

CHAPTER 5

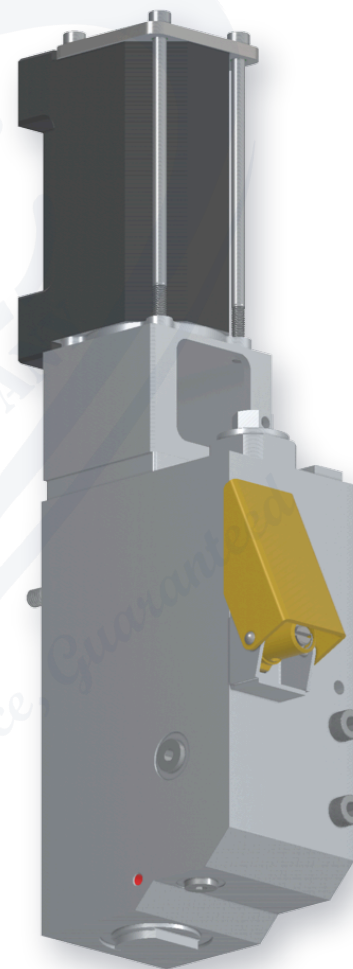
Legacy and ProBlue Melters

Legacy Series 7/10 and Nordson ProBlue Parts Guide

Repair parts for HMSC Legacy 7 and 10 and Nordson ProBlue 4, 7 and 10 melters: pump, manifold, filters, pneumatics and electronics.

