



## **INSTRUCTION MANUAL**

### **TWO COMPONENT GUN**

**# 106 036 00 (manual)**

**# 106 067 00 (automatic)**

**# 154 599 140 (BOOSTHOR automatic)**

**Manual : 574.035.112 - 1308**

*Date : 01/08/13 - Supersede : 16/11/11*

*Modif. : + # 154 599 140*

### **TRANSLATION FROM THE ORIGINAL MANUAL**

**IMPORTANT : Before assembly and start-up, please read and clearly understand all the documents relating to this equipment (professional use only).**

*THE PICTURES AND DRAWINGS ARE NON CONTRACTUAL. WE RESERVE THE RIGHT TO MAKE CHANGES WITHOUT PRIOR NOTICE.*

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TWO COMPONENT GUN**

**TABLE OF CONTENTS**

<b>01. WARRANTY</b> .....	<b>2</b>
<b>02. SAFETY INSTRUCTIONS</b> .....	<b>2</b>
<b>03. EXPLODED VIEW &amp; SPARE PARTS' LIST</b> .....	<b>5</b>
<b>04. MAINTENANCE</b> .....	<b>9</b>
<b>05. DISASSEMBLY</b> .....	<b>9</b>
<b>06. GUN ASSEMBLY</b> .....	<b>10</b>

Dear Customer,

You are the owner of our new equipment and we would like to take this opportunity to thank you.

To make sure your investment will provide full satisfaction, special care has been taken by KREMLIN REXSON during all designing and manufacturing processes.

To obtain the best result, safe and efficient operation of your equipment, we advice you to read and make yourself familiar with this instruction and service manual. Indeed, the non-compliance with instructions and precautions stated in this manual could reduce the equipment working life, result in operating trouble and create unsafe conditions.

## 01. WARRANTY

We reserve the right to make changes; these changes may be carried out after the receipt of the order. No claim will be accepted as a consequence of any change carried out in the instruction manuals or in the selection guides.

Our equipment is checked and tested prior to shipment. In the case of a problem arising with the equipment, this must be in writing, within ten days from the delivery date.

KREMLIN REXSON warrants all equipment manufactured bearing its name, to be free from defect in material or workmanship for a period of 12 months (one shift per day or 1800 hours - 1 term reached) from the date of delivery. Work life is based on single shift working - 8 hours per day. Warranty claims for defective items will only be accepted in writing and will be verified and confirmed by us.

The warranty does not cover fair wear and tear, damage or wear caused by misuse, improper maintenance or non-observance of our recommendations.

KREMLIN REXSON will repair or replace parts (carriage paid to our plant and accepted as defective by us). We shall not be liable for any losses, resulting from a production breakdown. Upon request, we can carry out service work at your premises; all expenses (travelling and accommodation) for KREMLIN REXSON technicians will be chargeable.

In the event that it is found that equipment has been tampered with, this will invalidate the warranty. Equipment that it is bought in will be subject to the suppliers' warranty.

## 02. SAFETY INSTRUCTIONS

### GENERAL SAFETY INSTRUCTIONS



**CAUTION : The equipment can be dangerous if you do not follow our instructions concerning installation and servicing described in this manual and in accordance with applicable European standards and local national safety regulations.**

**Please carefully read all the instruction literature before operating your equipment.**

**Only trained operators can use the equipment** (To acquire an essential training, please contact the "KREMLIN REXSON University" training center - Stains).

The foreman must ensure that the operator has understood the safety instructions for this equipment as well as the instructions in the manuals for the different parts and accessories.

Read carefully all instruction manuals, label markings before operating the equipment.

Incorrect use may result in injury. This equipment is for professional use only. It must be used only for what it has been designed for. Never modify the equipment. The parts and accessories supplied must be regularly inspected. Defective or worn parts must be replaced.

