



INSTRUCTION MANUAL

PNEUMATIC BOX FOR SIMPLE EXTRUSION GROUP

106 004

Manual : 574.095.112 - 1310

Date : 31/10/13 - Supersede : 03/11/11

Modif. : Page 4 (112 cycles → 1/2 cycle)

TRANSLATION OF 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.

KREMLIN - REXSON

150, avenue de Stalingrad

93 245 - STAINS CEDEX – France

☎ : 33 (0)1 49 40 25 25 Fax : 33 (0)1 48 26 07 16

www.kremlin-rexson.com



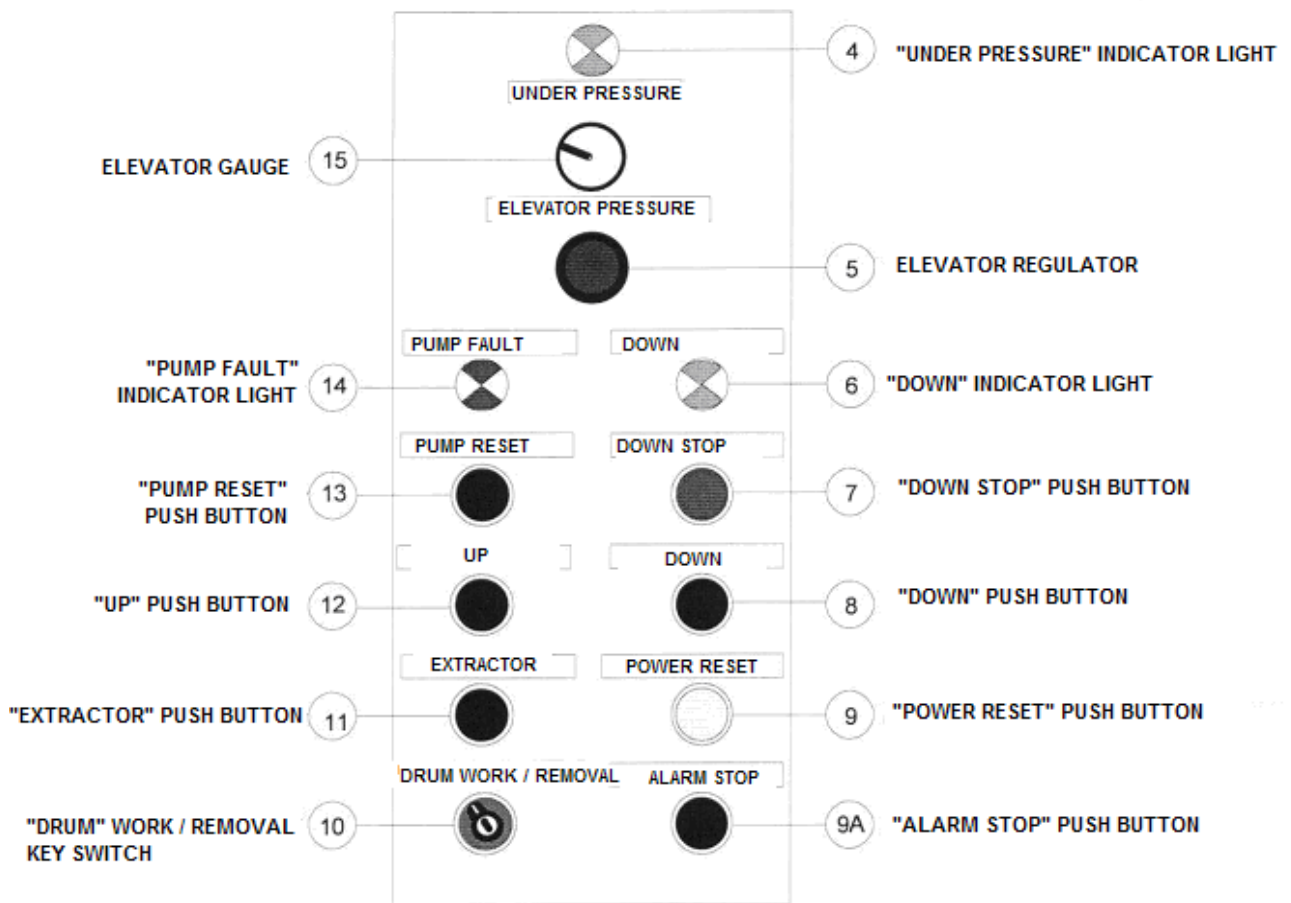
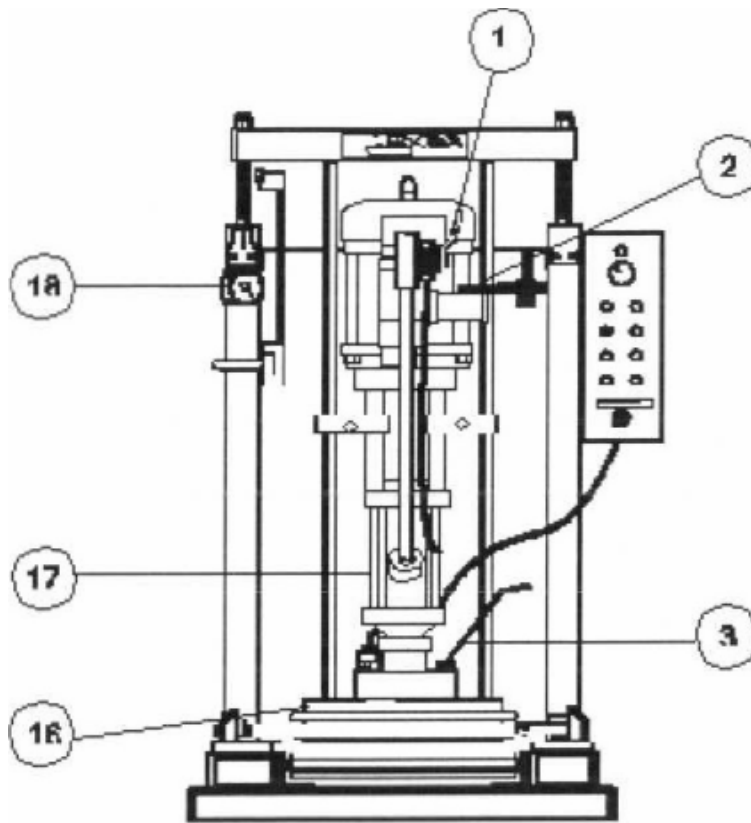
**INSTRUCTION MANUAL
PNEUMATIC BOX FOR SIMPLE EXTRUSION GROUP**