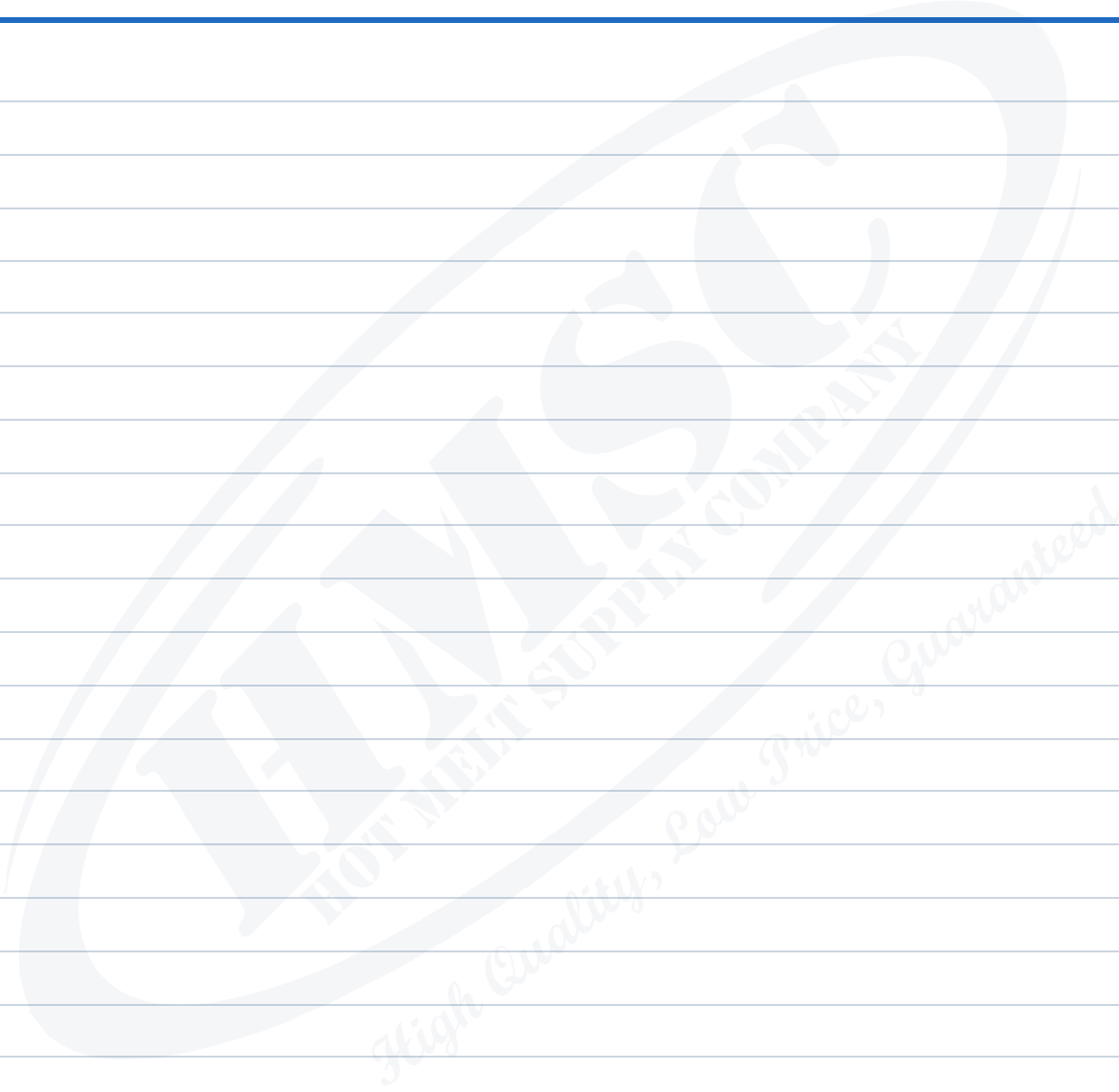
Revision 10/2026

Legacy Series 7/10 and Nordson ProBlue Parts Guide	5-1
Tank, Pump and Manifold	5-2
HMSC Legacy Series and ProBlue Pump	5-3
Legacy Pump Parts	5-4
Legacy Pump Parts: Air Section	5-5
Pump Seals, O-rings and Balls	5-6
Filters, Screens and Drain Valve	5-7
Manifold and Heater Block	5-8
Pneumatics	5-9
Temperature and Level	5-10
Electronics	5-11
More ProBlue Parts	5-12
Spare Parts Kits	5-13
Exchange Melters	5-14





Notes





Legacy Series 7/10 and Nordson ProBlue Parts Guide

Legacy Series 7/10 and Nordson ProBlue Parts Guide

1 Identify the melter

The model is on the ID plate and the front panel: P4, P7 or P10 (4, 7 or 10 liter tank). Most hydraulic parts are the same on all versions of the ProBlue and HMSC Legacy series melters.

2 Find the part

Our Legacy series melters share their hydraulic system with the ProBlue.

3 Order

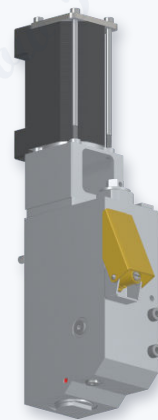
Scan the code on a part for its web page, or call 1-888-202-1788 with the HMSC or Nordson part number.

Legacy compatibility. All Legacy hydraulic components (pump, manifold, filter, seals, crossovers, valves) are fully compatible with ProBlue 4, 7 and 10 melters. Legacy electrical components are proprietary to HMSC. A complete electronics upgrade kit for ProBlue melters is available upon request.

Relieve system pressure and let the melter cool before opening the hydraulic system. Hot melt and heated parts cause burns. Follow the lockout and pressure relief steps in the manual.



