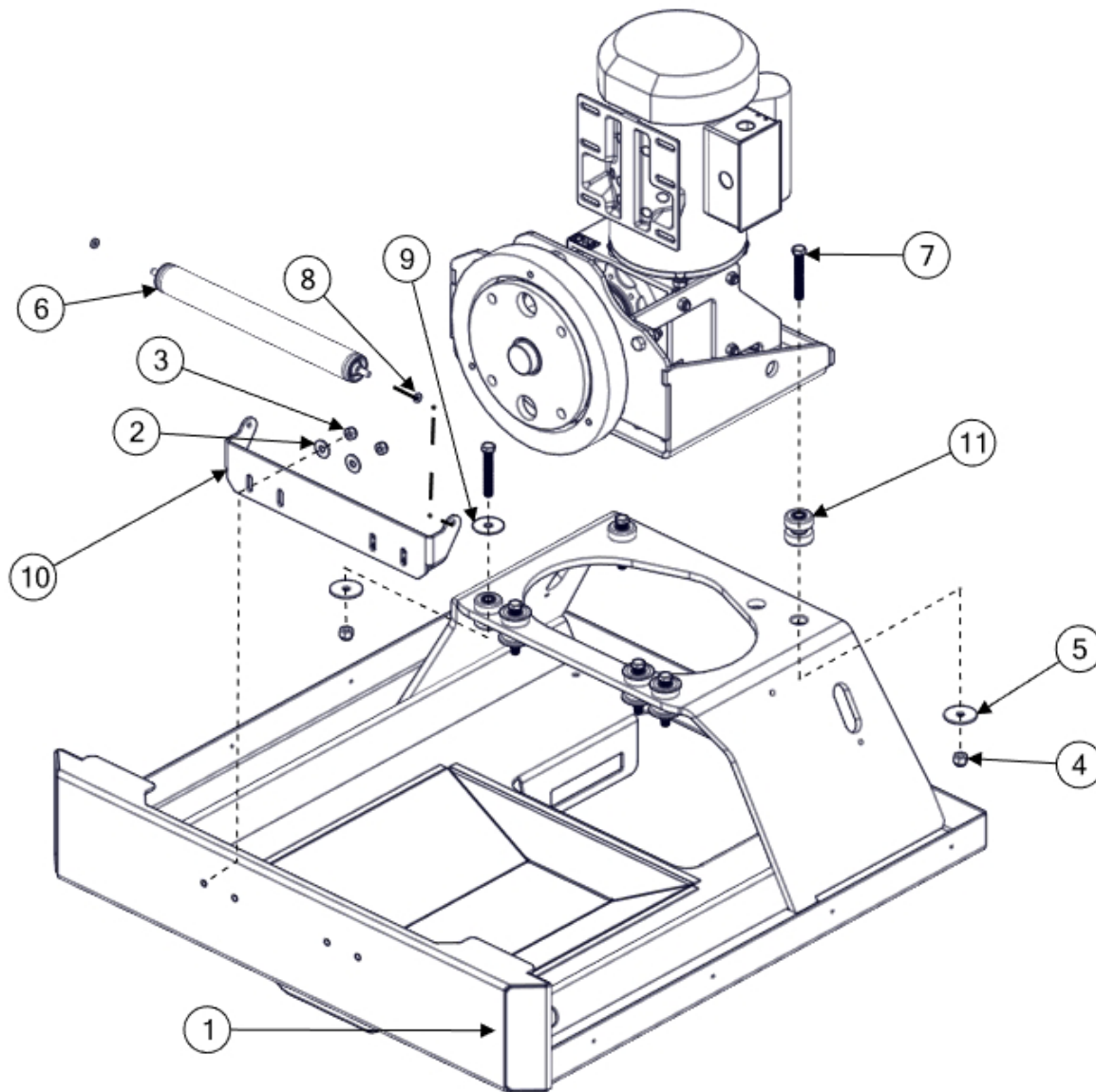


7.2 Wiring Diagram 5025UP3DL



8. Exploded Views

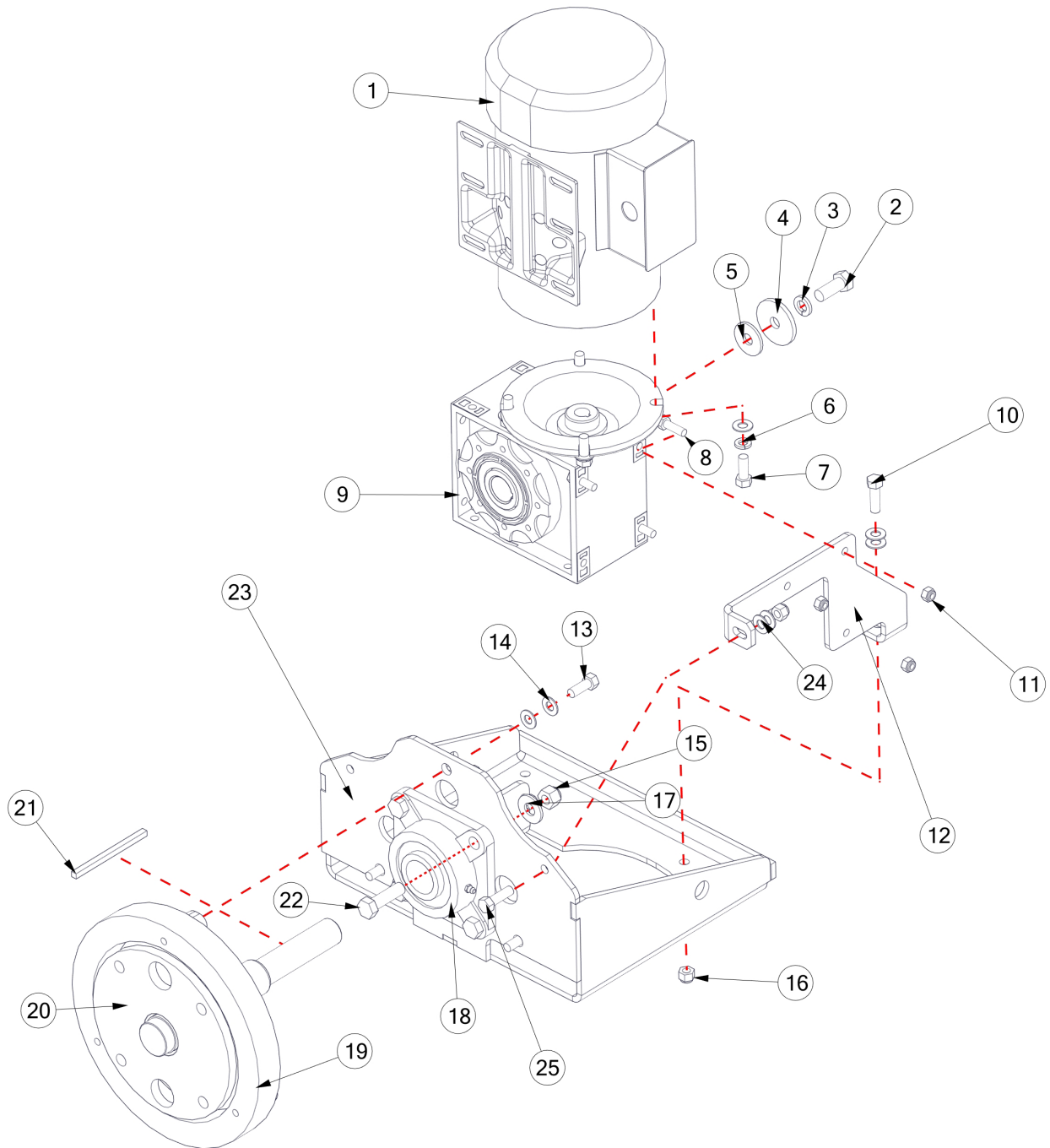
8.1 Frame and Drive



BOM ID	Description
1	9786804 Base Weldment
2	9100023 WASHER, FLAT 5_16 USS
3	9780182 Nut, Nylock 5_16-18
4	9780193 NUT, NYLOCK 3_8-16
5	9780368 Washer
6	9782520 ROLLER

BOM ID	Description
7	9783894 Screw Hex 3_8-16 x 2.50 Full Thd
8	9785537 WASHER, NEO, .195 ID, .438 OD, .093T
9	9786768 WASHER, FLAT, .406 ID X 1.50 OD X .062 TH, SS
10	9786803 BRACKET, ROLLER - 5025
11	9780367 Isolator

