

622-1A Meter-Mix Unit and Control Panel

332338A

EN

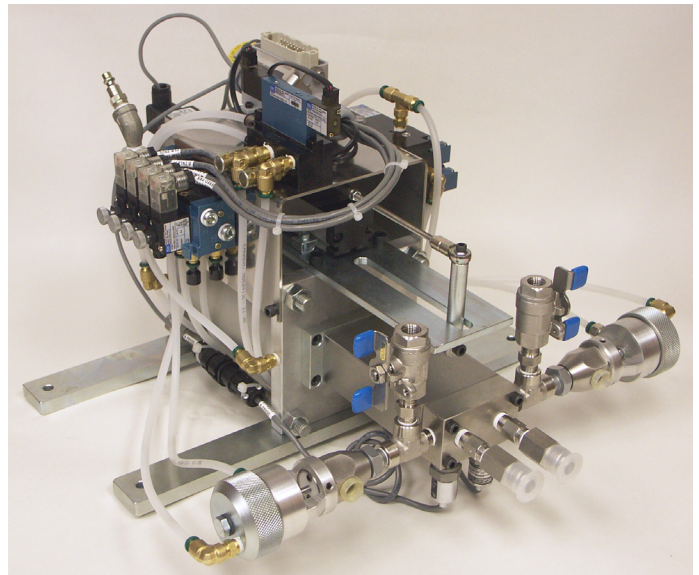
For metering, mixing, and dispensing of silicone material.
For professional use only.

Not approved for use in explosive atmospheres or hazardous locations.



Important Safety Instructions

Read all warnings and instructions in this manual and in the 622-1A Meter-Mix Unit and Control Panel-Operations manual. Save all instructions.



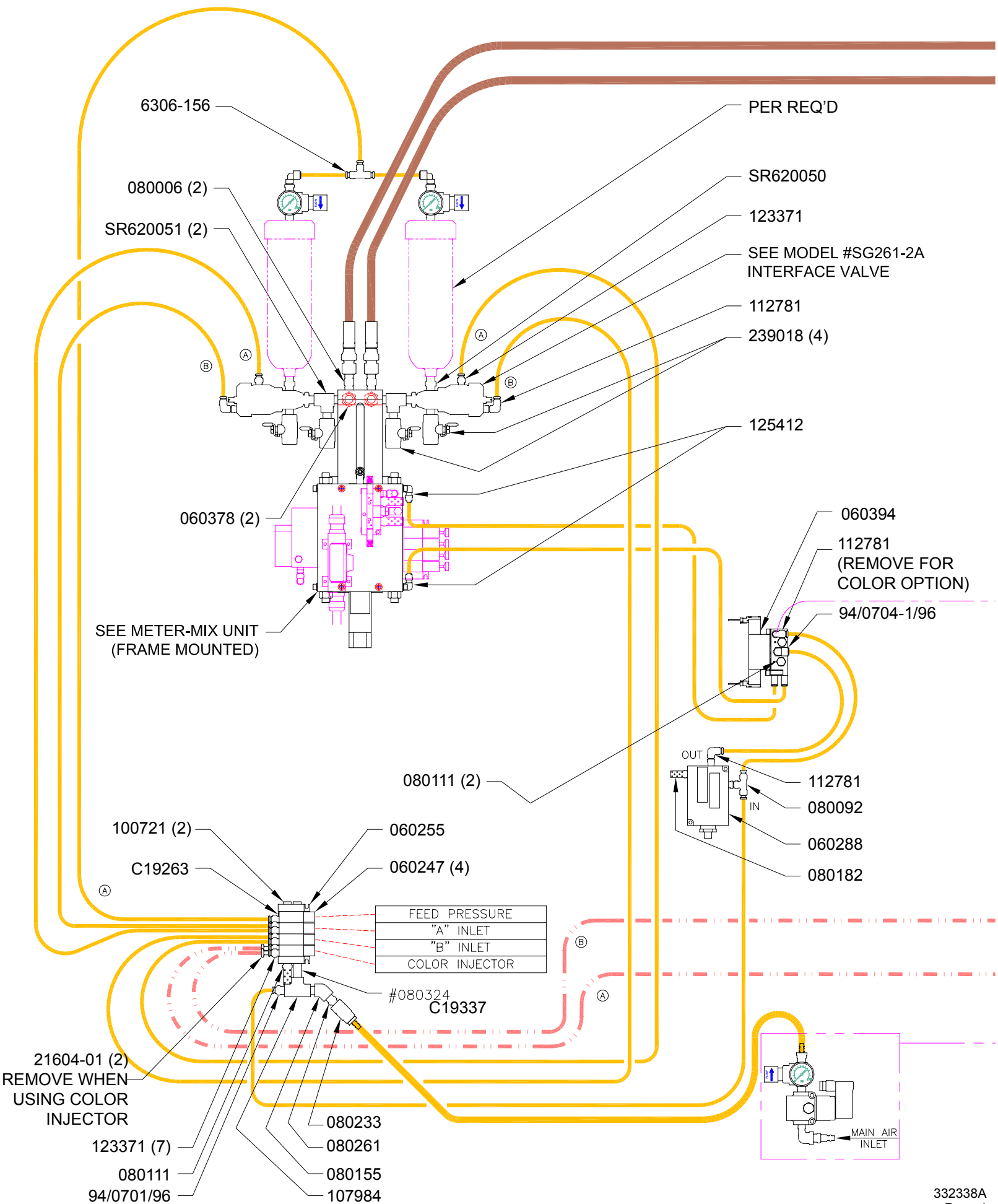
Models

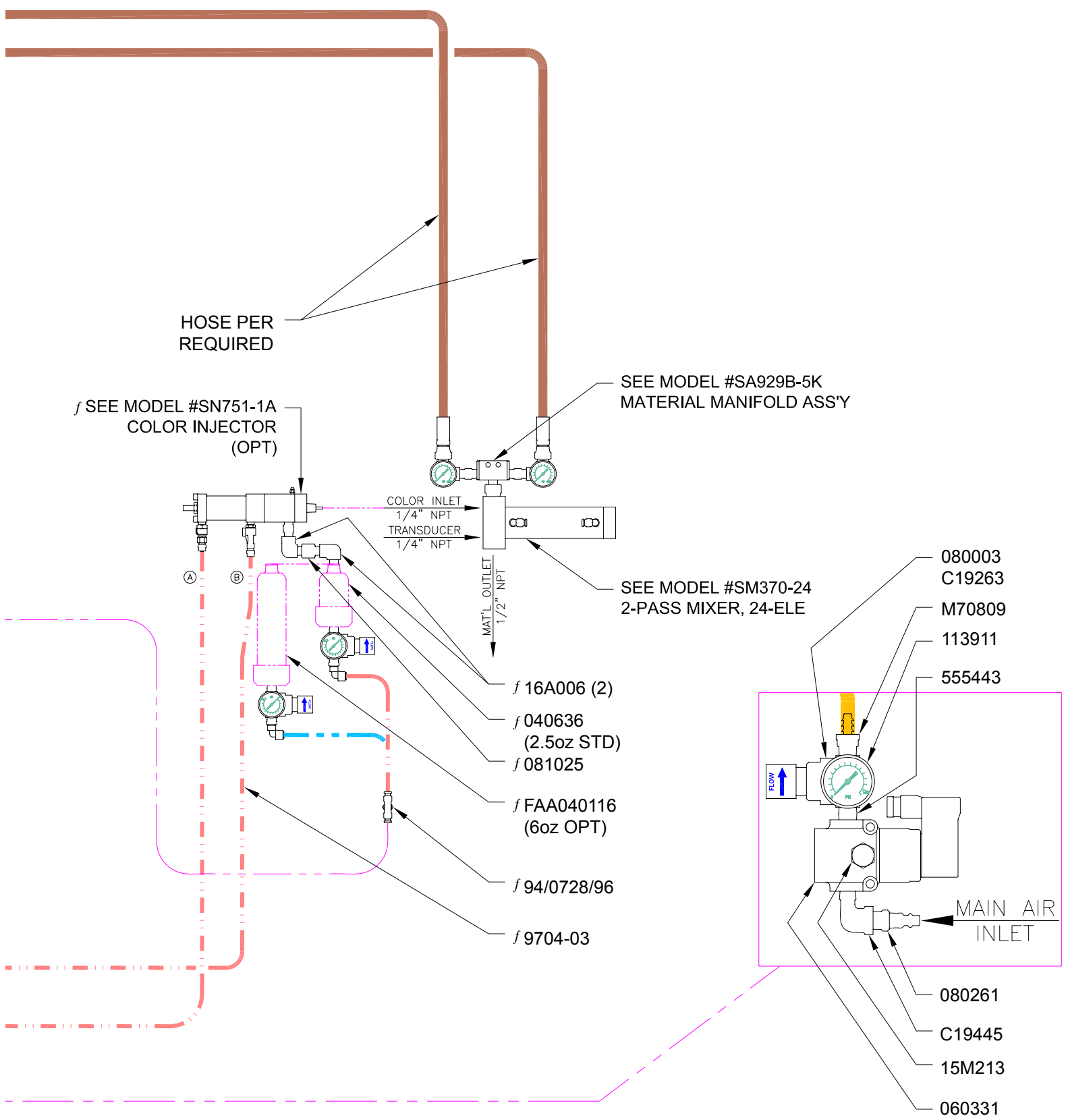
Part No.	Maximum Working Pressures psi (MPa, bar)	Description
622-1A	3000 (21, 207)	PLC, Linear Potentiometer Controlled, Fixed Ratio, Meter Mix Dispense Machine. Machine has proportional pneumatic control to provide automatic adjustment during material dispense. Material supply to the machine can be from 2.5-32 oz (74-946 ml) cartridges or a feed pump.

Related Manuals

Manual	Description
332077	622-1A Meter-Mix Unit and Control Panel, Operation

PNEUMATIC AND MATERIAL PARTS LIST 622-1A





NOTE:
f COLOR ONLY

KEY		
	MATL HOSE	
	AIR HOSE	
	AIR HOSE COLOR	
	AIR HOSE COLOR OPT	

PARTS LIST (MODEL 622 COMMON PARTS)

PART NO.	DESCRIPTION
060288	VALVE,PROPORTIONAL,1/8",NPTF,
060331	VALVE,MAC,1/4"NPT,FEMALE
060378	TRANSDUCER,DPHRAGM,0-5000PSI,1/4NPT
060394	SOLENOID,1/4" OD TUBE PORTS
080003	REGULATOR,AIR,0-100PSI,1/4" NPT
080006	VALVE,CHECK,1/4NPTX1/4NPT,SST
080092	FITTING,TEE,1/8NPT BRX1/4OD TUBE
080111	MUFFLER,1/4"NPT,BRASS
080155	FITTING,ELBOW,1/4NPTMX1/4NPTF,45
080182	FITTING,MUFFLER,1/8"NPTM,BRASS
080233	FITTING,1/4"ID HOSE BARBX1/4QC
080261	FITTING,1/4" NPTM X 1/4" BODY QC
081025	FITTING,1/4"NPTMX1/4"NPTF,316
100721	PLUG,PIPE
104984	FITTING,TEE,PIPE
112781	ELBOW,SWIVEL,90 DEG
113911	GAUGE,PRESSURE,AIR
113911	ARTWORK,GAUGE,PRESSURE,AIR
123371	FITTING,CONNECTOR,1/4TUBX1/8NPT,B
125412	FITTING,ELBOW,MALE,SWIVEL
15M213	MUFFLER,3/8
16A006	FITTING,ELBOW, STREET, SST
21604-01	PLUG,PLUG,TUBE,PLASTIC,1/4"DIA.
239018	VALVE,BALL,SST
555443	COUPLER,1/4 PIPE .875 LG SST
6306-156	FITTING,1/4 TUBE TEE-PRESTOLOK
94/0701/96	CONNECTOR,1/4TUBEX1/4NPT,M,BRS
94/0704-1/96	FITTING,ELBOW,SWVL,1/4TUBEX1/4NPT
94/0728/96	FITTING,TEE,BRANCH,1/4TBEX1/4NPT,
9704-03	HOSE,TUBNG,P.E., .250OD NATURA
C19263	PLUG,PIPE
C19337	FITTING,NIPPLE
C19445	FITTING,ELBOW,STREET
FAA040116	KIT,6 OUNCE,REGULATOR,GAUGE
M70809	FITTING,BARBED,HOSE
SA929B-5K	MANIFOLD,ASY,MINI,1/2IN,1/2OUT
SG261-2A	GUN,SINGLE-PART,MALE
SM370-24	MIXER,2PASS,24 ELEMENTS
SR620050	FITTING,NIPPLE,INLET
SR620051	FITTING,ALTER,STREET,TEE,1/4"

COLOR PARTS (ONLY)

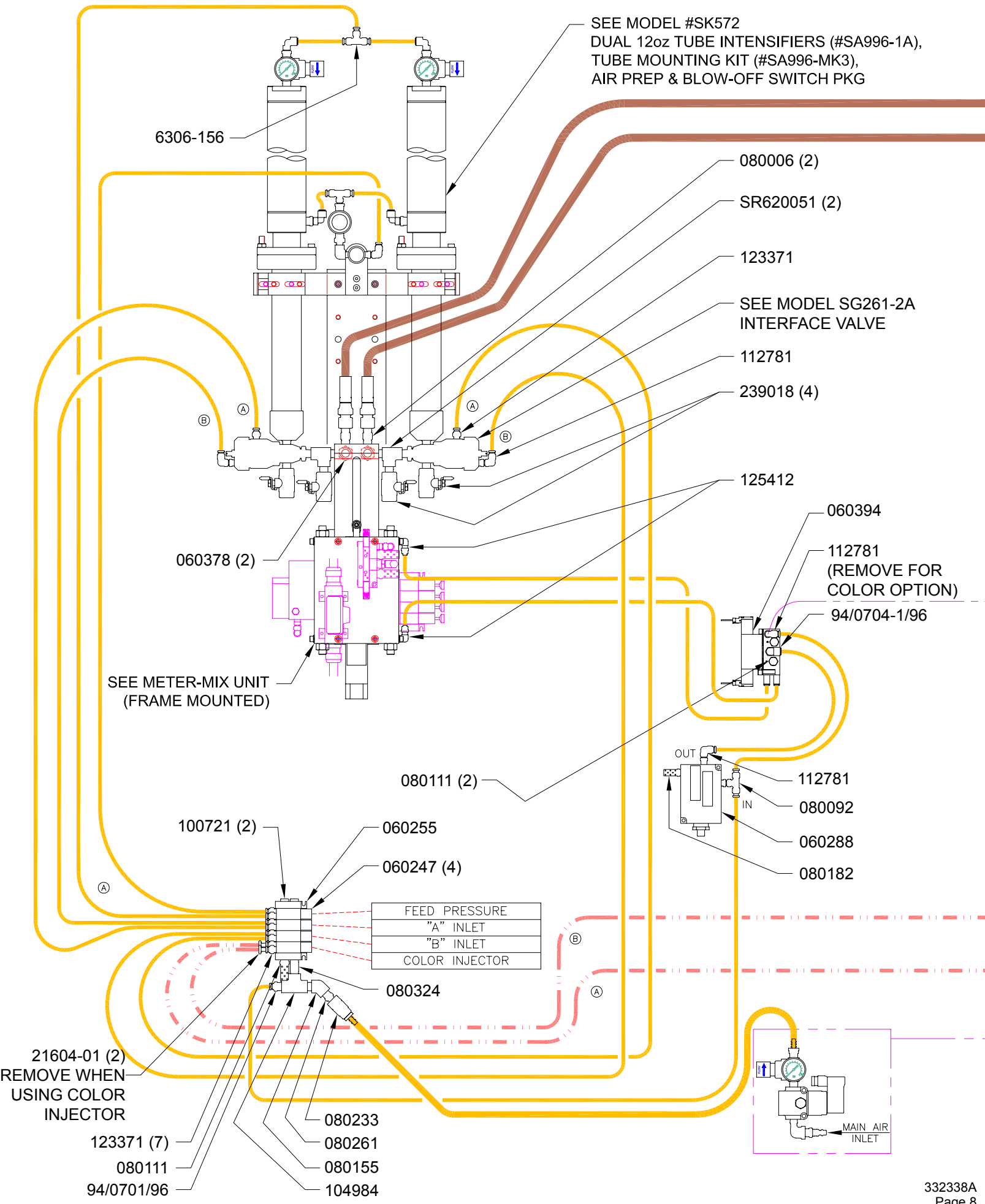
2.5oz STD: MODEL 622CF1

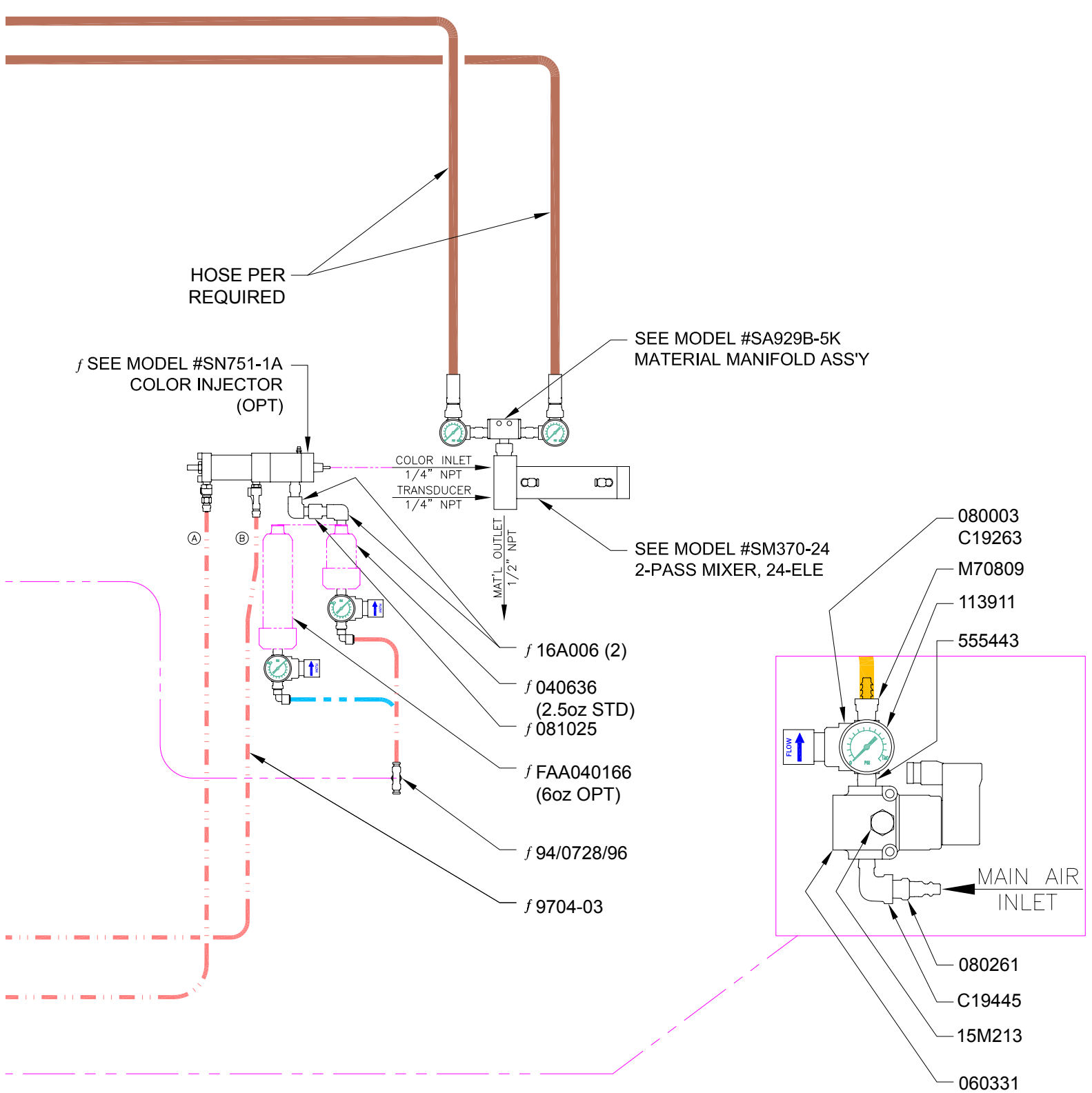
PART NO.	DESCRIPTION
040636	KIT,2.5 OUNCE,REGULATOR,GAUGE
080106	FITTING,TEE,1/4NPTX1/4ODTUBE,SWV
080484	FITTING,ELB,1/4MXF,316SS STL
081025	FITTING,1/4"NPTMX1/4"NPTF,316
SN751-1A	INJECTOR,ASSY,COLOR,INJECTOR

6oz STD: MODEL 622CF2

PART NO.	DESCRIPTION
040116	KIT,6.0 OUNCE,REGULATOR,GAUGE
080106	FITTING,TEE,1/4NPTX1/4ODTUBE,SWV
080484	FITTING,ELB,1/4MXF,316SS STL
081025	FITTING,1/4"NPTMX1/4"NPTF,316
SN751-1A	INJECTOR,ASSY,COLOR,INJECTOR

**PNEUMATIC AND MATERIAL
PARTS LIST
622-1A
with 12 oz tube intensifiers**





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f COLOR ONLY

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	AIR HOSE	
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060394	SOLENOID,1/4" OD TUBE PORTS
080003	REGULATOR,AIR,0-100PSI,1/4" NPT
080006	VALVE,CHECK,1/4NPTX1/4NPT,SST
080092	FITTING,TEE,1/8NPT BRX1/4OD TUBE
080111	MUFFLER,1/4"NPT,BRASS
080155	FITTING,ELBOW,1/4NPTMX1/4NPTF,45
080182	FITTING,MUFFLER,1/8"NPTM,BRASS
080233	FITTING,1/4"ID HOSE BARBX1/4QC
080261	FITTING,1/4" NPTM X 1/4" BODY QC
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100721	PLUG,PIPE
104984	FITTING,TEE,PIPE
112781	ELBOW,SWIVEL,90 DEG
113911	GAUGE,PRESSURE,AIR
113911	ARTWORK,GAUGE,PRESSURE,AIR
123371	FITTING,CONNECTOR,1/4TUBX1/8NPT,B
125412	FITTING,ELBOW,MALE,SWIVEL
15M213	MUFFLER,3/8
16A006	FITTING,ELBOW, STREET, SST
21604-01	PLUG,PLUG,TUBE,PLASTIC,1/4"DIA.
239018	VALVE,BALL,SST
555443	COUPLER,1/4 PIPE .875 LG SST
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9704-03	HOSE,TUBNG,P.E., .250OD NATURA
C19263	PLUG,PIPE
C19337	FITTING,NIPPLE
C19445	FITTING,ELBOW,STREET
FAA040116	KIT,6 OUNCE,REGULATOR,GAUGE
M70809	FITTING,BARBED,HOSE
SA929B-5K	MANIFOLD,ASY,MINI,1/2IN,1/2OUT
SG261-2A	GUN,SINGLE-PART,MALE
SM370-24	MIXER,2PASS,24 ELEMENTS
SR620051	FITTING,ALTER,STREET,TEE,1/4"

