



INSTRUCTION MANUAL

AUTOMATIC EXTRUSION GUN
MODEL ATG
(WITH PNEUMATIC OPENING AND CLOSING)

101 975 0101 - 101 975 0102 - 101 975 0103
- 101 975 0201

Manual : 574.107.112 - 1202

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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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**INSTRUCTION MANUAL
EXTRUSION AUTOMATIC GUN**

TABLE OF CONTENTS

1. WARRANTY 2

2. SAFETY INSTRUCTIONS 2

3. DIMENSIONS 5

4. FEATURES 5

5. EXPLODED VIEWS 6

6. SPARE PARTS' LIST 7

7. MAINTENANCE 9

8. REPLACEMENT OF THE NOZZLE 9

9. DISASSEMBLY OF THE GUN FLUID PART 9

10. DISASSEMBLY OF THE PNEUMATIC PART 10

11. CUP ASSEMBLY 10

12. GUN ASSEMBLY 11

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.

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 :

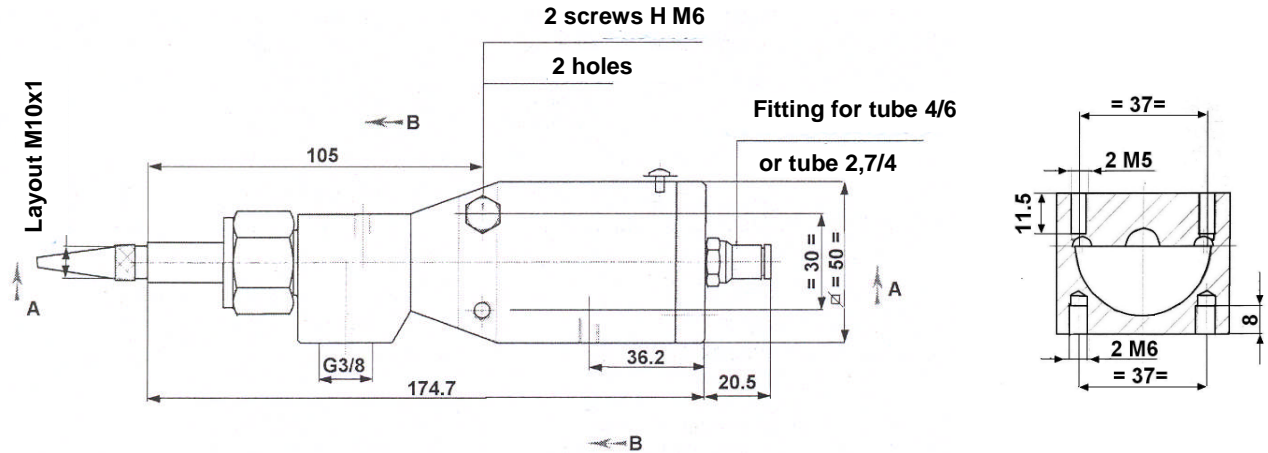
- Compatibility of wetted parts,
- Risks to staff and the surroundings,
- for worn or defective parts, for faulty equipment or units, or the quality of final product.