8.2 P3 Main Drive

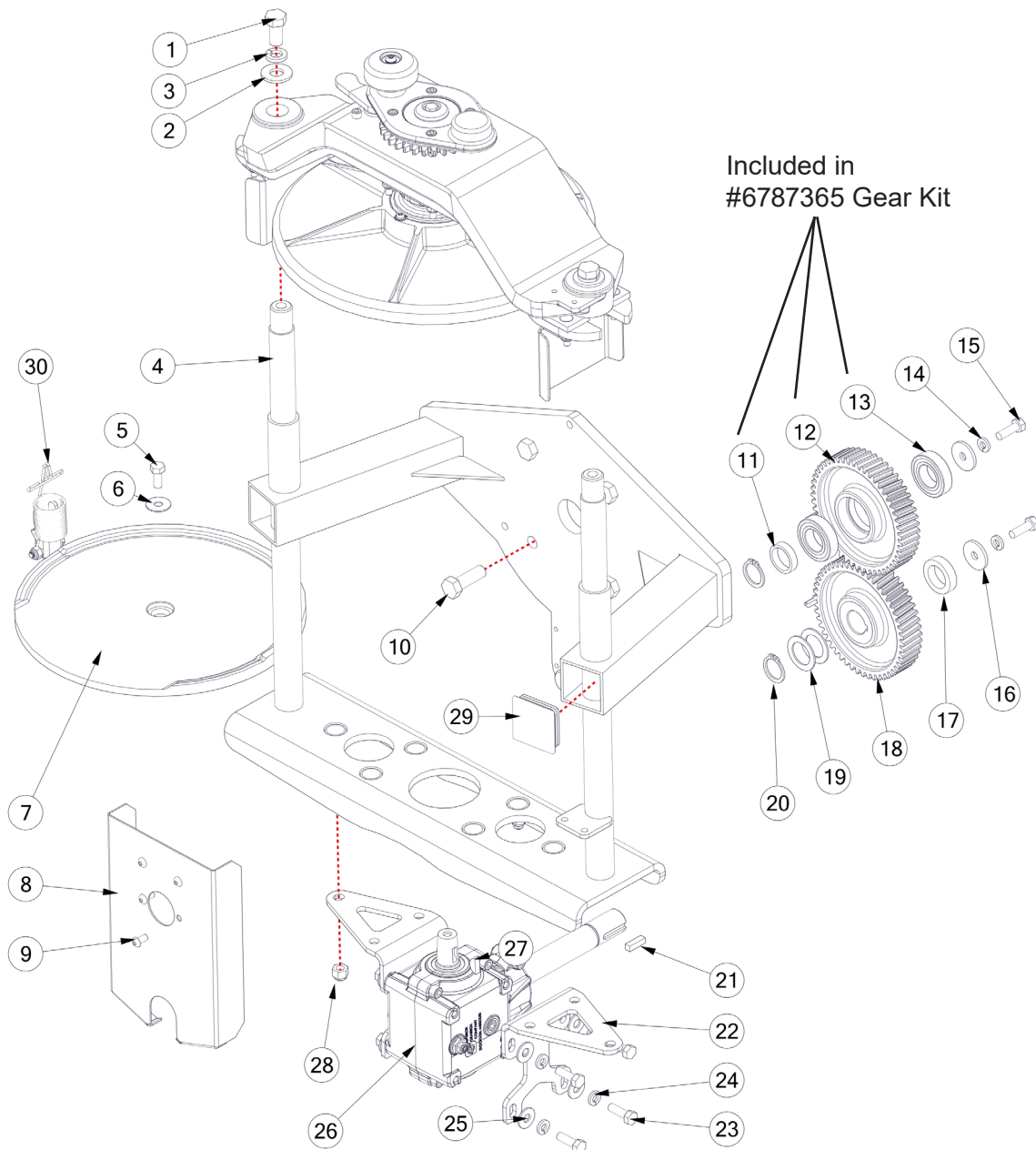


BOM ID	Description
1	5787536 MOTOR, 230VAC, 3 PH, PREM 1 HP, 56C FRAME
2	9788042 SCREW, HEX 1_2-13 X 1.25 GR5 Zinc Patch
3	9780214 Washer 1_2 LOCK
4	9781083 Washer, Flat .507 ID x 2.00 OD x .19 Thk
5	9785587 WASHER, FLAT .512 ID X 1.456 OD X .118 THK
6	9780402 Washer 3_8 split lock
7	9788040 SCREW HEX 3_8-16 X 1.00 GR8 Zinc Patch
8	9788029 Screw Hex 5_16 X 1 GR5 Zinc Patch
9	9785464 GEARBOX, RIGHT ANGLE SPEED REDUCER - 5925
10	9781228 Screw Hex 3_8 X 1 1_4
11	9780182 Nut, Nylock 5_16-18
12	9786713 BRACE, GEARBOX - 5025-5925
13	9788040 SCREW HEX 3_8-16 X 1.00 GR8 ZP Patch

BOM ID	Description
14	9100731 WASHER, FLAT 3_8 X .82 OD
15	9783383 Nut 1_2 Nylon Lock
16	9780193 NUT, NYLOCK 3_8-16
17	9688200 Washer 1_2
18	9786712 BEARING, FLANGE - INSIDE, 1.5 ID
19	9786711 GEAR, HELICAL, 76 TOOTH - 5025, RH - 5025
20	9786723 SHAFT, TUMBLER, 3 GEAR - 5025
21	9785585 KEY, SQUARE .250 X 4.125
22	9782172 Screw Hex 1_2 X 1_75
23	9786714 MOUNT, GEARBOX AND GEAR - 5025
24	9100731 WASHER, FLAT 3_8 X .82 OD
25	9781228 Screw Hex 3_8 X 1 1_4

...Exploded Views, Continued

8.3 Rotating Frame Assembly, Lower Section



BOM ID	Description
1	9780221 SCREW HEX 1_2-13 X 1.00 GR8 ZP Patch
2	9688200 Washer, Flat, 1/2
4	9786757 Weldment, Clamp Frame, 5025 Style 3 Gear
5	9788084 Screw Hex 5_16 X 3_4 GR8 ZP Patch
6	9787320 WASHER, FLAT, SS, .344 X 1.00 X .050 THK
7	6786508 BOTTOM PLATE KIT 5025
8	9786718 GUARD, GEARS - 5025
9	9783365 Screw Button 1_4 x .5
10	9782154 Screw Hex 1_2 X 1.50
11	9786744 SPACER, 1.000 ID X 1.25 OD, .305 LONG, 5025
12	9786810 GEAR, HELICAL, LH, 8DP, 38 TOOTH, MOLDED
13	9785467 BEARING, RADIAL BALL 25 MM X 47 MM X 12 MM
14	9760521 Washer 5_16 Lock, Split
15	9788029 Screw Hex 5_16 X 1 GR5 Zinc Patch
16	9784441 Washer, Fender 5_16