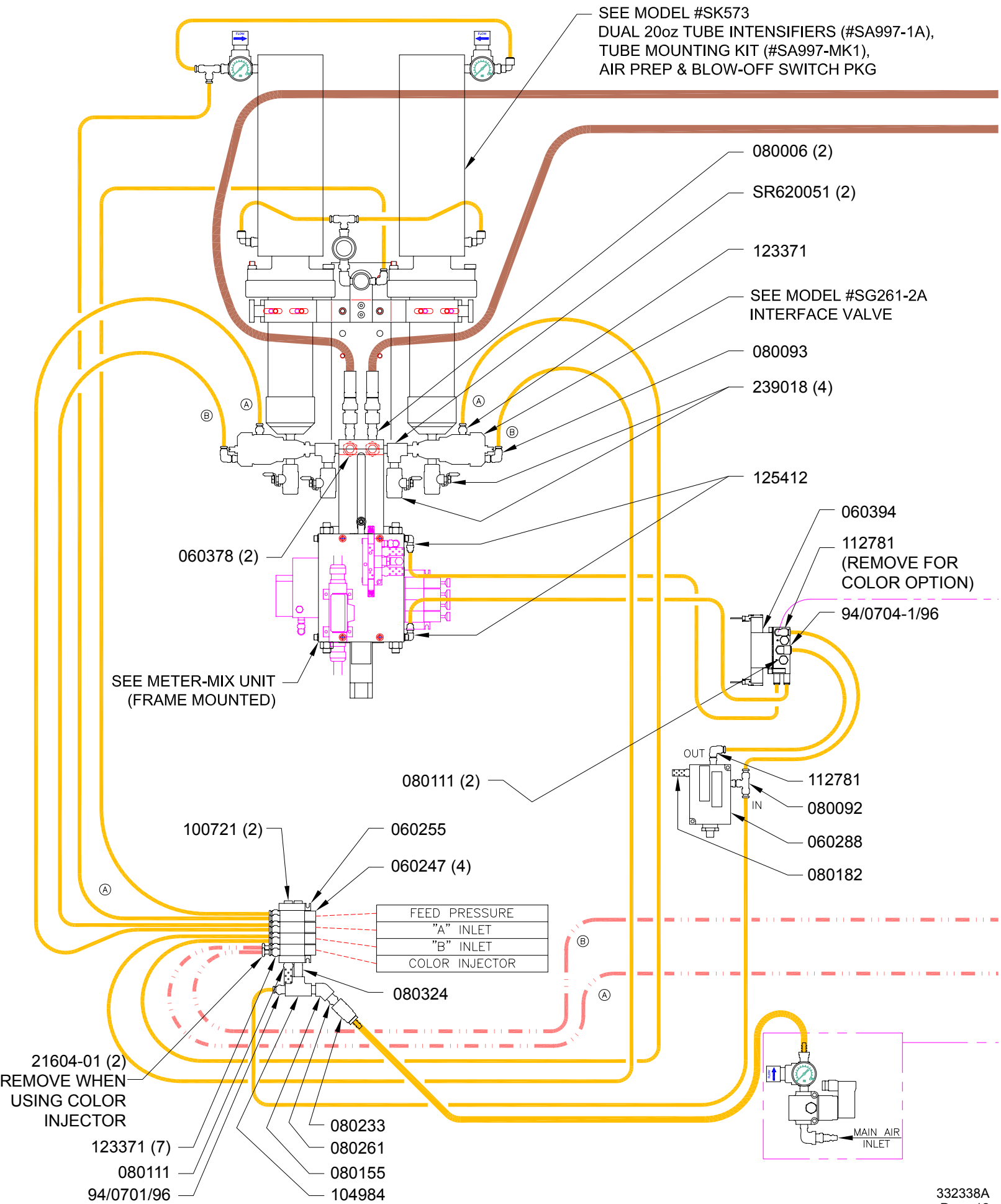
COLOR PARTS (ONLY)

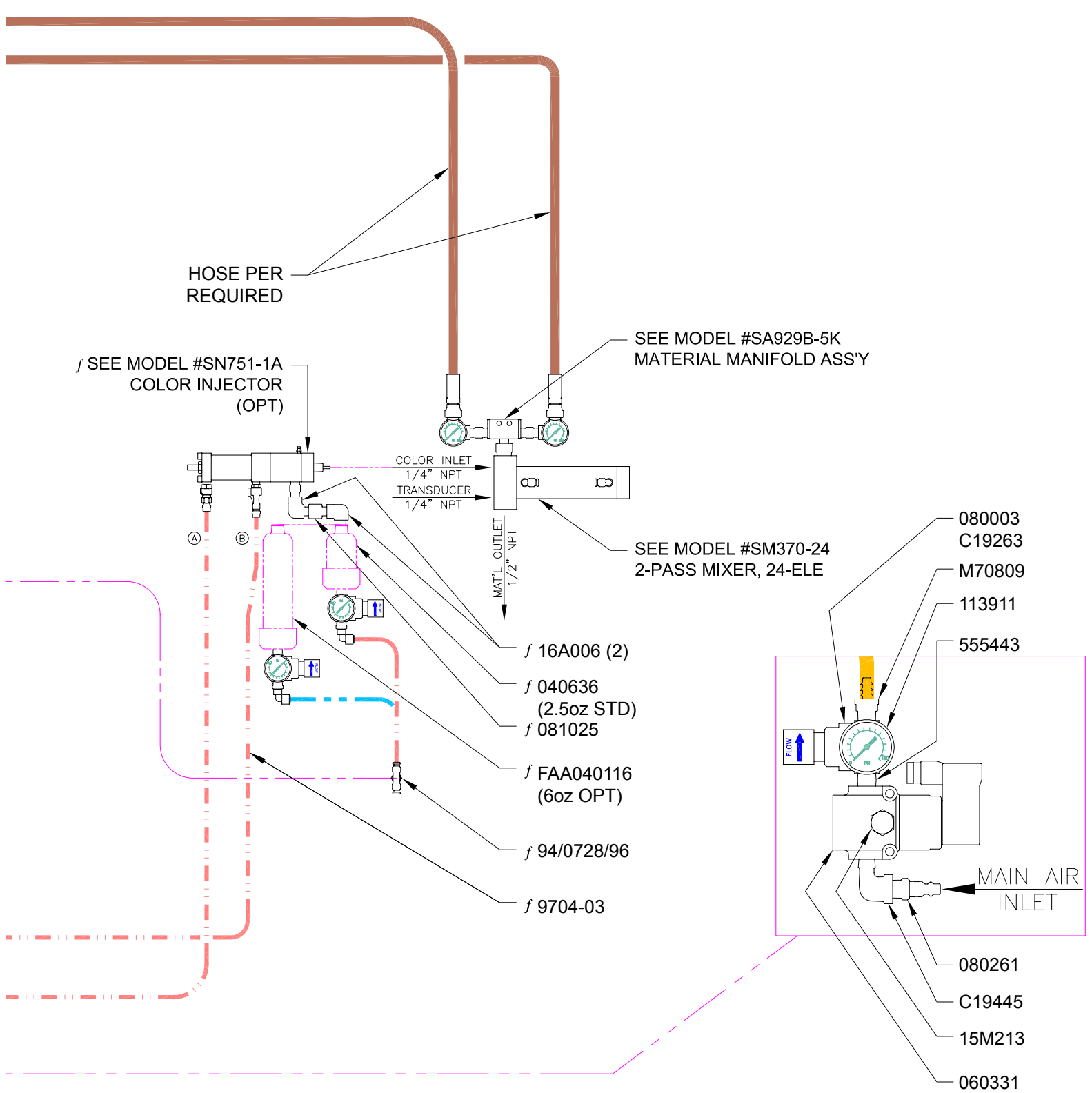
2.5oz STD: MODEL 622CF1

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SN751-1A	INJECTOR,ASSY,COLOR,INJECTOR

6oz STD: MODEL 622CF2

PART NO.	DESCRIPTION
040116	KIT,6.0 OUNCE,REGULATOR,GAUGE
080106	FITTING,TEE,1/4NPTX1/4ODTUBE,SWV
080484	FITTING,ELB,1/4MXF,316SS STL
081025	FITTING,1/4"NPTMX1/4"NPTF,316
SN751-1A	INJECTOR,ASSY,COLOR,INJECTOR





HOSE PER REQUIRED

f SEE MODEL #SN751-1A
COLOR INJECTOR
(OPT)

SEE MODEL #SA929B-5K
MATERIAL MANIFOLD ASS'Y

COLOR INLET
1/4" NPT
TRANSDUCER
1/4" NPT

SEE MODEL #SM370-24
2-PASS MIXER, 24-ELE

MAT'L OUTLET
1/2" NPT

- f 16A006 (2)
- f 040636 (2.5oz STD)
- f 081025
- f FAA040116 (6oz OPT)
- f 94/0728/96
- f 9704-03

- 080003
- C19263
- M70809
- 113911
- 555443

MAIN AIR INLET

- 080261
- C19445
- 15M213
- 060331

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f COLOR ONLY

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SG261-2A	GUN,SINGLE-PART,MALE
SM370-24	MIXER,2PASS,24 ELEMENTS
SR620051	FITTING,ALTER,STREET,TEE,1/4"

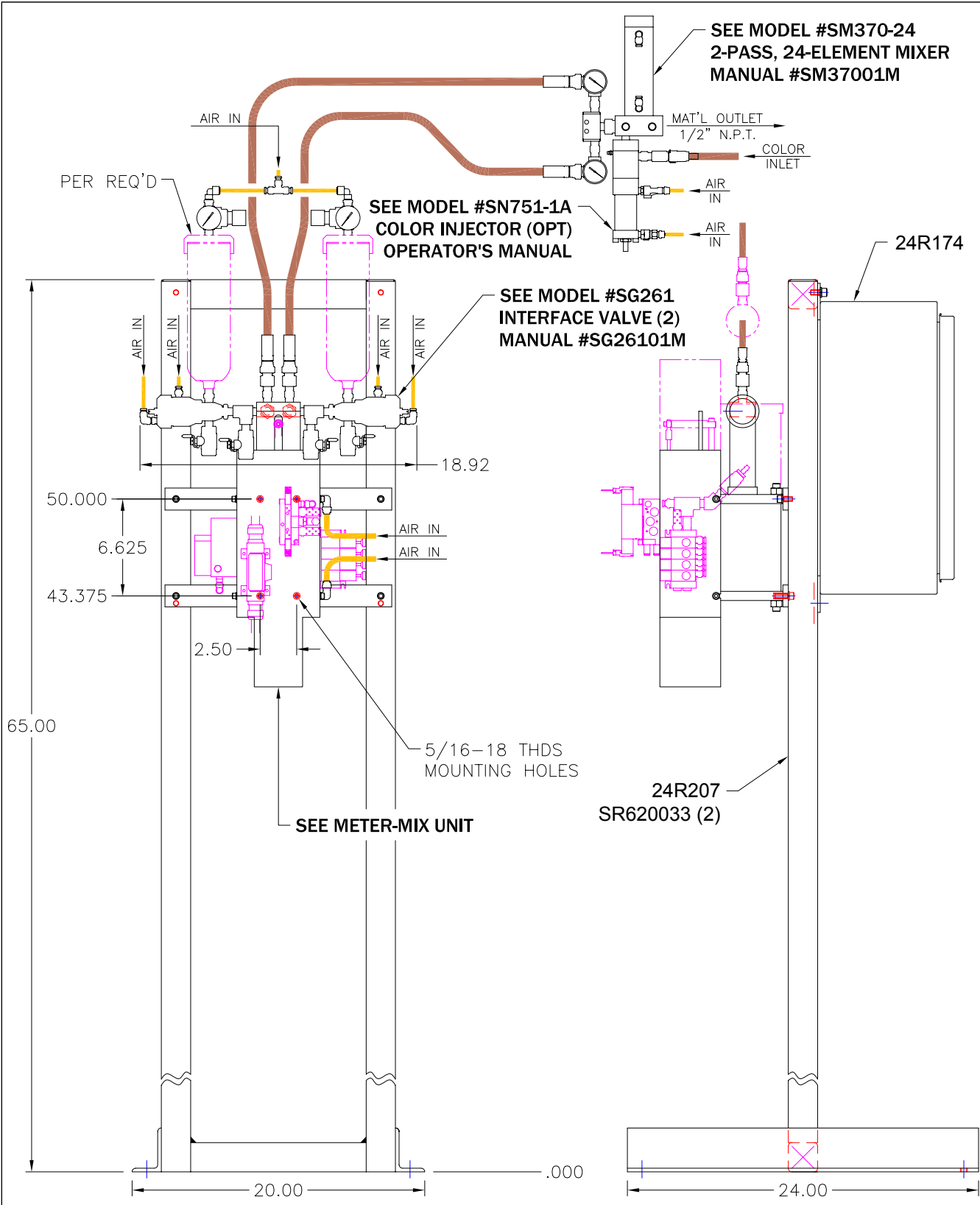
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PART NO.	DESCRIPTION
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080484	FITTING,ELB,1/4MXF,316SS STL
081025	FITTING,1/4"NPTMX1/4"NPTF,316
SN751-1A	INJECTOR,ASSY,COLOR,INJECTOR



PARTS LIST

PART NO	DESCRIPTION (QTY)
24R174	METER, HELI GEAR, STD RES, HTD, REN
24R207	FRAME, SR620031, POWER COATED
SG261	GUN, SINGLE-PART, FEMALE
SM370-24	MIXER, 2PASS, 24 ELEMENTS
SN751-1A	INJECTOR, ASSY, COLOR, INJECTOR
SR620033	PLATE, ASSY, 622-1A, MAIN



WIXOM, MI.

RELEASED: 1-31-07
 REVISED: 10-11-10

DESCRIPTION: MODEL #622-1A (ASS'Y #622-1A)
 MECHANICAL COMPONENTS (FRAME MOUNTED UNIT)

SEAL KIT ~ #622K

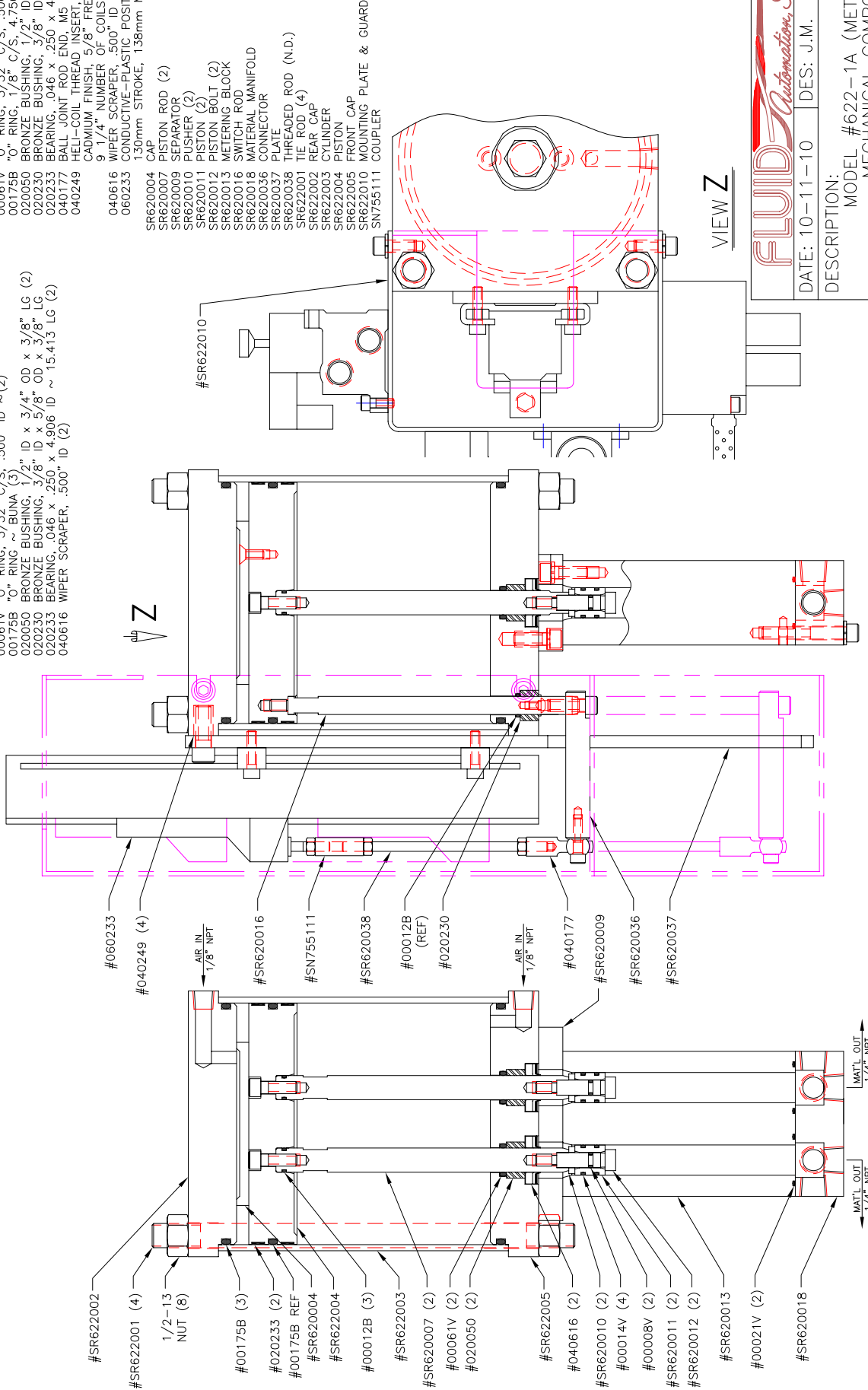
PART NO DESCRIPTION (QTY)

00008V	"O" RING, 1/16" C/S, .188" ID ~ (2)
00012B	"O" RING, 1/16" C/S, .375" ID ~ BUNA (3)
00014V	"O" RING, 1/16" C/S, .500" ID ~ (4)
00021V	"O" RING, 1/16" C/S, .937" ID ~ (2)
00061V	"O" RING, 3/32" C/S, .500" ID ~ (2)
00175B	"O" RING ~ BUNA (3)
020050	BRONZE BUSHING, 1/2" ID x 3/4" OD x 3/8" LG (2)
020230	BRONZE BUSHING, 3/8" ID x 5/8" OD x 3/8" LG
020233	BEARING, .046 x .250 x 4.906 ID ~ 15.413 LG (2)
040616	WIPER SCRAPER, .500" ID (2)

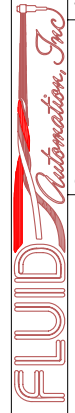
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00012B	"O" RING, 1/16" C/S, .375" ID ~ BUNA (3)
00014V	"O" RING, 1/16" C/S, .500" ID ~ (4)
00021V	"O" RING, 1/16" C/S, .937" ID ~ (2)
00061V	"O" RING, 3/32" C/S, .500" ID ~ (2)
00175B	"O" RING, 1/8" C/S, 4.750" ID ~ BUNA (3)
020050	BRONZE BUSHING, 1/2" ID x 3/4" OD x 3/8" LG (2)
020230	BRONZE BUSHING, 3/8" ID x 5/8" OD x 3/8" LG
020233	BEARING, .046 x .250 x 4.906 ID ~ 15.413 LG (2)
040177	BALL JOINT ROD END, M5 x 0.8 FEMALE
040249	HELI-COIL THREAD INSERT, 5/16-18 UNC THDS, CADMIUM FINISH, 5/8" FREE RUNNING, 380/400 OD, 9 1/4" NUMBER OF COILS NOMINAL LENGTH ~ SS (4)
040616	WIPER SCRAPER, .500" ID (2)
060233	CONDUCTIVE-PLASTIC POSITION TRANSDUCER 130mm STROKE, 138mm MECHANICAL STROKE
SR620004	CAP
SR620007	PISTON ROD (2)
SR620009	SEPARATOR
SR620010	PUSHER (2)
SR620011	PISTON (2)
SR620012	PISTON BOLT (2)
SR620013	METERING BLOCK
SR620016	SWITCH ROD
SR620018	MATERIAL MANIFOLD
SR620036	CONNECTOR
SR620037	PLATE
SR620038	THREADED ROD (N.D.)
SR622001	TIE ROD (4)
SR622002	REAR CAP
SR622003	CYLINDER
SR622004	PISTON
SR622005	FRONT CAP
SR622010	MOUNTING PLATE & GUARD
SN755111	COUPLER

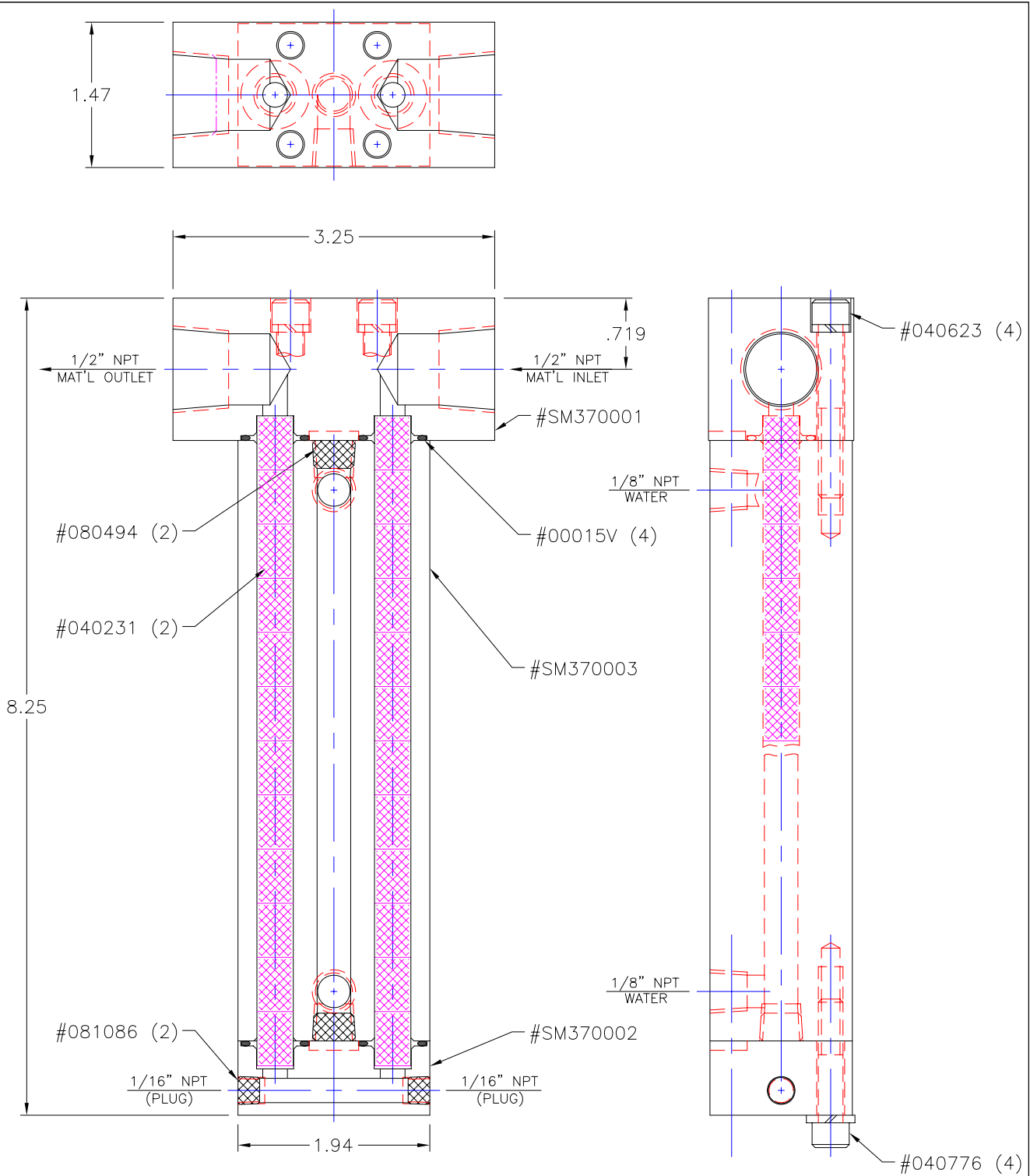


VIEW Z



DATE: 10-11-10 DES: J.M. CHK'D: FA

DESCRIPTION:
MODEL #622-1A (METER UNIT)
MECHANICAL COMPONENT



PARTS LIST

PART NO	DESCRIPTION (QTY)
00015V	"O" RING, 1/16" C/S, .562" ID ~ (4)
040231	12-ELEMENT MIXER (2)
040623	S.H.C.S., 1 3/4" LG. (4)
040776	S.H.C.S., 1 1/4" LG. (4)
080494	1/8" NPTM PIPE PLUG (2)
081086	1/16" NPTM PIPE PLUG (2)
SM370001	IN-OUT BLOCK
SM370002	RETURN BLOCK
SM370003	HOUSING