**Guards (air motor cover, coupling shields, housings,...) have been designed for a safe use of the equipment.**

**The manufacturer will not be held responsible for bodily injury or failure and / or damage to property due to removal or partial removal of the guards.**

**Never exceed the equipment components' maximum working pressure.**

Comply with regulations concerning safety, fire risks, electrical regulations in force in the country of final destination of the material. Use only products or solvent compatible with the parts in contact with the material (refer to data sheet of the material manufacturer).

## PICTOGRAMS

Nip hazard	Warning moving elevator	Warning moving parts	Warning moving shovel	Do not exceed this pressure	High pressure hazard
Relief or drain valve	Warning hose under pressure	Wear of glasses is obligatory	Wear of gloves is obligatory	Product vapor hazard	Warning hot parts or areas
Electrical hazard	Warning fire hazards	Explosion hazards	Grounding	Warning (User)	Warning serious injuries

### FIRE - EXPLOSION - SPARKS - STATIC ELECTRICITY HAZARDS

A poor earth connection, inadequate ventilation, sparks or static electricity can cause an explosion or fire. To avoid these risks when using or servicing KREMLIN REXSON equipment, the following safety procedures must be followed :



- ensure a good earth connection and ground the parts to be handled i.e. solvents, materials, components and equipment,
- ensure adequate ventilation,
- keep working area clean and free from waste solvents, chemicals, or solid waste i.e. rags, paper and empty chemicals drums,
- never use electrical switches / power if in an atmosphere of volatile solvent vapour,
- stop working immediately in case of electrical arcs,
- never store chemicals and solvents in the working area.
- use paint whose flash point is the highest possible to prevent from any formation of gas and inflammable vapours (refer to materials' safety instructions),
- install a cover on the drums to reduce the diffusion of gas and vapours in the spraybooth.

### TOXIC PRODUCT HAZARDS

Toxic products or vapours can cause severe injury not only through contact with the body, but also if the products are ingested or inhaled. It is imperative :



- to know the material products and their risks,
- notified or hazardous materials must be stored in accordance with the regulations,
- the material must be stored in an appropriate container, never place materials in a container where there is a risk of spillage or leakage,
- a procedure must be applied for the safe disposal of waste material. It must comply with all prevailing regulations and legislations of the country where the equipment is to be used,
- protective clothing should always be worn in compliance with the material manufacturers' recommendations,
- depending on the application and chemical safety instructions, safety glasses, hearing protective earplug, gloves, foot wear, protective masks and possible breathing equipment should be worn to comply with the regulations (Refer to chapter "Safety equipment of KREMLIN selection guide).



## CAUTION!

It is forbidden to use material containing high concentrations of halogenated hydrocarbon solvents with **aluminium** or **zinc fillers**. Non-compliance with the instructions may cause explosion risk causing serious or fatal injury.



## EQUIPMENT REQUIREMENTS

**Guards (air motor cover, coupling shields, housings,...) have been designed for a safe use of the equipment.**  
**The manufacturer will not be held responsible for bodily injury or failure and / or damage to property due to removal or partial removal of the guards.**

## PUMP



Before carrying out any work, it is imperative to read and clearly understand the disassembly and reassembly instructions before servicing. The operator must understand the equipment and the safety instructions. These instructions are available in the equipment manuals.



The air motor is designed to be mounted with a pump. Never modify any components or couplings. When operating, please keep hands away from moving parts. Before starting up the equipment, please read the PRESSURE RELIEF instructions. Please ensure that any relief or drain valves fitted are in good working order.

## HOSES

- Keep hoses out of circulation areas, moving parts or hot surfaces,
- Never expose product hoses to temperature higher than + 60°C / 140° F or lower than 0°C / 32° F,
- Never pull or use the hoses to move the equipment,
- Tighten all fittings as well as the hoses before operating the equipment,
- Check the hoses regularly; change them if they are damaged,
- Never exceed the maximum working pressure (MWP) indicated on the hose.