Legacy 10 melter



Legacy pump



ProBlue melter



LEGACY 7 FIGURE 7-1

Tank, Pump and Manifold

Legacy Series 7/10 and Nordson ProBlue Parts Guide

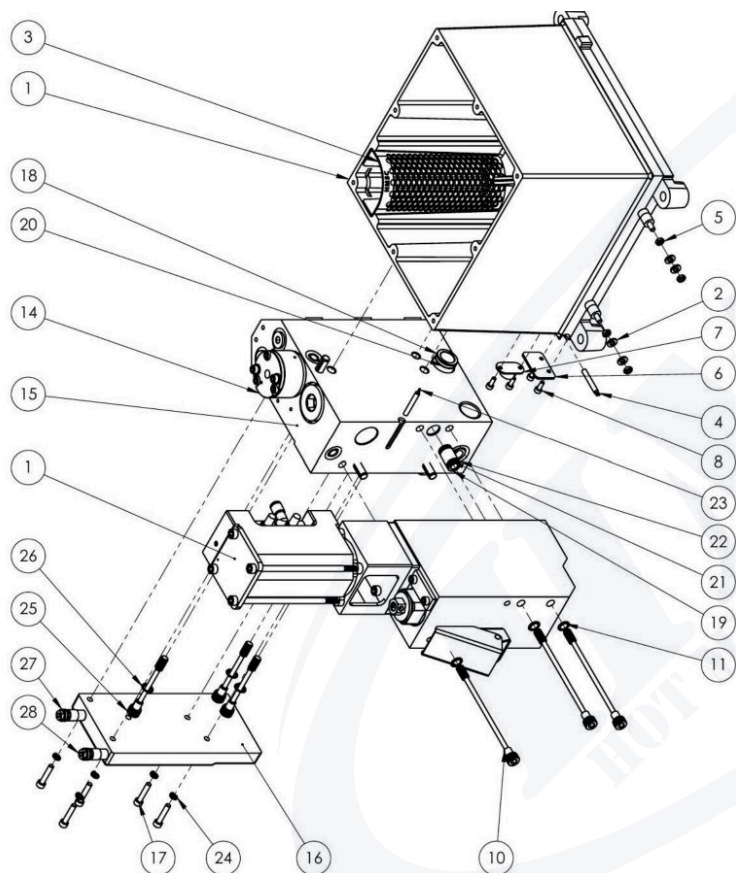


FIGURE 7-1

Item	HMSC part	Description	Replaces Nordson
1	HMS-0021-300-10-000	Tank, molded 7L, 230 V heater	Fits HMSC Legacy melters
3	HMS-0021-300-10-003	Tank screen	Fits HMSC Legacy melters
4	T10B83B0S web	RTD service kit, tank	1028320
6	HMS-0021-300-10-004	RTD clamp plate	Fits HMSC Legacy melters
7	T10B83B1S web	Thermostat service kit	1028321
9	HMS-1028303 web	Legacy pump, complete	1028303
10	T10A70H0S	Pump mounting screw, M8 x 133 mm (HMS-0021-000-00-009) (3)	1017060
14	T10B83P8S web	Pressure discharge valve	1028308
15	See page 5-8	Pump manifold (Manifold and Heater Block)	
16	T10H46E9S web	Manifold heating element, 230 V (480 V: T10H46F0S)	1064649 / 1064650
18	T10A71M6S	Crossover, tank to manifold	1017186
19	T10A71M9S	Crossover, pump to manifold	1017189
20	T9E11H1S web	O-ring, Viton (2)	941161
21	T9F40A3S web	Backup ring, PTFE (2)	954013
22	T9E01C3S web	O-ring, Viton (2)	940133
23	T10B83B0S web	RTD service kit, manifold	1028320
25	T10A70H0S	Pump mounting screw, M8 x 133 mm (3)	1017060

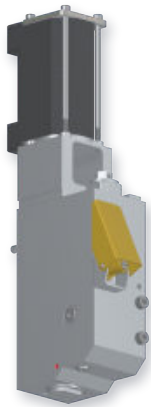
Fasteners and lubricants are not listed. Tank and tank screen are Legacy 7 parts: for a ProBlue pump inlet screen, see Filters, Screens and Drain Valve.



REPLACE THE PUMP, OR REBUILD IT WITH THE SERVICE KIT

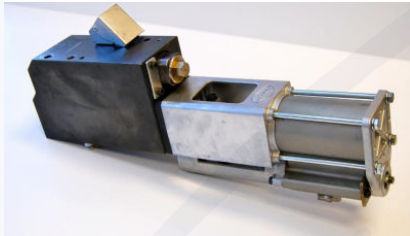
HMSC Legacy Series and ProBlue Pump

Legacy Series 7/10 and Nordson ProBlue Parts Guide



Legacy pump, new
HMS-1028303

Replaces Nordson 1028303
New HMSC Legacy pump.
Drop-in replacement for the
15:1 pump on P4, P7 and P10.



Pump, exchange
T10B83P3R

Replaces Nordson 1028303
Refurbished and tested 15:1
pump, 1 year limited
warranty. Requires your core.



HMSC

HMSC Legacy pump
rebuild kit

HMS-KIT-0021-200-1

Seals, O-rings, ball, plugs,
mufflers, pilot valve and
gasket for the Legacy pump.
Includes the highlighted items
on pages 5-4 and 5-5.

**Call to
order**



Pump service kit
T10B83P4S

Replaces Nordson 1028304
All O-rings, cups, seals and
hardware to rebuild the
pump.