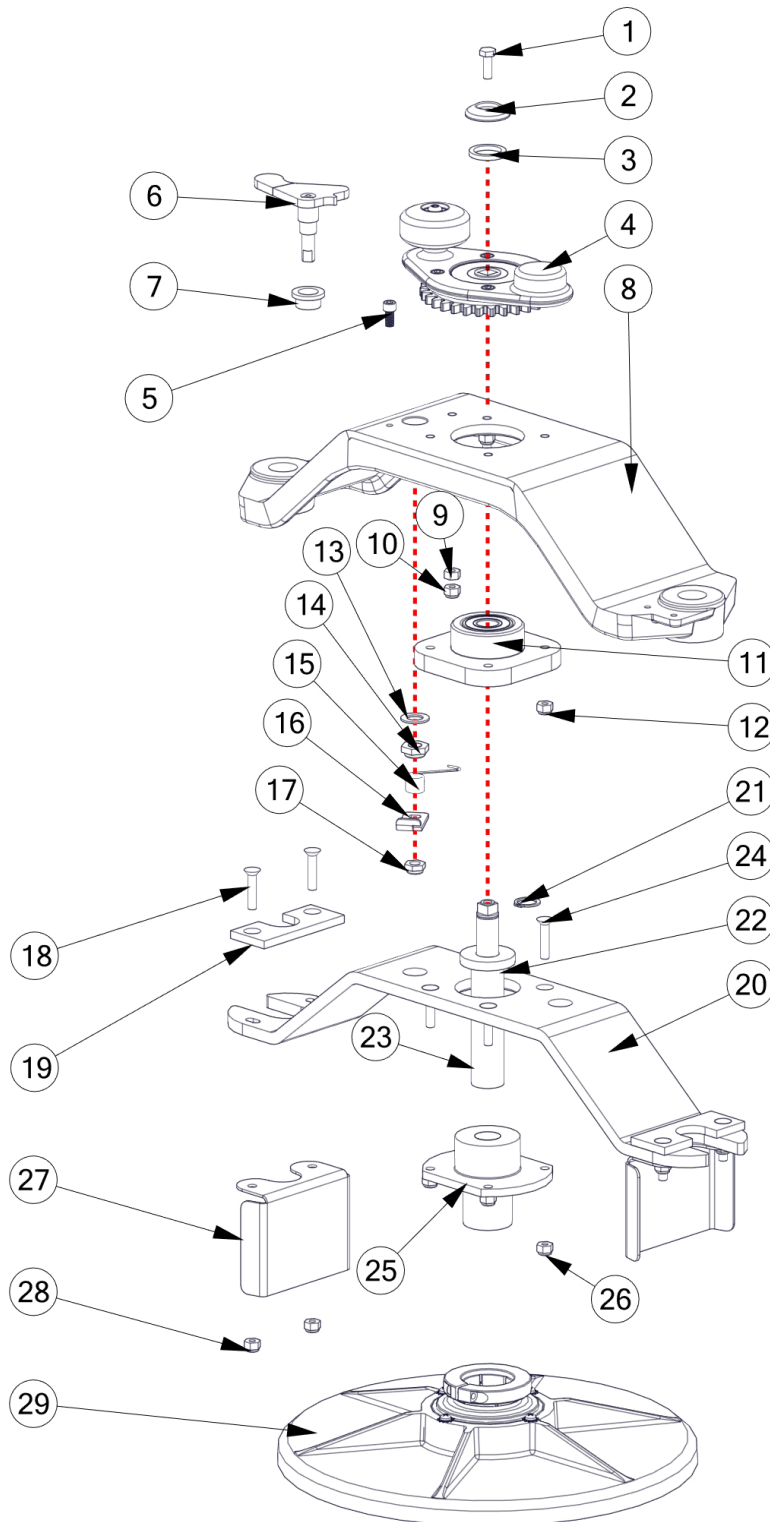
BOM ID	Description
17	9786731 SPACER, 1.005 ID X 1.50 OD X .38 LONG
18	9786811 GEAR, HELICAL, RH 8DP, 38 TOOTH, MOLDED
19	9786728 WASHER, SHIM, 1.005 ID X 1.50 OD
20	9786725 RETAINING RING, EXTERNAL, HD, 1.00 SHAFT
21	9786442 KEY, SQUARE .250 +.000 -.002 X .88 LG
22	9786743 BRACKET, GEARBOX SUPPORT - 5025 IN 5925
23	9788029 Screw Hex 5_16 X 1 GR5 Zinc Patch
24	9760521 Washer 5_16 Lock, Split
25	9100023 WASHER, FLAT 5_16 USS
26	6787325 KIT, 5025 RIGHT ANG GEAR BOX REPLACEMENT
27	9785481 KEY, WOODRUFF, NO. 806, FLAT BOTTOM
28	9780193 NUT, NYLOCK 3_8-16
29	9788515 Plug 2x2 Sq
30	9782872 SPRING, BAIL, EXTENSION - 5020

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

Exploded Views, Continued...

...Exploded Views, Continued

8.4 Rotating Frame Assembly, Upper Section



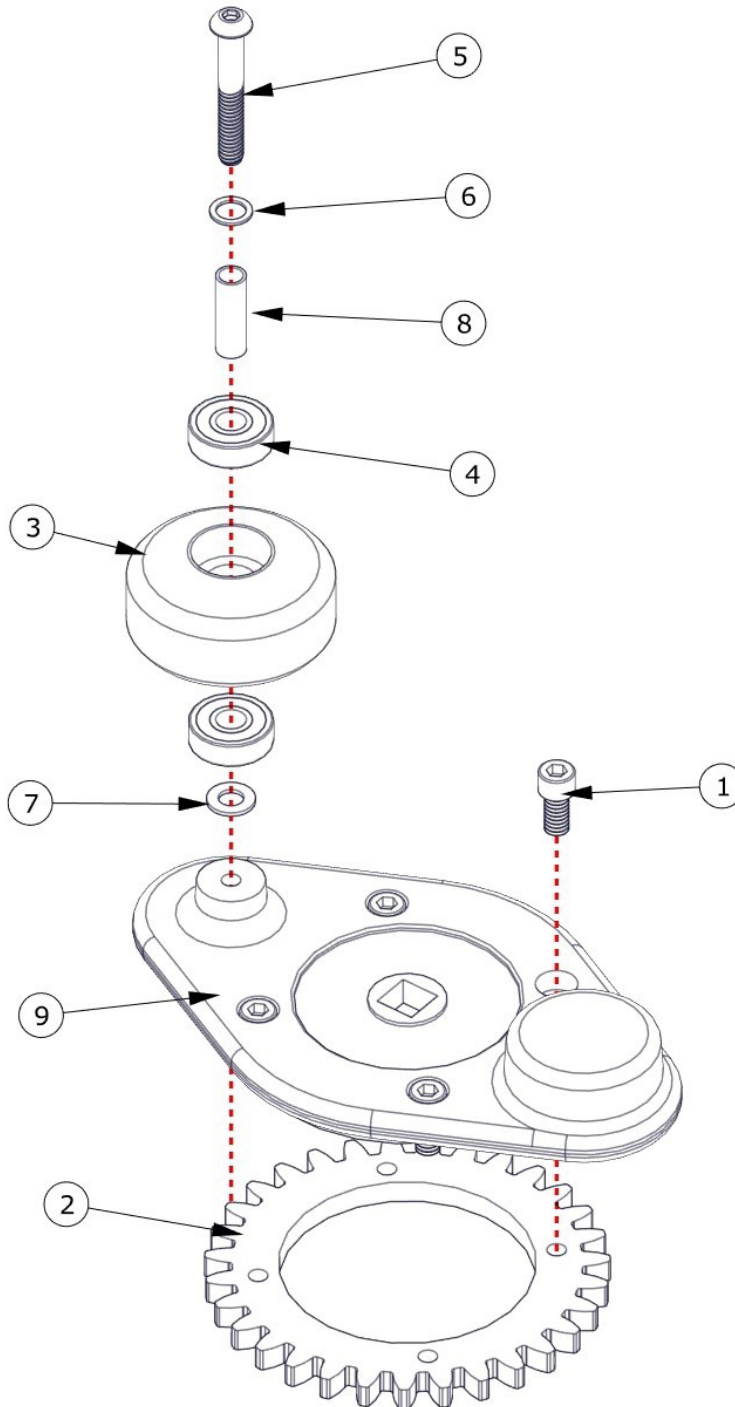
BOM ID	Description
1	9788088 Screw Hex Hd 1_4-20x0.75 GR8 ZP Patch
2	9787545 SPACER, HANDLE TOP - 5025
3	9787546 O-RING, SQUARE, VITON, DASH 212
4	6787542 Assy, Handle, Crank
5	9788026 Screw Socket Hd 1_4-20x0.50 Patch
6	6784490 Lever, Ratchet Pawl-KIT
7	9787051 BUSHING, BRONZE FLANGE
8	8786716 SUPPORT, TOP, LEADSCREW 5025
9	9654100 Nut 1_4-20
10	9780343 Nut 1_4-20 Nylon Lock
11	6783940 Brg Housing Assy, Double Row Ball Brg
12	9780343 Nut 1_4-20 Nylon Lock
13	9783963 SHIM .515 X .875 X .053
14	9783962 Nut 1_2-20 Nylon Lock Thin Jam
15	9783960 SPRING, TORSION LH
16	9784488 Plate, Spring
17	9783951 Nut, 3_8-16 Jam Nylon Lock
18	9782331 Screw, flat head 1_4 X 1.25
19	9783936 Guide, Alignment, Plastic
20	8783934 Bar, Clamp Guide
21	9784100 Ring, Retaining- External
22	9784892 WASHER, THRUST, THICK - 5025
23	6787543 Clamping Screw-KIT
24	9782331 Screw, flat head 1_4 X 1.25
25	9786720 Hub, Acme
26	9780343 Nut 1_4-20 Nylon Lock
27	9786753 GUARD, VERTICAL SLIDE - 5025
28	9780343 Nut 1_4-20 Nylon Lock
29	6786702 Top Plate Assembly

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

Exploded Views, Continued...