## USED PRODUCTS

Considering the wide variety of products that are available and can be used in our equipment it is impossible to check and make recommendations for all chemical data, regarding the risks of possible chemical attack and their long term chemical reaction

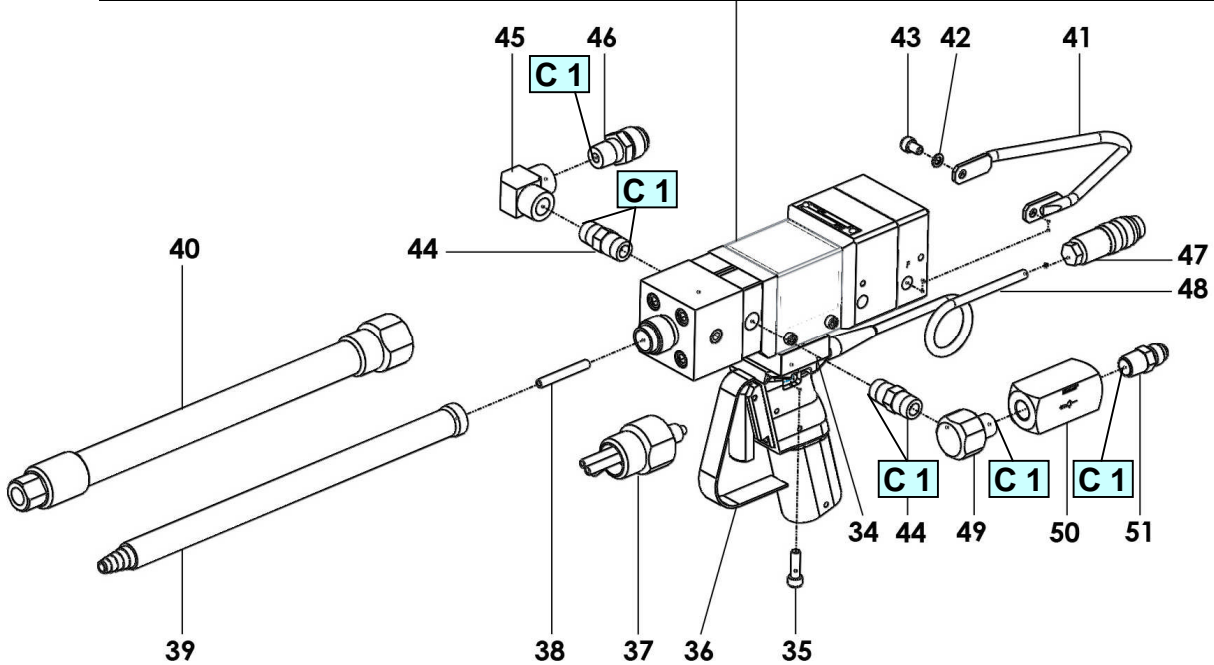
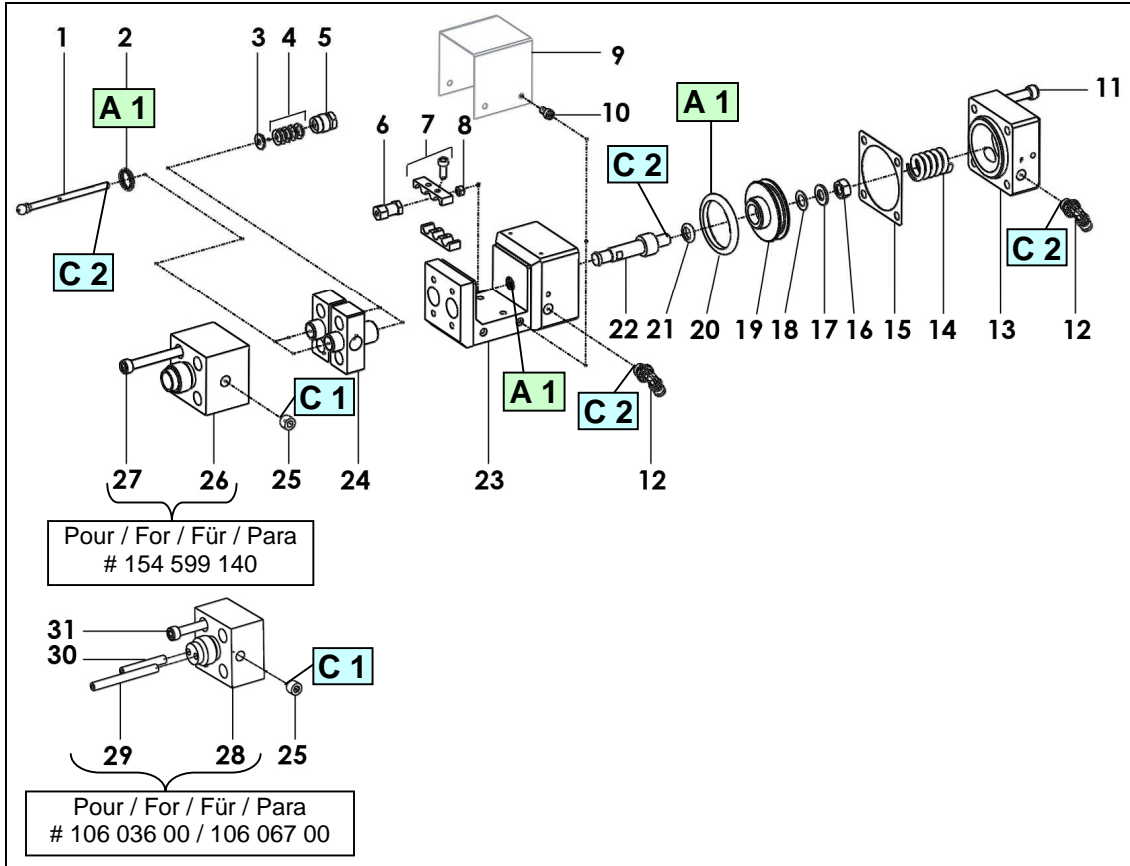
KREMLIN REXSON cannot be held liable for :

