

## EXTRUSION UNITS

### THOR

**60.60                      32.207**

**34.106                     53.216**

**63.106                     82.216**

### TECHNICAL FEATURES

### TRANSLATION OF THE ORIGINAL MANUAL

***IMPORTANT : Before assembly and start-up, please read and clearly understand all the documents relating to the equipment (professional use only).***

THE PICTURES AND DRAWINGS ARE NOT 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](http://www.kremlin-rexson.com)**

## 1. DESCRIPTION

The extrusion units are designed for pumping viscous materials.

They can process a wide range of materials including grease, adhesives, sealants and other similar materials. You can process products up to 1 million centipoises.

These extrusion units consist of :

- An extrusion pump,
- A single-post or twin-post ram,
- A follower plate with flat single seal or double O-Ring seal.

The modular conception allows you to install options (filters, regulators,...).

## 2. TECHNICAL FEATURES

### ▪ EXTRUSION UNIT - THOR 60.60

Motor type ..... 3000  
 Pump body type ..... 60 cc  
 Pressure ratio ..... 60/1  
 Weight (bare pump)..... 19 kg / 41.8 lb

#### Wetted parts :

Carbon steel

#### Tightness packings :

PTFE / PE

Motor stroke	120 mm	4.7"
Fluid volume per cycle	60 cm <sup>3</sup>	2.03 oz
Free flow rate (at 60 cycles)	3,6 l/min	0.95 US gal
Flow rate (at 30 cycles)	1,8 l	0.47 US gal
Maximum air inlet pressure	6 bar	87 psi
Maximum fluid pressure	360 bar	5221 psi
Weighted sound pressure (LAeq)	62.5 dBa	62.5 dBa
Maximum fluid temperature	60°C	140° F

*Nota : Data given for information only*

#### Test conditions - Noise level :

- Test duration : 30 s,
- Motor air pressure : 6 bar / 87 psi,
- Material used : water,
- Regulation valve,
- Flow rate : Pump adjusted at 20 cycles / minute.

▪ **EXTRUSION UNIT - THOR 34.106**

Motor type..... 3000  
 Pump body type ..... 106 cc  
 Pressure ratio ..... 34/1  
 Weight (bare pump)..... 18 kg / 39.6 lb

**Wetted parts :**

Carbon steel

**Tightness packings :**

PTFE / PE

Motor stroke	120 mm	4.7"
Fluid volume per cycle	106 cm <sup>3</sup>	3.58 oz
Free flow rate (at 60 cycles)	6,3 l/min	1.66 US gal
Flow rate (at 30 cycles)	3,18 l	0.84 US gal
Maximum air inlet pressure	6 bar	87 psi
Maximum fluid pressure	204 bar	2958.6 psi
Weighted sound pressure (LAeq)	62,5 dBa	62.5 dBa
Maximum fluid temperature	60°C	140° F

*Nota : Data given for information only*

**Test conditions - Noise level :**

- Test duration : 30 s,
- Motor air pressure : 6 bar / 87 psi,
- Material used : water,
- Regulation valve,
- Flow rate : Pump adjusted at 20 cycles / minute.

▪ **EXTRUSION UNIT - THOR 63.106**

Motor type..... 5000  
 Pump body type ..... 106 cc  
 Pressure ratio ..... 63/1  
 Weight (bare pump)..... 30 kg

**Wetted parts :**

Carbon steel

**Tightness packings :**

PTFE / PE

Motor stroke	120 mm	4.7"
Fluid volume per cycle	106 cm <sup>3</sup>	3.58 oz
Free flow rate (at 60 cycles)	6,3 l/min	1.66 US gal
Flow rate (at 30 cycles)	3,18 l	0.84 US gal
Maximum air inlet pressure	6 bar	87 psi
Maximum fluid pressure	378 bar	5482 psi
Weighted sound pressure (LAeq)	67,2 dBa	67.2 dBa
Maximum fluid temperature	60°C	140° F

*Nota : Data given for information only*

**Test conditions - Noise level :**

- Test duration : 30 s,
- Motor air pressure : 6 bar / 87 psi,
- Material used : water,
- Regulation valve,
- Flow rate : Pump adjusted at 20 cycles / minute.