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,

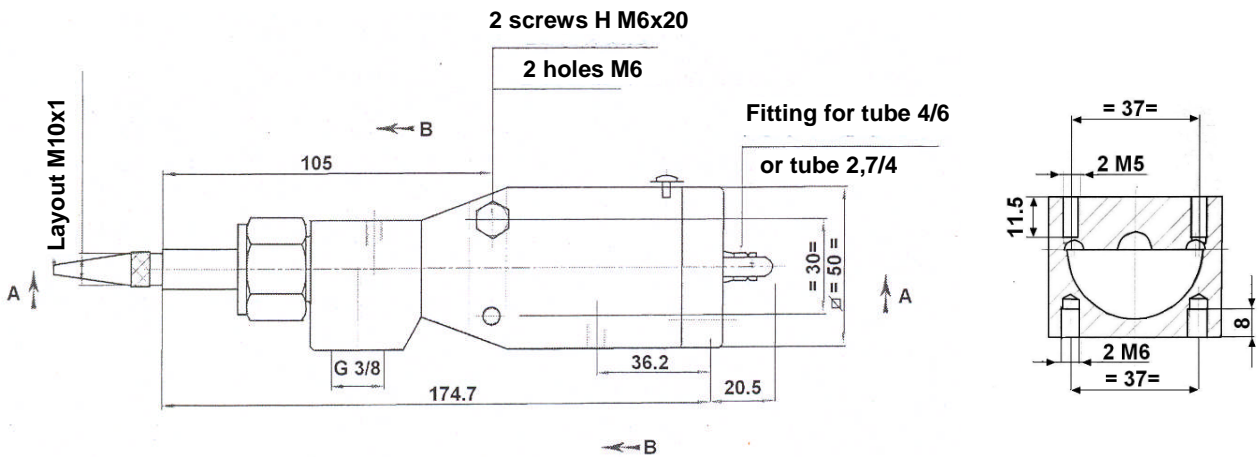
KREMLIN REXSON shall not be liable for physical injuries, direct or indirect material damages caused by the use of chemicals.