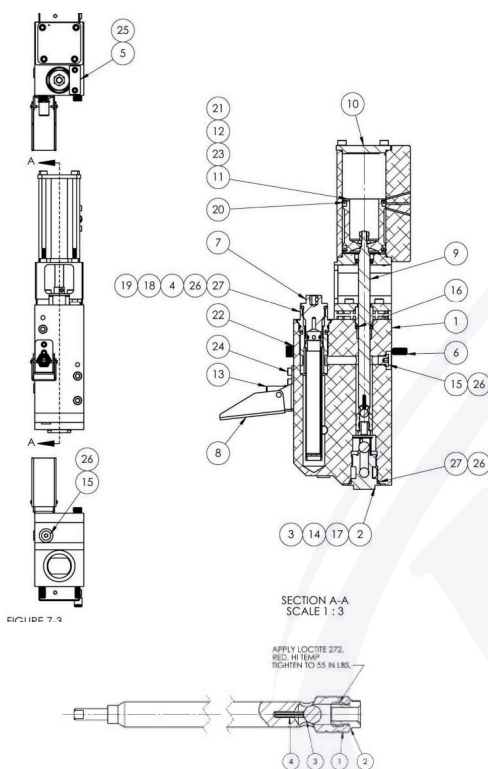
Pump	Nordson kit	HMSC
15:1 double acting (standard on P4, P7, P10)	1028303	HMS-1028303 new, T10B83P3R exchange
15:1 low viscosity	1073930	Call
6:1 double acting	1088212	Call



FIGURE 7-3 PUMP AND FIGURE 7-5 PISTON SHAFT

Legacy Pump Parts

Legacy Series 7/10 and Nordson ProBlue Parts Guide



Item	HMSC part	Description	Replaces Nordson
1	T10A68H3S	Body, pump / filter	1016863
2	T10A73B0S	Lower ball seat	1017320
3	T5P36N6S	Siphon ball cage	503696
4	T10B19F5S	Filter housing (adapter)	1021955
5	T10B12K0S	Retainer plate (filter anti-rotate)	1021270
6	T10A70H0S	Pump mounting screw, M8 x 133 mm (3)	1017060
7	T10B83P5S web	Filter assembly, 100 mesh	1028305
8	T10B27K9S	Drain chute (purge valve cover)	1022779
9	HMS-0021-200-05-004	Shaft, short, for Legacy pump	Fits HMSC Legacy melters
10	HMS-0021-200-05-000	Complete shifter / air section assembly, includes valve	Fits HMSC Legacy melters
11	HMS-0021-200-05-005	Air piston	Fits HMSC Legacy melters
12	HMS-0021-200-05-006	Washer	Fits HMSC Legacy melters
13	T2K60B4S web	Drain valve	276024
14	T9P00P1S web	Ball, stainless, .500	900001
15	T9K35E3S web	Plug, 7/16-20, O-ring (3)	973543
16	T2K31C9S web	Shaft seal	273139
17	T9E50C7S web	O-ring, Viton	945037
18	T9E02H1S web	O-ring, Viton	940261
19	T10A78E9S web	Backup ring, PTFE	1017849
20	HMS-0021-200-05-008	Air piston V-seal, 41.35 mm (2)	Fits HMSC Legacy melters

Highlighted items are included in the HMSC Legacy pump rebuild kit HMS-KIT-0021-200-1.

Piston shaft assembly (Figure 7-5)

Item	HMSC part	Description	Replaces Nordson
1	T10A72B9S	Piston shaft, pump	1017229
2	T5P37P9S	Seat, ball, pressure	503709
3	T9P00P0S web	Ball, stainless, .375	900000
4	T2K31C9S web	Spring seal	273139

Figures and item numbers are from the HMSC Legacy 7 manual (HMS-0021-USR-001). **web** = on www.hotmeltsupplyco.com; other part numbers: call 1-888-202-1788. Nordson and ProBlue are trademarks of Nordson Corporation. Hot Melt Supply Company is not affiliated with Nordson Corporation.



