



SPECIFICATIONS

EXTRUSION PUMP

Model 20-600

Manual : 1004 573.048.212

Date : 1/04/10 - Supersede : 1/08/08

Modif. : Update

ORIGINAL MANUAL

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

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

ADDITIONAL DOCUMENTATIONS FOR PUMP, MODEL 20-600

SPARE PARTS :	Wall mounted unit	(doc. 573.201.050)
	Fluid section	(doc. 573.567.040)
	Air motor	(doc. 573.507.040)
	Reversing block	(doc. 573.087.040)

KREMLIN - REXSON

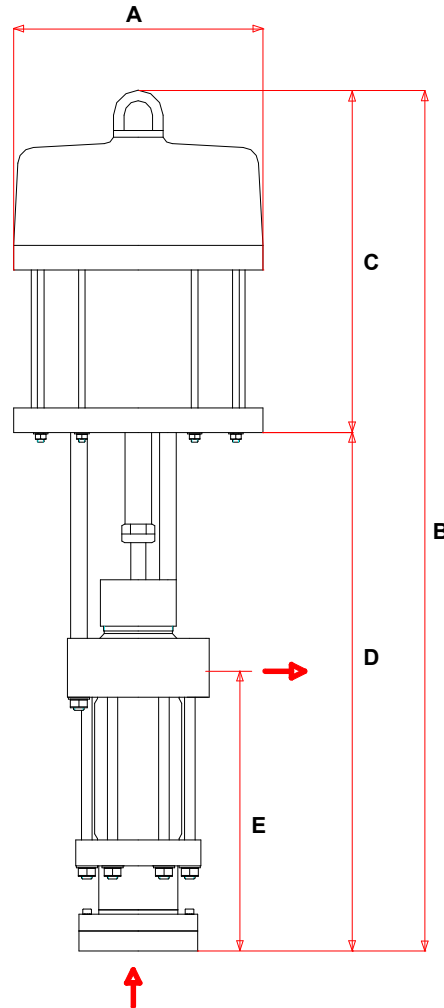
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■ DIMENSIONS

Ind.	A	B	C	D	E
mm	∅ 380	1305	520	785	410
"	15	51	21	31	16.2



2. MAINTENANCE



WARNING :

Before any intervention on the pump, shut off the compressed air and depressurize the circuits by triggering the spray gun and opening the drain valve.

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

■ DISASSEMBLY

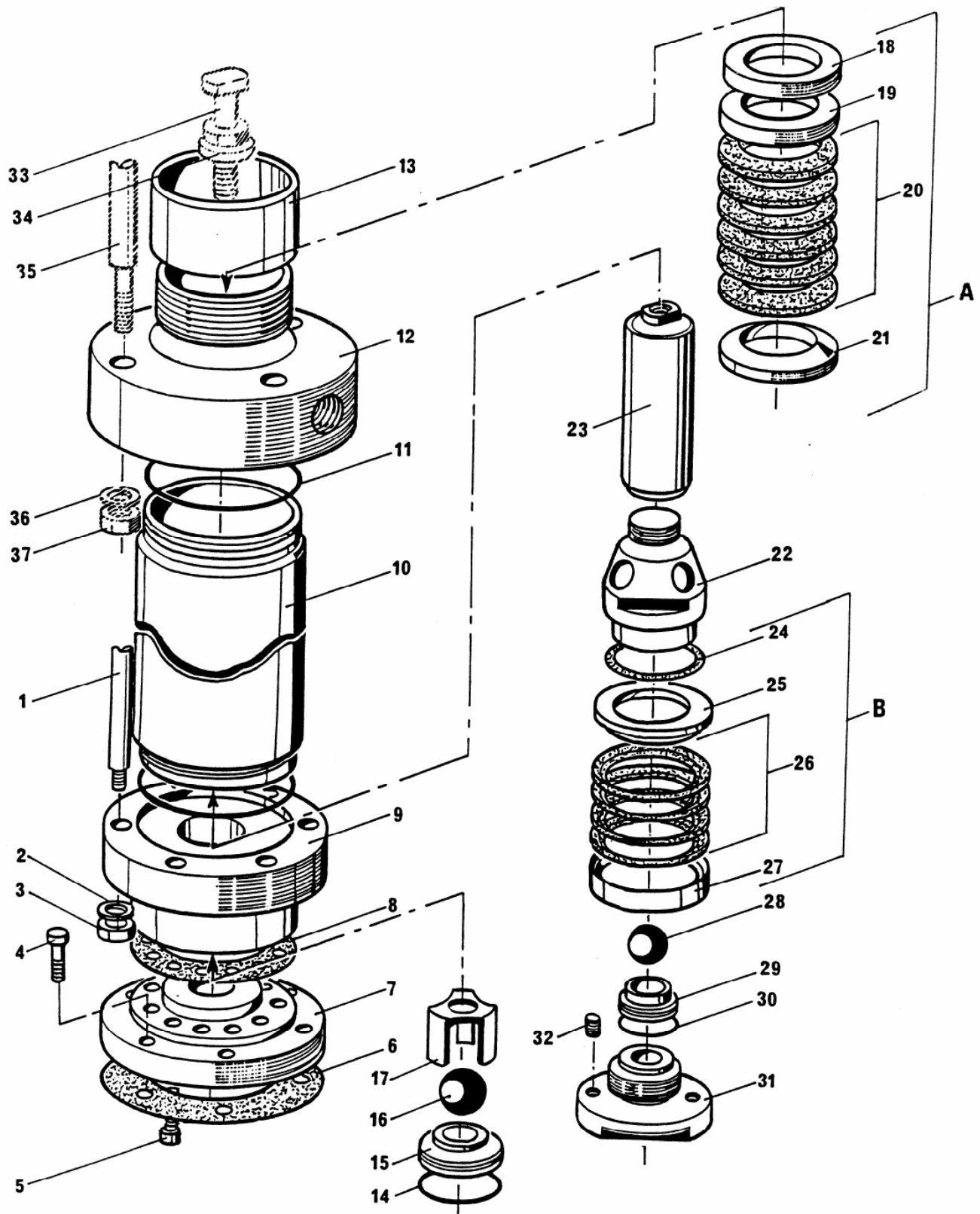
Disassemble the fluid section from the air motor.