TABLE OF CONTENTS

A. STARTING UP.....3

B. INSTRUCTIONS WHEN REMOVING THE DRUM4

C. ADJUSTMENT OF THE ANTI OVERSPEED4



A. STARTING UP

NOTA : The anti overspeed are preset in the factory; if you need to change them, refer to section C.

- 1 - Open the main air inlet valve (2); the "**UNDER PRESSURE**" indicator light (4) becomes green.
- 2 - Place the key switch (10) "**WORK 1-DRUM REMOVAL**" on "**REMOVAL DRUM**",
- 3 - Push the button (9) "**POWER RESET**". Check the indicator lights :
 - "**UNDER PRESSURE**" indicator light (4): green colour,
 - "**PUMP FAULT**" indicator light (14): red colour,
 - "**DOWN**" indicator light (6) : white colour.
- 4 - Unscrew the priming rod (3),
- 5 - Install air pressure on the elevator by means of the regulator (5) (minimum : 4 bar / 58 psi; maximum : 6 bar / 87 psi); check by means of the gauge (15).
- 6 - Lift the follower plate (16) in up position by means of the "**UP**" control button (12).

The elevator is in up position :

- 7 - Open the drum clamping,
- 8 - Place the material drum under the follower plate (16); take off the drum cover,
- 9 - Reclamp the drum.