FIGURE 7-4, AND THE PROBLUE MAGNETIC SHIFTER PARTS

Legacy Pump Parts: Air Section

Legacy Series 7/10 and Nordson ProBlue Parts Guide

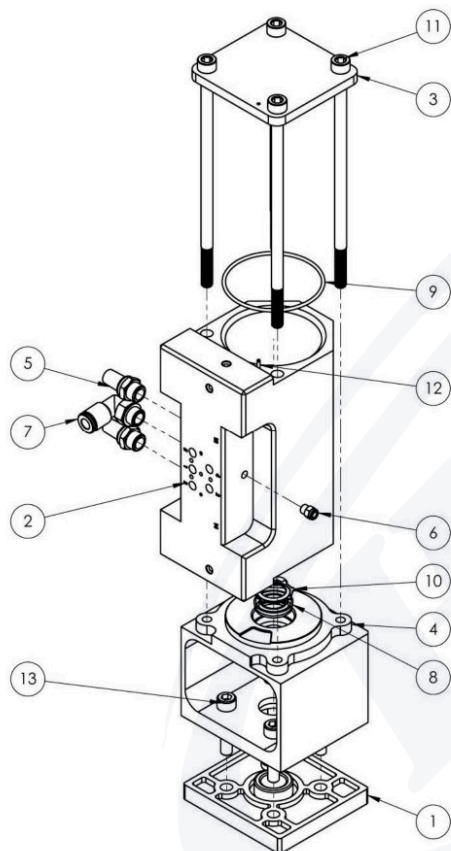


FIGURE 7-4

Item	HMSC part	Description	Replaces Nordson
1	T10A73P7S	Insulator, pump	1017307
2	HMS-0021-200-05-001	Air cylinder	Fits HMSC Legacy melters
3	HMS-0021-200-05-002	Head, cylinder, machined	Fits HMSC Legacy melters
4	HMS-0021-200-05-007	Frame, pump, machined	1016339
5	HMS-0021-200-05-029	Muffler (2)	Fits HMSC Legacy melters
7	T10B33P7S	L-fitting, 6 mm tube	1023307
8	T2K31C9S web	Shaft seal	273139
9	T9E03C2S web	O-ring, Viton (2)	940332
10	HMS-0021-200-05-036	Retaining ring, internal	Fits HMSC Legacy melters
11	HMS-0021-200-05-037	Air cylinder mount screw (4)	Fits HMSC Legacy melters
13	T9M21C5S	Screw, M6 x 30 (4)	982135
14	HMS-D3X	Pilot valve, ball detent, double air pilot	Fits HMSC Legacy melters
15	HMS-DG3X-G	Legacy pump gasket	Fits HMSC Legacy melters

Highlighted items are included in the HMSC Legacy pump rebuild kit HMS-KIT-0021-200-1.

ProBlue magnetic shifter parts

HMSC part	Description	Replaces Nordson
T10B44H5S	Shifter assembly, G1/8	1024465
T1H46P6S	Service kit, magnetic actuator, SP	164606
T10P60B7S	Service kit, valve assembly, SP	1006027
T1F50H8S	Can, SP	155068
T9M20B8S	Screw, socket, M5 x 20	982028
T9M20F9S	Screw, socket, M4 x 8	982059

The Legacy pump uses a pilot valve air section. ProBlue pumps use the magnetic shifter parts listed above. The hydraulic section is the same on both.

Figures and item numbers are from the HMSC Legacy 7 manual (HMS-0021-USR-001). [web](#) = on www.hotmeltsupplyco.com; other part numbers: call 1-888-202-1788. Nordson and ProBlue are trademarks of Nordson Corporation. Hot Melt Supply Company is not affiliated with Nordson Corporation.



EVERYTHING IN PUMP SERVICE KIT 1028304, SOLD ONE AT A TIME

Pump Seals, O-rings and Balls

Legacy Series 7/10 and Nordson ProBlue Parts Guide

 O-ring, .426 ID x .070 T9E01C3S Replaces Nordson 940133 Crossover tube (2)	 O-ring, 2.000 x 2.125 x .063 T9E03C2S Replaces Nordson 940332 Cylinder (2)	 O-ring, .50 x .75 x .125 T10A95A5S Replaces Nordson 1019515 Pump to manifold	 O-ring, .812 x 1.062 x .125 T9E21A1S Replaces Nordson 942111 Pump to manifold	 O-ring, .739 x .070 T9E01M1S Replaces Nordson 940181 Pump (4)
 O-ring, .676 ID x .070 T9E01K2S Replaces Nordson 940172 Piston cup stack	 O-ring, 1.25 x 1.375 x .063 T9E02H1S Replaces Nordson 940261 Pump	 Backup ring, PTFE, 1.273 T10A78E9S Replaces Nordson 1017849 Pump	 O-ring, 1 in tube T9E50C7S Replaces Nordson 945037 Lower ball seat	 O-ring, 3/4 in tube T9E50C9S Replaces Nordson 945039 Filter
 O-ring, .750 x .938 x .094 T9E11H1S Replaces Nordson 941161 Tank crossover (2)	 Backup ring, 7/16 x 9/16 T9F40A3S Replaces Nordson 954013 Crossover tube (2)	 Cup, U, Viton T9F21P0S Replaces Nordson 952100 Hydraulic piston	 Cup, piston, SP T1H30C9S Replaces Nordson 163039 Air piston (2)	 Seal, pump T2K31C9S Replaces Nordson 273139 Piston shaft
 Retaining ring, internal T9M63C1S Replaces Nordson 986331 U-cup retainer	 Plug, O-ring, 7/16-20 T9K35E3S Replaces Nordson 973543 Pump body (3)	 Ball, .500, 440 stainless T9P00P1S Replaces Nordson 900001 Lower (siphon) valve	 Ball, .375, 440 stainless T9P00P0S Replaces Nordson 900000 Piston (pressure) valve	Complete kit T10B83P4S Replaces Nordson 1028304 Also M6 screws, washers, lock nut and O-ring lubricant.