- Compatibility of wetted parts,
- Risks to staff and the surroundings,
- for worn or defective parts, for faulty equipment or units, or the quality of final product.

It is the responsibility of the user to know and prevent any possible risks such as toxic vapours, fires or explosions. He shall determine the risks of immediate reactions or pursuant to repeated exposures of the staff,

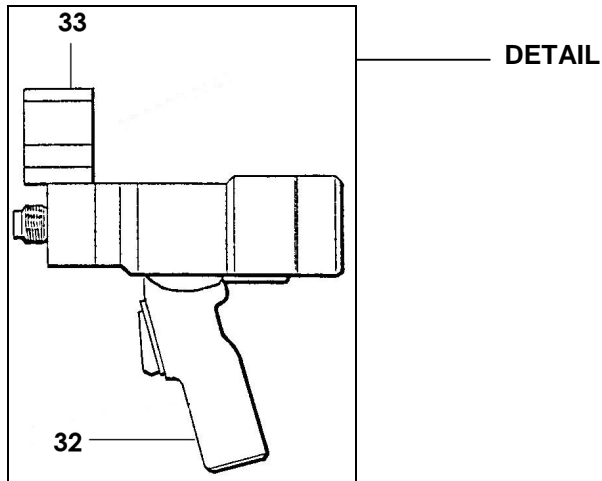
KREMLIN REXSON shall not be liable for physical injuries, direct or indirect material damages caused by the use of chemicals.