Down procedure :

- 10 - Push the "**DOWN**" button (8) to make the follower plate go down (the adjustment of the follower plate down speed is carried out by means of the regulator (5) adjusting the elevator air pressure),
- 11 - As soon as the plate is on the drum, air under the plate is exhausting from the priming rod hole,
- 12 - Wait until material flows from the priming rod,
- 13 - Install the priming rod (3),
- 14 - Check on the regulator (18) that pump (17) pressure is equal to 0 bar / 0 psi,
- 15 - Open the drain valve (1) of the pump,
- 16 - Reset the pump pushing the "**PUMP RESET**" button (13),
- 17 - Adjust progressively the pump (17) pressure by means of the regulator (18) to prevent the pump racing,
- 18 - Let flow material from the drain, wait until there is no more air,
- 19 - Close the pump drain valve (1),
- 20 - Place the key switch (10) "**WORK 1-DRUM REMOVAL**" on "**WORK**",
- 21 - Check the air pressure on the gauge (15); adjust it if necessary by means of the regulator (5),
- 22 - Push the "**DOWN**" push button (8); the "**DOWN**" indicator light (6) becomes green,
- 23 - Drain the distribution circuit by means of the material filter drain valve and of the gun opening.

B. INSTRUCTIONS WHEN REMOVING THE DRUM

After stopping the alarm pushing the **"STOP ALARM"** knob, please follow the instructions hereafter :

- 1 - The follower plate (16) is in low position; the **"PUMP FAULT"** indicator light becomes red (a pre end of drum information can signal previously the end of drum : electric information),
- 2 - Place the key switch (10) **"WORK 1-DRUM REMOVAL"** on **"DRUM REMOVAL"**,
- 3 - Install the follower plate pushing the **"UP"** push button (12) while injecting air with the **"EXTRACTOR"** push button (11),
Never push more than several seconds the **"EXTRACTOR"** push button.
- 4 - When the follower plate is in up position, clean the seal,
- 5 - Unclamp the drum, take it off and change it,
- 6 - Follow the start up procedure from the A7 stage to the A22 stage.

C. ADJUSTMENT OF THE ANTI OVERSPEED

That adjustment is carried out with the pump running light, without material.

- 1 - Open the box,
- 2 - Unscrew the 2 knurled screws from the 2 tempos,
- 3 - Adjust the pump to the maximum wanted speed by means of the mano regulator (18) (around 1/2 cycles/sec - 1 cycle = 1 return),
- 4 - Screw the knurled screw of the low tempo until you get an escape noise (time base),
- 5 - Screw the knurled screw of the up tempo until you get the tripping of the anti overspeed,
- 6 - Unscrew the 2 screws (2 turns) counterclockwise,
- 7 - Reset the pump by means of the **"PUMP RESET"** knob (13) then refine the adjustment if necessary,
- 8 - Lock the 2 screws by means of the lock nuts,
- 9 - Check the adjustment increasing the pressure in the moto pump by means of the mano regulator (18).

GESTION_MONTEE-BAISSE_VERIN

SOCIETE : **REXSON**

ADRESSE : Z.I. Villemilan

24 Avenue AMPERE

91320 WISSOUS

TEL : 01 60 13 59 00

FAX : 01 69 20 81 90

e-mail :

RESPONSABLE TECHNIQUE : M.BATICLE

N° PROJET : R-106004

N° SERIE :

FESTO

VOTRE PARTENAIRE EN AUTOMATISME

TEL 01.49.35.23.23 FAX 01.49.35.23.33 5 RUE MONTGOLFIER 93116 ROSNY SOUS BOIS

A	LIVRAISON	14/11/01	PERRIN
INDICE	LIVRAISON / MISE A JOUR	DATE	VISA

ORIGINAL - FESTO FRANCE

INTERVENANTS FESTO

CONSEILLER TECHNIQUE : Yann CREZE
 ASSISTANT TECHNIQUE : Carlos MARTINS
 REALISATION : J-Loup HARY
 MISE EN ROUTE : Client
 RESPONSABLE PROJET : J-Jacques PERRIN