All O-rings are Viton. Replace every seal you disturb, and use high temperature O-ring lubricant on assembly.



PUMP FILTER, INLET SCREEN, DRAIN

Filters, Screens and Drain Valve

Legacy Series 7/10 and Nordson ProBlue Parts Guide



Pump filter, 100 mesh, with O-ring

T10B83P5S

Replaces Nordson 1028305 / 1021919
Pump filter, all ProBlue melters. Change it on a schedule.



Filter screen only

T10B83P5S-screen

Replaces Nordson 1028305 screen
Replacement 100 mesh screen for the filter assembly.



Filter O-ring

T9E50C9S

Replaces Nordson 945039
3/4 in tube O-ring for the filter.



HMSC

Pump inlet screen, P4 / P7

T10B58M5S

Replaces Nordson 1025885 / 1022747
Tank outlet screen in front of the pump.

Call to
order

HMSC

Pump inlet screen, P10

T10A78N2S

Replaces Nordson 1017892
Tank outlet screen in front of the pump.

Call to
order



Drain valve assembly

T2K60B4S

Replaces Nordson 276024
Pump body drain valve.



Low viscosity pumps use filter 1021919 (same HMSC filter T10B83P5S). The air pre-filter is on the Pneumatics page. Relieve pressure before removing the filter.



Manifold and Heater Block

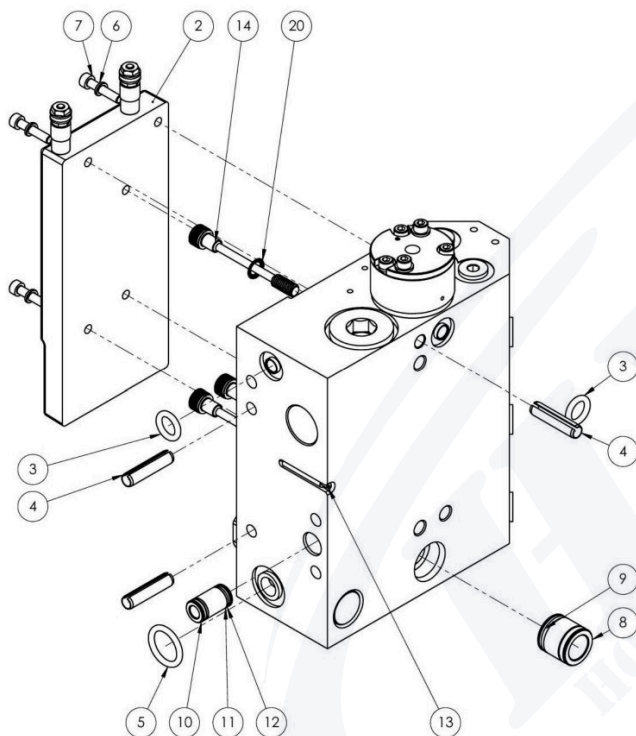


FIGURE 7-2

Item	HMSC part	Description	Replaces Nordson
2	T10H46E9S web	Manifold heating element, 230 V	1064649 / 1017723
2	T10H46F0S web	Manifold heating element, 480 V	1064650
3	T10A95A5S web	O-ring, Viton, DASH 206 (3)	1019515
5	T9E20M0S	O-ring, Viton, .796 x 1.074 x .139	942080
8	T10A71M6S	Crossover, tank to manifold	1017186
9	T9E11H1S web	O-ring, Viton (2)	941161
10	T10A71M9S	Crossover, pump to manifold	1017189
11	T9F40A3S web	Backup ring, PTFE (2)	954013
12	T9E01C3S web	O-ring, Viton (2)	940133
13	T10B83B0S web	RTD service kit	1028320
25	T10B83P8S web	Pressure discharge valve	1028308

Manifold service kit

T10B83P9S
Replaces Nordson
1028309
O-rings and lubricant.