SEAL KIT ~ #SK370-1

PART NO	DESCRIPTION (QTY)
00015V	"O" RING, 1/16" C/S, .562" ID ~ (4)

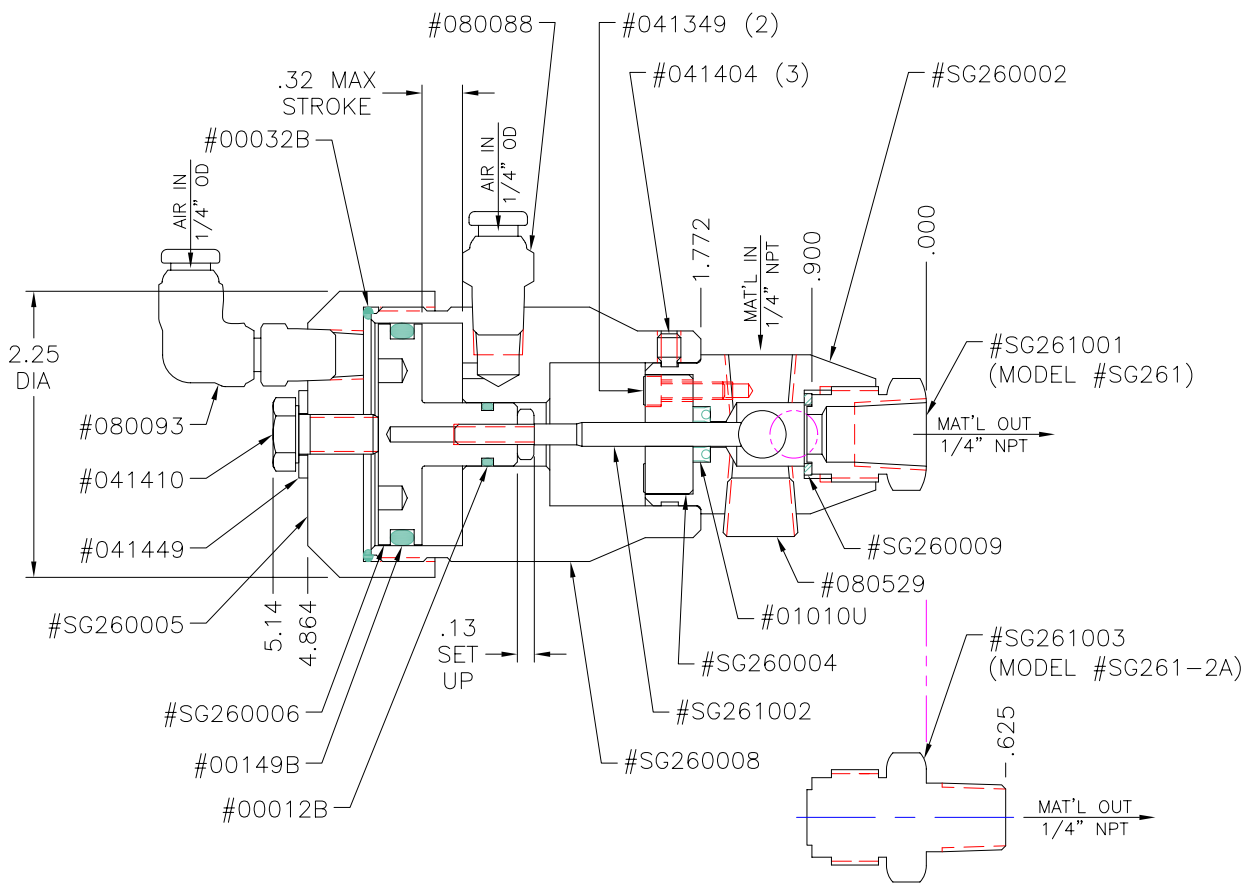


WIXOM, MI.

RELEASED: 5-10-05
 REVISED: 5-2-08

DESCRIPTION: MIXER MODEL #SM370-24 (ASS'Y #SM370) ~ MEDICAL
 2-PASS ~ .363" DIA. ~ 24-ELEMENT ~ WATER COOLED

MANUAL#: SM37001M



PARTS LIST

PART NO	DESCRIPTION (QTY)
00012B	"O" RING, 1/16" C/S, .375" ID ~ BUNA
00032B	"O" RING, 1/16" C/S, 1.875" ID ~ BUNA
00149B	"O" RING, 1/8" C/S, 1.500" ID ~ BUNA
01010U	POLYSEAL, .436 OD x .187 ID x .125 C/S ~ ULTRA YELLOW [FLUOROTREL]
041349	S.H.C.S., #6-32 x 1/2" LG ~ STEEL, BLACK OXIDE (2)
041404	SET SCREW, HEX SOCKET, EXTENDED DOG POINT, #10-24 CLASS 3A THREADS, 1/4" LG, ASTM F912 ~ BLACK ALLOY STEEL (3)
041410	H.H.C.S., 5/16-24 x 5/8" LG, CLASS 2A THREADS, R/C C25, ASME B18.2.1 ~ GRADE 5 STEEL, ZINC PLATED
041449	FLAT WASHER, 21/64" ID x 11/16" OD x .05-.07" THICK, INSULATING ~ HARD FIBER
080088	1/8" NPTM x 1/4" OD HOSE PUSH-ON STRAIGHT FTG, 300psi MAX PRESSURE ~ BRASS, NICKEL-PLATED
080093	1/8" NPTM x 1/4" OD HOSE PUSH-ON SWIVEL ELBOW, 300psi MAX PRESSURE ~ BRASS, NICKEL-PLATED
080529	1/4" NPTM PIPE PLUG, HEX SOCKET, 150psi MAX PRESSURE ~ 302 STAINLESS STL
SG260002	BODY
SG260004	BEARING
SG260005	CAP
SG260006	PISTON
SG260008	CYLINDER BODY
SG260009	NOSEPIECE SEAL
SG261001	NOSEPIECE (MODEL #SG261 ONLY)
SG261002	PLUNGER
SG261003	NOSEPIECE (MODEL #SG261-2A ONLY)

SEAL KIT ~ #SG260K

PART NO	DESCRIPTION (QTY)
00012B	"O" RING, 1/16" C/S, .375" ID ~ BUNA
00032B	"O" RING, 1/16" C/S, 1.875" ID ~ BUNA
00149B	"O" RING, 1/8" C/S, 1.500" ID ~ BUNA
01010U	POLYSEAL, .436 OD x .187 ID x .125 C/S ~ ULTRA YELLOW [FLUOROTREL]
SG260009	NOSEPIECE SEAL



WIXOM, MI.

RELEASED: 5-25-01

REVISED: 2-29-12

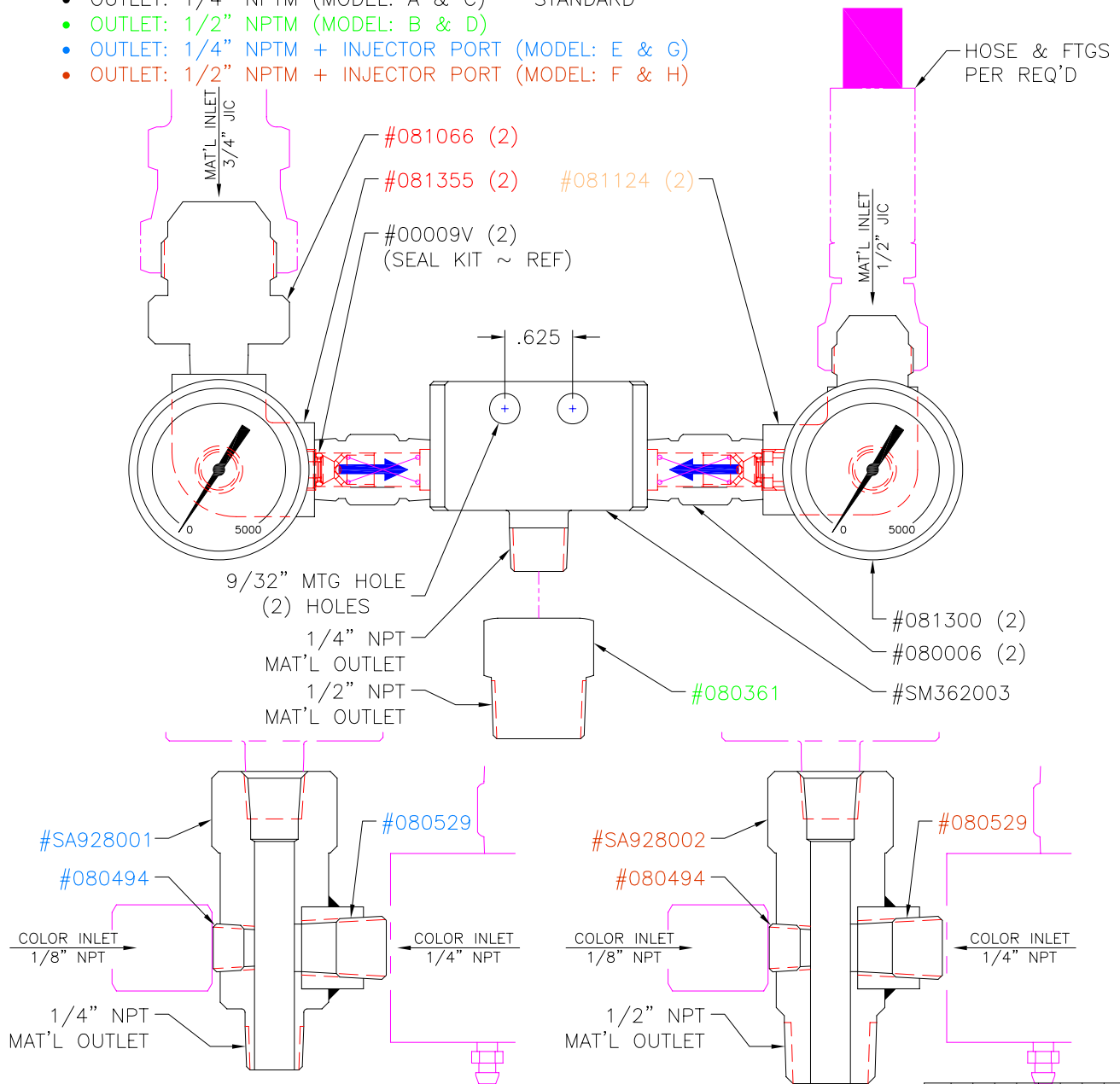
DESCRIPTION:

GUN MODEL #SG261 & SG261-2A (ASS'Y #SG261)
SHUT-OFF GUN ~ SINGLE PART

MANUAL#:SG26101M

NOTE: OPTIONAL PARTS NOTED BY COLOR, OTHER PARTS ARE COMMON.

- INLET: 1/2" JIC (MODEL: A, B, E & F)
- INLET: 3/4" JIC (MODEL: C, D, G & H)
- OUTLET: 1/4" NPTM (MODEL: A & C) ** STANDARD **
- OUTLET: 1/2" NPTM (MODEL: B & D)
- OUTLET: 1/4" NPTM + INJECTOR PORT (MODEL: E & G)
- OUTLET: 1/2" NPTM + INJECTOR PORT (MODEL: F & H)



PARTS LIST

PART NO	DESCRIPTION (QTY)	MODEL #							
		SA929A-5K	SA929B-5K	SA929C-5K	SA929D-5K	SA929E-5K	SA929F-5K	SA929G-5K	SA929H-5K
080006	1/4" NPTM x 1/4" NPTM CHECK VALVE, 15# CRACK PRESSURE ~ SS (2)	X	X	X	X	X	X	X	X
080361	1/2" NPTM x 1/4" NPTF BUSHING ~ 316 STAINLESS STL		X		X				
080494	1/8" NPTM PIPE PLUG, HEX SOCKET ~ 302 STAINLESS STL					X	X	X	X
080529	1/4" NPTM PIPE PLUG, HEX SOCKET ~ 302 STAINLESS STL					X	X	X	X
081066	3/4" JIC [1 1/16-12 UNF] 37dg FLARE TUBE x 1/4" NPTM HEX NIPPLE ~ 316 STAINLESS STL (2)				X	X			X
081124	1/2" JIC (3/4-16 UNF) 37dg FLARE TUBE x 1/4" NPTF ELBOW w-1/8" NPTF PORT ~ 316 STAINLESS STL (2)	X	X				X	X	
081300	GAUGE, 0-5000 psi + 0-34000 kPa, 1/8" NPTM CENTER BACK MOUNT, 1 1/2" [40mm] DIA GLYCERIN FILLED ~ 304 STAINLESS STL (2)	X	X	X	X	X	X	X	X
081355	1/4" NPTF x 1/4" NPTF ELBOW w-1/8" NPT GAUGE PORT ~ SS (2)			X	X				X
SA928001	ADAPTER w/ COLOR PORT-SA928 TO 1/4" NPTM						X		X
SA928002	ADAPTER w/ COLOR PORT-SA928 TO 1/2" NPTM							X	X
SM362003	MANIFOLD	X	X	X	X	X	X	X	X



WIXOM, MI.

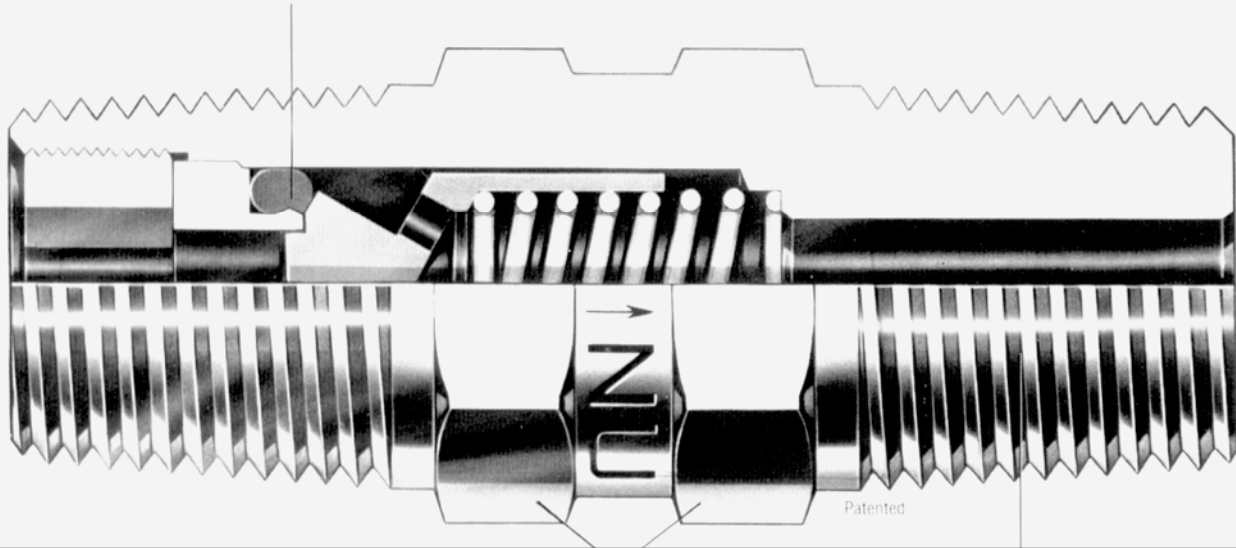
RELEASED: 9-11-08

REVISED: 3-9-12

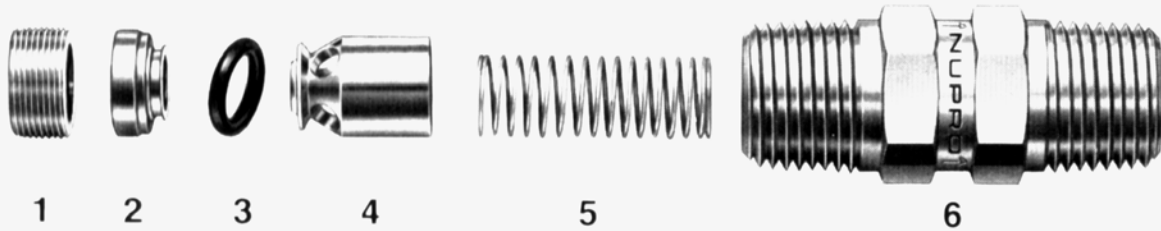
DESCRIPTION: ACCESSORY MODEL #SEE NOTE (ASS'Y #SA929) ~ MEDICAL
1:1 RATIO SILICONE MINI MANIFOLD

MANUAL#: SA92901M

FULLY CONTAINED O-RING SEAL



MATERIALS OF CONSTRUCTION



	F.A.I. PART NUMBERS			
	Ass'y #080006	Ass'y #080292	Ass'y #080005	Ass'y #080291
	316SS ~ 1/4" N.P.T.	316SS ~ 1/2" N.P.T.	Brass ~ 1/4" N.P.T.	Brass ~ 1/2" N.P.T.
1. Insert Lock Screw	080311	080273	080309	080279
2. Insert	080268	080269	080274	080275
3. O-Ring	00009V	00059V	00009B	00059B
4. Poppet	080270	080271	080276	080277
5. Spring	040182	040186	040182	040186
6. Body	080299	080300	080297	080298

FLUID Automation, Inc.

WIXOM, MI.

RELEASED: 5-5-97

REVISED: 10-7-10

DESCRIPTION:

CHECK VALVE ASSEMBLY
15# ~ NON-ADJUSTABLE



CA & CPA Series Check Valve Cracking Pressure Adjustment

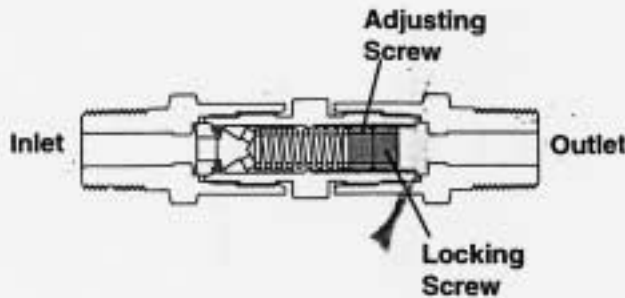
Tools Needed

CA & 4CPA
5/32 in. hex key

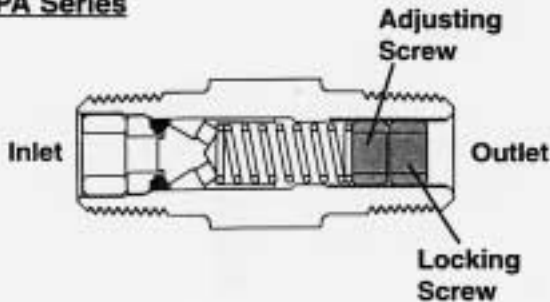


8CPA
5/16 in. hex key

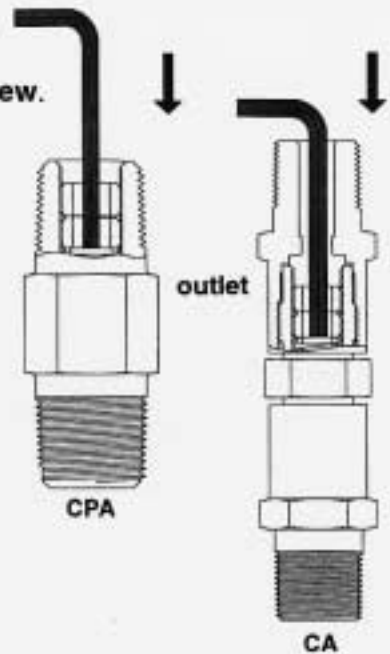
CA Series



CPA Series

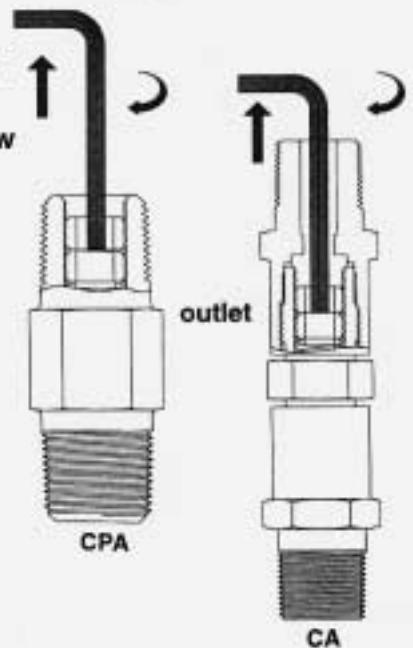


2. Slide wrench down into adjusting screw.



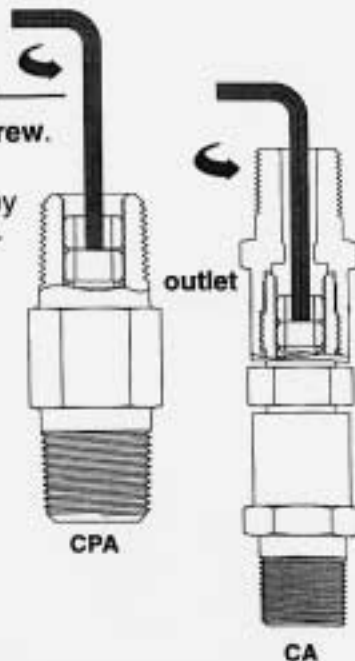
3. Turn both screws to reach desired cracking pressure. (Turn clockwise to increase cracking pressure, counter clockwise to decrease cracking pressure)

4. Slide wrench back up into locking screw and turn clockwise to lock.



1. Insert wrench into locking screw.

Loosen screw by turning counter-clockwise.