AGENCES FESTO FRANCE

NANTES : 02.40.48.98.00
 SARREGUEMINES : 03.87.95.97.50
 SECLIN : 03.20.62.94.94
 LYON : 04.72.05.66.00
 BORDEAUX : 05.57.26.19.00

RESPONSABLE DAO : J-Jacques PERRIN
 SERVICE : ESA

VERIFIE PAR :
 DATE :

PAGE :
 I

SOMMAIRE

NO FOLIO	DESIGNATION FOLIO	INDICE	DESSINATEUR	DATE
1	IMPLANTATION COFFRET	A	PERRIN	14/11/01
2	IMPLANTATION COFFRET	A	PERRIN	14/11/01
3	SCHEMA PNEUMATIQUE	A	PERRIN	14/11/01
4	SCHEMA PNEUMATIQUE	A	PERRIN	14/11/01

DESCRIPTION PROJECT :
DESCRIPTION PAGE :

GESTION_MONTEE-BAISSE_VERIN

SOCIETE : REXSON

NR PROJECT : R-106004

PESTO
Automatisme Industriel

PAGE
II

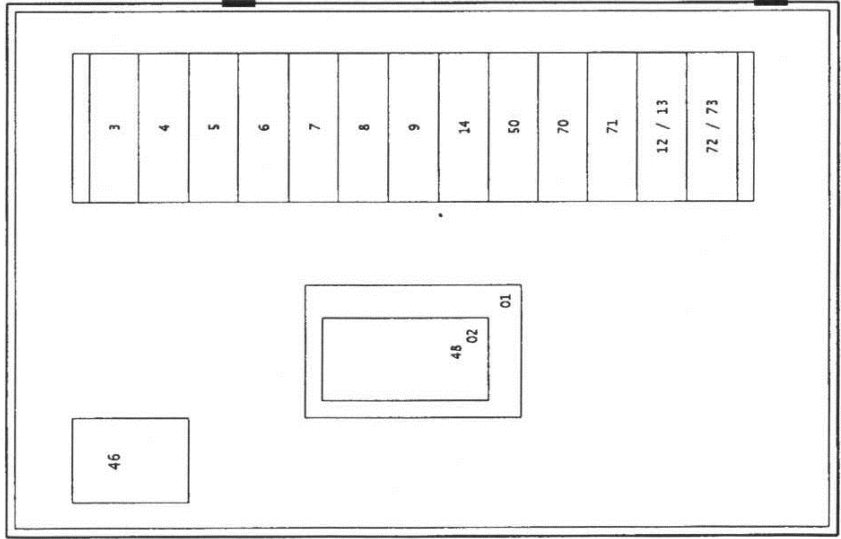
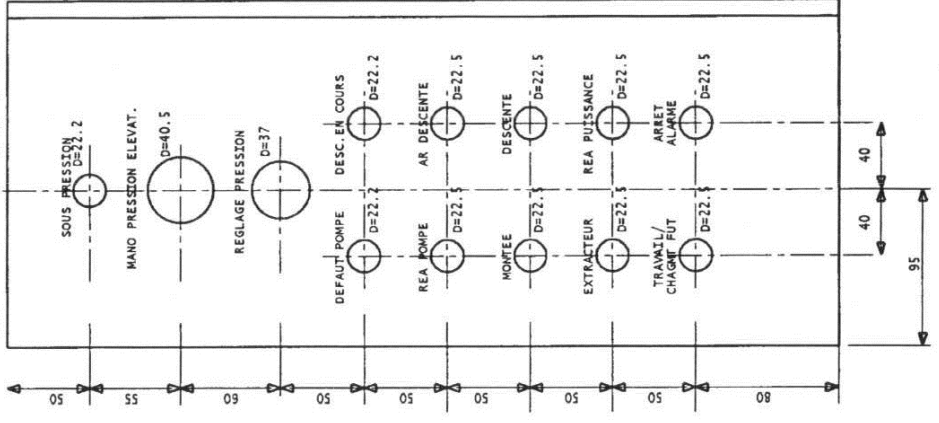
Nomenclature