...Exploded Views, Continued

8.5 Crank Handle



ID	Description
1	9788026 Screw Socket Hd 1_4-20x0.50 Patch
2	9783950 Gear, Ratchet
3	9784628 WHEEL, CRANK HANDLE - 5025
4	9784629 BEARING, RADIAL BALL, DOUBLE SHIELDED
5	9788025 Screw Button Hd 1_4-20x1.75 Patch

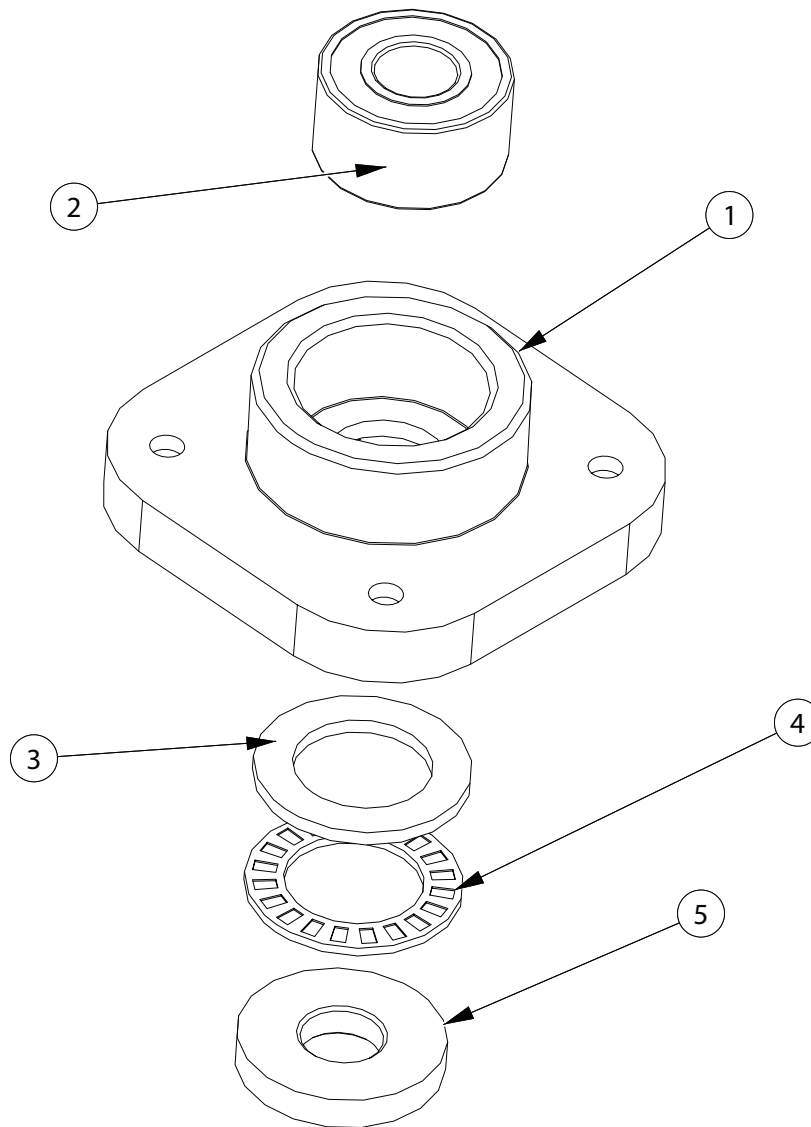
ID	Description
6	9784633 WASHER, SHIM, 5_16 X .030 THK
7	9784729 WASHER, SHIM 1_4
8	9785283 BUSHING, STEEL - 5025 CRANK HANDLE
9	9787063 HANDLE, CRANK, CAST - 5025

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

Exploded Views, Continued...

...Exploded Views, Continued

8.6 Double Row Bearing



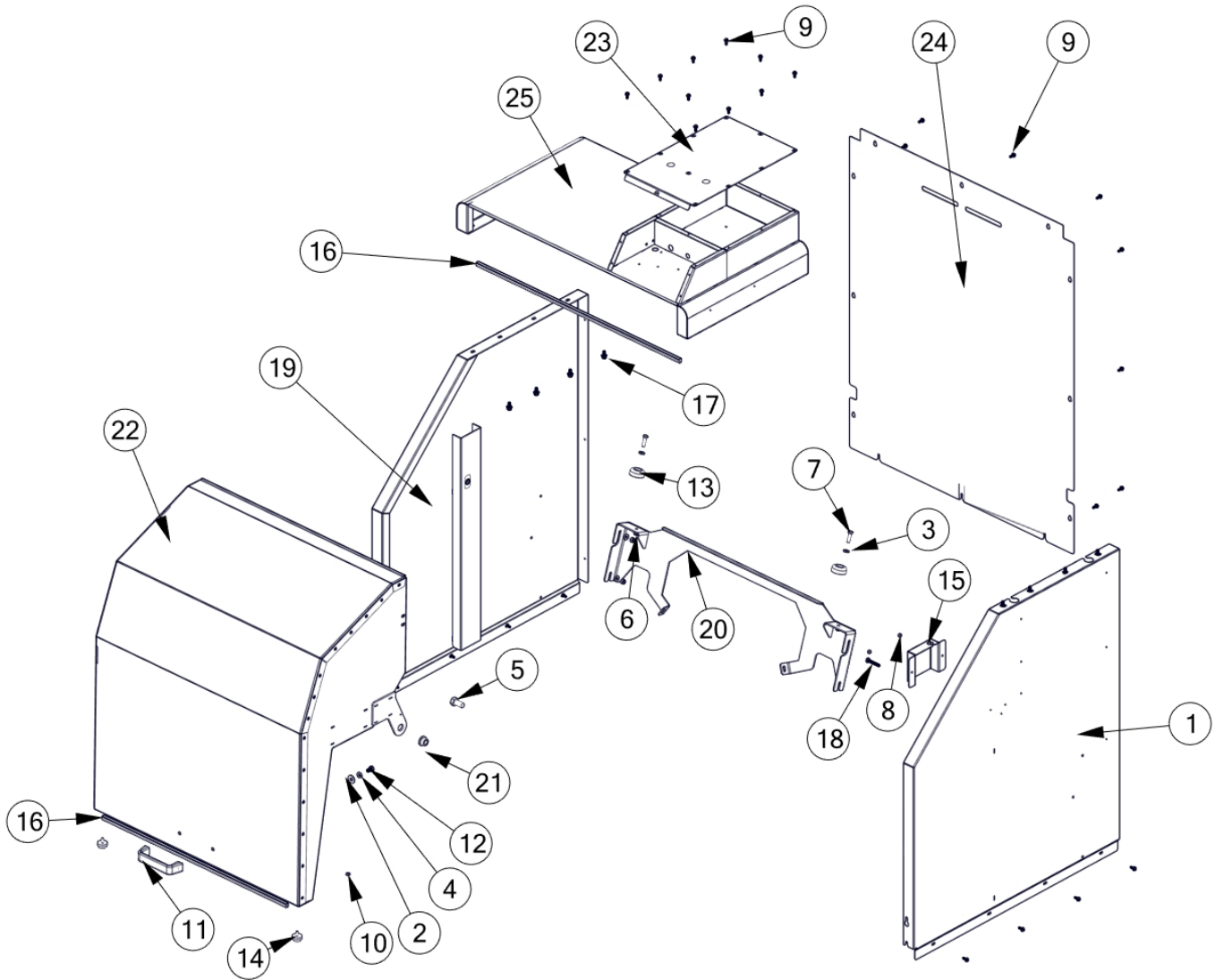
ID	Description
1	9783941 Brg Housing, Lead Screw, Double Ball Brg
2	9783942 Bearing, Double Row Radial Ball, 17mm Bore
3	9783943 Washer, Thrust Bearing, 1.125 Bore

ID	Description
4	9783944 Cage, Thrust Bearing, 1.125 Bore
5	9784892 WASHER, THRUST, THICK - 5025

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

Exploded Views, Continued...