3. DIMENSIONS

AUTOMATIC GUNS : # 101 975 0101, 101 975 0102, 101 975 0103



AUTOMATIC GUN (with opening/closing indicator) : # 101 975 0201

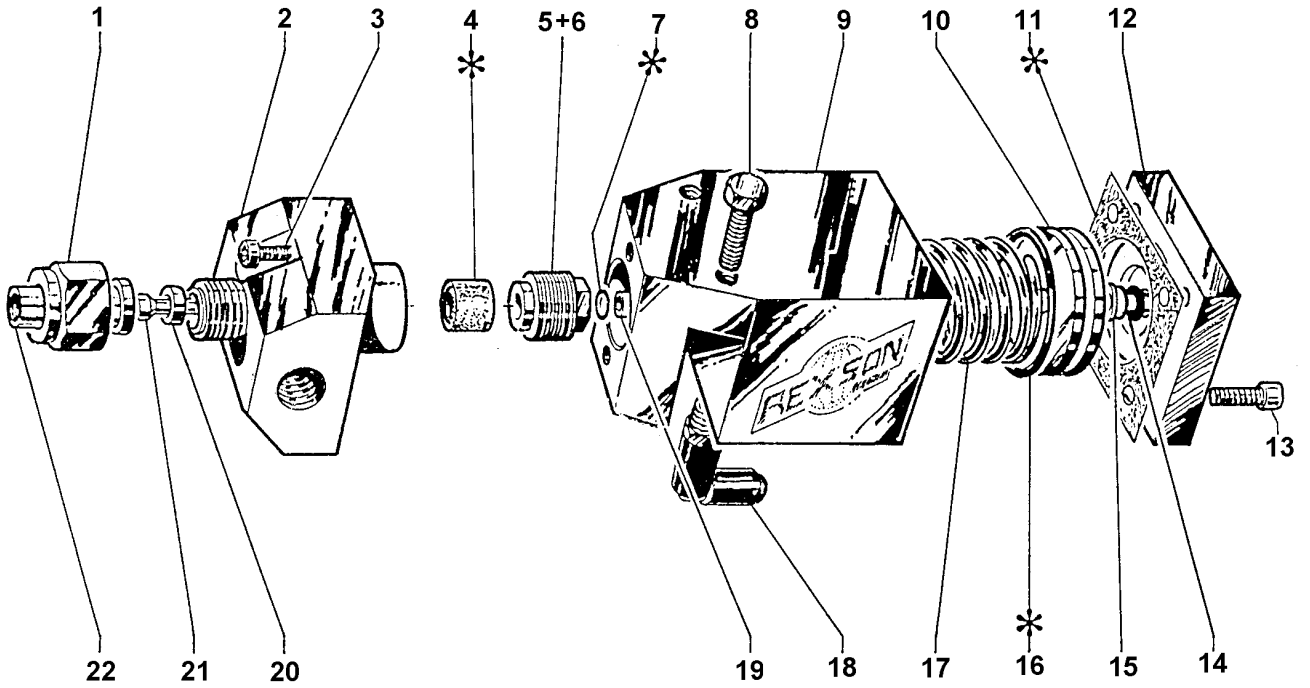


4. FEATURES

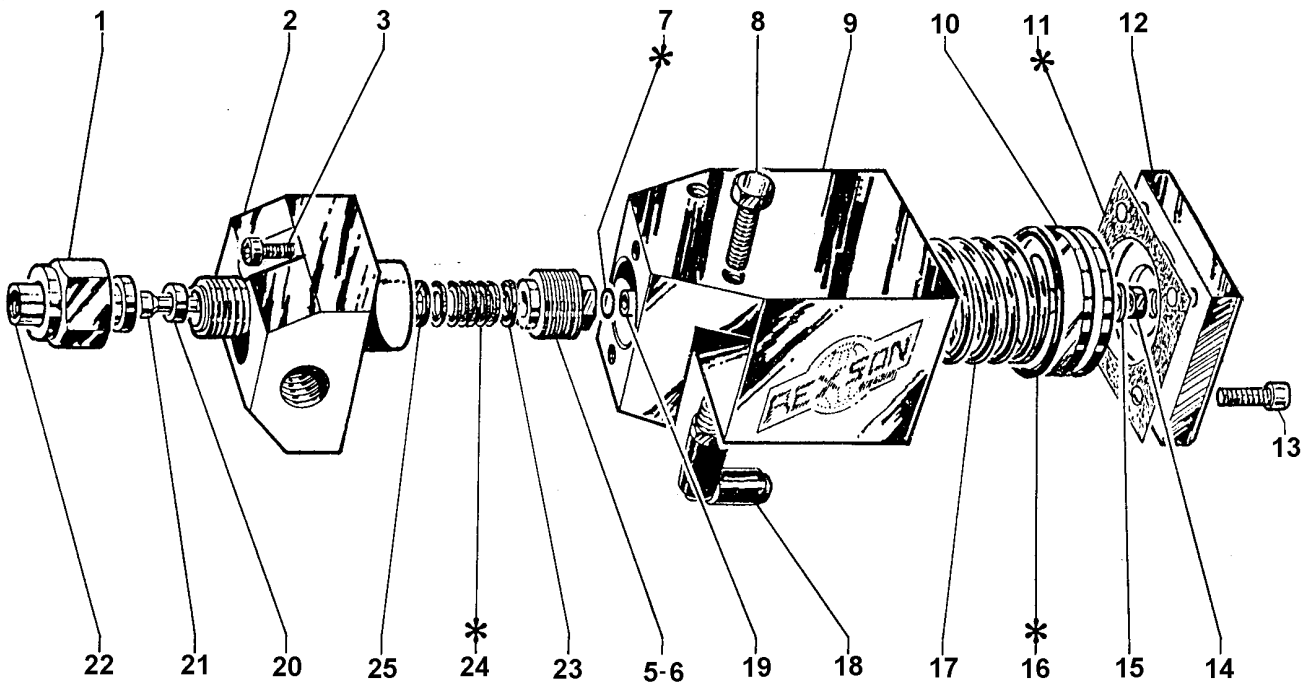
Features	GUNS			
	# 101 975 0101	# 101 975 0102	# 101 975 0103	# 101 975 0201
Kind of seals	PUR	PTFE	PEEK	PUR
Max fluid pressure	400 bar / 5801 psi			
Control air pressure	From 4 to 6 bar / from 58 to 87 psi			
Fluid inlet	Female 3/8" G			
Fluid outlet	Female M 10x100			
Air fitting	2 elbows → fitting, model Ø 2,7x4			
Maximum fluid temperature	60°C / 140° F			
Seat	Steel + carbide			
Weight	750 g / 1.6 lb			
Nozzle	Option (Ø 1.5 to 4 mm)			