No FOLIO	DESIGNATION FOLIO	INDICE	DESSINATEUR	DATE
1	NOMENCLATURE	A	PERRIN	14/11/01
2	NOMENCLATURE	A	PERRIN	14/11/01
3	NOMENCLATURE	A	PERRIN	14/11/01

DESCRIPTION PROJECT : DESCRIPTION PAGE :	SOCIETE : REXSON NR PROJECT : R-106004	PESTO Automatismes Industrie]	PAGE III
---	---	---	-------------

02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----

COTE GAUCHE La plaque passe cable se trouve au dessus



[COFFRET]
-E01

400x500x210

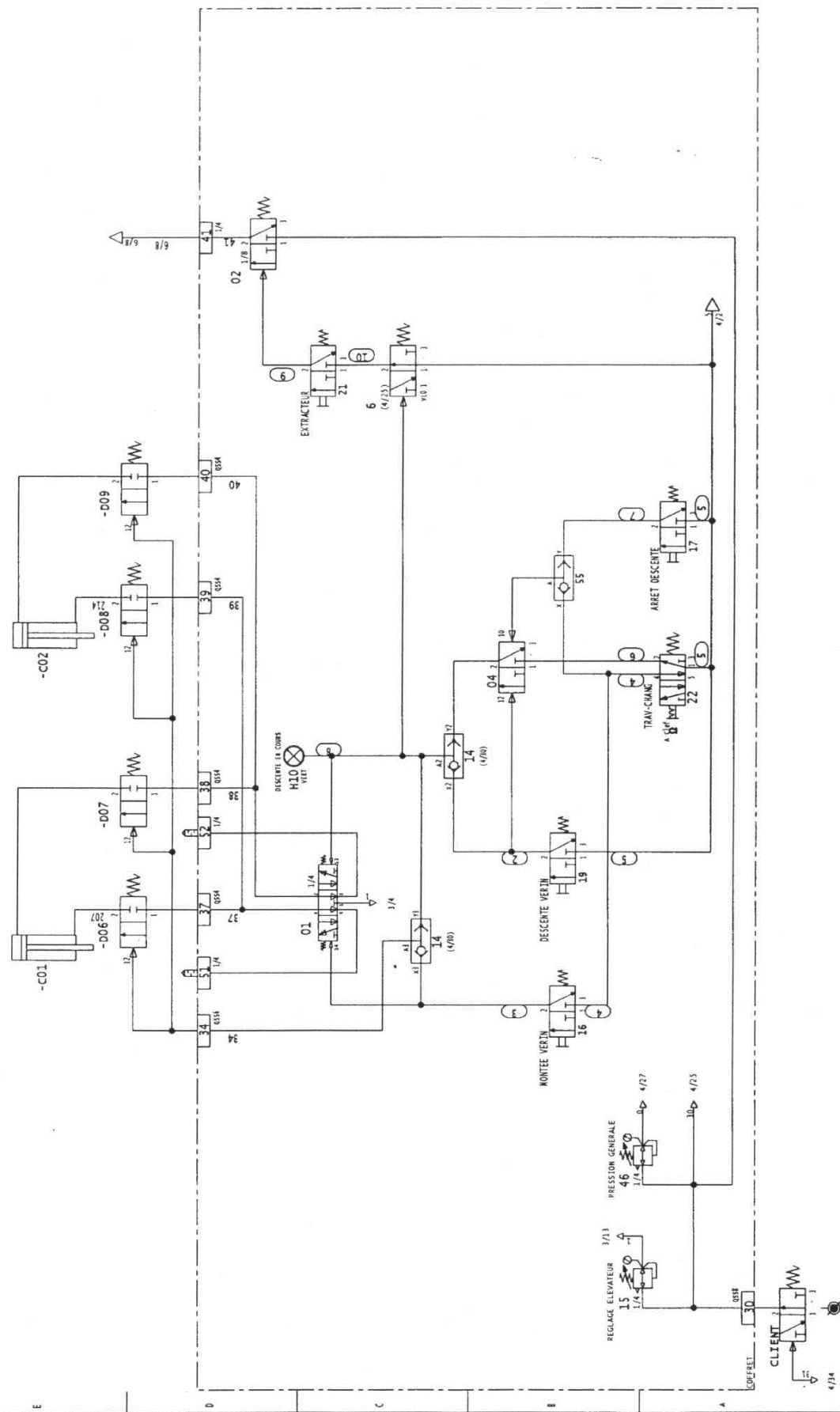
ECH 1:2

INDEXE		A	FERRIN	14/11/01	DESCRIPTION	GESTION MONTEE/BAISSE VERIN	SOCIETE :	REXSON	LOCALISATION	Folio
VISA				DATE	PAGE	IMPLANTATION COFFRET	NR PROJET :	R-106004	Coffret	1
Automatisme Industrie										

01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----

EXTRACTEUR

VERINS ELEVATEUR



A	PERLIN	14/11/01	DATE	DESCRIPTION	SCHEMA PNEUMATIQUE	MR PROJET :	R-106004	SOCIETE :	REXSON	LOCALISATION	Coiffet	FOLIO	3
---	--------	----------	------	-------------	--------------------	-------------	----------	-----------	--------	--------------	---------	-------	---

FESTO
Automatisme Industrie 1

NOMENCLATURE

REPERE	QTE	DESIGNATION	TYPE	REFERENCE	FABRICANT	COMMENTAIRE
