



## INSTRUCTION MANUAL

### AUTOMATIC EXTRUSION GUN (WITH PNEUMATIC OPENING AND CLOSING)

# 630 990 0101 - 630 990 0102 - 630 990 0201

# 630 990 0401

# 630 990 1101

# 630 990 1201 - 630 990 1203

Manual : 574.037.112 - 1602

Date : 17/02/16 - Supersede: 08/06/15

Modif.: + Servicing kit # 106 172

### 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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**INSTRUCTION MANUAL**  
**AUTOMATIC EXTRUSION GUN**

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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 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.

## 1. 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.

## 2. 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

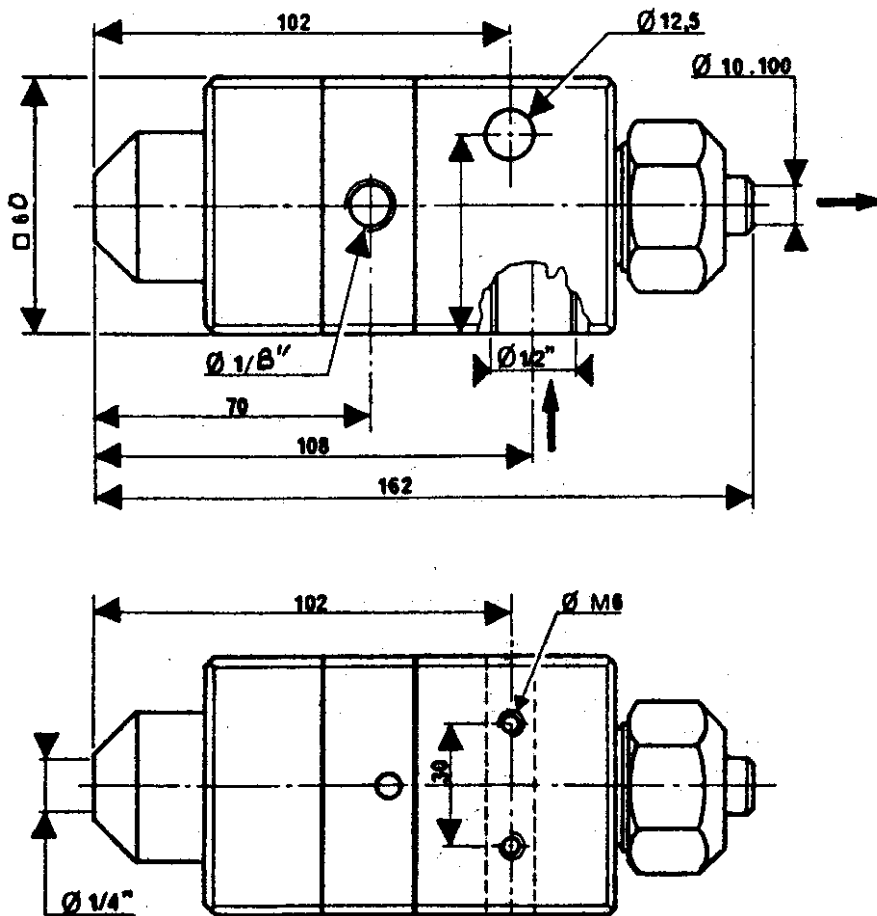
KREMLIN REXSON can not be held liable for :

- 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.