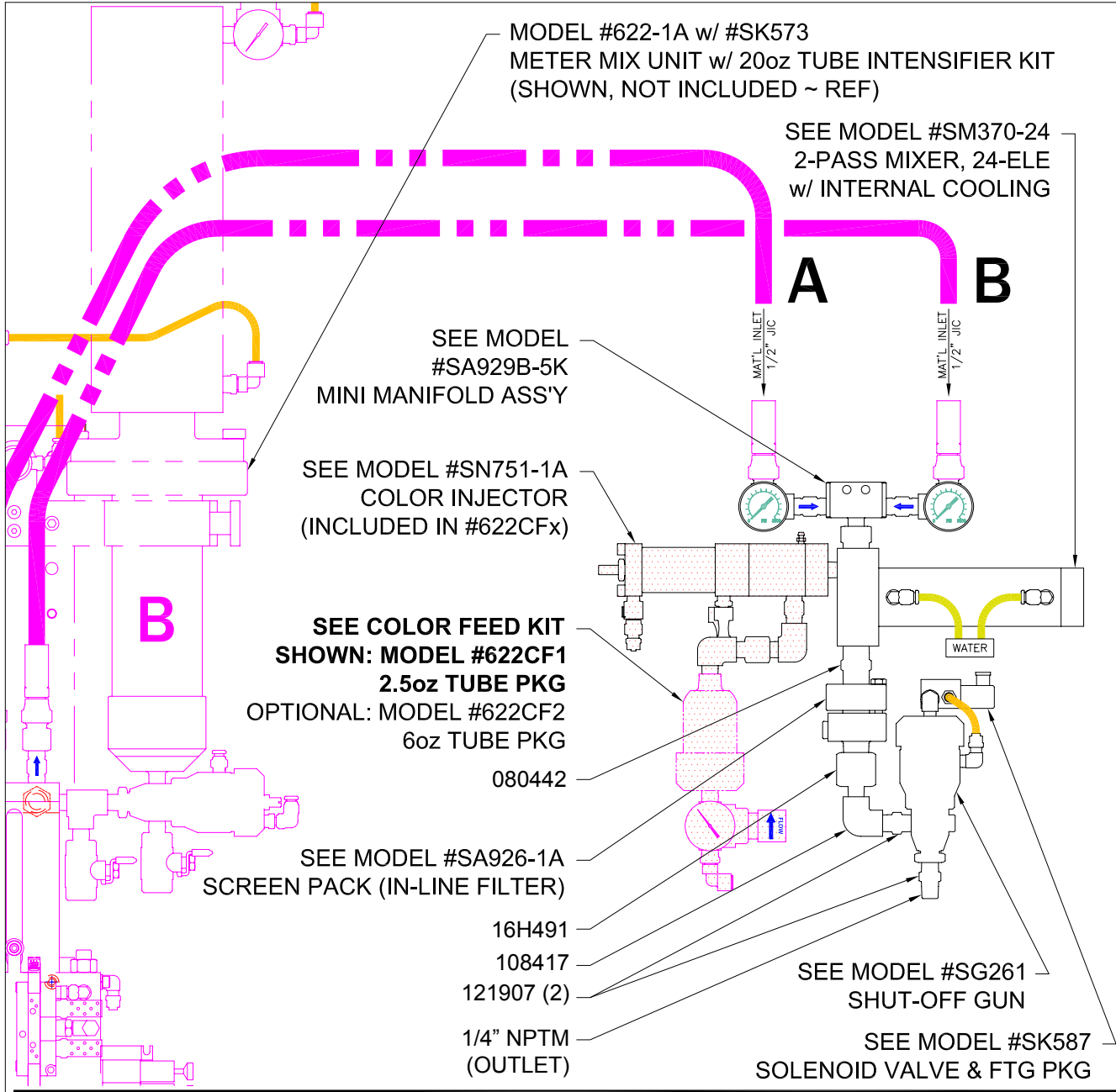


5. Verify cracking pressure and adjust screws if required.



NUPRO Company
4800 E. 345th Street
Willoughby, Ohio 44094, U.S.A.





PARTS LIST (MODEL #SK583)

PART NO	DESCRIPTION
080442	FITTING,NIPPLE,1/2"NPTMX1/2"NPTM
108417	ELBOW,FEMALE
121907	FITTING,NIPPLE,HEX,1/4NPT,SST,SWW
16H491	ADAPTER,1/2 NPT TO 1/4 NPT
SA926-1A	FILTER,IN-LINE,1/2" NPT
SA929B-5K	MANIFOLD,ASY,MINI,1/2IN,1/2OUT
SG261	FUNG,SINGLE-PART,FEMALE
SK587	KIT,SOLENOID VALVE,24VDC
SM370-24	MIXER,2PASS,24 ELEMENTS

COLOR FEED KIT w/CARTRIDGE TUBE PKG ~ ORDER SEPERATELY - PER REQUIRED

PART NO	DESCRIPTION
622CF1	KIT,COLOR FEED,2.5OZ
622CF2	KIT,COLOR FEED, 6OZ

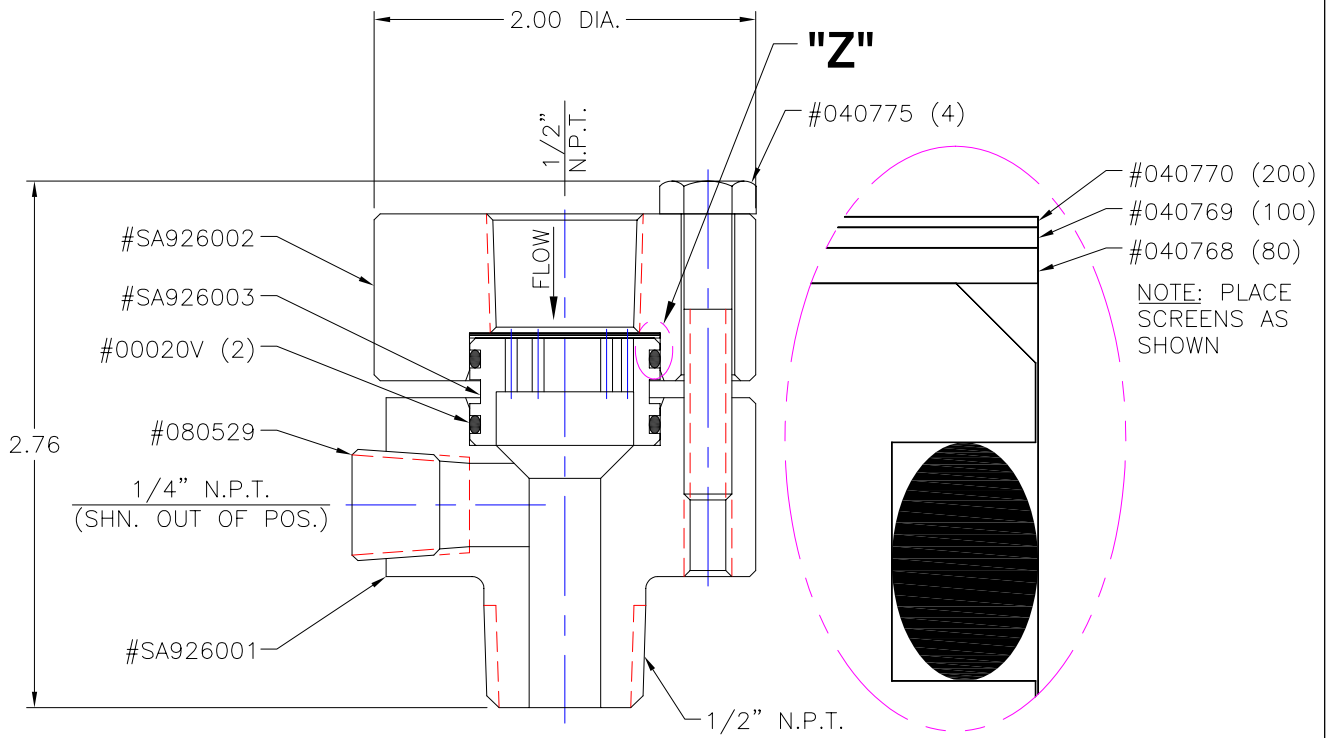


WIXOM, MI.

RELEASED: 8-13-08
REVISED: 6-5-12

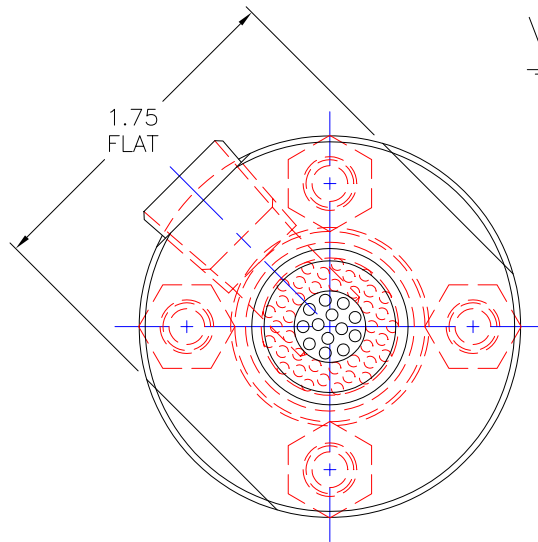
DESCRIPTION: MODEL #SK583 (ASS'Y #SK583)
BARREL STACK ~ MANIFOLD/MIXER/COLOR FEED KIT/FILTER/SHUT-OFF GUN w-SOLENOID & FTG PKG

MANUAL#:SK58301M



VIEW IN CIRCLE Z

SCALE ~ 20x



PARTS LIST

PART NO.	DESCRIPTION
00020V	"O" RING (2 REQ'D)
040768	WOVEN WIRE CLOTH (80 MESH)
040769	WOVEN WIRE CLOTH (100 MESH)
040770	WOVEN WIRE CLOTH (200 MESH)
040775	HEX. HD. BOLT (4 REQ'D)
080529	PIPE PLUG
SA926001	HOUSING - OUTLET
SA926002	HOUSING - INLET
SA926003	SCREEN SUPPORT

SEAL KIT ~ #SA926K

PART NO.	DESCRIPTION
00020V	"O" RING (2 REQ'D)
040768	WOVEN WIRE CLOTH (80 MESH, 178 MICRON)
040769	WOVEN WIRE CLOTH (100 MESH, 140 MICRON)
040770	WOVEN WIRE CLOTH (200 MESH, 120 MICRON)



WIXOM, MI.

RELEASED: 5-3-05

REVISED: 8-22-05

DESCRIPTION:

ACCESSORY MODEL #SA926-1A (ASS'Y #SA926)
SCREEN PACK ~ IN-LINE MATERIAL FILTER

INCLUDING: OPERATION, INSTALLATION & MAINTENANCE

RELEASED: 2-2-99

REVISED: 3-30-12

AIR CYLINDER DIA = 1.25"
METERING PIN DIA = .1875"
PRESSURE RATIO = 44:1

STROKE ADJUSTABLE 0.0" to 0.5"
SHOT VOLUME MAX = 0.0138³ "
(0.226cc)

FLUID METERING VALVE
ADJUSTABLE VOLUME

IMPORTANT: READ THIS MANUAL CAREFULLY BEFORE INSTALLING, OPERATION OR SERVICING THIS EQUIPMENT.

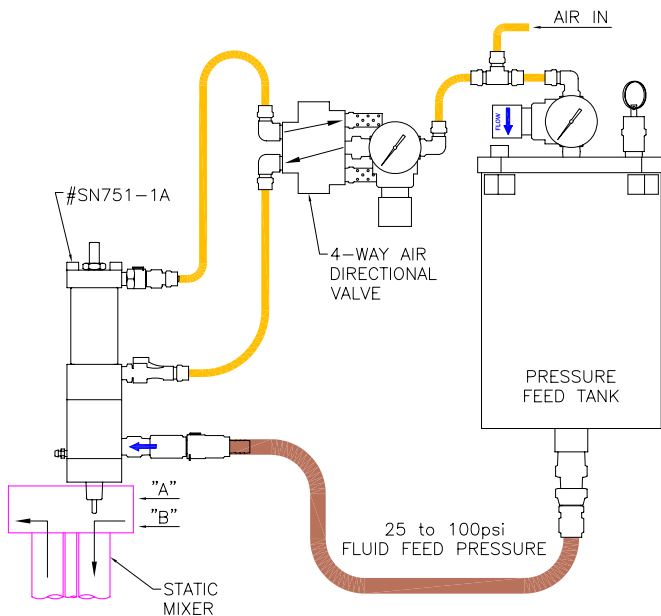
OPERATING PRECAUTIONS

- HEED ALL WARNINGS.
- WARNING: HIGH PRESSURE DEVICE. Improper usage of this equipment could result in serious injury. The possibility of injection into the flesh is a potential hazard. Never allow any part of the human body to come in front of or in direct contact with the material outlet. An injection injury can be serious. If injection should occur, contact a qualified physician immediately for treatment.
- COMPONENT RUPTURE. This unit is capable of producing high material pressure. Use appropriate outlet hose and valves.
- Be sure material hoses and other components are able to withstand fluid pressures developed by this unit.
- Materials and solvents being metered by this unit must be compatible with the parts of this unit that come in contact with material and solvent.
- SERVICING. Before servicing or cleaning this unit, or removing fluid hose or gun from a unit that has been used, be sure to disconnect air lines.

MAINTENANCE

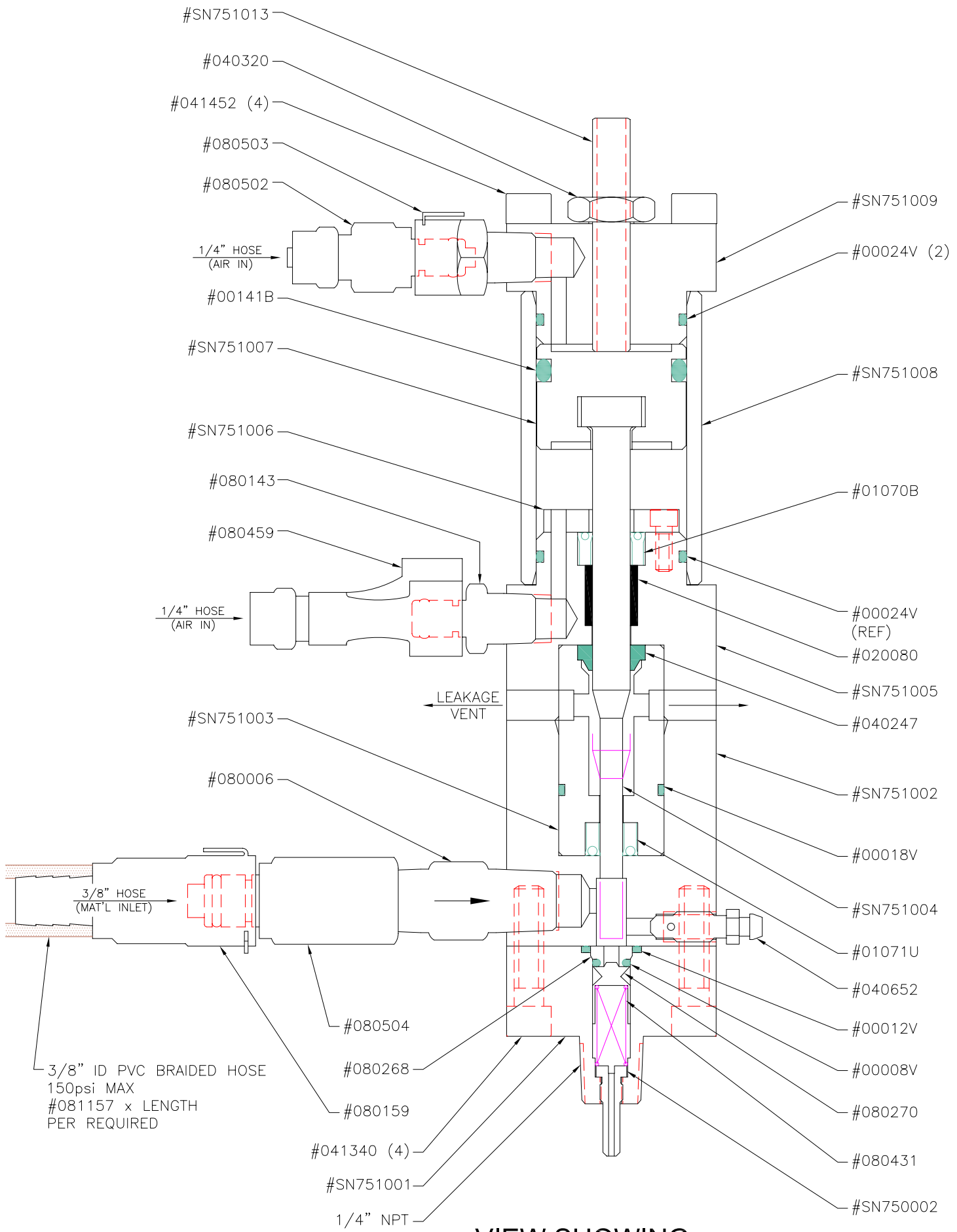
- Use a clean fluid supply, check valves will not function if foreign materials are present.
- If material appears at the leakage vents, replace seal #01071U.

TYPICAL HOOK-UP FOR #SN751-1A



COLOR INJECTOR DISASSEMBLY

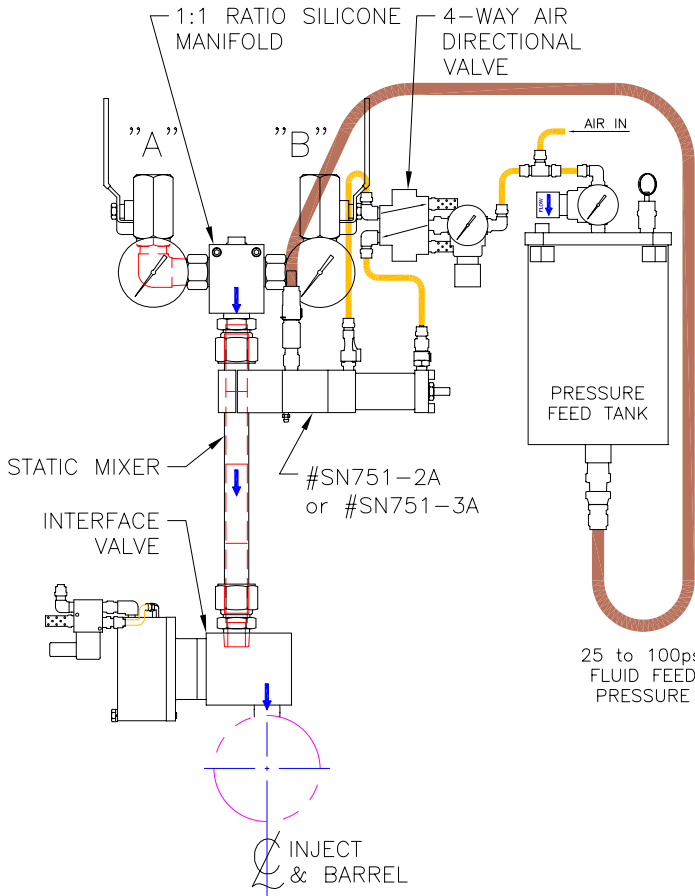
- Basic mechanical (S.A.E.) tools:
 - 7/64" Allen wrench
 - 5/32" Allen wrench
 - 3/16" Allen wrench
 - 9/16" open-end wrench
 - 5/8" open-end wrench
 - Flat head screwdriver
 - Once color injector is removed from machine place in vise (at flats just above check valve, with inject screw facing downward).
 - Remove (4) 1/4" screws (with 3/16" Allen wrench) opposite injection end.
 - Hold front cap and separate from block (use caution, to not damage metering pin while separating).
 - Slide front cap out of cylinder (set parts including cylinder and metering pin on workbench).
 - Remove (3) #6 screws (with 7/64" Allen wrench) from seal retainer, allowing the removal of seals and bearing.
 - Separate rear cap from cylinder, then remove seal.
 - Unscrew set screw (with 5/32" Allen wrench) from rear cap, allowing removal of locknut (with 5/8" open-end wrench).
 - Slide piston from cylinder, then remove metering pin and seal.
 - Take insert out of block (in vise) and remove seals and wiper ring.
 - Unfasten block from vise and refasten in vise at flats just below check valve, with inject screw facing upward.
 - Remove (4) 1/4" screws (with 3/16" Allen wrench), careful to not let insert, poppet, seal and spring fall out, allowing removal of said parts along with remaining seal.
 - Unscrew inject screw (with flat head screwdriver) from valve body.
 - Remove #6 screw (with 7/64" Allen wrench) from block.
 - Unfasten block from vise and refasten in vise with check valve facing upward and remove (with 9/16" open-end wrench).
 - Place all parts in a solvent tank for cleaning, except seal which will be damaged by the solvent.
- [Model SN751-2A & -3A only:
- Remove (4) 1/4" screws (with 3/16" Allen wrench) from mixer tube mtg. block and separate color injector from mixer tube.
 - Follow instructions as stated; substitute references to valve body with mixer tube mtg. block.]