50	1	REPARTITEUR	FR-12-PK3-B	8761	FESTO	
-E01	1	COFFRET AVEC PLATINE 500 400 210 RAL7032 ACIER	AE1045.600	AE1045.600	RITTAL	COFFRET
	1	CHASSIS	NRRQ-2N	9365	FESTO	COFFRET
PE1 a PE2	2	PRESSE ETOUPE + ECROU	PG07	260770+240702	CAPRI	
PE3 a PE4	2	PRESSE ETOUPE + ECROU	PG11	261170+241102	CAPRI	
30	1	TRAVERSEE DE CLOISON	QSS-8	153159	FESTO	
31 a 33	9	TRAVERSEE DE CLOISON	QSS-4	153157	FESTO	
35						
37 a 40						
45						
34	2	TRAVERSEE DE CLOISON	QSS-6	153158	FESTO	
42						
41	1	TRAVERSEE DE CLOISON	SCM-1/4	9971	FESTO	
	1	RACCORD	QS-1/4-8	153005	FESTO	
H07	1	ELEMENT SONORE	XVB-C9B	XVB-C9B	TELEMECANIQUE	
16	5	BOUTON POUSSOIR NOIR	T-22-SW	9289	FESTO	MONTEE VERIN
18 a 19						
21						
570						
	5	DISTRIBUTEUR TABLEAU	SV-3-M5	6817	FESTO	MONTEE VERIN
17	1	BOUTON POUSSOIR ROUGE	T-22-R	9997	FESTO	ARRET DESCENTE

INDICE		DESCRIPTION		SOCIETE : REXSON		LOCALISATION		Folio	
A	PERRIN	14/11/01	DESCRIPTION PROJET : GESTION_MONTEE-BAISSE_VERIN		REXSON				1
	VISA	DATE	DESCRIPTION PAGE : NOMENCLATURE		NR PROJET : R-106004	FESTO Automatisme Industrie]			

Ce plan est la propriété exclusive de FESTO, il ne peut être reproduit sans son autorisation écrite.