Heater block, 230 V

T10H46E9S
Replaces Nordson
1064649



Heater block, 480 V

T10H46F0S
Replaces Nordson
1064650



HMSC part	Description	Replaces Nordson
T10H46F3S	Manifold kit with heater block, 6 hose, 230 V	1064653
T10H46F4S	Manifold kit with heater block, 6 hose, 480 V	1064654



Pneumatics



Pressure control panel

T10B83P7S

Replaces Nordson 1028307
Regulator and gauge panel.



Pressure discharge valve

T10B83P8S

Replaces Nordson 1028308
PDV with screws and tee.



Air pre-filter

T10B32H7S

Replaces Nordson 1023267
Air filter assembly, 6 mm BSPP.



HMSC part	Description	Replaces Nordson
T10B33P7S	Elbow, male, 6 mm tube x G1/8	1023307
T10A95A1S	Tee, run, 6 mm tube, G1/8	1019511
T10B38F3S	Tubing, regulator to PDV, 6 mm (yellow)	1023853
T10B38F4S	Tubing, filter to regulator, 6 mm (blue)	1023854



RTD, OVER-TEMPERATURE THERMOSTAT, LEVEL SWITCH

Temperature and Level

Legacy Series 7/10 and Nordson ProBlue Parts Guide



RTD, 120 ohm nickel

T10B83B0S

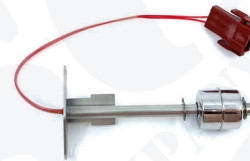
Replaces Nordson 1028320
Tank and manifold sensor, 2
per melter. Kit with screw,
terminal block and thermal
compound.



Thermostat, 500 degree

T10B83B1S

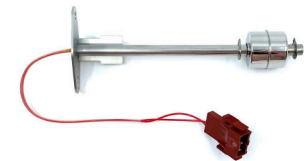
Replaces Nordson 1028321
Over-temperature (OOR)
thermostat, push-on, with
screws and compound.



Level switch kit, P4 / P7

T10C89K1S

Replaces Nordson 1038971
Tank level switch with nuts.



Level switch kit, P10

T10C89K2S

Replaces Nordson 1038972
Tank level switch with nuts.



Use thermal compound on the RTD and thermostat.



BOARD REPAIR SERVICE, CPU, POWER AND FUSES

Electronics

Legacy Series 7/10 and Nordson ProBlue Parts Guide



Hose / applicator module, repair service

TR10B83B8S

Replaces Nordson 1028328
We repair your module.
Drives two hose and
applicator pairs.



HMSC

Main board P10, repair service

TR10B83B3S

Replaces Nordson 1028323
We repair your main board.



Main board P4 / P7, repair service

TR10B83B2S

Replaces Nordson 1028322
We repair your main board.

Call to
order

CPU / display board

1028325

Replaces Nordson 1028325
P4, P7 and P10.



HMSC



Transformer power board

HMS-1041662

Replaces Nordson 1041662
400 / 480 V melters.



Main board fuse kit

T10B83B9S

Replaces Nordson 1028329
15 A and 2 A fuses with
covers.



Module fuses, pack of 5

T10B83C1S

Replaces Nordson 1028331
6.3 A fast acting, 5 x 20 mm.



6 hose expansion board

HMS-1028324

Replaces Nordson 1028324
P10 expansion to 6 hoses.

Call to
order

Electronics upgrade. Legacy electrical components are proprietary to HMSC. A complete electronics upgrade kit for ProBlue melters (power board, touch screen HMI, cable, bezel and panel) is available upon request.



More ProBlue Parts

Pump hardware and 6:1 pump parts

HMSC part	Description	Replaces Nordson
T10H54E5S	Cup, piston, 6:1 (2)	1065445
T10H54E6S	Washer, piston seal, 6:1	1065446
T10H54E7S	Washer, piston cup, 6:1 (2)	1065447
T9E13E0S	O-ring, -134, Viton, 6:1 (2)	941340
T9M21E7S	Screw, hex cap, M6 x 120 (4)	982147
T9M22C7S	Screw, hex cap, M6 x 35 (4)	982237
T9M21C5S	Screw, hex cap, M6 x 30	982135
T9M27M0S	Screw, socket, M5 x 10 (2)	982780
T9M34A0S	Washer, flat, M6	983410
T9M34P9S	Washer, lock, split, M6	983409
T10H41F7S	Nut, hex, lock, M6	1064157
T9M53P2S	Pin, roll, .125 x .500	985302
T9M54P1S	Pin, roll, .188 x 1.000 (2)	985401