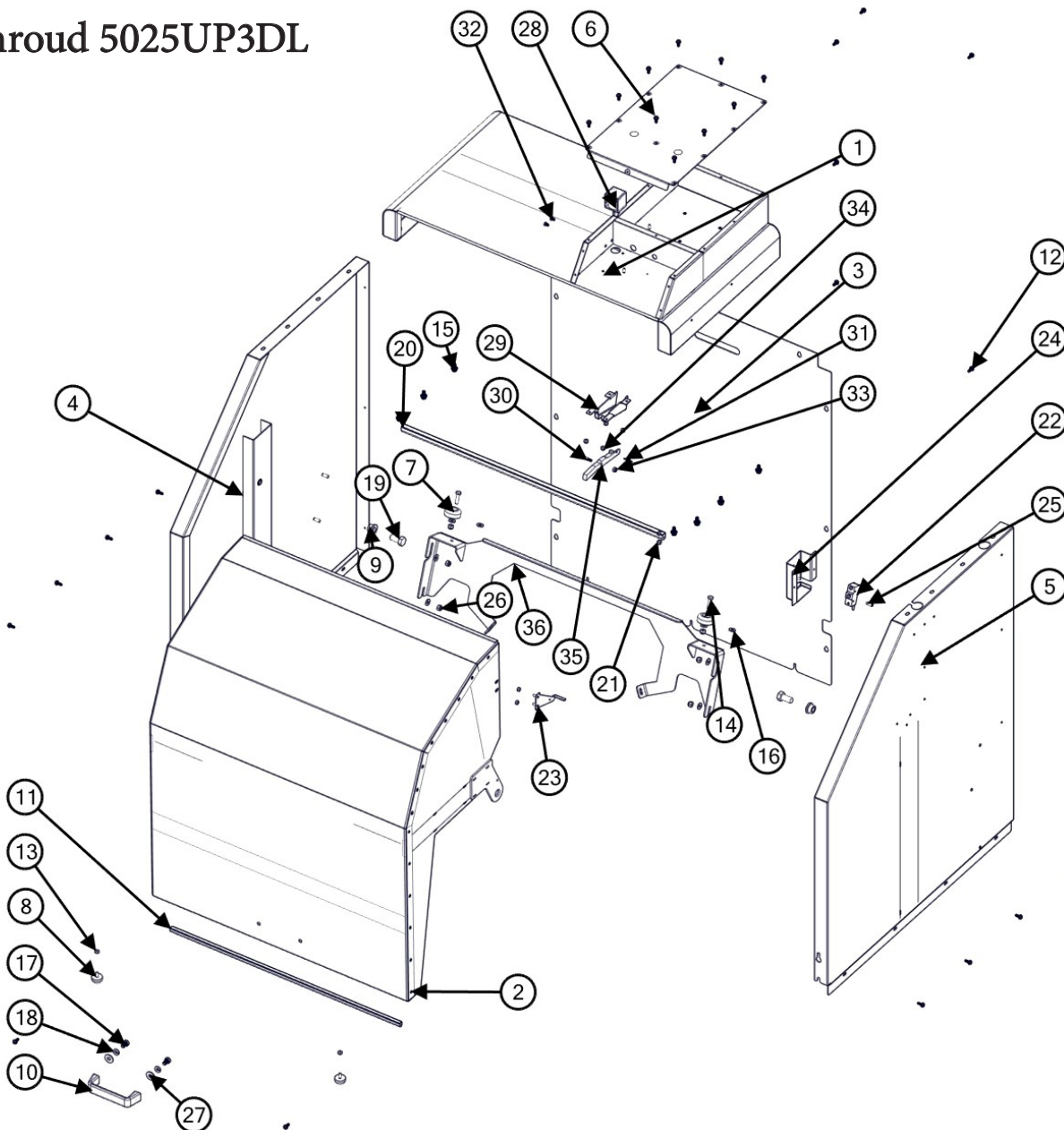
8.7 Shroud



BOM ID	Description
1	9786736 PANEL, SIDE, Right
2	9100023 WASHER, FLAT 5_16 USS
3	9760514 Washer 1_4 SAE .281 ID
4	9760521 Washer 5_16 Lock, Split
5	9788059 Screw Hex Hd 1_2-13x1.00 GR8 ZP Patch
6	9780343 Nut 1_4-20 Nylon Lock
7	9788039 Screw Hex Hd 1_4-20x1.00 GR8 ZP Patch
8	9781840 Nut, Keps #8-32
9	9783385 Screw, #10-32 SHWH Tap
10	9783426 Nut, Keps #10-32
11	9783987 Handle, Door - 5025
12	9788087 Screw Hex Hd 5_16-18x0.50 GR5 Zinc Patch
13	9783994 Bumper, Recess

BOM ID	Description
14	9785137 BUMPER, RUBBER - THREADED STUD
15	9785373 COVER, LIMIT SWITCH - 5925
16	9785773 SEAL, DOOR - 5925
17	9785779 SCREW, SERRATED FLANGE HEX HD, .25-20 X .50 LG
18	9785786 SCREW, HEX CAP 1_4-20 X 1.50 FULL THD
19	9786735 PANEL, SIDE, LEFT - 5925-5025
20	9786722 STOP, DOOR, ONE PIECE - 5925-5025
21	9786732 BEARING, BRONZE, FLANGED, .50 ID
22	9787704 WELDMENT, DOOR - 5025
23	9787706 COVER, VFD - 5025 3 PHASE
24	9787709 PANEL, BACK, 5025P3
25	9787703 PANEL, TOP, 5025 3PHASE

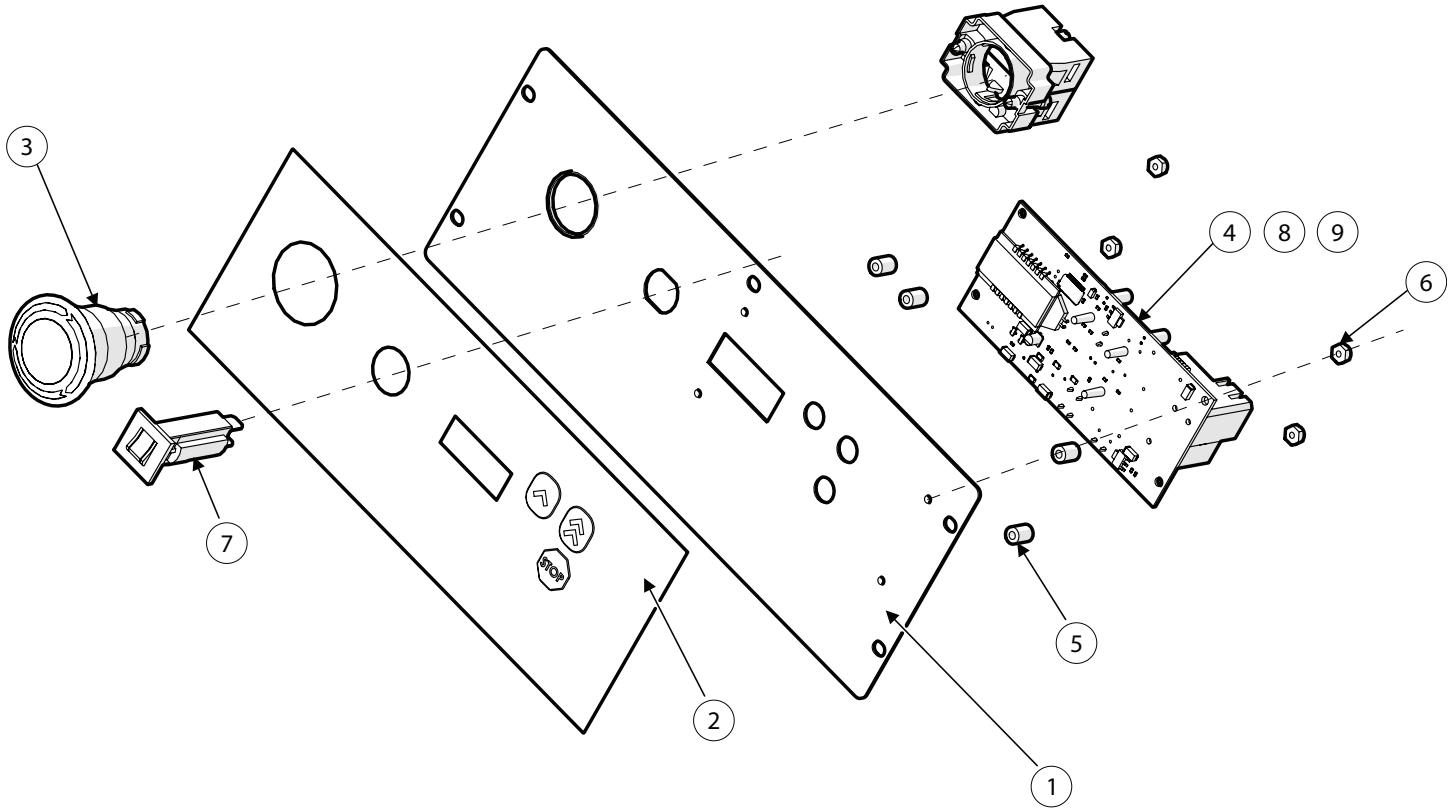
8.8 Shroud 5025UP3DL



ID	DESCRIPTION
1	9787703 PANEL, TOP, 5025 3 PHASE
2	9787704 WELDMENT, DOOR - 5025
3	9787709 PANEL, BACK, 5025P3
4	9786735 PANEL, SIDE, LEFT - 5925-5025
5	9786736 PANEL, SIDE, RIGHT - 5925-5025
6	9787706 COVER, VFD - 5025 3 PHASE
7	9783994 Bumper, Recess
8	9785137 BUMPER, RUBBER - THREADED STUD
9	9786732 BEARING, BRONZE, FLANGED, .50 ID
10	9783987 Handle, Door - 5025
11	9785773 SEAL, DOOR - 5925
12	9783385 Screw, #10-32 SHWH Tap
13	9783426 Nut, Keps #10-32
14	9788039 Screw Hex Hd 1_4-20x1.00 GR8 ZP Patch
15	9785779 SCREW, SERRATED FLANGE HEX HD, .25-20 X .50 LG
16	9760514 Washer 1_4 SAE .281 ID
17	9788087 Screw Hex Hd 5_16-18x0.50 GR5 Zinc Patch
18	9760521 Washer 5_16 Lock, Split
19	9788059 Screw Hex Hd 1_-13x1.00 GR8 ZP Patch