### 03. EXPLODED VIEW & SPARE PARTS' LIST



Index	Instructions	Description	Reference
<b>A 1</b>	PTFE grease	"TECHNILUB" grease (10 ml)	560.440.101
<b>C 1</b>	Medium strength - Aneorobic Pipe Sealant - Similar as Loctite 577		
<b>C 2</b>	Low strength - Aneorobic Adhesive - Loctite 222		

Ind	#	Désignation	Description	Bezeichnung	Denominación	Qté
<b>COMMON PARTS</b>						
*1	630 491	Pointeau	Needle	Nadel	Aguja	2
*2	NC /NS	Joint FKM	FKM seal	FKM Dichtung	Junta FKM	2
3	203 012	Rondelle	Washer	Scheibe	Arandela	2
*4	NC /NS	Joint	Seal	Packungsringe	Junta	10
5	203 011	Ecrou	Nut	Mutter	Tuerca	2
6	106 036 05	Noix de réglage	Adjustment piece	Regelungsstück	Tuerca de regulación	2
7	204 412	Bride	Flange	Klemmeinheit	Brida	1
8	953 010 012	Ecrou, HM4	Nut, model HM4	Mutter, HM4	Tuerca, tipo HM4	2
9	106 036 06	Carter	Housing	Gehäuse	Cárter	1
10	88 110	Vis, CHc M 4x16	Screw, model CHc M 4x16	Schraube, CHc M 4x16	Tornillo, tipo CHc M 4x16	4
11	933 151 443	Vis, CHc 6x35	Screw, model CHc 6x35	Schraube, CHc 6x35	Tornillo, tipo CHc 6x35	4
12	552 261	Raccord tournant	Swivel fitting	Drehgelenk	Racor giratorio	2
13	106 036 02	Couvercle	Cover	Deckel	Tapa	1
*14	630 612	Ressort	Spring	Feder	Muelle	1
*15	NC /NS	Joint	Seal	Dichtung	Junta	1
16	953 010 019	Ecrou, HM8	Nut, model HM8	Mutter, HM8	Tuerca, tipo HM8	1
17	88 404	Rondelle, AZ8	Washer, model AZ8	Scheibe, AZ8	Arandela, model AZ8	1
*18	NC / NS	Joint PTFE	PTFE seal	PTFE Dichtung	Junta PTFE	1
19	630 620	Piston	Piston	Kolben	Pistón	1
*20	NC /NS	Joint FKM	FKM seal	FKM Dichtung	Junta FKM	1
*21	NC / NS	Joint FKM	FKM seal	FKM Dichtung	Junta FKM	1
22	106 036 03	Tige de piston	Piston rod	Kolbenstange	Eje de pistón	1
23	106 036 01	Corps	Body	Körper	Cuerpo	1
24	106 047 01	Tête	Head	Kopf	Cabezal	2
25	906 333 106	Bouchon	Plug	Stopfen	Tapón	4
*-	<b>102 279</b>	<b>Pochette de joints (ind. 2, 4, 15, 18, 20, 21)</b>	<b>Seal kit (ind. 2, 4, 15, 18, 20, 21)</b>	<b>Dichtungssatz (Pos. 2, 4, 15, 18, 20, 21)</b>	<b>Bolsa de juntas (índ. 2, 4, 15, 18, 20, 21)</b>	<b>1</b>



Ind	#	Désignation	Description	Bezeichnung	Denominación	Qté
<b>SPECIFIC PARTS # 106 036 00 : MANUAL GUN</b>						
-	106 067 00	Pistolet automatique	Automatic gun	Automatikpistole	Pistola automática	1
28	204 410	Tête de mélange	Mixer head	Mischerkopf	Cabezal de mezcla	1
29	106 036 08	Tube de test	Test tube	Testrohr	Tubo de dosificación	1
30	106 036 07	Tube de test	Test tube	Testrohr	Tubo de dosificación	1
31	930 151 548	Vis, CHc 6x50	Screw, model CHc 6x50	Schraube, CHc 6x50	Tornillo, tipo CHc 6x50	4
*32	106 094 00	Poignée (voir doc. 574.073.110)	Handle (refer to doc. 574.073.110)	Handgriff (siehe Dok. 574.073.110)	Empuñadura (consultar doc. 574.073.110)	1
33	-	Vanne	Valve	Ventil	Válvula	1
-	106 073 77	Raccord	Fitting	Nippel	Racor	2