▪ **EXTRUSION UNIT - THOR 32.207**

Motor type.....5000  
 Pump body type .....207 cc  
 Pressure ratio .....32/1  
 Weight (bare pump).....31.5 kg / 69.4 Lb

**Wetted parts :**

Carbon steel

**Tightness packings :**

PTFE / PE

Motor stroke	120 mm	4.7"
Fluid volume per cycle	207 cm <sup>3</sup>	7 oz
Free flow rate (at 60 cycles)	12,4 l/min	3.27 US gal
Flow rate (at 30 cycles)	6,21 l	1.64 US gal
Maximum air inlet pressure	6 bar	87 psi
Maximum fluid pressure	192 bar	2784.5 psi
Weighted sound pressure (LAeq)	67,2 dBa	67.2 dBa
Maximum fluid temperature	60°C	140° F

*Nota : Data given for information only*

**Test conditions - Noise level :**

- Test duration : 30 s,
- Motor air pressure : 6 bar / 87 psi,
- Material used : water,
- Regulation valve,
- Flow rate: Pump adjusted at 20 cycles / minute.

▪ **EXTRUSION UNIT - THOR 53.216**

Motor type.....7000  
 Pump body type .....216 cc  
 Pressure ratio .....53/1  
 Weight (bare pump).....51 kg / 112 lb

**Wetted parts :**

Carbon steel

**Tightness packings :**

PTFE / PE

Motor stroke	120 mm	4.7"
Fluid volume per cycle	216 cm <sup>3</sup>	7.3 oz
Free flow rate (at 60 cycles)	12,9 l/min	3.41 US gal
Flow rate (at 30 cycles)	6,48 l	1.71 US gal
Maximum air inlet pressure	6 bar	87 psi
Maximum fluid pressure	318 bar	4612 psi
Weighted sound pressure (LAeq)	72,9 dBa	72.9 dBa
Maximum fluid temperature	60°C	140° F

*Nota : Data given for information only*

**Test conditions - Noise level :**

- Test duration : 30 s,
- Motor air pressure : 6 bar / 87 psi,
- Material used : water,
- Regulation valve,
- Flow rate: Pump adjusted at 20 cycles / minute.

▪ **EXTRUSION UNIT - THOR 82.216**

Motor type.....9000  
 Pump body type ..... 216 cc  
 Pressure ratio ..... 82/1  
 Weight (bare pump).....62 kg / 136.6 lb

**Wetted parts :**

Carbon steel

**Tightness packings :**

PTFE / PE

Motor stroke	120 mm	4.7"
Fluid volume per cycle	216 cm <sup>3</sup>	7.3 oz
Free flow rate (at 60 cycles)	12,9 l/min	3.41 US gal
Flow rate (at 30 cycles)	6,48 l	1.71 US gal
Maximum air inlet pressure	6 bar	87 psi
Maximum fluid pressure	492 bar	7135.5 psi
Weighted sound pressure (LAeq)	74,6 dBa	74.6 dBa
Maximum fluid temperature	60°C	140° F

*Nota : Data given for information only*

**Test conditions - Noise level :**

- Test duration : 30 s,
- Motor air pressure : 6 bar / 87 psi,
- Material used : water,
- Regulation valve,
- Flow rate: Pump adjusted at 20 cycles / minute.