### 3. DIMENSIONS



### 4. FEATURES

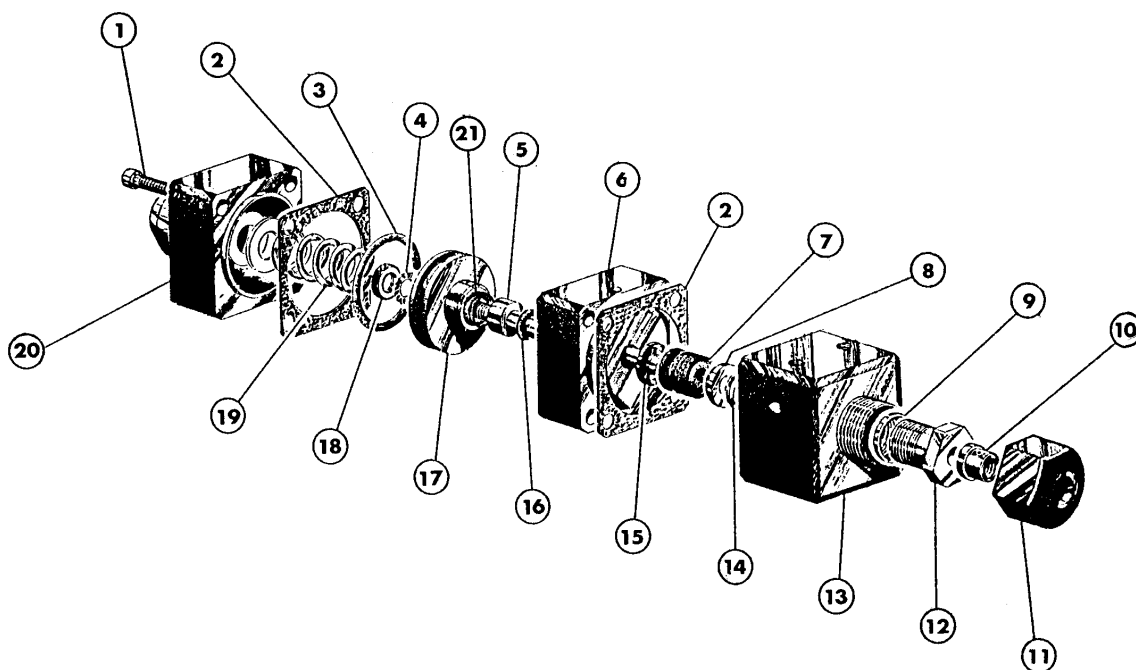
# Guns	Specificity	Maximum fluid pressure	Air pressure (control)	Packings	Seat
630 990 0101	-	150 bar / 2175 psi	From 4 to 6 bar / from 58 to 87 psi	PA 11	steel
630 990 0102	-	150 bar / 2175 psi	From 4 to 6 bar / from 58 to 87 psi	PTFE	steel
630 990 0201	-	150 bar / 2175 psi	From 4 to 6 bar / from 58 to 87 psi	PA 11	steel + carbide
630 990 0401	-	150 bar / 2175 psi	From 4 to 6 bar / from 58 to 87 psi	PA 11	steel
630 990 1101	with pneumatic assistance	250 bar / 3626 psi	From 4 to 6 bar / from 58 to 87 psi	PA 11	steel
630 990 1201	with pneumatic assistance	250 bar / 3626 psi	From 4 to 6 bar / from 58 to 87 psi	PA 11	steel + carbide
630 990 1203	with pneumatic assistance	250 bar / 3626 psi	From 4 to 6 bar / from 58 to 87 psi	PEEK	steel + carbide

Fluid inlet : F 1/2 G

Control air inlet (opening) : F 1/8 G

Control air inlet (closing) : F 1/4 G

## 5. EXPLODED VIEW



## 6. PARTS' LIST

- GUNS : # 630 990 0101, 630 990 0102, 630 990 0201, 630 990 0401

Ind	#	Désignation	Description	Bezeichnung	Denominación	Qté
<b>COMMON PARTS</b>						
1	933 151 523	Vis, CHc 6x45	Screw, CHc 6x45	Schraube, CHc 6x45	Tornillo, CHc 6x45	4
2	NC / NS	Joint	Seal	Dichtung	Junta	2
3	NC / NS	Joint FKM, R28	FKM seal, model R28	FKM Dichtung	Junta FKM, tipo R 28	1
4	88 404	Rondelle	Washer	Scheibe	Arandela	1
6	55 282	Corps de liaison	Intermediary body	Zwischenkörper	Cuerpo de conexión	1
8	81 75	Rondelle "M"	'M' washer	Stützring konvex	Arandela 'M'	1
9	NC / NS	Joint	Seal	Dichtung	Junta	1
13	630 991	Corps	Body	Körper	Cuerpo	1
*14	55 286	Ressort	Spring	Feder	Muelle	1
15	55 287	Rondelle "F"	'F' washer	Stützring konkav	Arandela 'H'	1
16	NC / NS	Joint FKM	FKM seal	FKM Dichtung	Junta FKM	1
17	630 620	Piston	Piston	Kolben	Pistón	1
18	953 010 019	Ecrou	Nut	Mutter	Tuerca	1
*19	630 612	Ressort	Spring	Feder	Muelle	1
20	630 793	Cylindre	Cylinder	Zylinder	Cilindro	1
21	NC / NS	Joint PTFE	PTFE seal	PTFE Dichtung	Junta PTFE	1