ID	DESCRIPTION
20	9787797 SEAL, TOP - 5025
21	9781383 NUT, NYLON LOCK #10-32
22	5783815 Switch, Limit 1hp
23	9787774 ACTUATOR, DOOR SWITCH - 5025DL
24	9787775 COVER, DOOR SWITCH, HIGH - 5025DL
25	9787891 CAP, PUSH-ON, SILICONE 5_32 IDx .64 HT
26	9780343 Nut 1_4-20 Nylon Lock
27	9100023 WASHER, FLAT 5_16 USS
28	5787618 SOLENOID, 120VDC, DOOR LOCK
29	9787689 BRACKET, LOCKING BAR - 5025 DOOR LOCK
30	9786864 SHOULDER BOLT .25 DIA X 1.25 LG
31	9787632 COTTER PIN, 1_16 X .75 LG
32	9787634 SCREW, HEX #10-32 X .25 SS
33	9782004 Nut #10-24 Nylon Lock
34	9785126 Nut #8-32 Nylon Lock
35	9787690 BAR, LOCKING 05025UDL
36	9786722 STOP, DOOR, ONE PIECE - 5925-5025

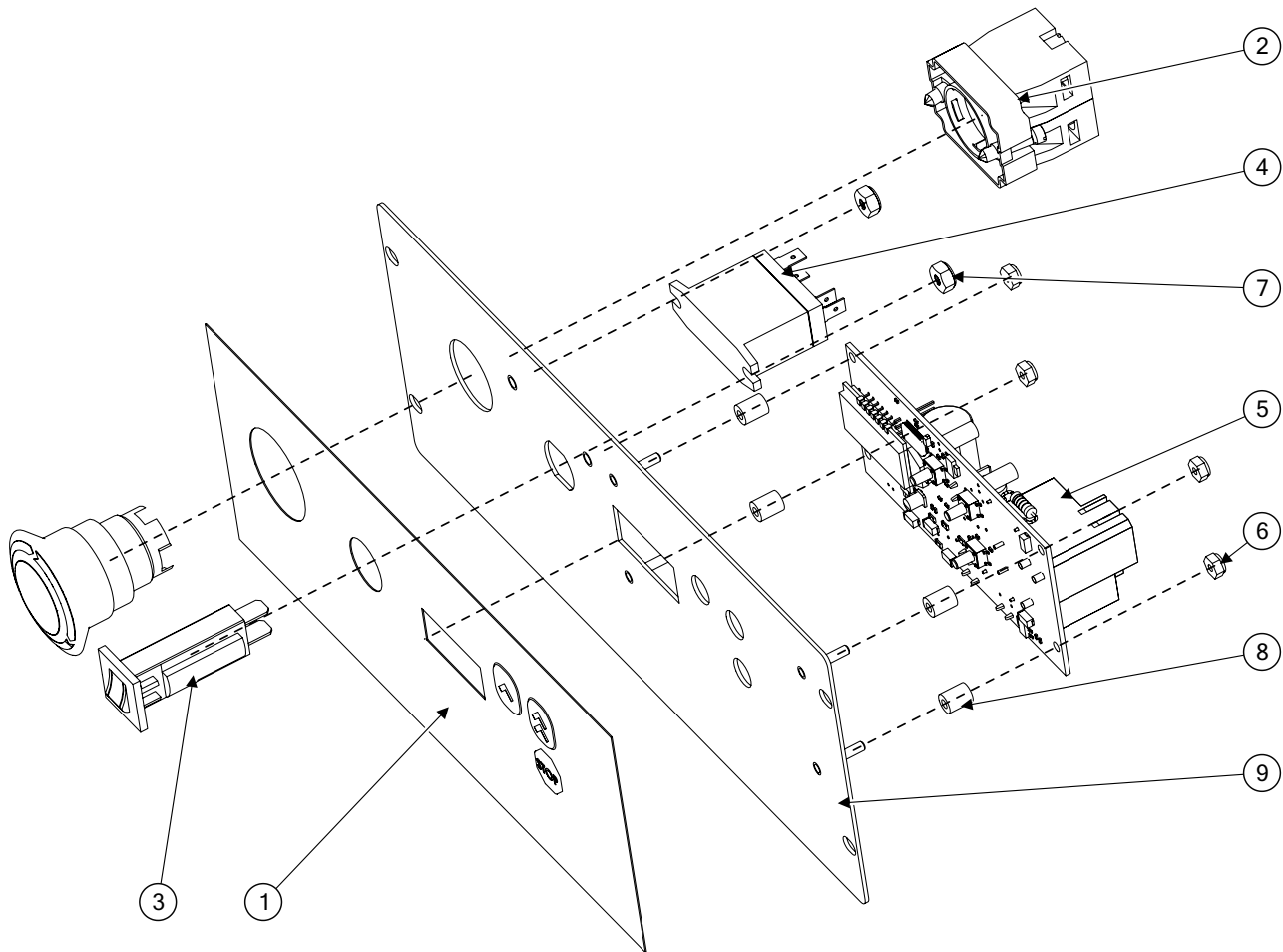
8.9 Digital Display 5025



BOM ID	Description
1	9787701 PLATE, CONTROL PANEL - 5025
2	1786198 LABEL, CONTROL, DIGITAL DISPLAY - 5315
3	5784827 E-STOP SWITCH
4	5786234 TIMER, DIGITAL, HORIZONTAL DISPL, 120V STANDARD

BOM ID	Description
5	9786232 SPACER
6	9783595 Nut, Lock, Nylon 4-40
7	5785315 Circuit Breaker, 20 Amp, Pop-out
8	5787693 DIGITAL DISPLAY, 120V, HORIZONTAL, DOOR LOCK
9	5787716 DIGITAL DISPLAY, 5025 3 PHASE