5. EXPLODED VIEWS

GUNS : # 101 975 0101, 101 975 0201



GUNS : # 101 975 0102, 101 975 0103



6. SPARE PARTS' LIST

COMMON PARTS						
Ind	#	Désignation	Description	Bezeichnung	Denominación	Qté
1	204 133	Chapeau	Cover	Haube	Tapa	1
2	204 192	Tête	Head	Kopf	Cabezal	1
3	933 151 385	Vis, CHc 5x30	Screw, CHc 5x30	Schraube, CHc 5x30	Tornillo, CHc 5x30	2
5	210 805	Presse-étoupe	Cup	Zugentlastung	Prensa-estopa	1
* 7	NCS / NSS	Joint FKM	FKM seal	FKM Dichtung	Junta FKM	1
8	933 011 277	Vis, H 6x20	Screw, H 6x20	Schraube, H 6x20	Tornillo, H 6x20	2
9	203 576	Corps	Body	Körper	Cuerpo	1
10	203 016	Piston	Piston	Kolben	Pistón	1
* 11	NCS / NSS	Joint	Seal	Dichtung	Junta	1
* 16	NCS / NSS	Joint FKM	FKM seal	FKM Dichtung	Junta FKM	1
* 17	203 575	Ressort	Spring	Feder	Muelle	1
18	552 261	Coude, Ø4 1/8"	Elbow, Ø4 1/8"	Winkelnippel, Ø4 1/8"	Codo, Ø4 1/8"	2
19	203 570	Tige	Rod	Stange	Eje	1
* 20	204 132	Siège	Seat	Sitz	Asiento	1
* 21	203 571	Aiguille	Needle	Nadel	Aguja	1
22	203 569	Porte-buse	Nozzle holder	Düsehalter	Porta-boquilla	1

SPECIFIC PARTS (# 101 975 0101)						
Ind	#	Désignation	Description	Bezeichnung	Denominación	Qté
* 4	NCS / NSS	Joint	Seal	Dichtung	Junta	1
6	210 803	Guide tige de piston	Piston rod guide	Kolbenstangenführung	Guía eje de pistón	1
12	203 574	Couvercle	Cover	Deckel	Tapa	1
13	933 151 221	Vis, CHc 5x16	Screw, CHc 5x16	Schraube, CHc 5x16	Tornillo, CHc 5x16	4
14	953 010 014	Ecrou, HM5	Nut, HM5	Mutter, HM5	Tuerca, HM5	1
15	88 372	Rondelle, M5	Washer, M5	Scheibe, M5	Arandela, M5	1
*	103 894	Pochette de joints (ind. 4, 7, 11, 16)	Seal kit (ind. 4, 7, 11, 16)	Dichtungssatz (Pos. 4, 7, 11, 16)	Bolsa de juntas (Índ. 4, 7, 11, 16)	1

* Pièces de maintenance préconisées tenues en stock

* Preceding the index number denotes a suggested spare part.

* Bezeichnete Teile sind empfohlene Ersatzteile.

* Piezas de mantenimiento preventivas a tener en stock.

N C S : Non commercialisé seul.

N S S : Denotes parts are not serviceable separately.

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

N S S : no suministrado por separado.

SPECIFIC PARTS (# 101 975 0102)

Ind	#	Désignation	Description	Bezeichnung	Denominación	Qté
12	203 574	Couvercle	Cover	Deckel	Tapa	1
13	933 151 221	Vis, CHc 5x16	Screw, CHc 5x16	Schraube, CHc 5x16	Tornillo, CHc 5x16	4
14	953 010 014	Ecrou, HM5	Nut, HM5	Mutter, HM5	Tuerca, HM5	1
15	88 372	Rondelle, M5	Washer, M5	Scheibe, M5	Arandela, M5	1
6	210 804	Guide tige de piston	Piston rod guide	Kolbenstangesführung	Guía de eje de pistón	1
*23	NCS / NSS	Rondelle "F"	'F' washer	Stützring konkav	Arandela "H"	1
*24	NCS / NSS	Joint chevron PTFE	PTFE chevron seal	PTFE Packungsring	Junta chevrón PTFE	6
*25	NCS / NSS	Rondelle "M"	'M' washer	Stützring konvex	Arandela "M"	1
*	101 635	Pochette de joints (ind. 7, 11, 16, 23, 24x6, 25)	Seal kit (ind. 7, 11, 16, 23, 24x6, 25)	Dichtungssatz (Pos. 7, 11, 16, 23, 24x6, 25)	Bolsa de juntas (ind. 7, 11, 16, 23, 24x6, 25)	1