**VIEW SHOWING
MODEL #SN751-1A**

TYPICAL HOOK-UP FOR #SN751-2A or #SN751-3A

W/ RECIPROCATING SCREW INJECTION MOLDING MACHINE



SN751 (#SN751) COLOR INJECTOR PARTS LIST

PART NO DESCRIPTION (QTY)

*	00006V	"O" RING, 1/16" C/S, .125" ID
	00008V	"O" RING, 1/16" C/S, .188" ID
	00012V	"O" RING, 1/16" C/S, .375" ID
	00018V	"O" RING, 1/16" C/S, .750" ID
	00024V	"O" RING, 1/16" C/S, 1.125" ID ~ (2)
	00141B	"O" RING, 1/8" C/S, 1.000" ID ~ BUNA
	01070B	POLYPAK SEAL TYPE "B", .562 OD x .312 ID x .125 C/S ~ LUBRIT, 95D
	01071U	POLYPAK SEAL TYPE "B", .437 OD x .187 ID x .125 C/S ~ LUBRIT, 95D
	020080	CAST BRONZE SLEEVE BEARING, 7/16" OD x 5/16" ID x 1/2" LG
*	040057	7/8" DIA x 2" MIXER ELEMENT (3)
	040247	WIPER RING, 5/16" ROD DIA, TYPE "D"
	040320	SELF-SEALING LOCKNUT, 5/16-24 THREADS, MEDIUM PRESSURE ~ BRASS
	040652	BLEEDER SCREW, 1/4-28 THDS
	041340	S.H.C.S., 1/4-20 x 1" LG ~ GRADE 5 STEEL, BLACK OXIDE (4)
	041452	S.H.C.S., 1/4-20 x 4 1/2" LG, CLASS 3A THREADS ~ GRADE 8 STEEL (4)
	080006	1/4" NPTM x 1/4" NPTM CHECK VALVE, 15# CRACK PRESSURE ~ SS
*	080136	1" OD TUBE COMPRESSION x 3/4" NPTM HEX NIPPLE ~ SS (2)
	080143	1/8" NPTM x 1/8" FLOW QUICK COUPLING INSERT ~ THERMOPLASTIC
	080159	3/8" ID HOSE BARB x 1/4" FLOW QUICK COUPLING BODY ~ BRASS
	080268	INSERT ~ SS
	080270	POPPET ~ SS
	080431	SPRING, 50psig ~ SS
	080459	1/8" FLOW x 1/4" OD HOSE QUICK COUPLING BODY ~ THERMOPLASTIC
	080502	1/8" FLOW x 1/4" OD HOSE QUICK COUPLING INSERT ~ THERMOPLASTIC
	080503	1/8" NPTM x 1/8" FLOW QUICK COUPLING BODY ~ THERMOPLASTIC
	080504	1/4" NPTF x 1/4" FLOW QUICK COUPLING INSERT ~ BRASS
	SN750002	INJECT SCREW
	SN751001	VALVE BODY
	SN751002	BLOCK
	SN751003	INSERT
	SN751004	PIN
	SN751005	FRONT CAP
	SN751006	SEAL RETAINER
	SN751007	PISTON
	SN751008	CYLINDER
	SN751009	REAR CAP
*	SN751010	MIXER TUBE MTG. BLOCK
	SN751011	TUBE
	SN751012	MIXER
	SN751013	SET SCREW

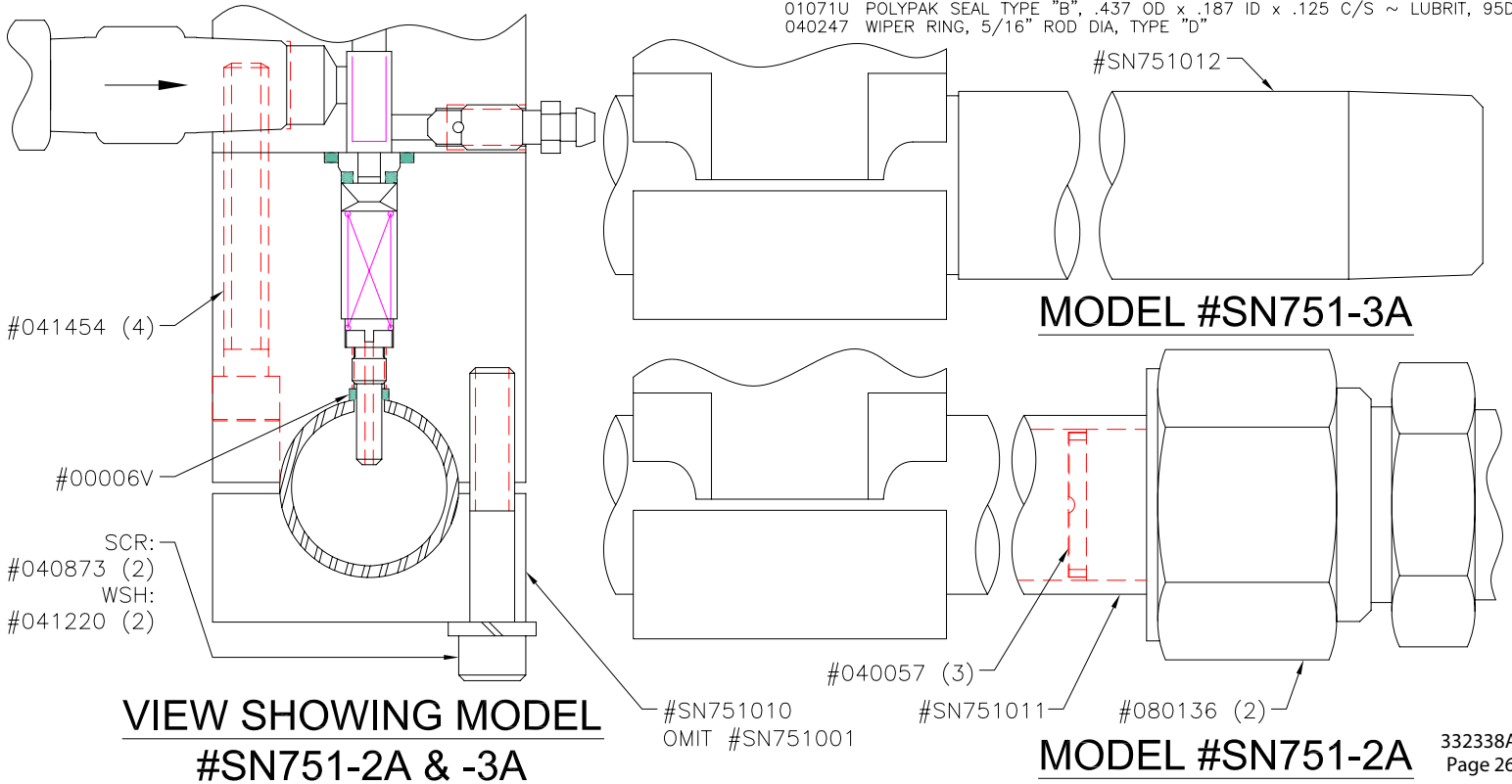
* OPTIONAL EQUIPMENT

SEAL KITS

SN751K:

PART NO DESCRIPTION (QTY)

	00006V	"O" RING, 1/16" C/S, .125" ID
	00008V	"O" RING, 1/16" C/S, .188" ID
	00009V	"O" RING, 1/16" C/S, .218" ID
	00012V	"O" RING, 1/16" C/S, .375" ID
	00018V	"O" RING, 1/16" C/S, .750" ID
	00024V	"O" RING, 1/16" C/S, 1.125" ID ~ (2)
	00141B	"O" RING, 1/8" C/S, 1.000" ID ~ BUNA
	01070B	POLYPAK SEAL TYPE "B", .562 OD x .312 ID x .125 C/S ~ LUBRIT, 95D
	01071U	POLYPAK SEAL TYPE "B", .437 OD x .187 ID x .125 C/S ~ LUBRIT, 95D
	040247	WIPER RING, 5/16" ROD DIA, TYPE "D"

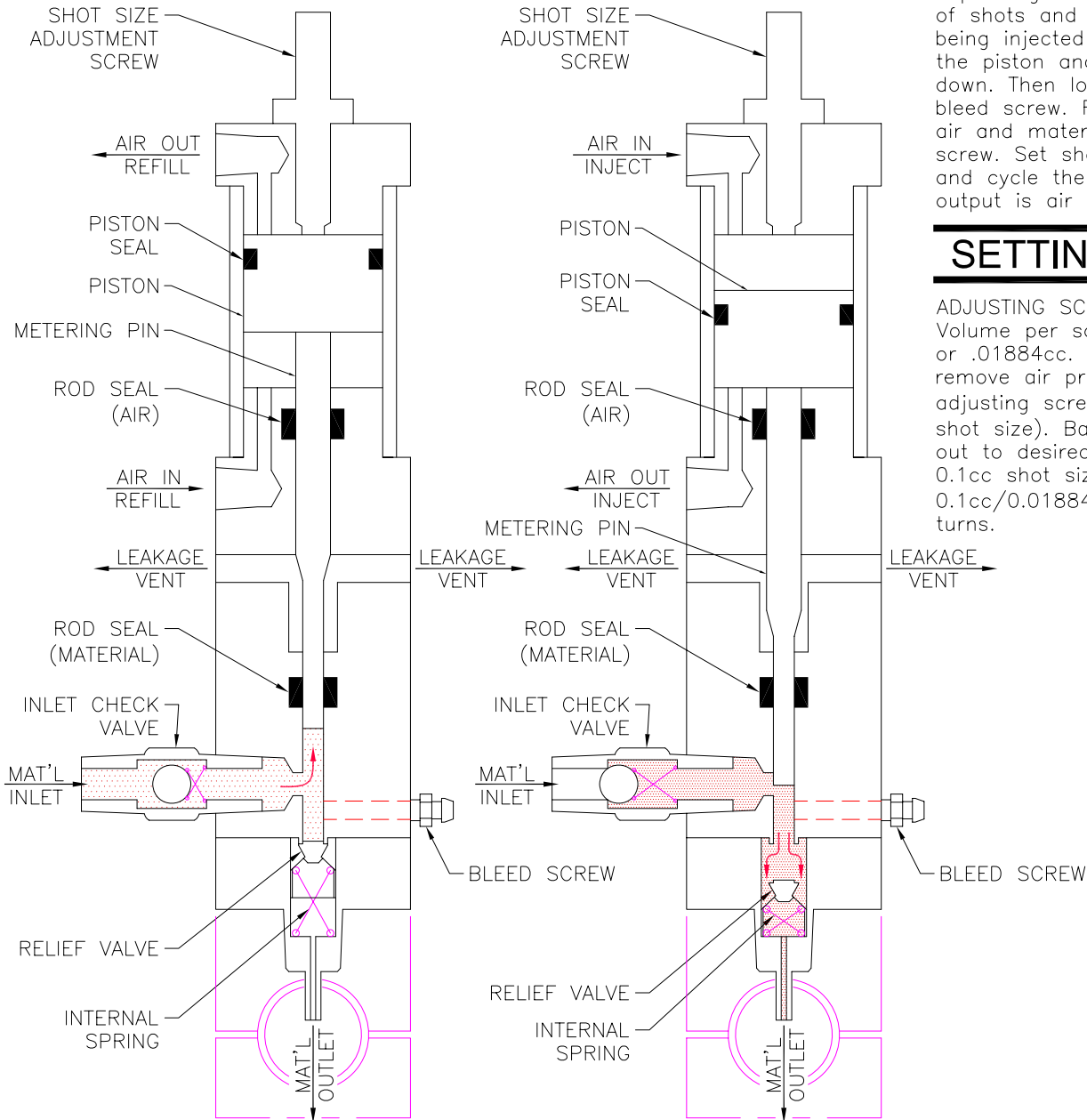


VIEW SHOWING MODEL
#SN751-2A & -3A

MODEL #SN751-2A

THEORY OF OPERATION

OPERATION



Material supply pressure 25psi minimum, up to 100psi if the fluid is viscous or shot frequency is fast. Refill and inject air supply pressure should be regulated at 20 to 100psi depending on viscosity and frequency of shots and pressure of the stream being injected into. AIR BLEED. Extend the piston and metering pin fully down. Then loosen or remove the bleed screw. Feed pressure will purge air and material out the hole. Tighten screw. Set shot size at maximum and cycle the valve several times till output is air free.

SETTING SHOT SIZE

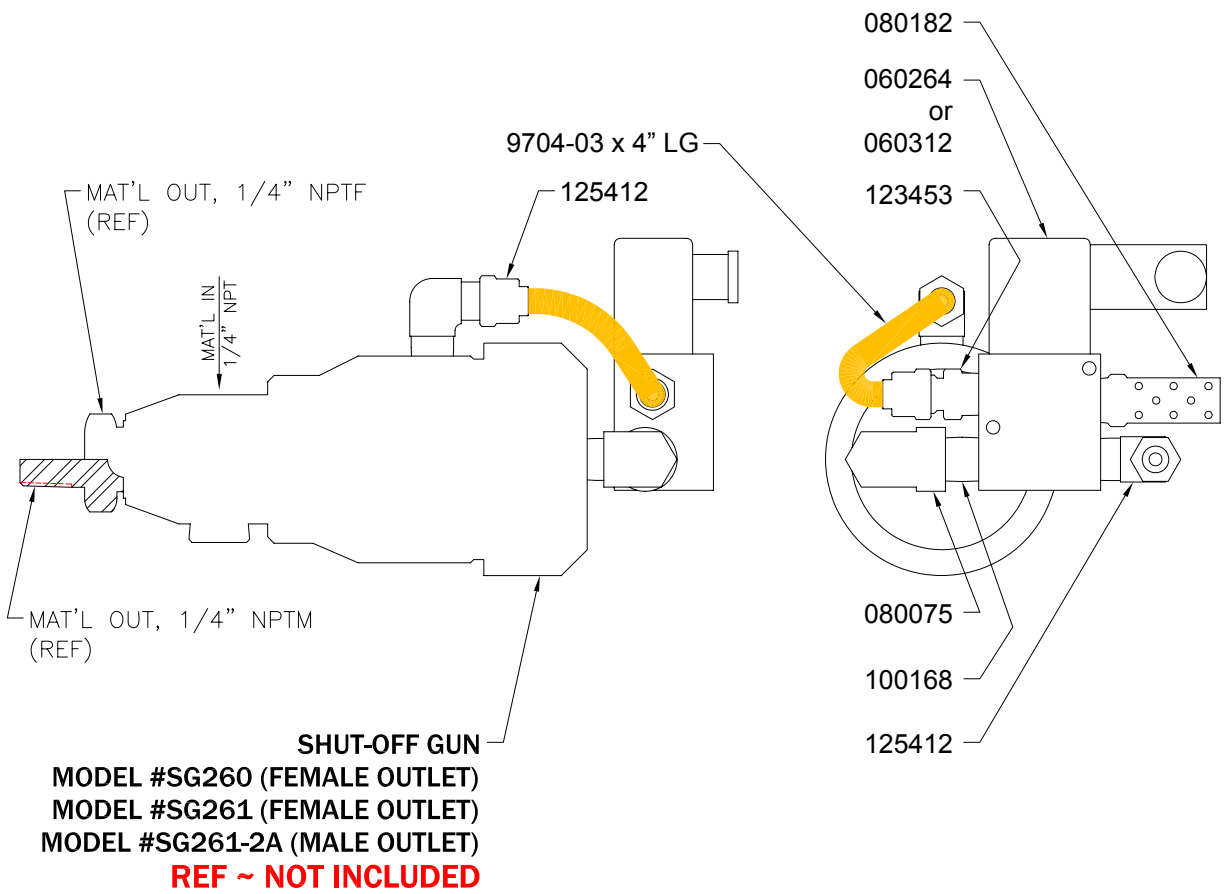
ADJUSTING SCREW. 24 thread/inch. Volume per screw turn = $.00115\text{in}^3$ or $.01884\text{cc}$. To set shot size, first remove air pressure then thread the adjusting screw into bottom (zero shot size). Back the adjusting screw out to desired shot size. Example - 0.1cc shot size, requires $0.1\text{cc}/0.01884\text{cc per turn} = 5.3$ turns.

REFILL (UPSTROKE)

- AIR MOVES THE PISTON AND METERING PIN UP.
- MATERIAL PRESSURE (25 to 100psi) OPENS THE INLET CHECK VALVE ALLOWING MATERIAL TO FILL THE VOLUME PREVIOUSLY OCCUPIED BY THE METERING PIN.
- THE INLET CHECK VALVE IS RE-SEATED BY THE INTERNAL SPRING.
- MATERIAL DOES NOT ESCAPE THROUGH THE OUTLET BECAUSE OVER 120psi IS REQUIRED TO UNSEAT THE RELIEF VALVE.

INJECT (DOWN STROKE)

- THE INLET CHECK VALVE IS ALREADY CLOSED.
- AIR MOVES PISTON AND METERING PIN DOWN.
- MATERIAL PRESSURE BUILDS IMMEDIATELY, OPENING THE RELIEF VALVE AND ALLOWING MATERIAL TO EXIT.



PARTS LIST

PART NO	DESCRIPTION	MODEL #	
		SK587	SK587-110VAC
060264	VALVE,DIRECT SOLENOID & REMOTE	X	
060312	VALVE,DIRECT SOLENOID, 110 VAC		X
080075	FITTING,ELBOW,STR.90, 1/8"NPT,CS	X	X
080182	FITTING,MUFFLER,1/8"NPTM,BRASS	X	X
100168	NIPPLE,CLOSE	X	X
125412	FITTING,ELBOW,MALE,SWIVEL	X	X
123453	FITTING,1/4TUBEX1/8NPT,M,NPB	X	X
9704-03	HOSE,TUBING,P.E.,.25,NATURAL	X	X

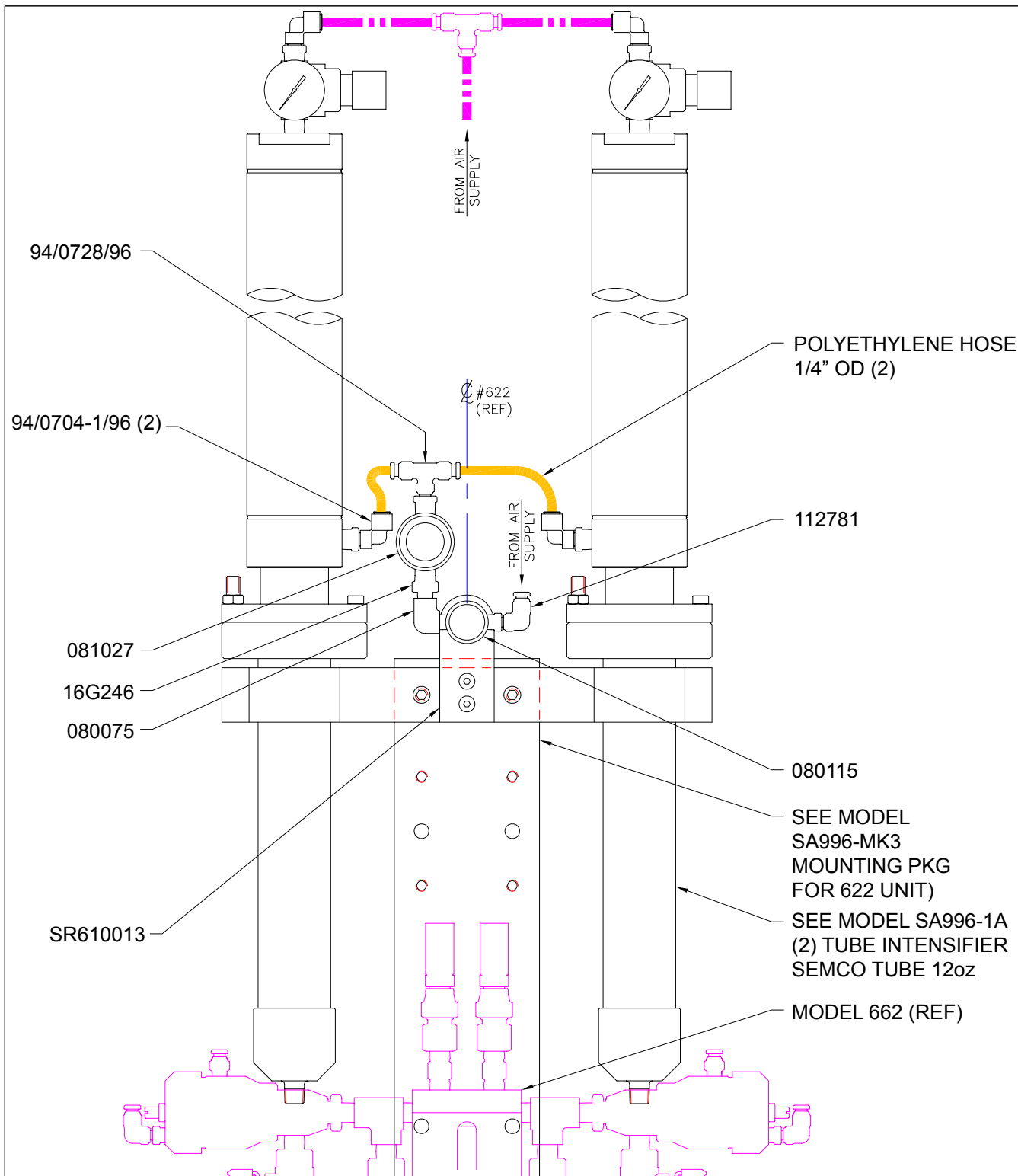


WIXOM, MI.

RELEASED: 11-6-08
 REVISED: 1-13-12

DESCRIPTION: MODEL # SEE NOTE (ASS'Y #SK587)
 SOLENOID VALVE & FTG PACKAGE FOR SHUT-OFF GUNS

MANUAL#:SK58701M



PARTS LIST (MODEL SK572)

PART NO	DESCRIPTION
080075	FITTING, ELBOW, STR, 90, 1/8" NPT, CS
080115	VALVE, AIR, 3W, 1/8" NPTF, PB ACT
081027	REGULATOR, MINI, 0-60 PSI, 1/4 NPTF
112781	ELBOW, SWIVEL, 90 DEG
16G246	FITTING, 1/4 NPT X 1/8 NPT
94/0704-1/96	FITTING, ELBOW, SWVL, 1/4 TUBEX 1/4 NPT
94/0728/96	FITTING, TEE, BRANCH, 1/4 TUBEX 1/4 NPT
SR610013	BRACKET, PUSH BUTTON
SA996-1A	TUBE INTENSIFIER, SEMCO TUBE 12oz
SA996-MK3	FRAME MOUNTING KIT, TUBE INTENSIFIER, SEMCO TUBE 12oz



WIXOM, MI.

RELEASED: 4-10-08

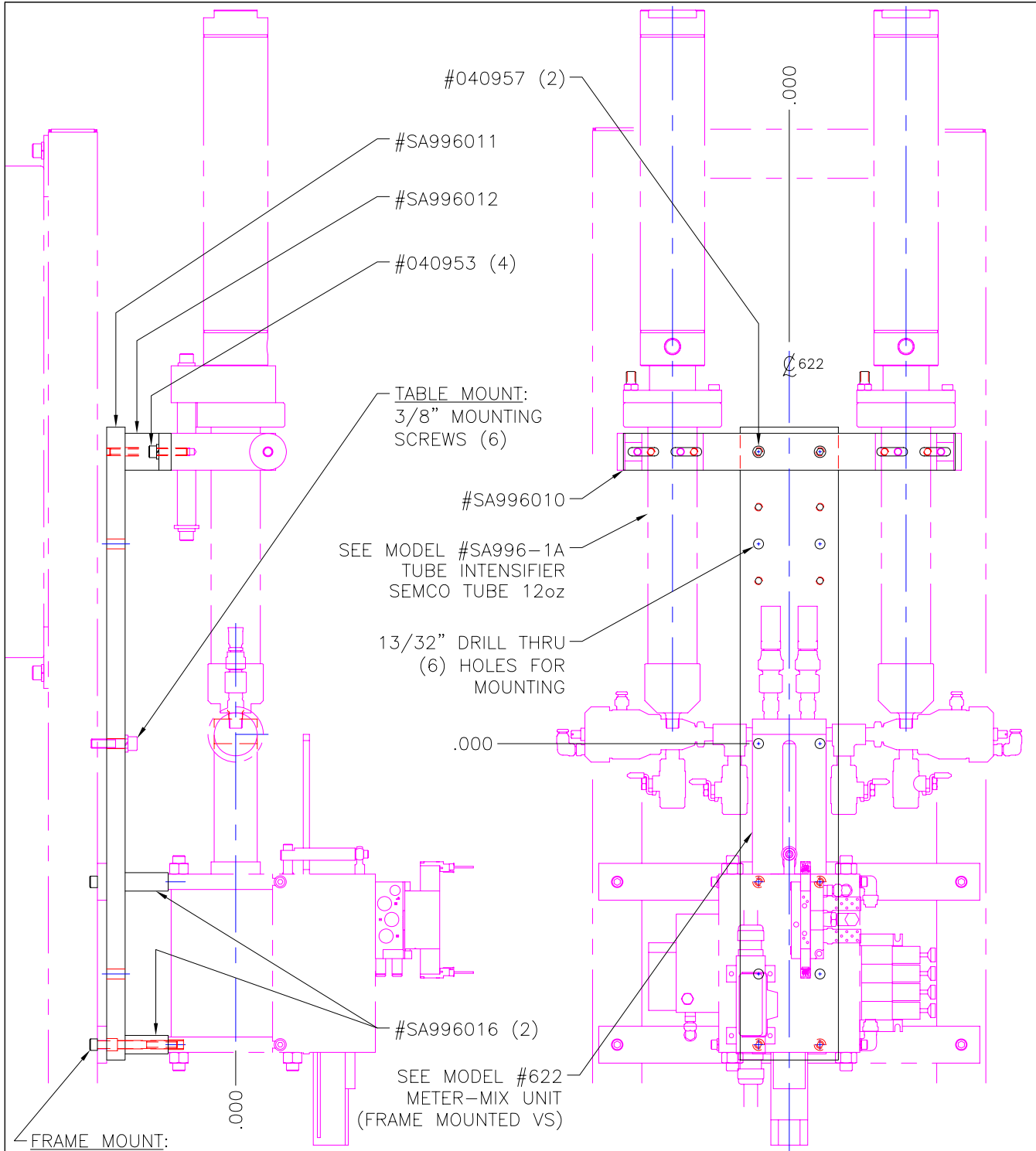
REVISED: ~

DESCRIPTION:

MODEL #SK572 (ASS'Y #SK572)

DUAL 12oz TUBE INTENSIFIER & MTG KIT, AIR PREP & BLOW OFF SWITCH FOR #622 UNIT

MANUAL#: SK57201M



- FRAME MOUNT:
 #040938: 5/16-18 x 3 1/4" LG S.H.C.S. (4)
 NO FRAME MOUNT:
 #040888: 5/16-18 x 2 3/4" LG S.H.C.S. (4)