Ind	#	Désignation	Description	Description	Denominación	Qté
<b>SPECIFIC PARTS</b>						
<b>630 990 0101</b>						
*5	630 994	Tige de pointeau	Needle rod	Nadelstange	Eje de aguja	1
7	NC / NS	Joint chevron, PA11	Chevron seal, PA11	Packungsring, PA11	Junta chevrón, PA11	5
10	630 421	Embout de buse	End piece	Endstück	Terminal de boquilla	1
11	630 993	Chapeau	Hat	Haube	Tapa	1
*12	630 992	Siège (acier)	Seat (steel)	Sitz (Stahl)	Asiento (acero)	1
*	<b>101 192</b>	<b>Pochette de joints (Ind. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>Seal kit (Ind. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>Dichtungssatz (Pos. 2 (2x), 3, 7 (5x), 9, 16, 21)</b>	<b>Bolsa de juntas (Ind. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>1</b>

<b>630 990 0102</b>						
*5	630 994	Tige de pointeau	Needle rod	Nadelstange	Eje de aguja	1
7	NC / NS	Joint chevron, PTFE	Chevron seal, PTFE	Packungsring, PTFE	Junta chevrón, PTFE	5
10	630 421	Embout de buse	End piece	Endstück	Terminal de boquilla	1
11	630 993	Chapeau	Hat	Haube	Tapa	1
*12	630 992	Siège (acier)	Seat (steel)	Sitz (Stahl)	Asiento (acero)	1
*	<b>103 103</b>	<b>Pochette de joints (Ind. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>Seal kit (Ind. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>Dichtungssatz (Pos. 2 (2x), 3, 7 (5x), 9, 16, 21)</b>	<b>Bolsa de juntas (Ind. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>1</b>

<b>630 990 0201</b>						
*5	630 973	Aiguille (avec bille carbure)	Needle (with carbide ball)	Nadelstange (mit Kugel aus Karbid)	Aguja (con bola de carburo)	1
7	NC / NS	Joint chevron, PA11	Chevron seal, PA 11	Packungsring, PA 11	Junta chevrón PA 11	5
10	630 421	Embout de buse	End piece	Endstück	Terminal de boquilla	1
11	630 993	Chapeau	Hat	Haube	Tapa	1
*12	210 331	Siège (acier + carbure)	Seat (steel + carbide)	Sitz (Stahl + Karbid)	Asiento (acero + carburo)	1
*	<b>101 192</b>	<b>Pochette de joints (Ind. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>Seal kit (Ind. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>Dichtungssatz (Pos. 2 (2x), 3, 7 (5x), 9, 16, 21)</b>	<b>Bolsa de juntas (Ind. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>1</b>
*	<b>106 172</b>	<b>Pochette de maintenance (Ind. 5, 12)</b>	<b>Servicing kit (Ind. 5, 12)</b>	<b>Reparatursatz (Pos. 5, 12)</b>	<b>Bolsa de mantenimiento (Ind. 5, 12)</b>	<b>1</b>

<b>630 990 0401</b>						
*5	630 994	Tige de pointeau	Needle rod	Nadelstange	Eje de aguja	1
7	NC / NS	Joint chevron, PA11	Chevron seal, PA 11	Packungsring, PA 11	Junta chevrón PA 11	5
11	203 048	Chapeau	Hat	Haube	Tapa	1
*12	630 992	Siège (acier)	Seat (steel)	Sitz (Stahl)	Asiento (acero)	1
*	<b>101 192</b>	<b>Pochette de joints (Ind. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>Seal kit (Ind. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>Dichtungssatz (Pos. 2 (2x), 3, 7 (5x), 9, 16, 21)</b>	<b>Bolsa de juntas (Ind. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>1</b>

\* 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.

