



**INSTRUCTION MANUAL**

**HEATED EXTRUSION MANUAL ASSEMBLY  
WITH CARTRIDGE GUN**

**# 102 964**

**Manual : 574.350.112 - 1106**

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*Modif. Update*

**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.*

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**ADDITIONAL DOCUMENTATIONS**

Cold extrusion gun	Doc. 574.057.112
Temperature regulator	Doc. 3216

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 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 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

A	B	F	E	C	G
<b>NIP HAZARD</b>	<b>WARNING MOVING ELEVATOR</b>	<b>WARNING MOVING PARTS</b>	<b>WARNING MOVING SHOVEL</b>	<b>DO NOT EXCEED THIS PRESSURE</b>	<b>HIGH PRESSURE HAZARD</b>
H	J	L	K	M	O
<b>RELIEF OR DRAIN VALVE</b>	<b>WARNING HOSE UNDER PRESSURE</b>	<b>WEAR GLASSES OBLIGATORY</b>	<b>WEAR OF GLOVES IS OBLIGATORY</b>	<b>PRODUCT VAPOR HAZARDS</b>	<b>WARNING HOT PARTS OR AREAS</b>
N	P	R	I	Q	S
<b>ELECTRICAL HAZARD</b>	<b>WARNING FIRE HAZARDS</b>	<b>EXPLOSION HAZARDS</b>	<b>GROUNDING</b>	<b>WARNING (USER)</b>	<b>WARNING SERIOUS INJURIES</b>

## 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 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 working pressure (WP) 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,

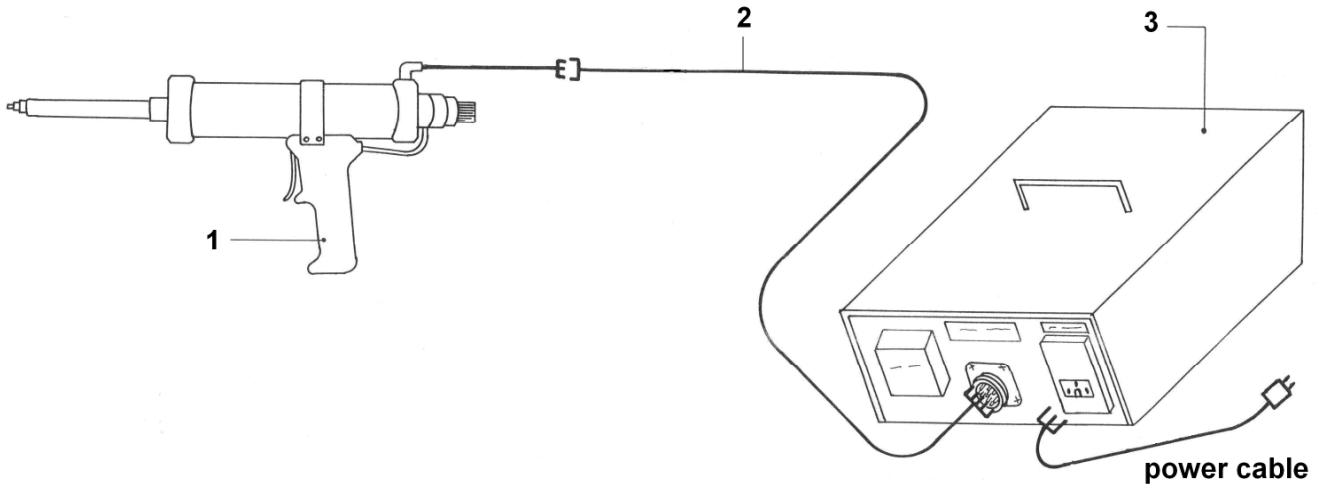
KREMLIN REXSON shall not be liable for physical injuries, direct or indirect material damages caused by the use of chemicals.

### 03. TECHNICAL FEATURES

The equipment consists of :

- An heated gun (1) for extrusion of materials with 310 cm<sup>3</sup> standard cartridge,
- A connection extension (2) (length : 5 m / 16.4 ft)
- A power supply (3) to carry out the stoking and the temperature regulation.

The gun handle has a thermal insulation. That provides a good handling and enables to make easier the fine sprayings.



Power supply electric supply :	220V monophasé
Gun electric supply :	24V
Extrusion temperature :	< 80°C
Temperature regulation :	Pt 100 drill and regulator with variable instruction
Stoking power :	24 V / 140 Watts.
Supply air pressure :	Maximum 7 bar / 101.5 psi
Connection extension :	Length : 5m / 16.4 ft / 8 pin-Jaeger connector

### 04. START UP

Unscrew the gun front hat, insert the cartridge onto the gun body and screw again the hat.

Put the gun on to heat by means of the power supply.

Adjust the material application temperature.

Wait until the temperature is stabilized.