NOMENCLATURE

REPERE	QTE	DESIGNATION	TYPE	REFERENCE	FABRICANT	COMMENTAIRE
	1	DISTRIBUTEUR TABLEAU	SV-3-M5	6817	FESTO	ARRET DESCENTE
22	1	TETE SELECTEUR 2 POSIT A CLEF 45	ZB2-8G2	ZB2-8G2	PARKER	TRAV-CHANG
	1	DISTRIBUTEUR DE BASE 3/2 NF	PXB-81011	PXB-81011	PARKER	TRAV-CHANG
	1	DISTRIBUTEUR ADDITION DE BASE 3/	PXB-81921	PXB-81921	PARKER	TRAV-CHANG
S20	1	BOUTON POUSSOIR JAUNE	T-22-G	9290	FESTO	REA PUISSANCE
	1	DISTRIBUTEUR TABLEAU	SV-3-M5	6817	FESTO	REA PUISSANCE
15	1	MANO DETENDEUR	LR-1/4-D-MINI	159625	FESTO	
	1	MANOMETRE DE PRECISION TABLEAU	FMA-40-10-1/4-EN	159596	FESTO	
46	1	DETENDEUR	LRMA-1/8-QS4	153489	FESTO	
12	2	CONVERTISSEUR	PE-1/8-2MX2	13691	FESTO	
72						
Q01	1	LIMITEUR DE DEBIT	GR-M5-B	151213	FESTO	
6 a 7	2	DISTRIBUTEUR PNEUMATIQUE	VL/0-3-PK3X2	4245	FESTO	VLO 1
01	1	DISTRIBUTEUR PNEUMATIQUE	VL-5/3E-1/4-B	14297	FESTO	
02	2	DISTRIBUTEUR PNEUMATIQUE	VL/0-3-1/8-B	7803	FESTO	7803
48						
03	1	DISTRIBUTEUR PNEUMATIQUE	J-5-PK3	4503	FESTO	
04	2	DISTRIBUTEUR PNEUMATIQUE	J-3-PK3	10772	FESTO	
71						
05	1	SOUAPE DE REGLAGE	VD-3-PK3	9270	FESTO	
70	1	GENERATEUR D'IMPULSION	VLK-3-PK3	9639	FESTO	


A	PERRIN	14/11/01	DESCRIPTION : GESTION_MONTÉE-BAISSE_VERIN	SOCIETE : REXSON	Automatisme Industriel	LOCALISATION	Folio
INDEXE	VISA	DATE	DESCRIPTION : PAGE : NOMENCLATURE	NR PROJET : R-106004			2

Ce plan est la propriété exclusive de FESTO, il ne peut être reproduit sans son autorisation écrite.

NOMENCLATURE

REPERE	QTE	DESIGNATION	TYPE	REFERENCE	FABRICANT	COMMENTAIRE
14	1	BATTERIE DE FONCTION OU	OS-PK-3-6/3	4232	FESTO	
54 a 55	2	ELEMENT FONCTION OU	OS-PK-3	6684	FESTO	
51 a 52	2	SILENCIEUX	U-1/4-B	6842	FESTO	
	2	TRAVERSEE DE CLOISON	QSSF-1/4-88	153166	FESTO	
53	1	SILENCIEUX	U-1/4-B	6842	FESTO	
08	1	TEMPORISATEUR	VZ-3-PK3	5755	FESTO	0.25-5sec
09	1	TEMPORISATEUR	VZ0-3-PK3	5754	FESTO	0.25-5sec
H10 a H11	2	VOYANT PNEUMATIQUE	OH-22-VERT	4237	FESTO	DESCENTE EN COURS
H23	1	VOYANT PNEUMATIQUE	OH-22-ROUGE	4131	FESTO	DEFAULT
DIV	1	ACCESSOIRES SUIVANTS :	--	--	FESTO	
	4	GOUJON	GOUJON M8x30 (50)	GOUJON	FESTO	

Ce plan est la propriété exclusive de FESTO, il ne peut être reproduit sans son autorisation écrite.

A	PERRIN	14/11/01	DESCRIPTION : GESTION_MONTEE-BAISSE_VERIN	SOCIETE : REXSON			LOCALISATION	Folio 3
INDICE	VISA	DATE	DESCRIPTION PAGE : NOMENCLATURE	MR PROJET : R-106004				