PARTS LIST (MODEL SA996-MK3)

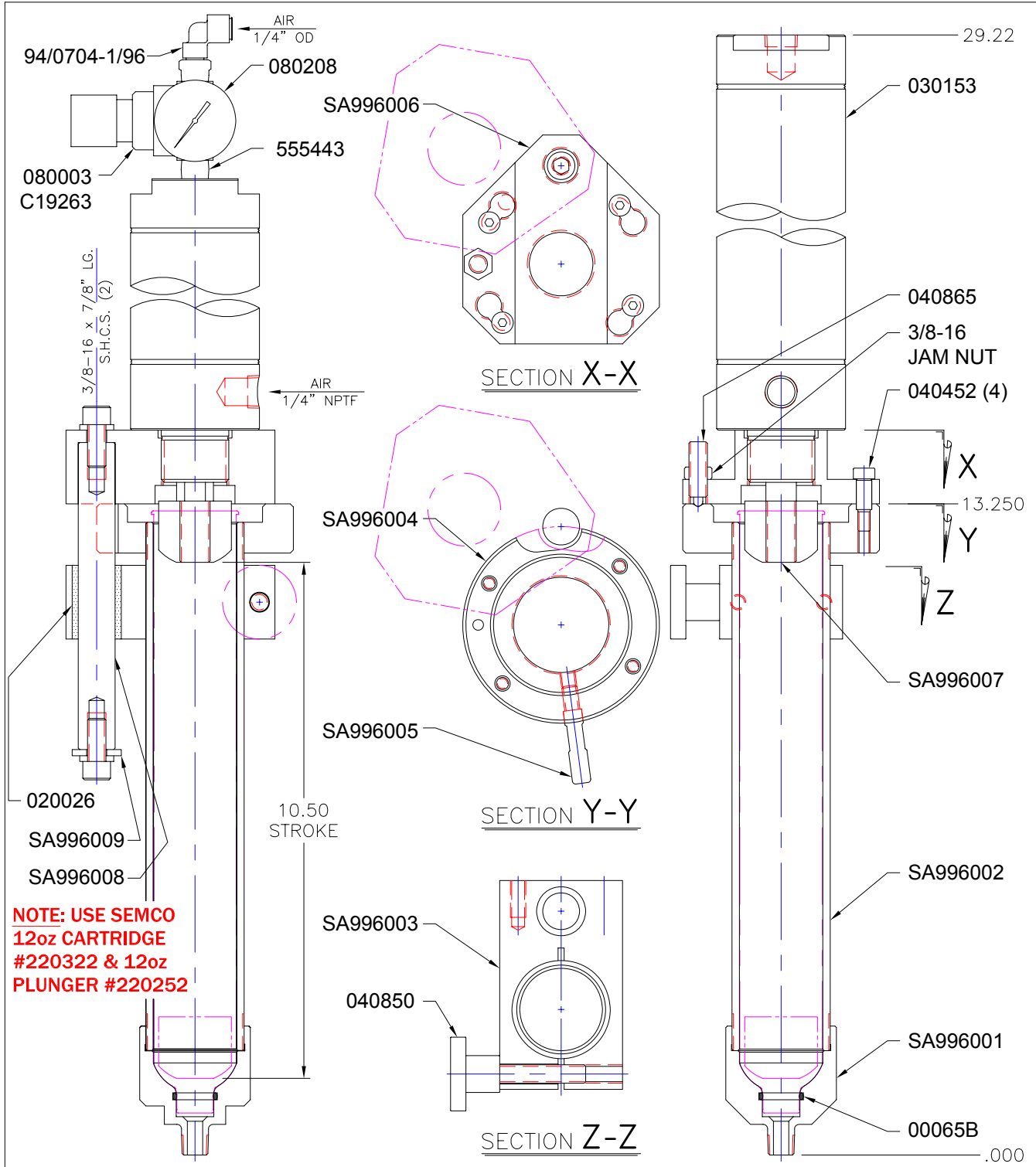
PART NO	DESCRIPTION (QTY)
040888	S.H.C.S., 5/16-18 x 2 3/4" LG (4) - NO FRAME MOUNT
040938	S.H.C.S., 5/16-18 x 3 1/4" LG (4) - FRAME MOUNT
040953	S.H.C.S., 5/16-18 x 1 1/4" LG (4)
040957	S.H.C.S., 5/16-18 x 2 1/2" LG (2)
SA996010	MTG BRACKET
SA996011	MTG PLATE
SA996012	SPACER (620 FRAME MNT - TUBE)
SA996016	SPACER (622 FRAME MNT - METER) (2)



WIXOM, MI.

RELEASED: 11-16-07
 REVISED: 4-4-08

DESCRIPTION: ACCESSORY MODEL #SA996-MK3 (ASS'Y #SA996)
 TUBE INTENSIFIER (MOUNTING PKG FOR 622)



**NOTE: USE SEMCO
12oz CARTRIDGE
#220322 & 12oz
PLUNGER #220252**

PARTS LIST (MODEL SA996-1A)

PART NO	DESCRIPTION	PART NO	DESCRIPTION
00065B	O-RING,BUNA,116,70A	SA996001	CAP
020026	BUSHING,3/4"IDX1"ODX1.5LG,SAE	SA996002	TUBE
030153	CYLINDER,AIR,2.5"BARX10.5STROKE	SA996003	MOUNTING BLOCK
040452	SHOULDER BOLT, 5/16X5/8LG	SA996004	CLAMP RING
040850	HAND KNOB	SA996005	SHAFT
040865	PLUNGER,SPRING,ROUND NOSE,3/8-16	SA996006	PIVOT MOUNT
080003	REGULATOR,AIR,0-100PSI,1/4" NPT	SA996007	PUSHER
080208	GAUGE,0-160PSI	SA996008	SHAFT
555443	COUPLER,1/4 PIPE .875 LG SST	SA996009	WASHER
94/0704-1/96	FITTING,EBLOW,SWVL,1/4TUBEX1/4NPT		
C19263	PLUG, PIPE		

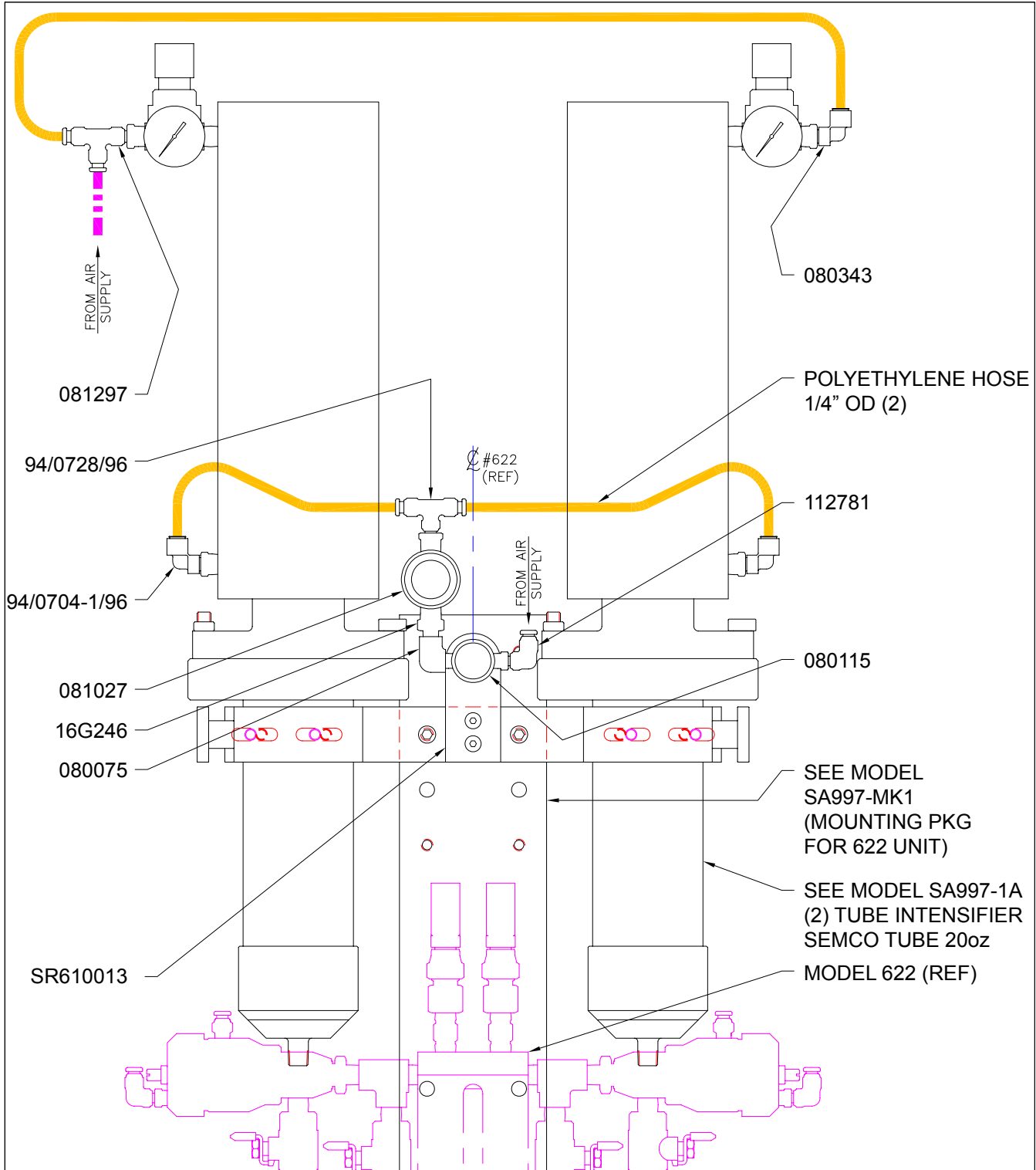


WIXOM, MI.

RELEASED: 4-11-06
REVISED: 5-12-11

DESCRIPTION: ACCESSORY MODEL #SA996-1A (ASSY #SA996)
TUBE INTENSIFIER ~ SEMCO TUBE 12oz

MANUAL#:SA99601M



PARTS LIST (MODEL SK573)

PART NO	DESCRIPTION
080075	FITTING,ELBOW,STR,90,1/8"NPT,CS
080115	VALVE,AIR,3W,1/8"NPTF,PB ACT
081027	REGULATOR,MINI,0-60PSI,1/4NPTF
081297	FITTING,SWIVEL,1/4NPTMX1/4OD HOSE
112781	ELBOW,SWIVEL,90 DEG
16G246	FITTING,1/4NPT X 1/4NPT
94/0728/96	FITTING,TEE,BRANCH,1/4TBEX1/4NPT
94/0704-1/96	FITTING,ELBOW,SWVL,1/4TUBEX1/4NPT
SR610013	BRACKET,PUSH BUTTON
SA997-1A	CARTRIDGE,TUBE,INTENSIFIER
SA997-MK1	KIT,MOUNTING,20OZ,INTENSIFIER

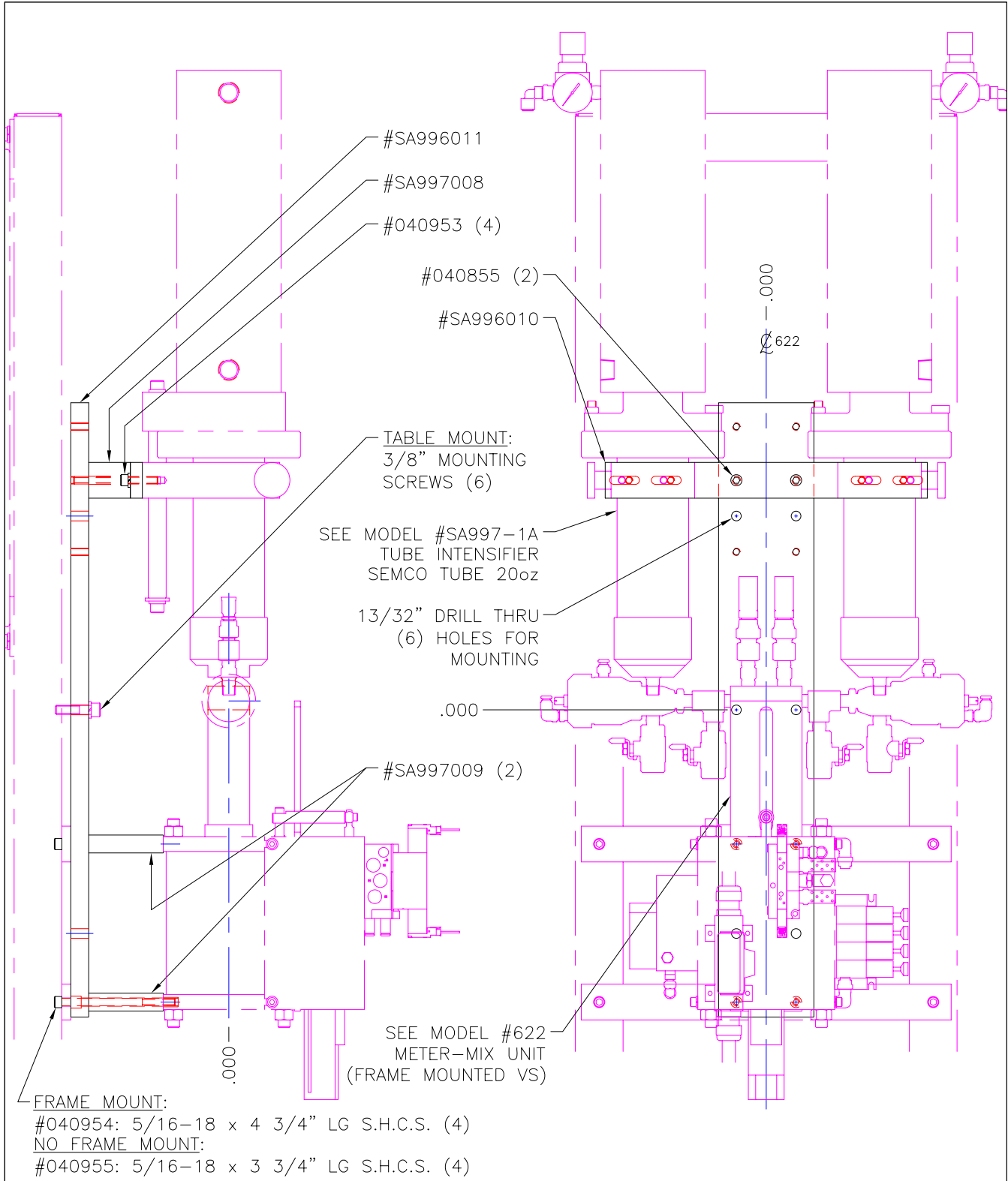


WIXOM, MI.

RELEASED: 4-10-08
 REVISED: ~

DESCRIPTION: MODEL #SK573 (ASS'Y #SK573)
 DUAL 20oz TUBE INTENSIFIER & MTG KIT, AIR PREP & BLOW OFF SWITCH FOR #622 UNIT

MANUAL#:SK57301M



FRAME MOUNT:
 #040954: 5/16-18 x 4 3/4" LG S.H.C.S. (4)
 NO FRAME MOUNT:
 #040955: 5/16-18 x 3 3/4" LG S.H.C.S. (4)

PARTS LIST (MODEL SA997-MK1)

PART NO	DESCRIPTION (QTY)
040855	S.H.C.S. ~ 5/16-18 x 3" LG (2)
040953	S.H.C.S. ~ 5/16-18 x 1 1/4" LG (4)
040954	S.H.C.S. ~ 5/16-18 x 5 1/2" LG (4) - FRAME MOUNT
040955	S.H.C.S. ~ 5/16-18 x 4 1/2" LG (4) - NO FRAME MOUNT
SA996010	MTG BRACKET
SA996011	MTG PLATE
SA997008	SPACER (622 FRAME MNT - TUBE)
SA997009	SPACER (622 FRAME MNT - METER) (2)



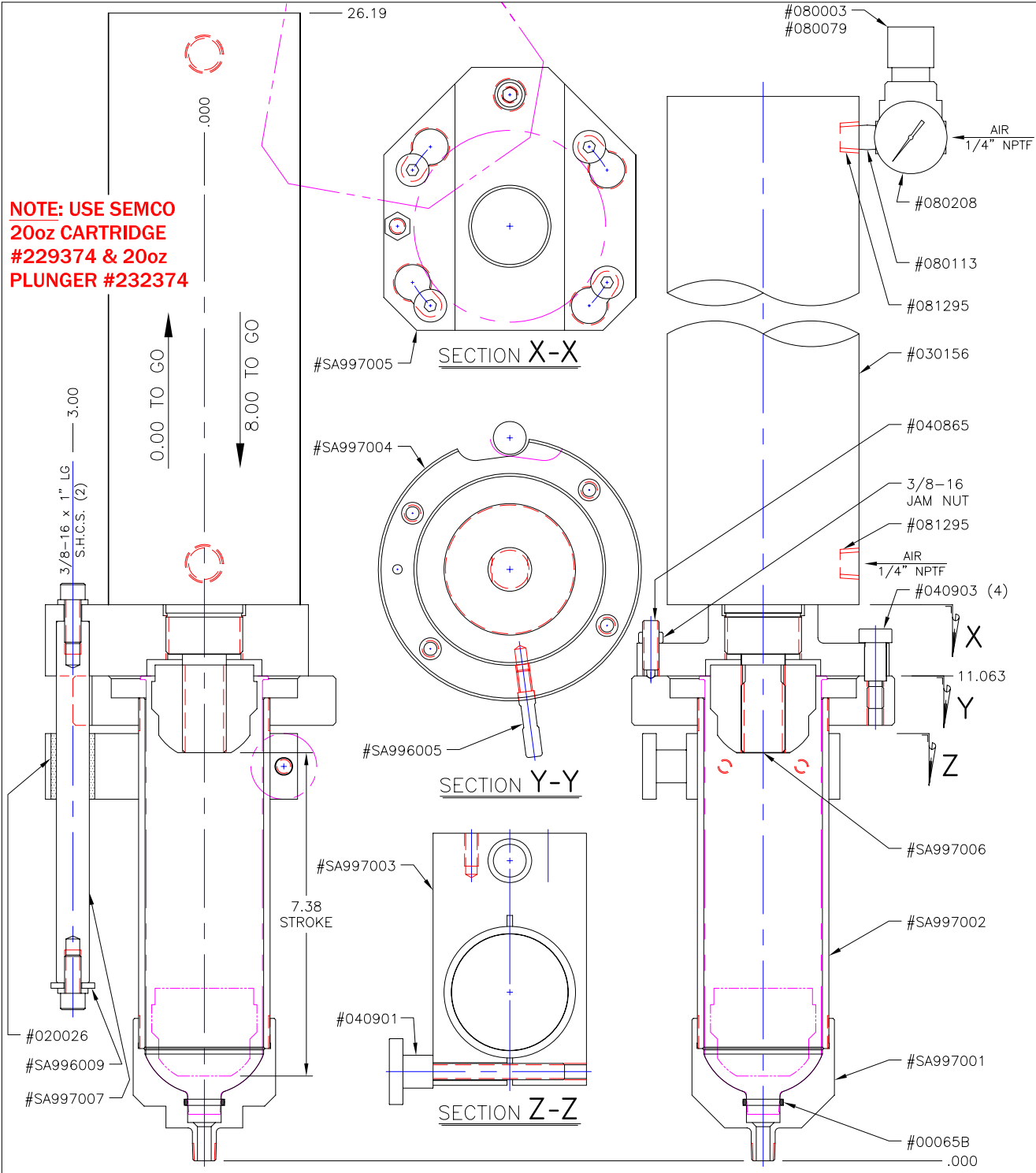
WIXOM, MI.

RELEASED: 4-10-08
 REVISED: ~

DESCRIPTION: ACCESSORY MODEL #SA997-MK1 (ASS'Y #SA997)
 TUBE INTENSIFIER (MOUNTING PKG FOR 622 ~ FRAME MOUNT STYLE)

MANUAL#: SA99702M

**NOTE: USE SEMCO
20oz CARTRIDGE
#229374 & 20oz
PLUNGER #232374**



PARTS LIST (MODEL SA997-1A)

PART NO DESCRIPTION (QTY)

00065B	"O" RING, 3/32" C/S, .750" ID ~ BUNA
020026	BRONZE BUSHING, 3/4" ID x 1" OD x 1 1/2" LG
030156	CYLINDER, AIR, 4" BORE x 8" STROKE ~ ALUMINUM
040865	SPRING PLUNGER, ROUND NOSE
040901	HAND KNOB
040903	SHOULDER BOLT, 1/2" DIA x 7/8" LG (4)
080003	PRESSURE REGULATOR, 0-100psi
080079	1/8" NPTM PIPE PLUG
080113	1/4" NPTM x 1/4" NPTM CLOSE NIPPLE
080208	GAUGE, 0-160psi
081295	1/2" NPTM x 1/4" NPTF BUSHING, FLUSH MOUNT (2)

PART NO DESCRIPTION (QTY)

SA996005	SHAFT
SA996009	WASHER
SA997001	CAP
SA997002	TUBE
SA997003	MOUNTING BLOCK
SA997004	CLAMP RING
SA997005	PIVOT MOUNT
SA997006	PUSHER
SA997007	SHAFT



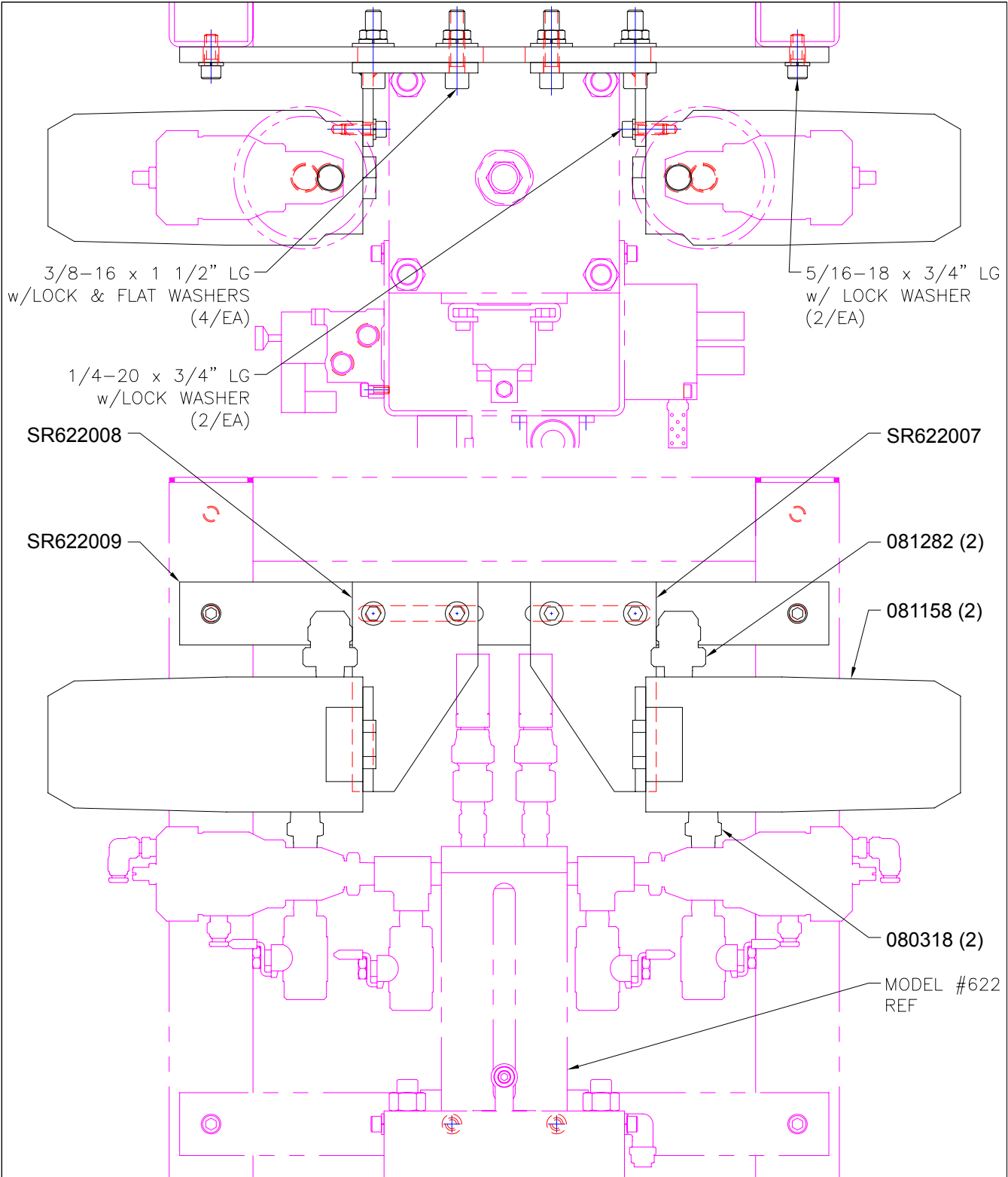
WIXOM, MI.