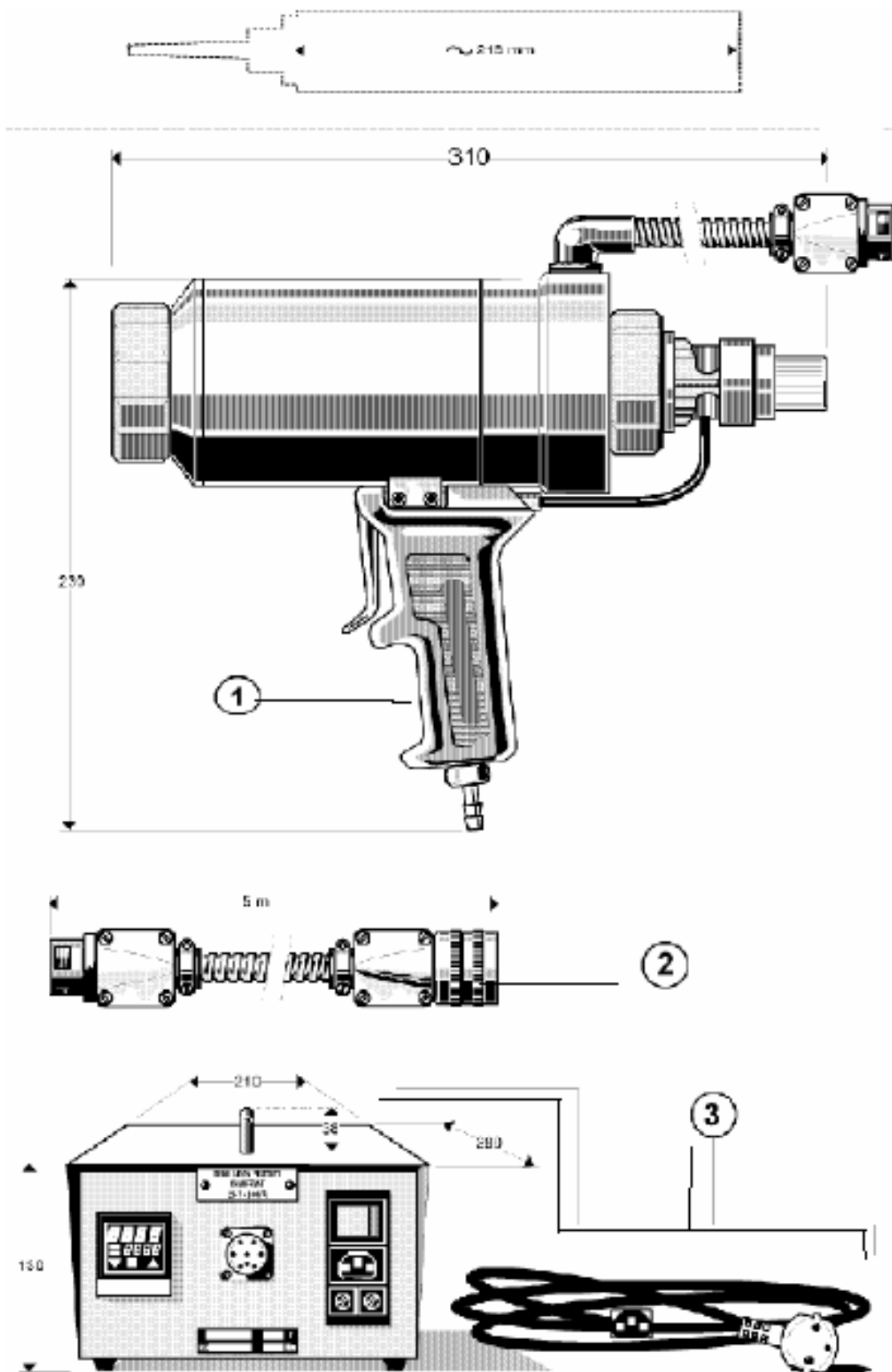
Supply the gun with compressed air (maximum 7 bar / 101.5 psi).

Trigger the gun and applicate the bead.



**Caution : the application is an hot spraying application.**

## 05. EXPLODED VIEW





## 06. SPARE PARTS' LIST

Ind.	#	Description	Qty
1	102 962	Heated cartridge gun	1
-	670 240	▪ Cold cartridge gun (for details > refer to instruction manual # 574.057.112)	1
-	204 292	▪ Pt 100 drill	1
-	90 445	▪ Heated collar (24V - 70W)	2
2	102 966	Connection extension	1
3	102 967	Storing and regulation power supply	1

## 07. MAINTENANCE

Do not leave material dry on the gun.

Never use solvent when the gun is hot and connected to the power supply.

Change or repair the defective electric cable.

After a use time, tighten the electric connectors.

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**

**The seals will be damaged.**



**Never clean the material at the end of the nozzle without depressurizing and shutting down completely the gun trigger.**

**Leave the gun cool before using cleaning solvent.**