SPECIFIC PARTS (# 101 975 0103)

Ind	#	Désignation	Description	Bezeichnung	Denominación	Qté
12	203 574	Couvercle	Cover	Deckel	Tapa	1
13	933 151 221	Vis, CHc 5x16	Screw, CHc 5x16	Schraube, CHc 5x16	Tornillo, CHc 5x16	4
14	953 010 014	Ecrou, HM5	Nut, HM5	Mutter, HM5	Tuerca, HM5	1
15	88 372	Rondelle, M5	Washer, M5	Scheibe, M5	Arandela, M5	1
6	210 804	Guide tige de piston	Piston rod guide	Kolbenstangesführung	Guía de eje de pistón	1
*23	NCS / NSS	Rondelle "F"	'F' washer	Stützring konkav	Arandela 'H'	1
*24	NCS / NSS	Joint chevron PEEK	PEEK chevron seal	PEEK-Packungsring	Junta chevrón PEEK	6
*25	NCS / NSS	Rondelle "M"	'M' washer	Stützring konvex	Arandela "M"	1
*	107 346	Pochette de joints (ind. 7, 11, 16, 23, 24x6, 25)	Seal kit (ind. 7, 11, 16, 23, 24x6, 25)	Dichtungssatz (Pos. 7, 11, 16, 23, 24x6, 25)	Bolsa de juntas (ind. 7, 11, 16, 23, 24x6, 25)	1

SPECIFIC PARTS (# 101 975 0201)

Ind	#	Désignation	Description	Bezeichnung	Denominación	Qté
*4	NCS / NSS	Joint	Seal	Dichtung	Junta	1
6	210 803	Guide tige de piston	Piston rod guide	Kolbenstangesführung	Guía de eje de pistón	1
12	207 215	Couvercle	Cover	Deckel	Tapa	1
13	88 129	Vis, CHc M5x18	Screw, CHc M5x18	Schraube, CHc M5x18	Tornillo, CHc M5x18	4
-	207 214	Témoin d'ouverture	Opening / closing indicator	Öffnungsanzeiger	Peón testigo	1
*	103 894	Pochette de joints (ind. 4, 7, 11, 16)	Seal kit (ind. 4, 7, 11, 16)	Dichtungssatz (Pos. 4, 7, 11, 16)	Bolsa de juntas (ind. 4, 7, 11, 16)	1

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

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

8. REPLACEMENT OF THE NOZZLE

- Unscrew the nozzle from the nozzle holder (22) and remove the nozzle,
- Clean the cover, the threading of the gun head (2) and the threading of the nozzle holder with a dry rag,
- Change the nozzle,
- Screw the nozzle on the nozzle holder.

9. DISASSEMBLY OF THE GUN FLUID PART

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 holder (22) and remove the nozzle,
- Unscrew the needle (21),
- Loosen the cup nut (2 turns),
- Unscrew the screws (3) and take off the gun head (2) from the body (9),
- **For the guns, # 101 975 0101 and 101 975 0201**, unscrew completely the cup nut, take off the piston rod guide (6) and the seal (4). **For the gun, # 101 975 0102**, unscrew completely the cup nut (5), take off the guide (6), the 'F' washer (23), the 6 seals (24) and the 'M' washer (25).
- Clean the parts with a solvent compatible with the material to be sprayed,
- Check the parts and change them if necessary.