RELEASED: 3-5-07

REVISED: 4-10-08

DESCRIPTION:

ACCESSORY MODEL #SA997-1A (ASSY #SA997)
TUBE INTENSIFIER ~ SEMCO TUBE 20oz



PARTS LIST (MODEL #SK576)

PART NO	DESCRIPTION
081158	FLUID REGULATOR,1000-3000PSI,3/8"NPTF
081282	FITTING,3/4"JIC
113070	FITTING,NIPPLE,REDUCER,3/8-14
SR622007	BRACKET,REGULATOR,MATERIAL,LH,622
SR622008	BRACKET,REGULATOR,MATERIAL,RH,622
SR622009	STRAP



WIXOM, MI.

RELEASED: 5-21-08
REVISED: 3-27-12

DESCRIPTION:

MODEL #SK576 (ASS'Y #SK576)
PRESSURE REGULATOR KIT, INCLUDES MTG & FTGS ~ FOR FAI MODEL #622)

MANUAL#:SK57601M

OPERATOR'S MANUAL

INCLUDING: OPERATION, INSTALLATION & MAINTENANCE

84501X

RELEASED: 8-20-99

REVISED: 3-23-11

(REV. F)

HIGH PRESSURE MATERIAL REGULATOR



**READ THIS MANUAL CAREFULLY BEFORE INSTALLING,
OPERATING OR SERVICING THIS EQUIPMENT.**

It is the responsibility of the employer to place this information in the hands of the operator. Keep for future reference.

SERVICE KITS

Use only genuine Bink's replacement parts to assure compatible pressure rating and longest service life.

863001 valve kit for seat replacement on models 845012 (see page 4).
863005 valve kit for ball and seat replacement on models 845013 (see page 4).

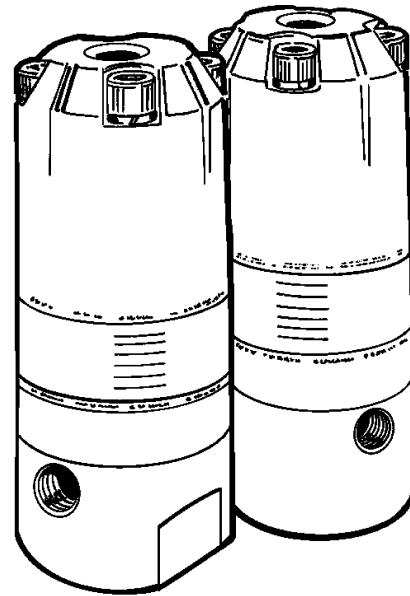
863007 valve kit for ball and seat replacement on models 845010, 845011 and 845014 (see page 4).

863008 diaphragm kit for replacement of diaphragms (see page 4).

863013 rebuild kit for general repair of the 845010, 845011 and 845014 regulators. This includes an 863008 diaphragm kit and an 863007 valve kit.

863014 rebuild kit for general repair of the 845012 regulators. This includes an 863008 diaphragm kit and an 863001 valve kit.

863015 rebuild kit for general repair of the 845013 regulators. This includes an 863008 diaphragm kit and an 863005 valve kit.



SPECIFICATIONS

Model Series	84501X
Type	
845010, 845011, 845013, 845014 ..	Downstream
845012	Back Pressure
Body Material	
845010, 845011, 845012, 845013 ..	300 series Stainless Steel
845014	Carbon Steel
Seat Material	Tungsten Carbide
Ball Size	
845010, 845011, 845014	0.1875" dia.
845012, 845013	0.2500" dia.
Material Inlet / Outlet	3/8 - 18 N.P.T.F.
Dimensional Data	See page 7

PERFORMANCE DATA

Regulated Pressure Range with Maximum Regulated Pressure	
845010, 845014	400 - 1250 p.s.i. (27.6 - 86.2 bar)
845011	1000 - 3000 p.s.i. (69 - 206.9 bar)
845012	100 - 3000 p.s.i. (6.9 - 206.9 bar)
845013	2000-5000 p.s.i. (137.9-344.8 bar)
Maximum Inlet Pressure	
845010, 845012, 845014	3000 p.s.i. (206.9 bar)
845011, 845013	6000 p.s.i. (413.8 bar)
Maximum Temperature Limits	0° to 200° F (-18° to 93° C)

BINKS®

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International Office
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Dorset, BH11 9LH, England
Tel. 0 1202 571111 Fax 0 1202 593863

OPERATING AND SAFETY PRECAUTIONS



- ▲ Read and heed all Warnings and Safety Precautions before operation of this unit.
- ▲ Use only genuine Bink's replacement parts to assure compatible pressure rating and longest service life.
- ▲ Be certain anyone operating this equipment or fluid system has been trained to use it safely.

⚠ WARNING HIGH PRESSURE DEVICE. IMPROPER USAGE OF THIS EQUIPMENT COULD RESULT IN SERIOUS INJURY. The possibility of injection into the flesh is a potential hazard. Wear approved safety glasses or face shield and other equipment as needed to prevent injury. Never allow any part of the human body to come in front of or in contact with the material outlet, the tip, or the material outlet of the dispensing device. An injection injury can be serious. If an injection accident should occur, it is very important that you contact a qualified physician for immediate treatment.

⚠ WARNING MISAPPLICATION HAZARD. DO NOT USE THE REGULATOR WHEN THE FLUID INLET PRESSURE IS TOO HIGH FOR THE DESIGNED OPERATING RANGE. Excessive inlet pressure can cause a Lock-Out situation. Lock-Out occurs when the inlet pressure is beyond the regulator's spring capacity. THE VALVE WILL NOT OPEN. Attempts to disassemble components while in a Lock-Out condition may result in injury.

⚠ WARNING COMPONENT RUPTURE. DO NOT OPERATE REGULATOR AT AN INLET PRESSURE GREATER THAN SPECIFIED. To avoid possible damage or personal injury, DO NOT operate this unit at pressure higher than the stated operating range as it appears on the model plate.

⚠ WARNING DISASSEMBLY HAZARD. DO NOT DISASSEMBLE THIS REGULATOR WHEN IT IS UNDER PRESSURE. RELIEVE PRESSURE IN THE PUMPING SYSTEM BEFORE ATTEMPTING SERVICE OR DISASSEMBLY PROCEDURES. Disconnect air lines and carefully bleed pressure off the system. Be certain the system is not maintaining pressure due to a material restriction in the hose, line, dispensing device, or the spray or extrusion tip. Failure to relieve pressure both up stream and downstream may result in an injury upon disassembly.

⚠ WARNING BONNET REMOVAL HAZARD. DO NOT ATTEMPT TO REMOVE THE FOUR BONNET RETAINING BOLTS WITHOUT FIRST RELIEVING THE TENSION ON THE MAIN SPRING. Failure to relieve tension could result in an accident upon disassembly.

⚠ WARNING PREVENT FIRES. KEEP SOLVENTS AWAY FROM HEAT, SPARKS OR OPEN FLAME. Keep containers closed when not in use. When pumping, flushing or recirculating volatile solvents, be certain the area is adequately ventilated.

⚠ CAUTION FLUSH SUPPLY LINE. Before installing fluid regulator blow the supply lines clear and flush to remove contaminants.

INSTALLATION

- Refer to the typical installation view which best applies.
- Locate the regulator as close as possible to the spray gun or dispensing device for best pressure control.
- Identify the regulator INLET / OUTLET (flow direction). The regulator

- is marked with an arrow on the body base (refer to figure 7, page 7).
- When flexible fluid lines are used, mount the regulator securely using the (2) 1/4" - 20 threaded holes in the base (see figure 7, page 7).
- Flush supply line before installing regulator.

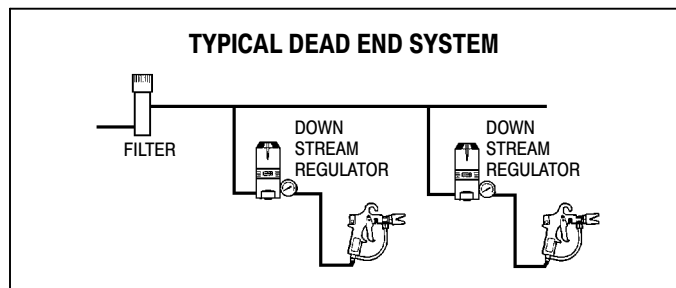
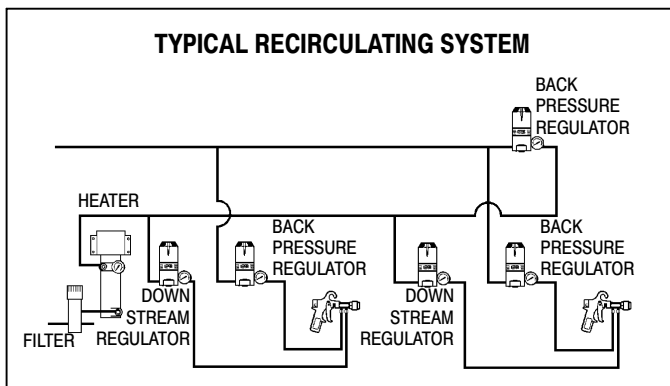


FIGURE 1

OPERATING INSTRUCTIONS

Refer to pages 4 and 5 for parts reference.

- To **INCREASE** outlet pressure, turn the (6) adjusting screw **CLOCKWISE** (see figure 2).
- To **DECREASE** outlet pressure, turn the (6) adjusting screw **COUNTERCLOCKWISE** (see figure 2).

NOTE: (20) 3/8" Allen wrench is included to make necessary pressure adjustments.

FLUSH-OUT FEATURE FOR DOWNSTREAM MODELS ONLY (see figure 3).

- Flush the regulator periodically. The interval may vary depending on the amount and type of material used.
- By using a wrench and "flush-out" plug (provided), the operator is able to move the entire spindle downward and force the ball off the seat, which should purge the regulator of particle build-up.

NOTE: The flush-out procedure temporarily overrides the adjusted pressure. It will not, however, affect the regulator setting when flushing operation is completed.

FLUSH-OUT PROCEDURE

1. Remove spray gun or dispensing device, this will allow any particles to clear from the system.
2. Insert (21) flush-out plug and turn clockwise until it touches the (4) washer (see view on page 5).
3. Turn up to two turns maximum. This will allow the ball to unseat and pass material at free flow (unregulated). **DO NOT** attempt to turn further to avoid damage.
4. Turn the plug back to its original position.

SEAT PLUG FEATURE

The (47) plug located at the base of the regulator can be removed for access to the ball and seat assembly for cleaning and inspection for wear. With this feature the regulator does not have to be unthreaded from the pumping system. Be certain to relieve system pressure (See "WARNING: DISASSEMBLY HAZARD").

MAINTENANCE

- Disassembly should be done on a clean work bench and use clean cloths.
- If replacement parts are necessary, refer to the parts list and drawings on pages 4 and 5.
- Upon reassembly, lubricate parts and use Loctite where indicated. Follow the torque specifications as shown.
- Service kits are available which include parts typically needed for an overhaul.
- Keep good records of service activity and include the regulator in a preventive maintenance program.

VIEW OF SPRING ADJUSTMENT PROCEDURE.

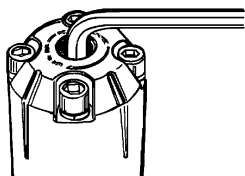


FIGURE 2

VIEW OF FLUSH-OUT PLUG

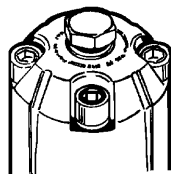


FIGURE 3

TROUBLE SHOOTING

No fluid pressure.

- Check for damaged or worn diaphragms.
- Look for possible obstruction by hardened material or foreign matter, periodically use the regulator "flush-out" feature (downstream models only). Use a Fluid Filter upstream from the regulator.

Pressure creeps above the setting when system is dead ended and in a static (no flow) mode.

- Check for dirty seat and clean as appropriate.
- Check for worn or damaged seat and replace if necessary.

Outlet pressure drops below setting.

- Check pump for proper operation and check for possible leakage problems.
- Look for a clogged supply line problem, flush the supply line.

Fluid leakage from spring housing.

- Check the bonnet hold-down screws and the plate hold down screws and re-torque as needed.
- Check for damaged diaphragm, replace as needed.

Regulator will not function, even when dispensing device is opened.

- Check for possible obstruction in the fluid line.
- Inlet pressure is too high causing a "Lock-Out" situation. Read "WARNING: MISAPPLICATION HAZARD" found on page 2.

TYPICAL DOWNSTREAM REGULATOR CROSS SECTION VIEW SHOWING MAJOR COMPONENTS

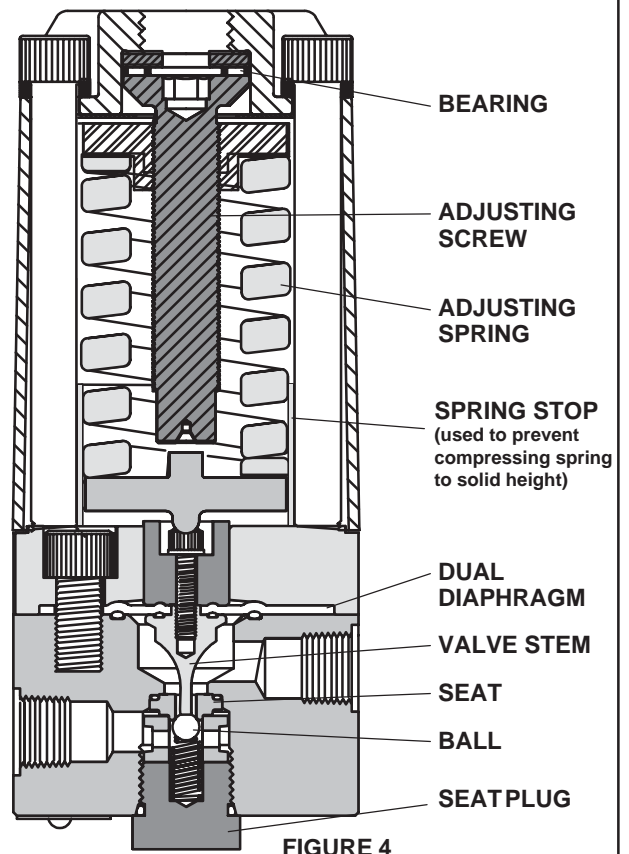


FIGURE 4

PARTS LIST / 84501X REGULATOR

863001 Valve Kits include: (for models 845012)	Item #	41	42								
	Qty	1	1								
863005 Valve Kits include: (for models 845013)	Item #	41	42	43	44						
	Qty	1	1	1	1						
863007 Valve Kits include: (for models 845010, 845011 and 845014)	Item #	41	42	43	44						
	Qty	1	1	1	1						
863008 Diaphragm Repair Kits include: (for all models)	Item #	16	17	18	19					Operator's Manual	
	Qty	1	1	1	1					1	
863013 Rebuild Kits include: (for models 845010, 845011 and 845014)	Item #	16	17	18	19	41	42	43	44	Operator's Manual	
	Qty	1	1	1	1	1	1	1	1	1	
863014 Rebuild Kits include: (for models 845012)	Item #	16	17	18	19	40	41	42			Operator's Manual
	Qty	1	1	1	1	1	1	1			1
863015 Rebuild Kits include: (for models 845013)	Item #	16	17	18	19	41	42	43	44	Operator's Manual	
	Qty	1	1	1	1	1	1	1	1	1	

84501X COMMON PARTS

ITEM	DESCRIPTION (Size in inches)	Qty	Part No.	Mtl	ITEM	DESCRIPTION (Size in inches)	Qty	Part No.	Mtl
1	Housing	(1)		[A]	17	Diaphragm (.020" thick, white)	(1)		[T]
2	Bolt (7/16" - 20 x 5-1/2")	(4)		[C]	18	"O" Ring (3/32" x 1-3/8" o.d.)	(1)		[T]
3	Washer (7/16" i.d.)	(4)		[C]	19	"O" Ring (1/16" x 9/16" o.d.)	(1)		[T]
4	Washer (1.162" o.d. x .125" thick)	(1)		[C]	⊗ 20	3/8" Allen Wrench (not shown)	(1)		[C]
5	Thrust Bearing (1.173" o.d.)	(1)	873330	[C]	⊗ 21	Flush-Out Plug (not shown)	(1)		[C]
6	Adjusting Screw (5/8" - 24, left hand)	(1)	873331	[C]	22	Spring Stop	(1)	873563	[SS]
7	Plate	(1)		[SS]	40	Valve Stem 845010, 845011, 845013, 845014	(1)	873052	[TC/SS]
8	Adjusting Nut	(1)	873332	[C]		845012	(1)	873057	[TC/SS]
9	Spring				41	"O" Ring (1/16" x 5/8" o.d.)	(1)		[T]
	845010, 845014 (green) 100 - 1250 in. lbs	(1)	873050	[C]	42	Seat	(1)		[TC]
	845011, 845012 (red) 1000 - 3000 in. lbs	(1)	873051	[C]	43	Ball 845010, 845011, 845014 (.1875" dia.)	(1)		[TC]
	845013 (yellow) 2000 - 5000 in. lbs	(1)	873053	[C]		845013 (.2500" dia.)	(1)		[TC]
10	Cap Screw (#10 - 32 x 7/8")	(1)		[C]	44	Spring	(1)		[SS]
11	Lock Washer (.196" i.d.)	(1)		[C]	45	Flow Tube	(1)	873045	[SS]
12	Small Plate	(1)		[C]	46	"O" Ring (3/16" x 15/16" o.d.)	(1)		[T]
13	Piston	(1)		[C]	47	Seat Plug Assembly (includes item 46)	(1)	863002	[SS]
14	Cap Screw (7/16" - 20 x 7/8")	(2)		[C]	48	Base 845010, 845011, 845012, 845013	(1)		[SS]
15	Plate	(1)		[C]		845014	(1)		[C]
16	Diaphragm (.048" thick, cream)	(1)		[H]					

⊗ Except models 845012.

PARTS LIST / 84501X REGULATOR

TORQUE REQUIREMENTS

NOTE: DO NOT OVERTIGHTEN FASTENERS.

(2) Torque alternately.

1.) Snug.

2.) 20 - 25 ft lbs (27.1 - 33.9 Nm).

(10) 65 - 75 in. lbs (7.3 - 8.5 Nm).

(14) Torque alternately.

1.) Snug.

2.) 20 - 25 ft lbs (27.1 - 33.9 Nm).

3.) 50 - 55 ft lbs (67.8 - 74.6 Nm).

LUBRICATION - SEALANTS

1 Apply Dri-Slide upon assembly.

2 Apply Loctite nickel anti-seize to threads.

3 Apply clutch grease.

4 Apply Loctite 242 to threads.

MATERIAL CODE

[A] = Aluminum

[C] = Carbon Steel

[H] = TPE

[SS] = Stainless Steel

[T] = PTFE

[TC] = Tungsten Carbide

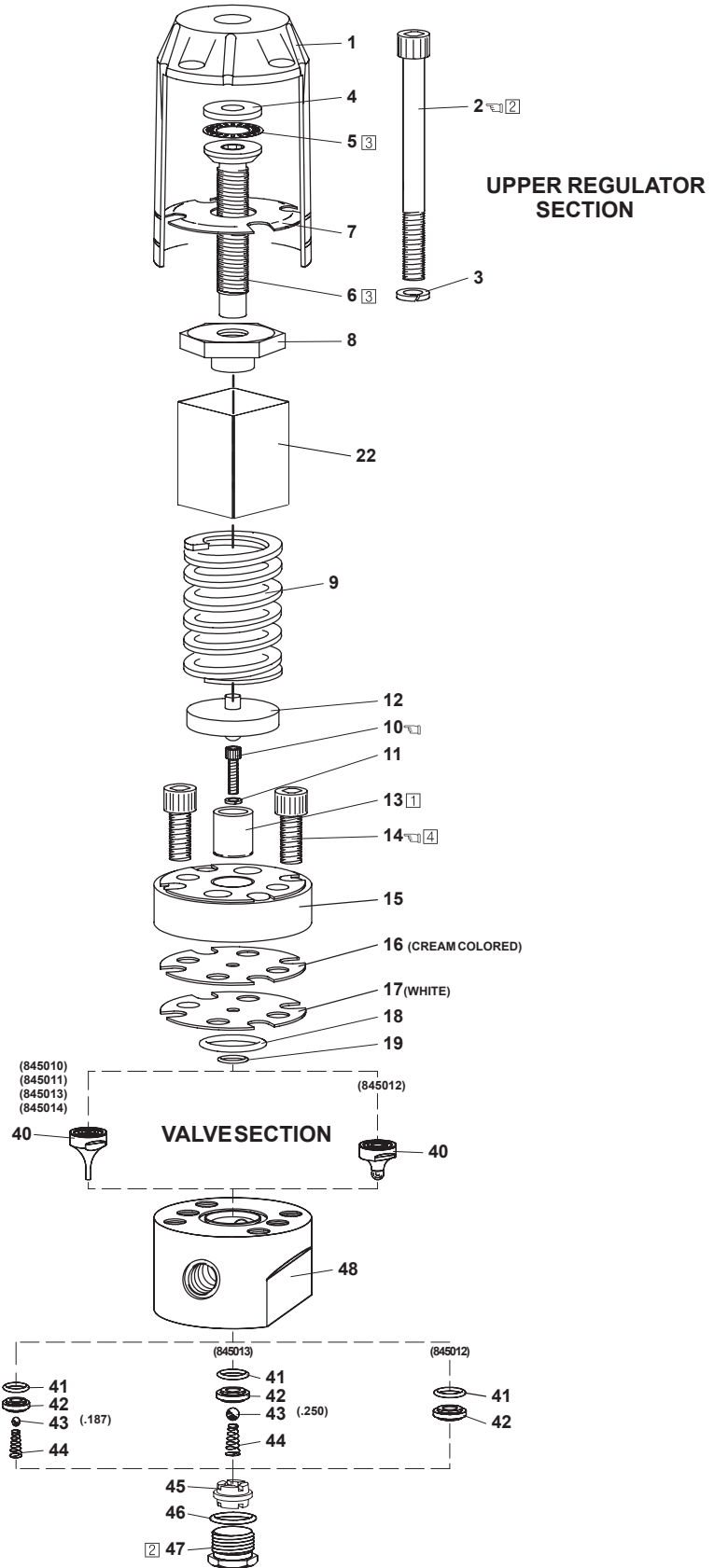


FIGURE 5

REGULATOR DISASSEMBLY

REFER TO PAGES 4 AND 5.

