

## Service Bulletin

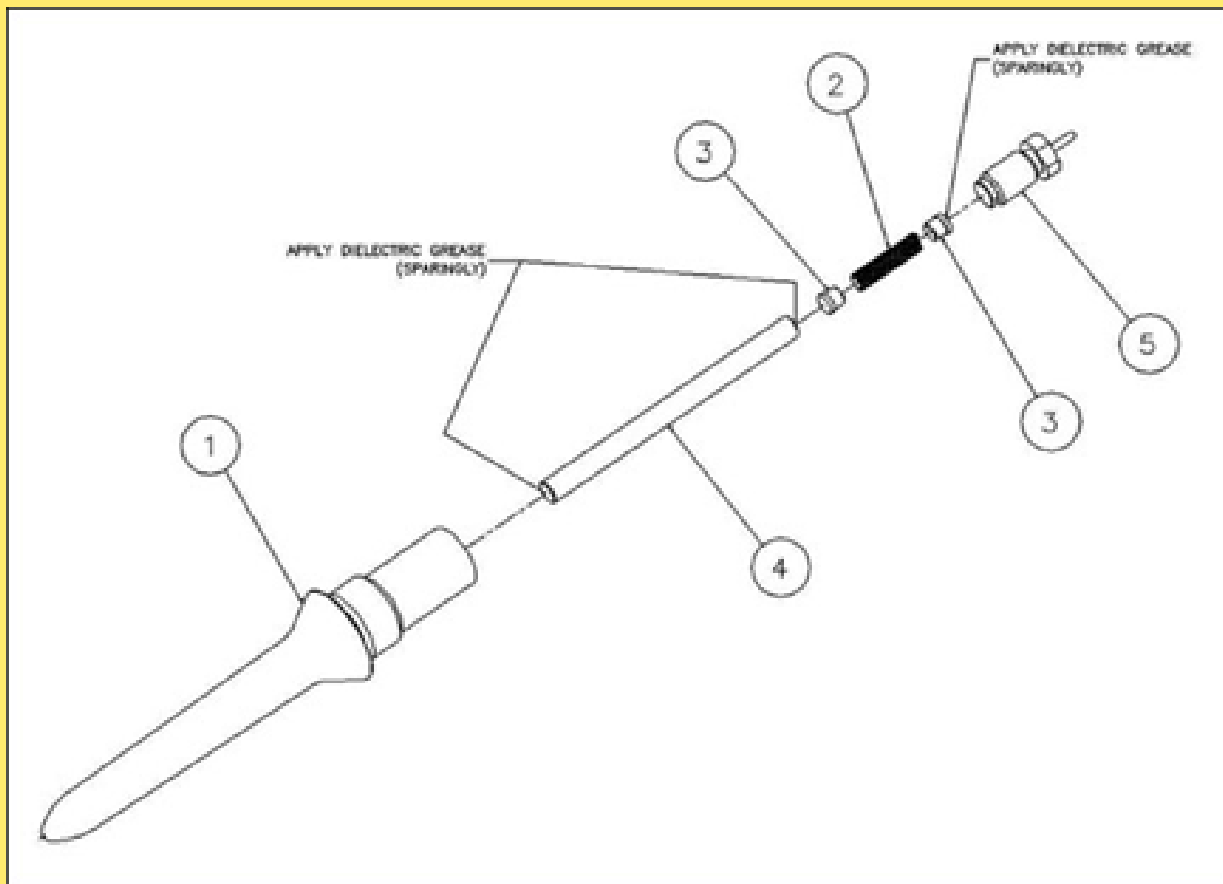
Bulletin No. 06-07  
May 31, 2007

**To:** ITW Ransburg and ITW Automotive Finishing Distributors  
**Subject:** RMA-303 and MMA-303 High Voltage Electrode Body

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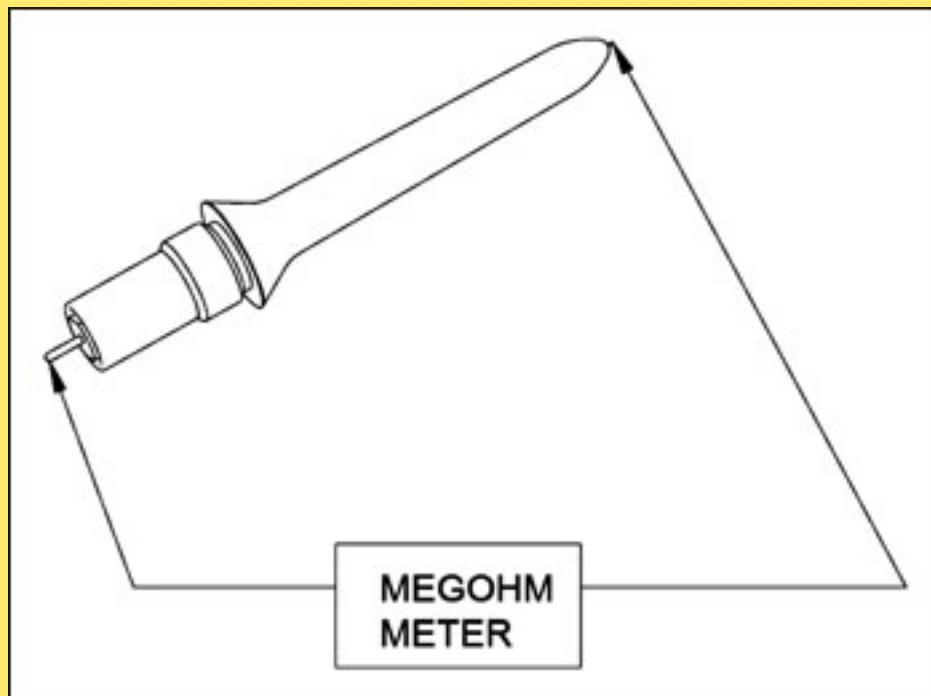
The RMA-303 and MMA-303 complete Electrode Body Assembly (P/N A11342-00), may now be purchased as a separate component (P/N A11343-00 & A-11343-01). The electrode can now be repaired in the field or rebuilt by the customer instead of being sent to the factory for rebuild.

Instructions to build the assembly are as follows:



1. Remove components from the old electrode assembly. Wipe all of the old dielectric grease off the resistor and spring contact ends. Wipe the resistor with Naphtha and dry. (Do not soak any of the components in solvent)
2. Screw plug bodies (Item 3) into the spring (Item 2) at each end. Make sure spring coils are fully assembled onto plugs.

3. Apply dielectric grease (59972-00) to the resistor (Item 4) as noted. Place resistor into the electrode body (Item 1). Next apply dielectric grease onto the spring sub-assembly made in the previous step then place into the electrode body (Item 1) on top of the resistor. Screw the contact body (Item 5) into the electrode body. Tighten the contact body until seated into the electrode body. Finger-tightened is adequate. Do not over-tighten.
4. Using a Yokogawa meter set to 1000V and Mega ohm scales. Clip one lead to contact pin and touch the other end to the wire protruding from the end of the electrode assembly. The reading on the digital display should read:
  - A11343-00: 152 and 168 MEG.
  - A11343-01: 98 and 102 MEG.



If the assembly fails the test, disassemble, visually inspect all mating surfaces, re-assemble and test again. If the electrode still fails return components to ITW Ransburg manufacturing.