10. DISASSEMBLY OF THE PNEUMATIC PART

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

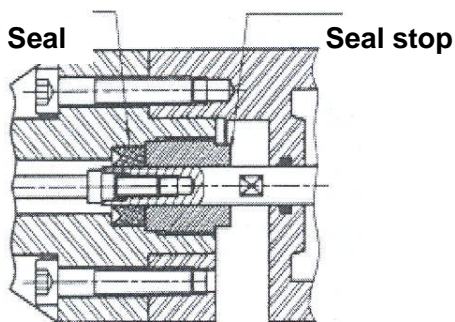
The manufacturer will not be held responsible for bodily injury or failure and / or damage to property due to removal or partial removal of the guards

- Unscrew the screws (13),
- Take off the cover (12) and remove the seal (11),
- Unscrew the nut (14) and remove the washer (15). **For the gun, # 101 975 0201**, unscrew the opening / closing indicator.
- Take off the piston (10), use compressed air with a blower to inject air on the fitting (18). Orientate the outlet of the piston downwards and prevent the rod (19) from moving back to avoid damaging the seals. Remove the spring (17) and take off the seal (16),
- Take off the rod (19) frontward and the seal (7) from the body (9),
- Clean the parts with a dry rag,
- Check the parts and change them if necessary.

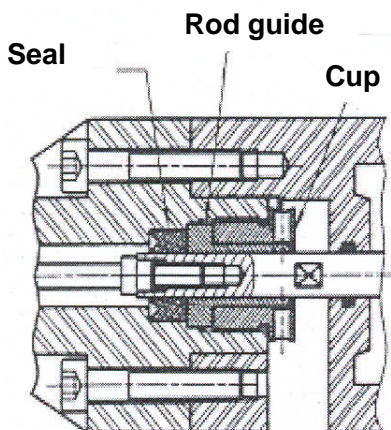
11. CUP ASSEMBLY

Versions 101 975 0101 & 101 975 0201

Old assembly

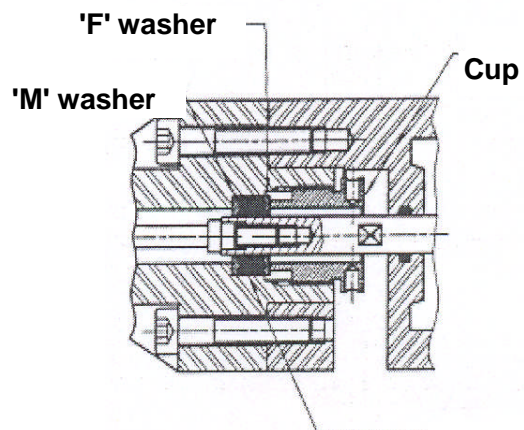


New assembly

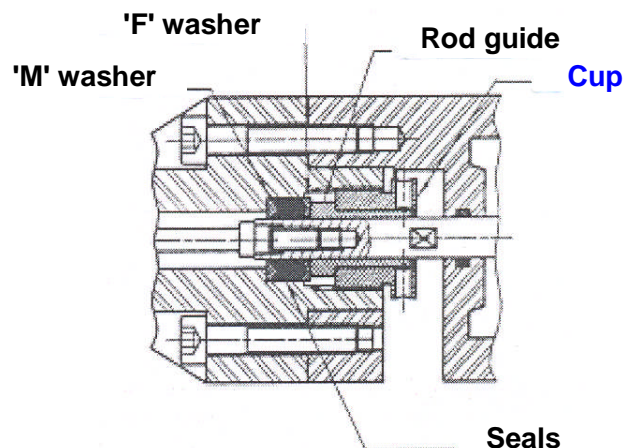


Version 101 975 0102

Old assembly



New assembly Seals



Seals

12. 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 assembly on the reverse order of the disassembly. Lubricate the movable parts of the fluid part with grease and the parts of the pneumatic part with light oil.

IMPORTANT :

- **For the guns, # 101 975 0101 and 101 975 0201**, the seal (4) assembly is carried out by means of the tool,
- The rod (19) assembly is carried out frontward of the body to prevent from damaging the seal (7),
- **For the gun, # 101 975 0201**, assemble the needle (21) and the opening/closing indicator with "Low strength - Aneorobic adhesive - Loctite".