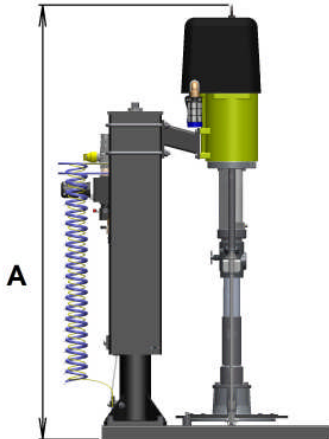
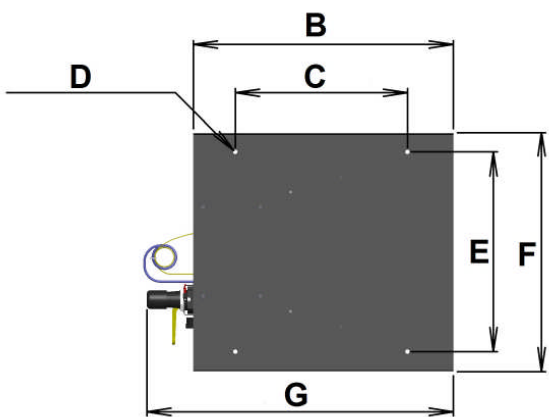
▪ **FITTINGS**

<b>Air</b>	Inlet	F 3/4" G
<b>Material</b>	Inlet	Ø 80 mm
	Outlet	M 3/4" G

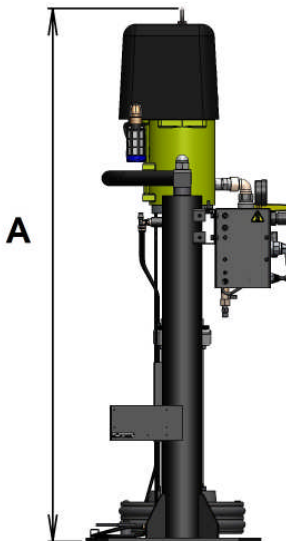
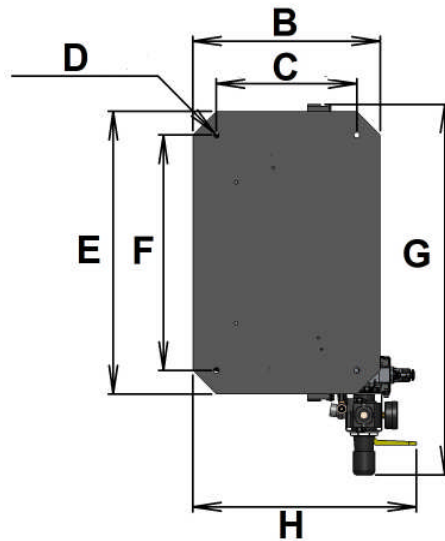
▪ **DIMENSIONS**

- Extrusion unit - THOR 60.60

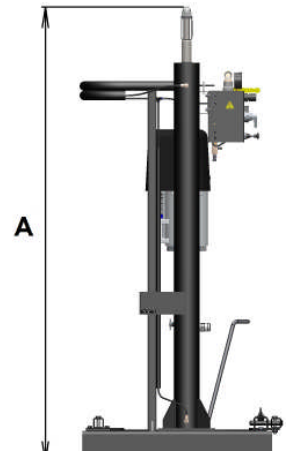
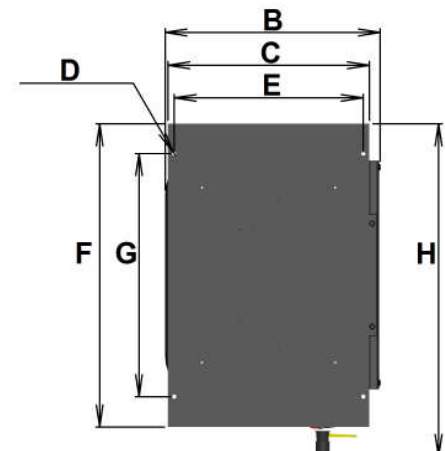
**Mini single**

						
<b>Ind.</b>	<b>mm</b>	<b>Ind.</b>	<b>mm</b>	<b>Ind.</b>	<b>mm</b>	
<b>A</b>	High position	1721	<b>B</b>	650	<b>C</b>	430
	Low position	1246	<b>D</b>	Ø 10.7	<b>E</b>	500
	Stroke	475	<b>F</b>	600	<b>G</b>	766