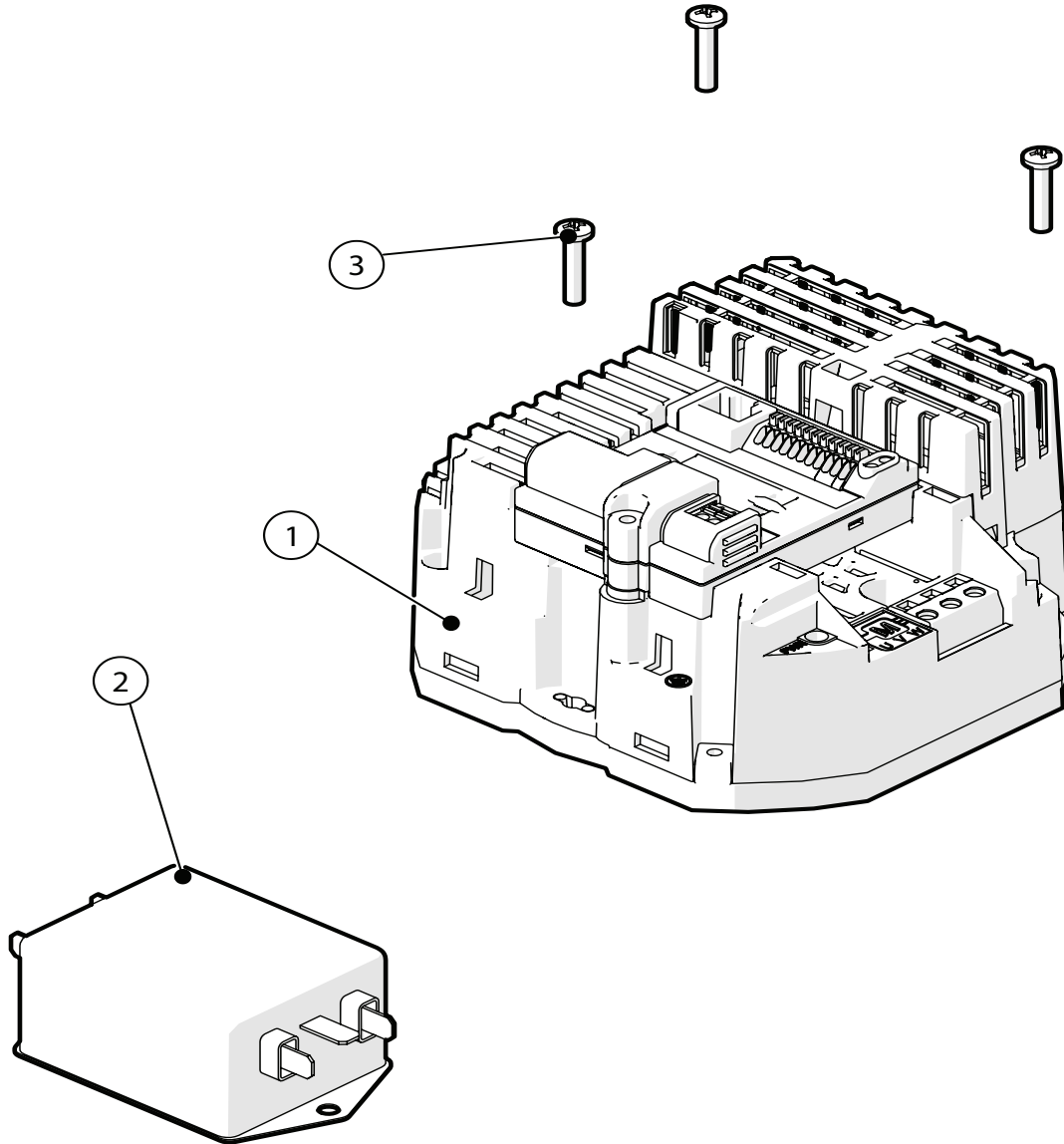
8.10 Digital Display 5025UP3DL



ID	Description
1	1786198 LABEL, CONTROL, DIGITAL DISPLAY - 5315
2	5784827 E-STOP SWITCH
3	5785315 Circuit Breaker, 20 Amp, Pop-out
4	5787532 RELAY, 120VAC COIL, 10 AMP, 250VAC (Door Lock Only)
5	5787693 DIGITAL DISPLAY, 120V, HORIZONTAL, DOOR LOCK

ID	Description
6	9783595 Nut, Lock, Nylon 4-40
7	9785171 NUT, 6-32 NYLON LOCK
8	9786232 SPACER
9	9787701 PLATE, CONTROL PANEL - 5025

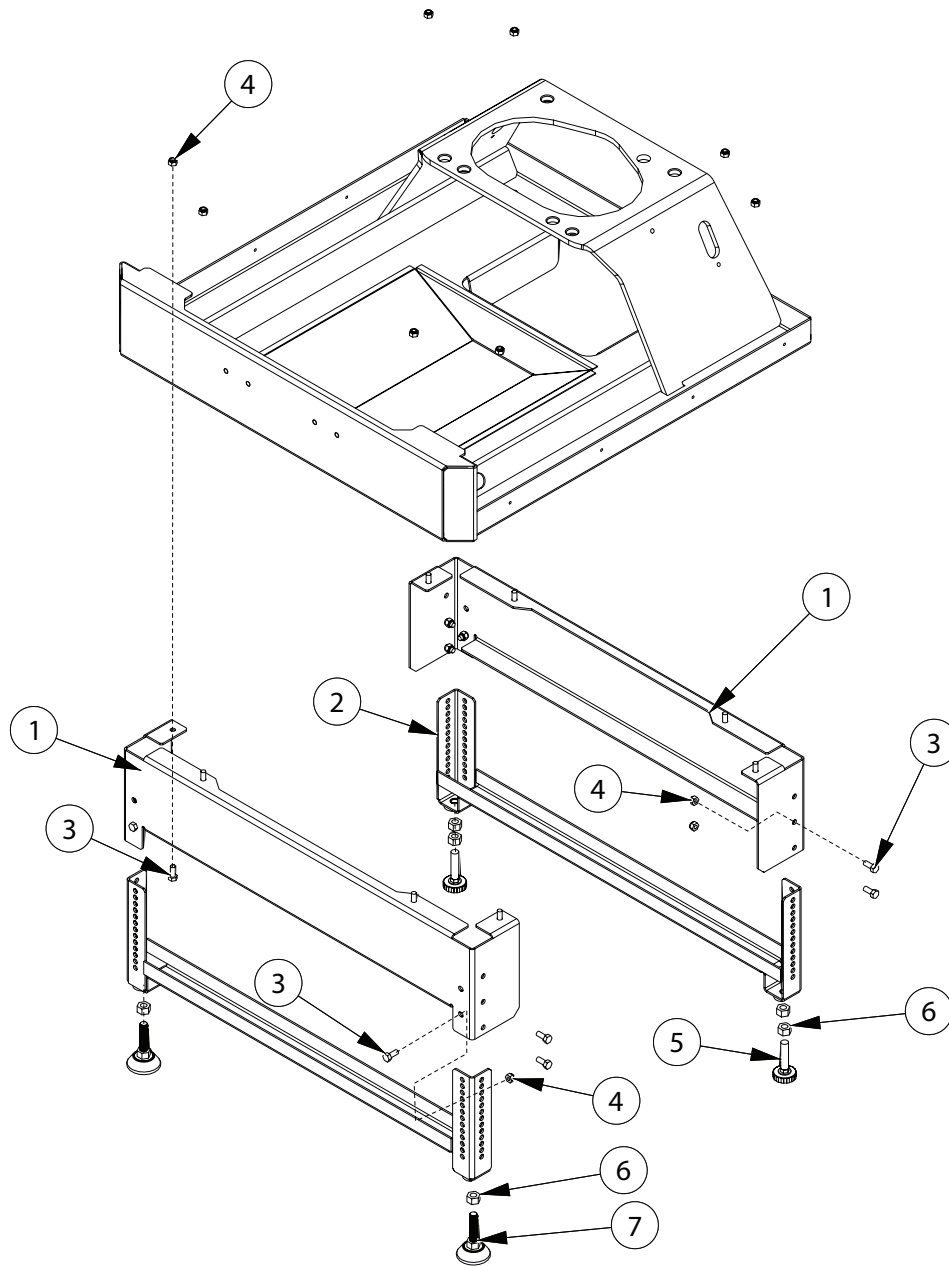
8.11 3 Phase Components



BOM ID	Description
1	6787753 VFD, 120VAC 1 PH IN , 230V 3 PHASE
2	5787723 LINE FILTER, SINGLE STAGE, 20 AMP
3	9782013 SCREW, PAN HD PH 8-32 X .7 5