Chassis, switch and lubricants

HMSC part	Description	Replaces Nordson
T10A79E7S	Switch, rocker, SPST, 250 V, 16 A	1017947
T10A88B1S	Plate, conduit, chassis	1018821
1018819-Coat	Sub-base, P7 / P10, powder coated (exchange)	1018819
1021660-Coat	Chassis, P4, powder coated (exchange)	1021660
1018822-Coat	Chassis, P7 / P10, powder coated (exchange)	1018822
1051033-Coat	Tank, P4, 230 V, PTFE coated (exchange)	1051033
T11B02P1S	Lubricant, O-ring, NSF-H1, tube	1120201 / 900493
T9P04N3S	Lubricant, high temperature	900493
T11B02N0S	Lubricant, SP pump, high temperature	1120290 / 211228
HMS-900344	Lubricant, Never-Seez, 8 oz	900344

These parts are stocked by HMSC and not listed on the web store. Part numbers ending in -Coat are exchange items: we refinish your part (powder coat or PTFE coating), exchange for your core. Call 1-888-202-1788 with the HMSC or Nordson part number.



KEEP THE RIGHT PARTS ON THE SHELF

Spare Parts Kits

Legacy Series 7/10 and Nordson ProBlue Parts Guide

Basic spare parts kit: HMSC T10B83C2S (replaces Nordson 1028332)

Qty	HMSC	Part	Nordson	
1	T10B83P5S	Filter, 100 mesh	1028305	
1	T10B83B0S	RTD kit	1028320	
1	T10B83B1S	Thermostat kit	1028321	
1	TR10B83B8S	Hose / applicator module (repair service)	1028328	
1	T10B83B9S	Main board fuse kit	1028329	
1	T10B83C1S	Module fuses	1028331	

Order the basic kit complete as T10B83C2S, or the parts one at a time.

Expanded spare parts (Nordson 1028333)

Qty	HMSC	Part	Nordson	
5	T10B83P5S	Filter, 100 mesh	1028305	
1	T10B83B0S	RTD kit	1028320	
1	T10B83B1S	Thermostat kit	1028321	
1	TR10B83B8S	Hose / applicator module (repair service)	1028328	
1	T10B83B9S	Main board fuse kit	1028329	
1	T10B83C1S	Module fuses	1028331	
1	T10B83P4S	Pump service kit	1028304	
1	T10B83P9S	Manifold service kit	1028309	
1	T10B32H7S	Air filter	1023267	

Keep a basic kit on the shelf for every production line. Add the expanded parts where downtime is expensive.



REFURBISHED PROBLUE MELTERS, EXCHANGE FOR YOUR CORE

Exchange Melters

Legacy Series 7/10 and Nordson ProBlue Parts Guide



ProBlue P4 T10B22C0S

Replaces Nordson 1022230
2 hose / gun
240 V



ProBlue P4 T10B22C1S

Replaces Nordson 1022231
4 hose / gun
240 V



ProBlue P4 T10B22C7S

Replaces Nordson 1022237
2 hose / gun
400 / 480 V, no transformer

**Call to
order**

ProBlue P7 T10B22C2S

Replaces Nordson 1022232
2 hose / gun
240 V



ProBlue P7 T10B22C3S

Replaces Nordson 1022233
4 hose / gun
240 V



ProBlue P7 T10B22C9S

Replaces Nordson 1022239
4 hose / gun
400 / 480 V, no transformer



ProBlue P10 T10B22C4S

Replaces Nordson 1022234
2 hose / gun
240 V



ProBlue P10 T10B22C5S

Replaces Nordson 1022235
4 hose / gun
240 V



ProBlue P10 T10B22C6S

Replaces Nordson 1022236
6 hose / gun
240 V



Completely refurbished and tested, 1 year limited warranty. Exchange requires an equivalent core; parts missing or damaged beyond repair are extra. 400 / 480 V melters ship without the transformer. Additional configurations are available upon request; please call if you need help identifying your machine.



Not finding your part?

We stock more ProBlue parts than we can list here. Call 1-888-202-1788 or email sales@hotmeltsupplyco.com with the Nordson part number, or scan for all ProBlue service items.