Ind	#	Désignation	Description	Bezeichnung	Denominación	Qté
<b>SPECIFIC PARTS # 106 067 00 : AUTOMATIC GUN</b>						
28	204 410	Tête de mélange	Mixer head	Mischerkopf	Cabezal de mezcla	1
29	106 036 08	Tube de test	Test tube	Testrohr	Tubo de dosificación	1
30	106 036 07	Tube de test	Test tube	Testrohr	Tubo de dosificación	1
31	930 151 548	Vis, CHc 6x50	Screw, model CHc 6x50	Schraube, CHc 6x50	Tornillo, tipo CHc 6x50	4



Ind	#	Désignation	Description	Bezeichnung	Denominación	Qté
<b>SPECIFIC PARTS # 154 599 140 : BOOSTHOR AUTOMATIC GUN</b>						
26	209 381	Tête de mélange	Mixer head	Mischerkopf	Cabezal de mezcla	1
27	930 151 598	Vis CHc M 6x60	Screw, model M 6x60	Schraube, M 6x60	Tornillo, tipo M 6x60	4
34	054 599 142	Interface poignée/corps	Handle/body interface	Verbindungsstück Handgriff/Pistolenkörper	Interfaz empuñadura/cuerpo	1
35	88 129	Vis CHc M5x18	Screw, model CHc M 5x18	Schraube, CHc M 5x18	Tornillo, tipo CHc M 5x18	2
36	921 290 101	Poignée	Handle	Handgriff	Empuñadura	1
37	054 599 143	Tête contrôle de dosage	Head	Testkopf für Dosierung	Cabezal control de dosificación	1
38	209 384	Tube test base	Base test tube	Testrohr für Basis	Tubo de dosificación base	1
39	107 100 24	Mélangeur statique (voir doc. 574.082.110)	Static mixer (refer to doc. 574.082.110)	Statisches Mischrohr (siehe Dok. 574.082.110)	Mezclador estático (consultar doc. 574.082.110)	1
40	107 125 0 500	Mélangeur statique (voir doc. 574.082.110)	Static mixer (refer to doc. 574.082.110)	Schutzrohr für Mischrohr (siehe Dok. 574.082.110)	Mezclador estático (consultar doc. 574.082.110)	1
41	054 599 144	Etrier	U-bolt	Bügel	Horquilla	1
42	963 210 064	Rondelle WZ5	Washer, model WZ5	Scheibe, WZ5	Arandela, tipo WZ5	2
43	88 127	Vis CHc M5x8	Screw, model CHc M 5x8	Schraube, CHc M 5x8	Tornillo, tipo CHc M 5x8	2
44	551 218	Raccord	Fitting	Nippel	Racor	2
45	551 008	Coude FF 400 bar	Elbow, model FF 400 bar / 5801.2 psi	Winkelnippel IG-IG 400 bar	Codo, tipo HH 400 bar	1
46	905 160 212	Mamelon M 1/4G x M 3/4 JIC	Nippel, model double male 1/4G x 3/4 JIC	Doppelnippel AG ¼"G x AG ¾ JIC	Manguito, tipo M 1/4G x M 3/4 JIC	1
47	901 460 107	Prise Male 3 broches	Male connector 3 pins	Stecker mit 3 Stiften	Toma macho 3 tomas	1
48	76 505	Câble Longueur : 15m	Cable Length : 15m	Kabel Länge: 15m	Cable Longitud : 15m	1
49	550 534	Raccord coudé	Elbow fitting	Winkelnippel	Racor acodado	1
50	903 160 516	Clapet anti-retour	Non-return valve	Rückschlagventil	Válvula anti-retorno	1
51	550 542	Raccord M 1/4" G Co - M 1/2" JIC	Fitting, model double male 1/4" G Co - M 1/2" JIC	Doppelnippel AG ¼" G Co – AG ½" JIC	Racor, tipo M 1/4" G Co - M 1/2" JIC	1
52	88 123	Vis CHc M 5x20	Screw, model CHc M5x20	Schraube, CHc M5x20	Tornillo, tipo CHc M5x20	2