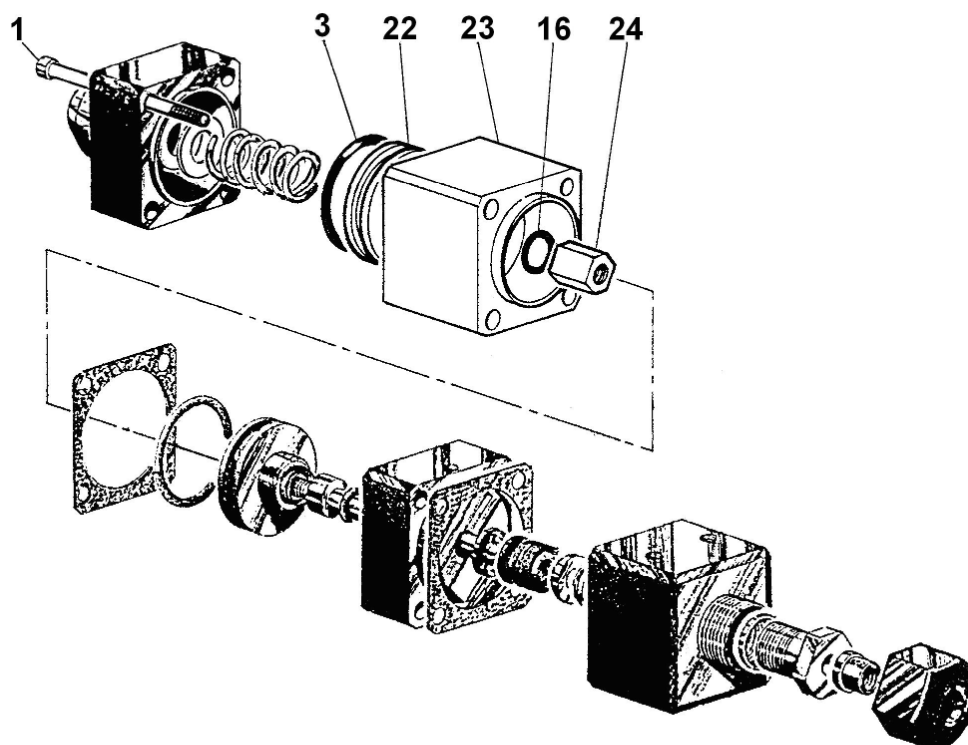
N S : Denotes parts are not serviceable.

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

N S : no suministrado.



- GUNS : # 630 990 1101, 630 990 1201, 630 990 1203



Ind	#	Désignation	Description	Bezeichnung	Denominación	Qté
<b>COMMON PARTS</b>						
1	88 783	Vis, CHc M6x85	Screw, CHc M6x85	Schraube, CHc M6x85	Tornillo, CHc M6x85	4
2	NC / NS	Joint	Seal	Dichtung	Junta	2
3	NC / NS	Joint FKM	FKM seal	FKM Dichtung	Junta FKM	1
6	55 282	Corps de liaison	Intermediary body	Zwischenkörper	Cuerpo de conexión	1
8	81 75	Rondelle "M"	'M' washer	Stützring konvex	Arandela 'M'	1
9	NC / NS	Joint	Seal	Dichtung	Junta	1
11	203 048	Chapeau	Hat	Haube	Tapa	1
13	630 991	Corps	Body	Körper	Cuerpo	1
*14	55 286	Ressort	Spring	Feder	Muelle	1
15	55 287	Rondelle "F"	'F' washer	Stützring konkav	Arandela 'H'	1
16	NC / NS	Joint FKM	FKM seal	FKM Dichtung	Junta FKM	1
17	630 620	Piston	Piston	Kolben	Pistón	1
19	630 612	Ressort	Spring	Feder	Muelle	1
20	630 793	Cylindre	Cylinder	Zylinder	Cilindro	1
21	NC / NS	Joint PTFE	PTFE seal	PTFE Dichtung	Junta PTFE	1
22	206 768	Piston	Piston	Kolben	Pistón	1
23	206 767	Cylindre intermédiaire	Intermediate cylinder	Zwischenzylinder	Cilindro intermediario	1
24	206 769	Ecrou de butée	Stop nut	Anschlagsmutter	Tuerca de tope	1
*	630 614	Joint	Seal	Dichtung	Junta	1