Unscrew cup (13).

Remove the nuts (3) and the tie-rods (1).

Remove the upper flange (12).

→ Remove A packing (ind.18 to 21).



Remove cylinder (10) from the lower flange (9).

➔ Remove B packing (ind. 24 to 27).

➔ Remove the piston (23).

Unscrew the screws (5) to separate lower flange (9) from the suction flange (7).

➔ Remove suction valve (ind. 14 to 17).

■ REASSEMBLY

Replace all flat seals. Lubricate them.

Clean the parts with white spirit.

UPPER PACKING

Install chevron seals (20), the rings (19-21) and the support washer (18) of the upper packing into exhaust flange (12). Make sure you properly install the parts (refer to detail on drawing).

Screw the cup (13) by hand without tightening the exhaust flange (12).

Insert piston (23) into parts (13, A, 12) from 13 to 12 to assure the proper orientation of the chevron seals.

Nota : 6 NBR chevron seals or 7 PTFE B chevron seals depending upon version.

LOWER PACKING

Install seal (30) on ball seat (29).

Install the ball (28) and the seat (29) into valve body (22).

Install chevron seals (26), the support rings (25-27) and 1 or 2 lock-washers (24) onto valve body (22). Make sure you properly installed the parts (refer to detail on drawing).

Tighten the lower packing by screwing the exhaust seat support (31) into exhaust valve (22).

Apply low strength - Aneorobic Adhesive - Loctite 222 on the 2 screws (32). Screw them into support (31) to assure the proper tightening of the exhaust valve.

Screw and tighten the exhaust valve (22) into the piston (23).

First, apply low strength - Aneorobic Adhesive - Loctite 222 to prevent from the unscrewing of the whole.

Lubricate the seals (26) mounted on the exhaust valve as well as the inside of the cylinder (10) to prevent from damaging the seals when assembling.

Install lower flange (9) on the cylinder (10). Fix the whole by means of the 6 tie-rods (1), of the washers (2) and of the nuts (3). Tighten the screws onto the tie-rods and torque to 8 m/kg.

SUCTION VALVE

Position ball cage (17), the ball (16) and the suction seat (15) with its seal (14) into lower flange (9).

Install suction flange (7) with paper seal (8) on lower flange (9) and secure with its 12 screws (5).

Warning : after reassembling on the air motor, fill up the cup with lubricant, supply the pump with air and gradually increase pressure to maximum for the setting of the seals.

After half an hour, depressurize the pump and check the torque.