\* Pièces de maintenance préconisées.

\* Preceding the index number denotes a suggested spare part.

\* Bezeichnete Teile sind empfohlene Ersatzteile.

\* Piezas de mantenimiento preventivas.

N C : Non commercialisé.

N S : Denotes parts are not serviceable.

N S: Bezeichnete Teile gibt es nicht einzeln, sondern nur  
komplett.

N S : no suministrado.

## 04. MAINTENANCE

**Guards (air motor cover, coupling shields, housings ...) have been designed for safe use of the equipment.**

**The manufacturer will not be held responsible for bodily injury or failure and / or damage to property due to removal or partial removal of the guards**

Before any removal or intervention on the gun, you must isolate it by means of a safety valve (compulsory upstream of the gun) and ensure that the working pressure has been drained to avoid risks of serious injuries : spatters especially in eyes or injections under the skin can cause a blood poisoning when using such material.

The maintenance consists in checking seals as well as the parts of the gun following fluid leaks or only for a preventive maintenance.

We advice you to change the parts with an unfair wear and tear.

**DO NOT SOAK THE GUN INTO SOLVENT  
TO PREVENT FROM DAMAGING THE SEALS OF THE PNEUMATIC PART.**

## 05. DISASSEMBLY

**Guards (air motor cover, coupling shields, housings ...) have been designed for safe use of the equipment.**

**The manufacturer will not be held responsible for bodily injury or failure and / or damage to property due to removal or partial removal of the guards**

### A. DISASSEMBLY OF THE FLUID PART

- Shut off air.
- **Carry out the depressurize procedure.**
- Unscrew the fixing nut of the static mixer, change the mixer.
- Unscrew the 4 screws (10) with the 4 mm / 0.15" wrench; put aside the housing (9).
- Unscrew the 4 screws (27 or 31) with the 6 mm / 0.23" wrench.
- Put aside the mixer head (26 or 28).
- Unscrew the 2 screws holding the flange assembly (7) with the 4 mm / 0.15" wrench.
- Disassemble the 2 flanges (7).
- Take off the 2 heads (24).

**NOTA : For the versions # 106 036 00 and # 106 067 00, the two heads are fitted with fittings. Do not install other fitting to prevent from damaging the needle.**

- Block the adjustment part (6) with the 10 mm / 0.4" wrench, then unscrew the nut (8) with the 7 mm / 0.27" wrench, take off the needle (1) frontwards, put it aside, check and change if necessary the seal (2).
- Unscrew the cup nut (5), take off the seals (4) and the washer (3).
- Clean the heads (24) and the mixer head (26 or 28) with solvent and brush.

## B. DISASSEMBLY OF THE PNEUMATIC PART

- Take off the screws (11) by means of the 6 mm / 0.23" wrench.
- Remove the cover (13), then the seal (15), the spring (14) and the seal (20), change if necessary.
- Push and take off the piston assembly backwards and put aside the body (23).
- Take off the nut (16) and the washer (17).
- Put aside the piston (19) and check the seals (18, 20 and 21), change them if necessary.
- Take off the piston rod (22).

## 06. GUN ASSEMBLY

**Guards (air motor cover, coupling shields, housings ...) have been designed for safe use of the equipment.  
The manufacturer will not be held responsible for bodily injury or failure and / or damage to property due to removal or partial removal of the guards**

Carry out the gun assembly in the reverse order of the disassembly sequence using grease or glue when necessary. When assembly, change the seals (refer to package of seals) and other parts if necessary.