Ind	#	Désignation	Description	Bezeichnung	Denominación	Qté
<b>SPECIFIC PARTS</b>						
<b># 630 990 1101</b>						
*5	630 994	Tige de pointeau	Needle rod	Nadelstange	Eje de aguja	1
7	NC / NS	Joint chevron, PA11	Chevron seal, PA 11	Packungsring, PA11	Junta chevrón PA 11	5
*12	630 992	Siège (acier)	Seat (steel)	Sitz (Stahl)	Asiento (acero)	1
*	<b>101 192</b>	<b>Pochette de joints (Ind. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>Seal kit (Ind. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>Dichtungssatz (Pos. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>Bolsa de juntas (Índ. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>1</b>
<b># 630 990 1201</b>						
*5	630 973	Aiguille (avec bille carbure)	Needle (with carbide ball)	Nadelstange	Aguja (con bola de carburo)	1
7	NCS / NSS	Joint chevron, PA11	Chevron seal, PA 11	Packungsring, PA 11	Junta chevrón PA 11	5
*12	210 331	Siège	Seat	Sitz	Asiento	1
*	<b>101 192</b>	<b>Pochette de joints (Ind. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>Seal kit (Ind. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>Dichtungssatz (Pos. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>Bolsa de juntas (Índ. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>1</b>
*	<b>106 172</b>	<b>Pochette de maintenance (Ind. 5, 12)</b>	<b>Servicing kit (Ind. 5, 12)</b>	<b>Reparatursatz (Pos. 5, 12)</b>	<b>Bolsa de mantenimiento (Índ. 5, 12)</b>	<b>1</b>
<b># 630 990 1203</b>						
*5	630 973	Aiguille (avec bille carbure)	Needle (with carbide ball)	Nadelstange (mit Kugel aus Karbid)	Aguja (con bola de carburo)	1
7	NC / NS	Joint chevron, PEEK	Chevron seal, PEEK	Packungsring, PEEK	Junta chevrón PEEK	5
*12	210 331	Siège	Seat	Sitz	Asiento	1
*	<b>107 345</b>	<b>Pochette de joints (Ind. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>Seal kit (Ind. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>Dichtungssatz (Pos. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>Bolsa de juntas (Índ. 2x2, 3, 7x5, 9, 16, 21)</b>	<b>1</b>
*	<b>106 172</b>	<b>Pochette de maintenance (Ind. 5, 12)</b>	<b>Servicing kit (Ind. 5, 12)</b>	<b>Reparatursatz (Pos. 5, 12)</b>	<b>Bolsa de mantenimiento (Índ. 5, 12)</b>	<b>1</b>

\* 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.

## 7. 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.

**DON'T SOAK THE ENTIRE GUN INTO SOLVENT TO PREVENT FROM DAMAGING THE SEALS.**

## 8. REPLACEMENT OF THE NOZZLE

- Unscrew the nozzle from the nozzle end (10),
- Change the nozzle and screw it on the nozzle end.

## 9. GUN 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**

- Unscrew the nozzle from the nozzle end (10),
- Remove the hat (11) and take off the nozzle end (10),
- Unscrew the seat (12) and remove the seal (9),
- Unscrew the screws (1), remove the cylinder (20), the spring (19) and the seal (2),
- Take off the piston (17) and the needle rod (5) from the intermediary body (6),
- Take off the seal (3),
- Unscrew the nut (18) and remove the washer (4),
- Take off the needle rod (5) from the piston (17) and the seal (22),
- Take off the intermediary body (6), the seal (2) and the seal (16),
- Take off the "F" washer (15), the seals (7), the "M" washer (8) and the spring (14),
- Clean, except the seals, the parts with a solvent compatible with the material to be sprayed,
- Check carefully the parts, change them if necessary.

## 10. GUN ASSEMBLY

Carry out the gun assembly in the reverse order of the disassembly. Lubricate the movable parts and grease the seals. Use grease to lubricate the movable parts of the fluid part and a light oil for the parts of the pneumatic part.

**IMPORTANT** : When the operating pressure is upper than 160 bar / 2320.5 psi, fix the rear part of the spring (19) with 2 washers (P.N° : 963 020 024).