FOR "WARNINGS", REFER TO "OPERATING AND SAFETY PRECAUTIONS" ON PAGE 2 FOR DETAILS.

BEFORE SERVICING, READ "WARNING: DISASSEMBLY HAZARD." FOUND ON PAGE 2.

TOOLS REQUIRED: Small bench vise, 3/8" allen wrench (included), 5/32 allen wrench, torque wrench and Loctite 242.

NOTE: It is not always necessary to remove the regulator from the fluid line to service or inspect only the valve section.

BEFORE DOING ANY IN-LINE SERVICE, ALL FLUID PRESSURE MUST BE RELIEVED. HEED ALL WARNINGS FOUND ON PAGE 2.

ALLEN WRENCH NOTE: The 3/8" allen wrench is included and can be used for several functions including: Regulator adjustment (spring type models), removal and assembly of the long bonnet bolts and the short plate bolts.

VALVE SEAT NOTE: Before deciding to order a general repair kit to service the whole regulator, check the easiest things first. Remove and inspect the valve seat for dirt, foreign matter, damage or wear (steps 1 - 3).

DOWNSTREAM STYLE MODELS

1. Remove the (46 / 47) base plug / "O" ring assembly which will allow removal of the (44) spring, (43) ball, (45) flow tube, (42) seat and (41) "O" ring.

BACK PRESSURE STYLE MODELS

2. Remove the (46 / 47) base plug / "O" ring assembly which will allow the removal of the (45) flow tube, (42) seat and (41) "O" ring.
3. Inspect the (42) seat for dirt, damage or wear.

READ "WARNING: BONNET REMOVAL HAZARD" FOUND ON PAGE 2.

4. Remove the four (2) long bolts to allow removal of the Bonnet / Adjusting Screw Assembly.

NOTE: The (6) adjusting screw, (5) thrust bearing and (4) washer are retained by (7) plate which is pressed into place. It should not be necessary to disassemble these parts during normal service.

5. Remove the (9) regulator spring and (12) small plate.
6. Remove the (14) bolts.
7. Remove the (15) plate.
8. Remove the stem / diaphragm and piston assembly.
9. Place the stem in a vise, locate and secure on the stem flats provided.
10. Using a 5/32" hex allen wrench, remove the (10) screw.
11. Remove the (11) lockwasher, (13) piston, two (16, 17) diaphragms, (18, 19) "O" rings, from the (40) valve stem.

REGULATOR REASSEMBLY

Also refer to parts list and views on pages 4 and 5.

1. Place the (40) stem in a vise. Use the flats provided.
2. Position the (19) "O" ring in the groove.
3. Place the (17) white diaphragm onto the (40) stem center.
4. Place the (16) cream colored diaphragm onto the (40) stem.
5. Place the (13) piston on the assembly.
6. Install the (11) lockwasher and the (10) screw. **NOTE:** Make certain the diaphragm holes are in alignment before tightening the (10) screw. Torque to 65 - 75 in. lbs (7.34 - 8.47 Nm).

SERVICE HINT: Use the (14) screw to help align the diaphragm holes.

7. Remove the diaphragm / piston / stem assembly from the vise.

UPPER REGULATOR BODY SECTION REASSEMBLY

☆ **NOTE:** (from page 4 parts list) If the (1) housing has been removed and disassembled, the (7) plate should be replaced.

8. Place the (48) base in a vise, using the flats.
9. Place the (15) plate over the diaphragm / piston / stem assembly.

10. Apply Loctite 242 to the (14) screw.

11. Install the (14) screws.

NOTE: Tighten the short bolts alternately and evenly.

- Tighten snug.
 - Tighten to 20 - 25 ft lbs (27.1 - 33.9 Nm).
 - Tighten to 50 - 55 ft lbs (67.8 - 74.6 Nm).
12. Place the (12) plate (ball side down) into the hex of the (10) screw.
 13. Place the (9) spring on top of the (12) plate.
 14. Place the bonnet / adjusting screw assembly over the spring.
 15. Retain the bonnet with the (3) lockwashers and (2) bolts. Tighten alternately until snug, then torque to 20 - 25 ft lbs (27.1 - 33.9 Nm).
 16. Place the (18) "O" ring into the groove.
 17. Apply "DRI-SLIDE" to the surface of the (13) piston.
 18. Install the diaphragm / piston / stem assembly and align with the base hole pattern.
 19. Turn the regulator over and vise on flats.

REGULATOR VALVE SECTION REASSEMBLY

DOWNSTREAM MODELS

- Install (41) "O" ring.
- Install (42) seat.
- Install the (45) flow tube.
- Install the (43) ball.
- Install the (44) spring with the narrow end against the ball.
- Install the (47) valve plug and "O" ring assembly.
- Tighten until snug.

BACK PRESSURE MODELS

- Install (41) "O" ring.
- Install (42) seat.
- Install the (45) flow tube.
- Install the (47) valve plug and "O" ring assembly.
- Tighten until snug.

PERFORMANCE DATA

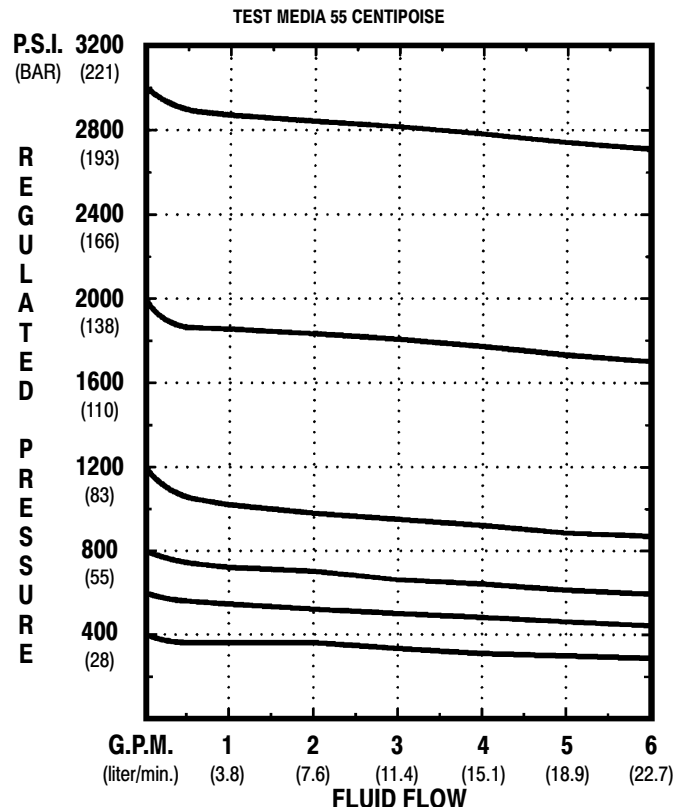
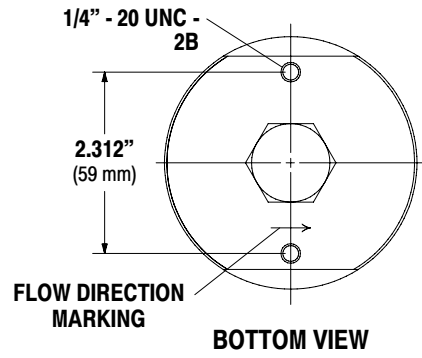
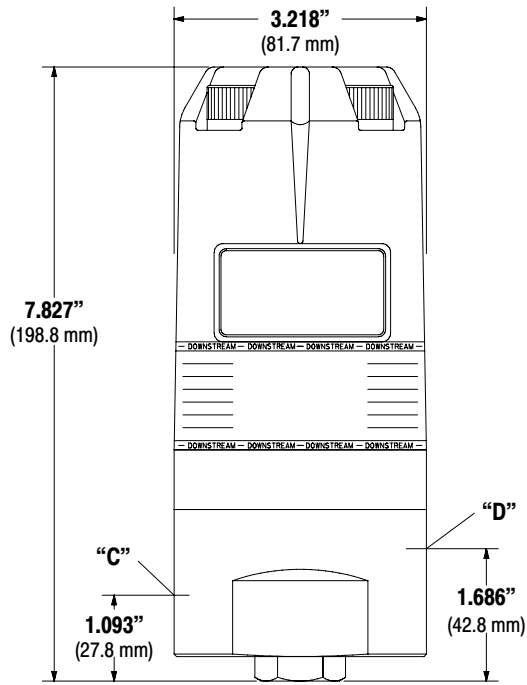


FIGURE 6

SERVICE NOTE: "DRI-SLIDE", FXR is a commercially available Anti-Rust lubricant (contains 9% Molybdenum Disulfide) or Molybdenum Disulfide Powder with or without light oil carrier.

DIMENSIONAL DATA



"C" and "D" thread = 3/8 - 18 N.P.T.F.

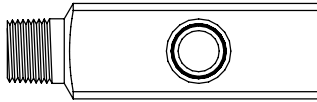
NOTE:

- 845010, 845011, 845013 and 845014 (downstream models) "C" is the **INLET** port, "D" is the **OUTLET** port.
- 845012 (back pressure models) "D" is the **INLET** port, "C" is the **OUTLET** port.

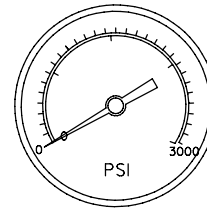
FIGURE 7

OPTIONAL ACCESSORIES

GAUGE AND AUXILIARY PORT

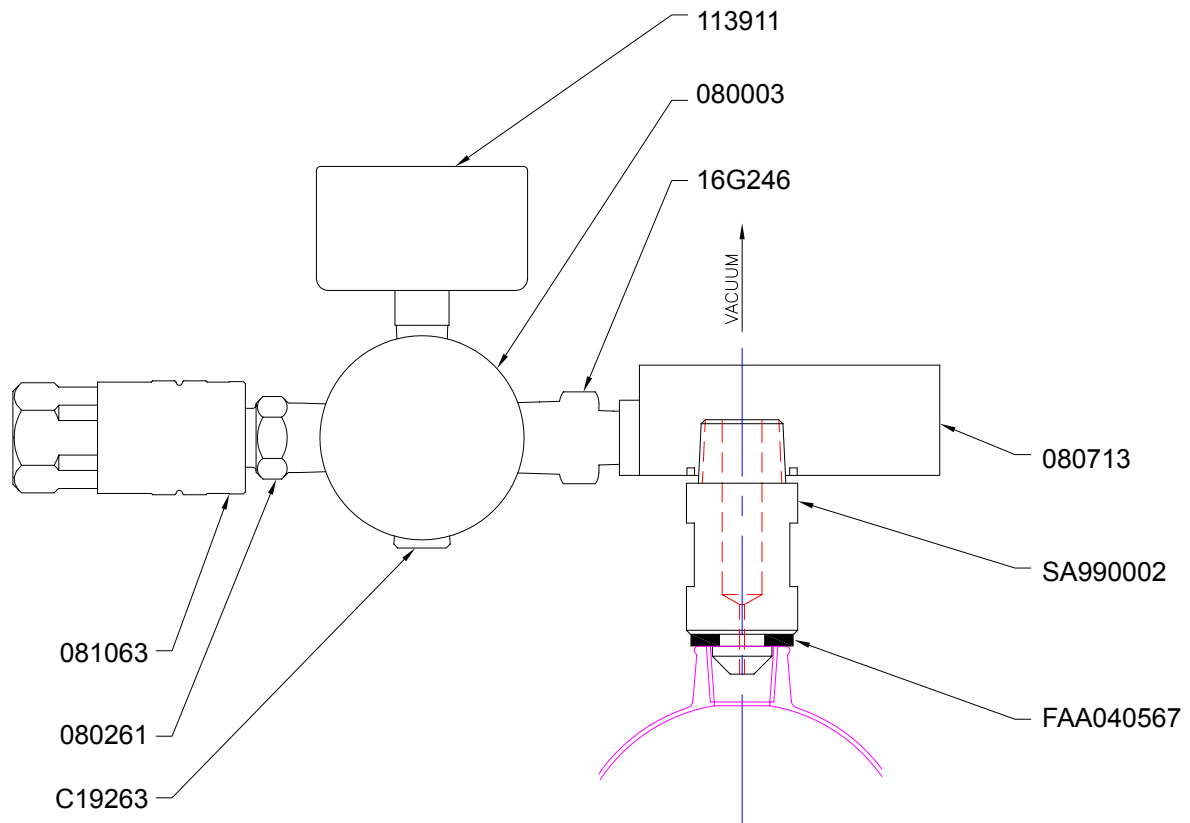


873056 Outlet Adapter
3/8 - 18 N.P.T.F. - 1



Rear Mount Gauge

- | | | |
|--------|-----------------|-----------------|
| 873054 | 0 - 5000 p.s.i. | Stainless Steel |
| 873055 | 0 - 3000 p.s.i. | Stainless Steel |



PARTS LIST

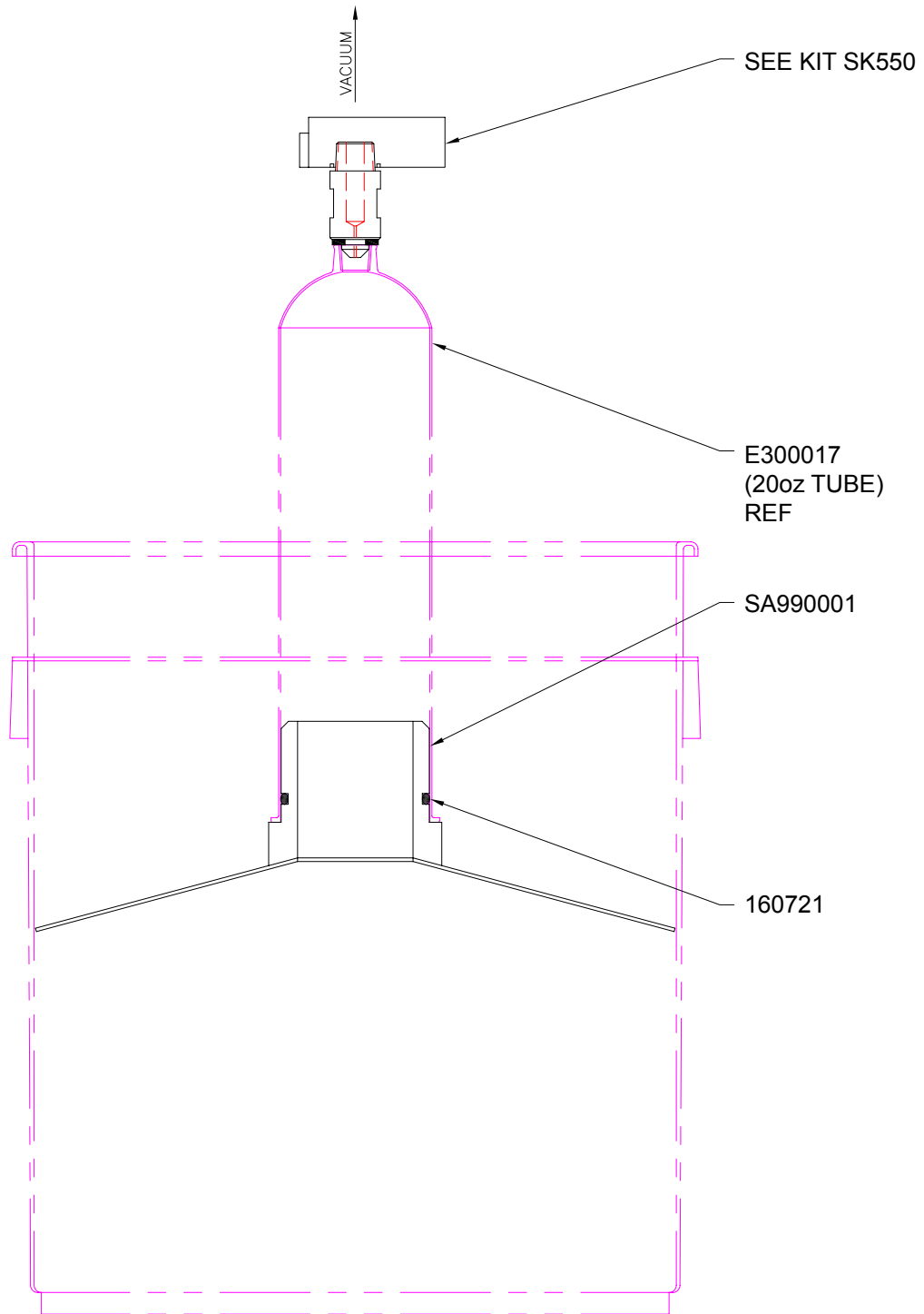
PART NO.	DESCRIPTION
080003	REGULATOR,AIR,0-100PSI,1/4" NPT
080261	FITTING,1/4" NPTMX1/4BODY QC
080713	PUMP,VACUUM,3/8"NPSMX10L
081063	FITTING,1/4"NPTFX1/4"QC
113991	GAUGE,PRESSURE,AIR
16G246	FITTING,1/4NPT X 1/8NPT
C19263	PLUG,PIPE
FAA040567	WASHER,SEALING,3/8" SCREW
SA990002	ADAPTER



RELEASED: 12-22-04
REVISED:

DESCRIPTION:

KIT MODEL #SK550 (ASS'Y #SK550)
VACUUM PUMP (TUBE REFILL)



PARTS LIST

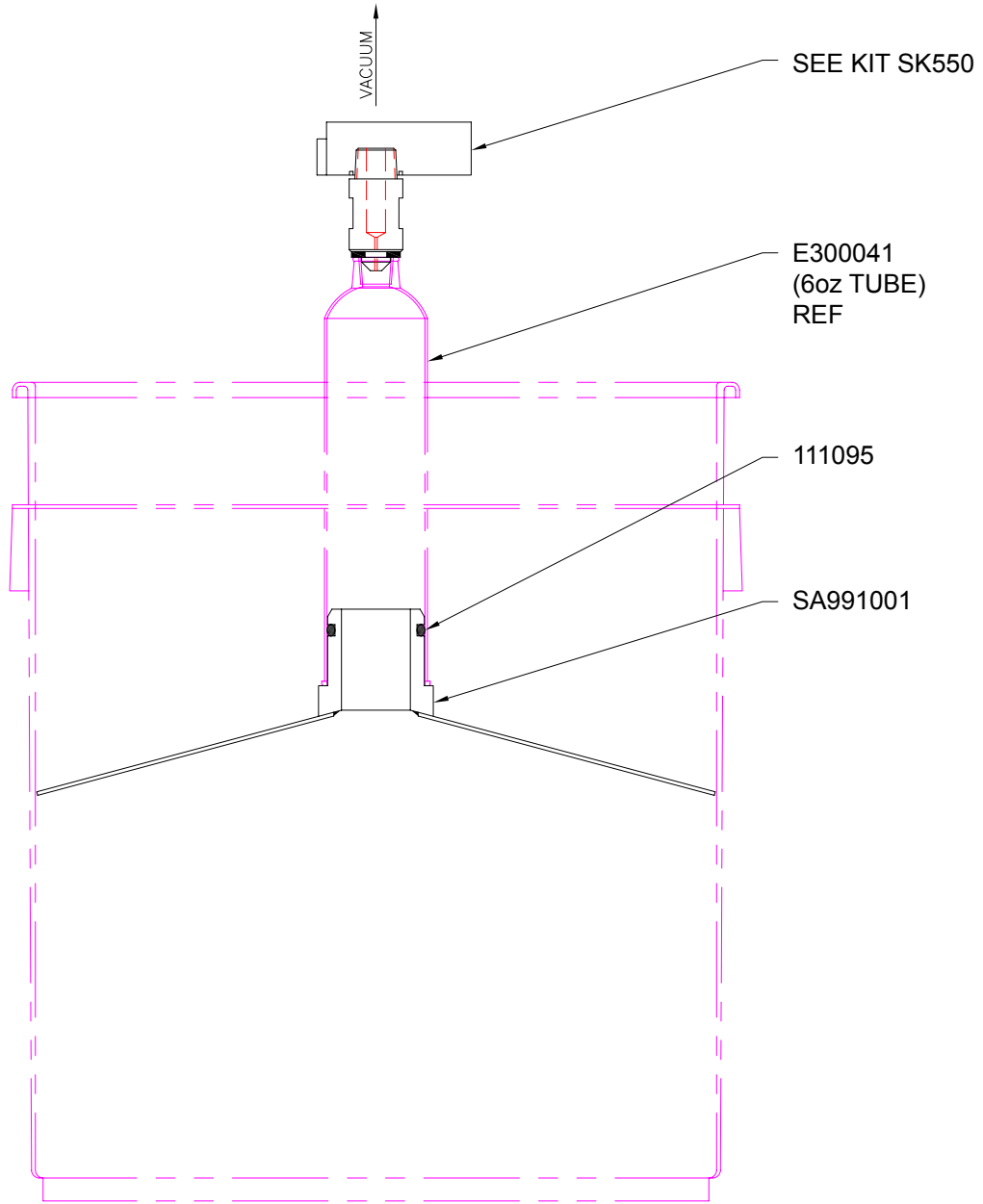
PART NO	DESCRIPTION (QTY)
160721	PACKING,O-RING,BUNA-N
SA990001	PLATE,FOLLOW,HUB,20oz,5GAL



WIXOM, MI.

RELEASED: 5-19-03
 REVISED: 9-25-09

DESCRIPTION: ACCESSORY MODEL #SA990 (ASS'Y #SA990)
 20oz. TUBE REFILL



PARTS LIST

PART NO	DESCRIPTION
111095	PACKING,O-RING,VALVE
SA991001	PLATE,FOLLOW,HUB,6/12-oz,5GAL



WIXOM, MI.

RELEASED: 12-22-03
REVISED: 6-3-08

DESCRIPTION:

ACCESSORY MODEL #SA991 (ASS'Y #SA991)
6oz & 12oz TUBE REFILL

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Graco warrants all equipment referenced in this document which is manufactured by Graco and bearing its name to be free from defects in material and workmanship on the date of sale to the original purchaser for use. With the exception of any special, extended, or limited warranty published by Graco, Graco will, for a period of twelve months from the date of sale, repair or replace any part of the equipment determined by Graco to be defective. This warranty applies only when the equipment is installed, operated and maintained in accordance with Graco's written recommendations.

This warranty does not cover, and Graco shall not be liable for general wear and tear, or any malfunction, damage or wear caused by faulty installation, misapplication, abrasion, corrosion, inadequate or improper maintenance, negligence, accident, tampering, or substitution of non-Graco component parts. Nor shall Graco be liable for malfunction, damage or wear caused by the incompatibility of Graco equipment with structures, accessories, equipment or materials not supplied by Graco, or the improper design, manufacture, installation, operation or maintenance of structures, accessories, equipment or materials not supplied by Graco.

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TO PLACE AN ORDER, contact your Graco distributor or call to identify the nearest distributor.

Phone: 612-623-6921 **or Toll Free:** 1-800-746-1334 **Fax:** 330-966-3006

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Graco reserves the right to make changes at any time without notice.*

For patent information, see www.graco.com/patents.

Original instructions. This manual contains English. MM 332338

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