...Exploded Views, Continued

8.12 Riser Kit, Model 5025-U



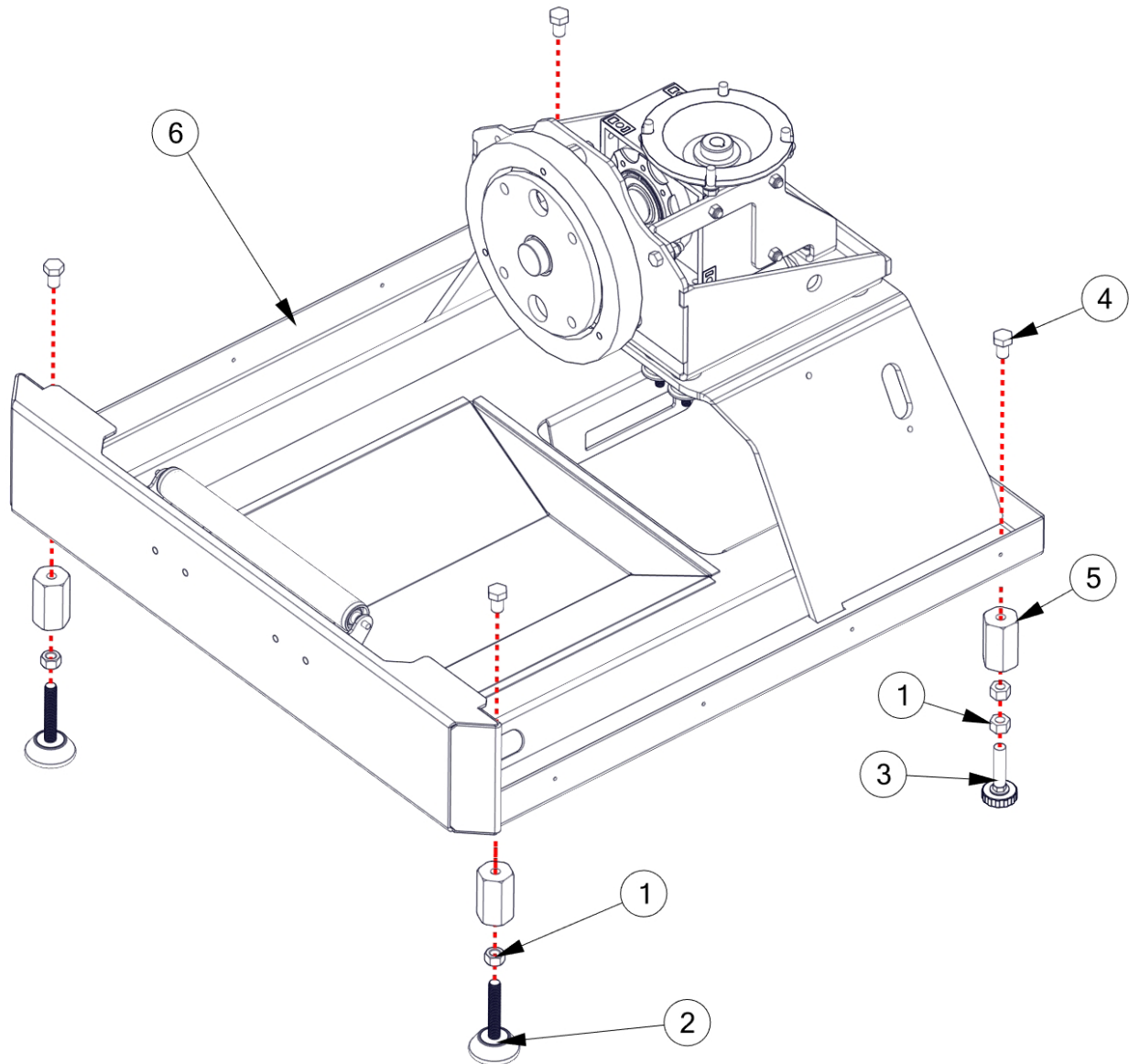
ID	Description
1	9786767 RISER, UNIVERSAL RR - 5025 - 5925
2	9786766 LEG, CROSSBAR, UNIVERSAL RR - 5025 - 5925
3	9782407 Screw Hex 5_16 X 3_4
4	9780182 Nut, Nylock 5_16-18
5	9785721 FOOT, GLIDER - 1_2-13
6	9781711 NUT, 1_2-13
7	9785722 FOOT, NON SKID, LEVELING - 1_2-13

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

Exploded Views, Continued...

...Exploded Views, Continued

8.13 Feet, Model 5025

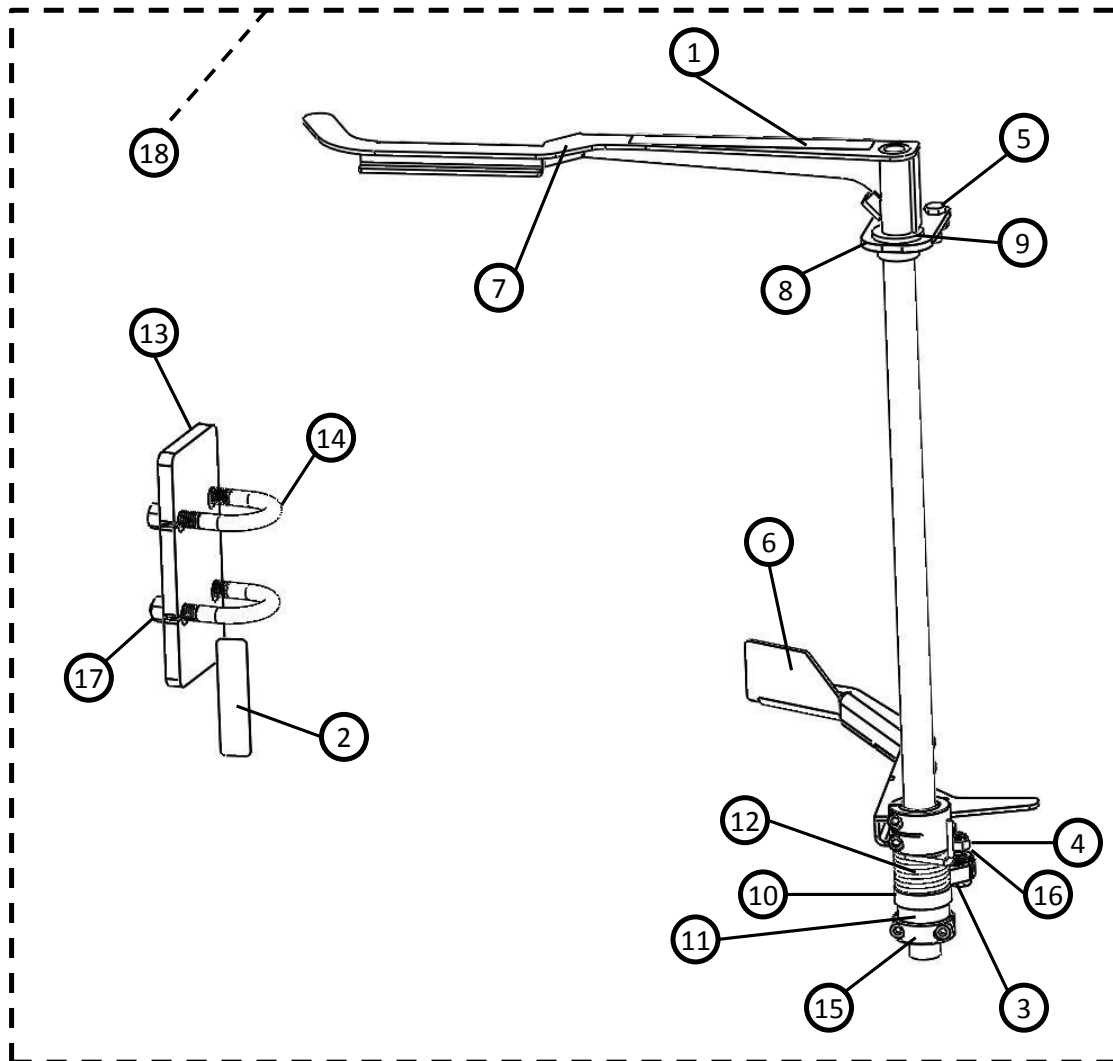


ID	Description
1	9781711 NUT, 1_2-13
2	9785722 FOOT, NON SKID, LEVELING - 1_2-13
3	9785721 FOOT, GLIDER - 1_2-13

ID	Description
4	9788059 SCREW HEX 1/2-13 X 1.00 ZP PATCH
5	9786765 RISER, HEX, FLOOR - 5025 - 5925
6	9786804 BASE WELDMENT - 5925-5025

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

8.14 Pail Extractor (Optional)



ID	Description	ID	Description
1	1787358 EXTRACTOR PULL INSTRUCTIONS LABEL	10	9787389 BRACKET, THICK, BEARING, EXTRACTOR ARM
2	1787362 LABEL, EXTRACTOR	11	9787395 BUSHING, BRONZE, LOWER, EXTRACTOR
3	9787550 SCREW HEX 1/4-20 X 1 1/8"	12	9787399 TORSION SPRING, RH
4	9780343 NUT 1/4-20 NYLOCK	13	9787625 COUNTER WEIGHT, EXTRACTOR
5	9159200 SCREW HEX 1/4-20 X 3/4"	14	9787626 U BOLT, 3/8-16, 1.5" DIA X 2.5" LONG
6	9786758 EXTRACTOR ARM, POST APRIL 2014	15	9787433 SHAFT COLLAR, .75" ID, 2 PIECE
7	9786760 HANDLE, EXTRACTOR, POST APRIL 2014	16	9787472 WASHER, ALIGNMENT, .250"
8	9786761 BRACKET, BEARING, EXTRACTOR ARM	17	9787627 NUT, KEPS 3/8"-16
9	9786762 BRONZE BUSHING	18	6787451 EXTRACTOR KIT

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 5025P3, 5025UP3, 5025U2P3, 5025UP3DL

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
Fax: 763.533.0015
E-mail: info@radiaproducts.com

www.radiaproducts.com



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www.radiaproducts.com



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