### Mini twin

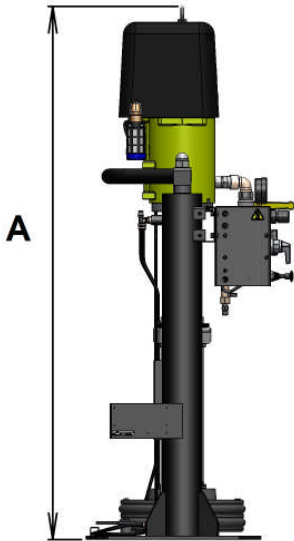
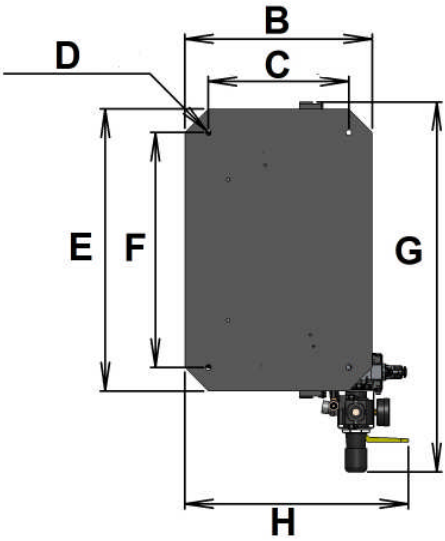
						
						<b>Ind.</b>
<b>A</b>	High position	2003	<b>B</b>	400	<b>C</b>	300
	Low position	1215	<b>D</b>	Ø 12	<b>E</b>	600
	Stroke	788	<b>F</b>	500	<b>G</b>	786
			<b>H</b>	478		

### Twin

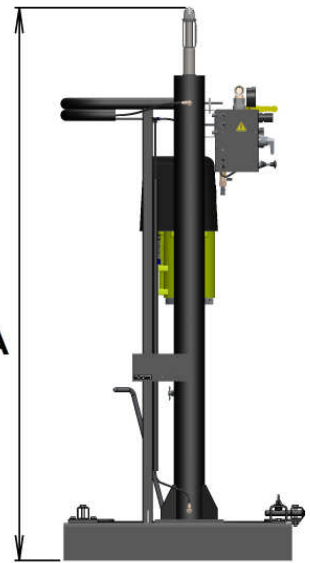
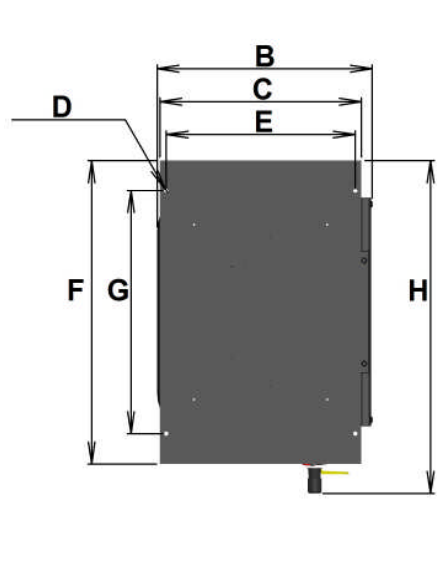
						
						<b>Ind.</b>
<b>A</b>	High position	2657	<b>B</b>	711	<b>C</b>	666
	Low position	1607	<b>D</b>	Ø 14	<b>E</b>	625
	Stroke	1050	<b>F</b>	1000	<b>G</b>	800
			<b>H</b>	1096		