### For the assembly of the heads (26 or 28) :

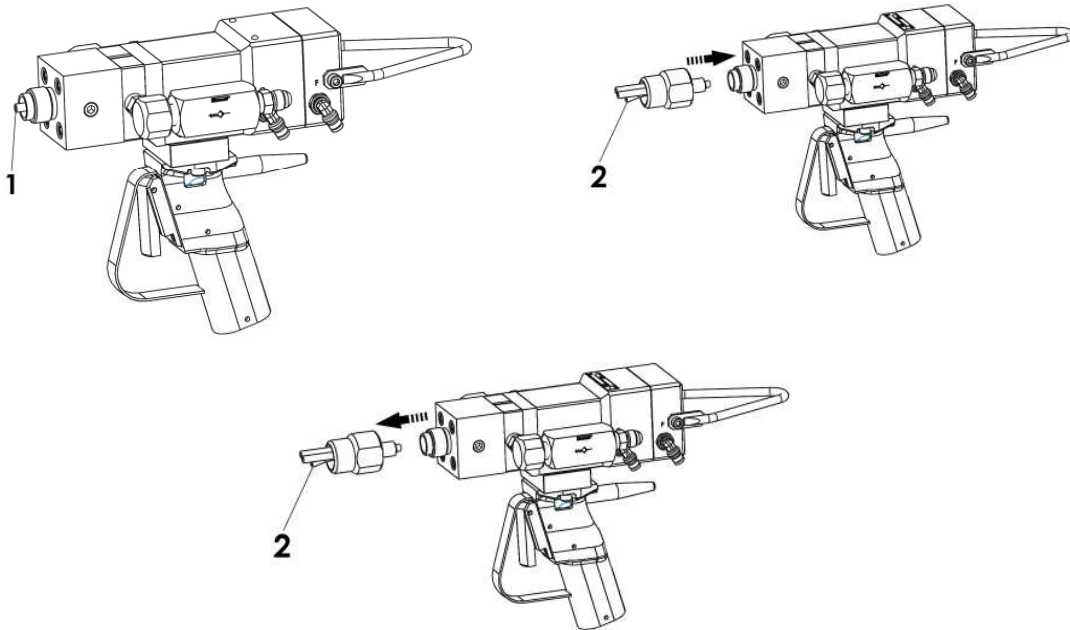
- Insert the "M" washers (3) and the seals into the heads (26 or 28), ensure seals are correctly positioned ("V" point tightening side), screw the nut of the cup without using tools, only to position correctly the seals.
- Insert the needles (1) in each head and be careful not to damage the seals. Install the adjustment piece (6) and the nut (8) without blocking them.
- Remount the flanges (7), without blocking them; install the mixing head (26 or 28); do not forget the O Rings (2), lock with the screws (27 or 31).

### Adjustment of the needles :

- The end of the needles must stick out of the nut (8) of 3 mm / 0.12".
- When the gun is working, ensure the tightness of the mixer head. If a leak appears, unscrew the nut (8) and the adjustment (6). Push the needle on the seat until the leak is eliminated. Install the adjustment pieces (6), the nuts (8) and the screws.

**For the assembly of the BOOSTHOR mixing head (37) and its use :**

- The kit enables you to calibrate the BOOSTHOR machine (For more informations, please refer to Doc. 578.196.110).



- Remove the static mixer (39) and remove the center injection cata nozzle/tube (1) located at the front material outlet of the gun.
- Screw the ratio kit on the gun aircap as well as the central nozzle (2).

**After the calibration procedure:**

- Unscrew the ratio kit on the gun aircap as well as the central nozzle (2).
- Clean the ratio kit after using it to prevent from material drying. If the ratio kit is not correctly cleaned up, it becomes useless.