



MANUAL INSTRUCTION

M 85 GUN

Manual ref : 0504 573.115.112

Date : 13/04/05 - Supersede : 10/02/03 - Update

Dear Customer,

We thank you very much for purchasing an accessory from KREMLIN range. Special care has been taken during all designing and manufacturing process to make sure your investment will provide full satisfaction. To get the best result, safe and efficient operation of your M 80 gun, we advice you to read and make yourself familiar with this instruction and service manual.

1. EC DECLARATION OF CONFORMITY

The manufacturer : **KREMLIN REXSON** with assets of 6 720 000 Euros

Head office : 150, avenue de Stalingrad 93 245 - STAINS CEDEX - FRANCE

Tel. 33 (0)1 49 40 25 25 - Fax : 33 (0)1 48 26 07 16

Herewith declares that : Gun, is in conformity with the provisions of :

Machinery Directive (Directive 98/37/EEC) and with national implementing legislation.

Established in Stains, on March 1st 2003,

Daniel TRAGUS
President

2. USER'S SAFETY GUIDELINES

To be used only in well-ventilated areas to protect your health and prevent any fire or explosion hazard.

Do not aim the gun towards individuals or animals.

3. SPECIFICATIONS

The M 85 gun is a manual gun for cold extrusion. It is designed for depositing large quantities of material in bead form.

It is supplied with material from a pressure pot (for glues) or from a piston pot (for thick materials).

To easier implement, a swivel fitting can fit the gun.

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4. TECHNICAL FEATURES

Maximum pressure of supplying material : 240 bar/ 3480 psi

Nozzle options : Ø 0,8 mm / 0.03", Ø 1 mm / 0.04", Ø 2 mm / 0.08", Ø 4 mm / 0.16", Ø 5,5 mm / 0.22"

Supplying material : via a fluid hose Ø 6,35 mm / 1/4" ou 9,52 mm / 3/8"

Material maximum temperature : 50°C / 122 °F

Weight: 600 g / 1.32 lb

Metals in contact with the material : aluminium, stainless steel, nickel-plated brass

5. ADJUSTMENTS

■ BEAD WIDTH

Choose the nozzle by considering the bead to deposit.

■ MATERIAL FLOW

You can adjust the flow by means of the intervention on the needle running (Milled knob placed at the back lower part of the gun).

6. GUN CLEANING

Never use metallic brushes, files or pliers when dismantling the gun

■ SHORT BREAKS (LESS THAN 3 HOURS)

Remove the paint on the nozzle with a brush and solvent. Otherwise, leave the equipment as it is.

■ LONG BREAKS

Remove the nozzle then the needle backwards of the gun with the wrench provided. Soak the parts. Brush them. Clean the internal part of the gun . Carefully, brush the threaded parts.

Never soak the gun in solvent

7. TROUBLESHOOTING CHART

TROUBLE	CAUSE	SOLUTION
Material is no longer coming out of the gun	Blocked nozzle	Check material supply circuit. Cut the pressure on the pump. Remove and clean the nozzle. Depressurize the circuit.
Deformed bead	Worn nozzle	Replace it.
Extrusion of intermittent material	Lack of material Nozzle not tightened correctly	Check supplying material Tighten the nozzle
Fluid leak in front of the gun	Dirt in the fluid Bad tightness between the needle ball and its seat.	Trigger the gun 3 or 4 times Clean seat or replace needle and seat.