- Extrusion unit - THOR 34.106

**Mini twin**

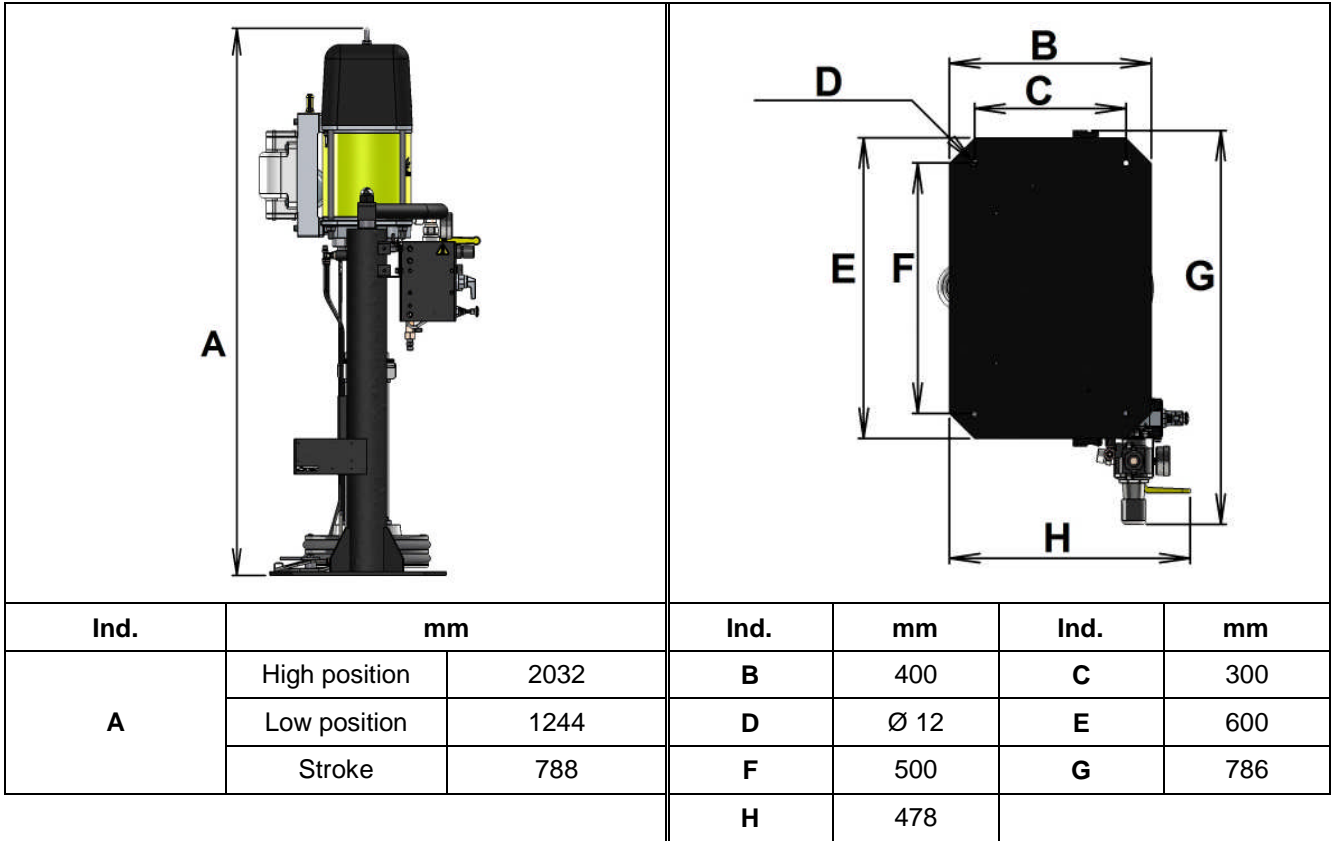
						
						<b>Ind.</b>
<b>A</b>	High position	2003	<b>B</b>	400	<b>C</b>	300
	Low position	1215	<b>D</b>	Ø 12	<b>E</b>	600
	Stroke	788	<b>F</b>	500	<b>G</b>	786
			<b>H</b>	478		

**Twin**

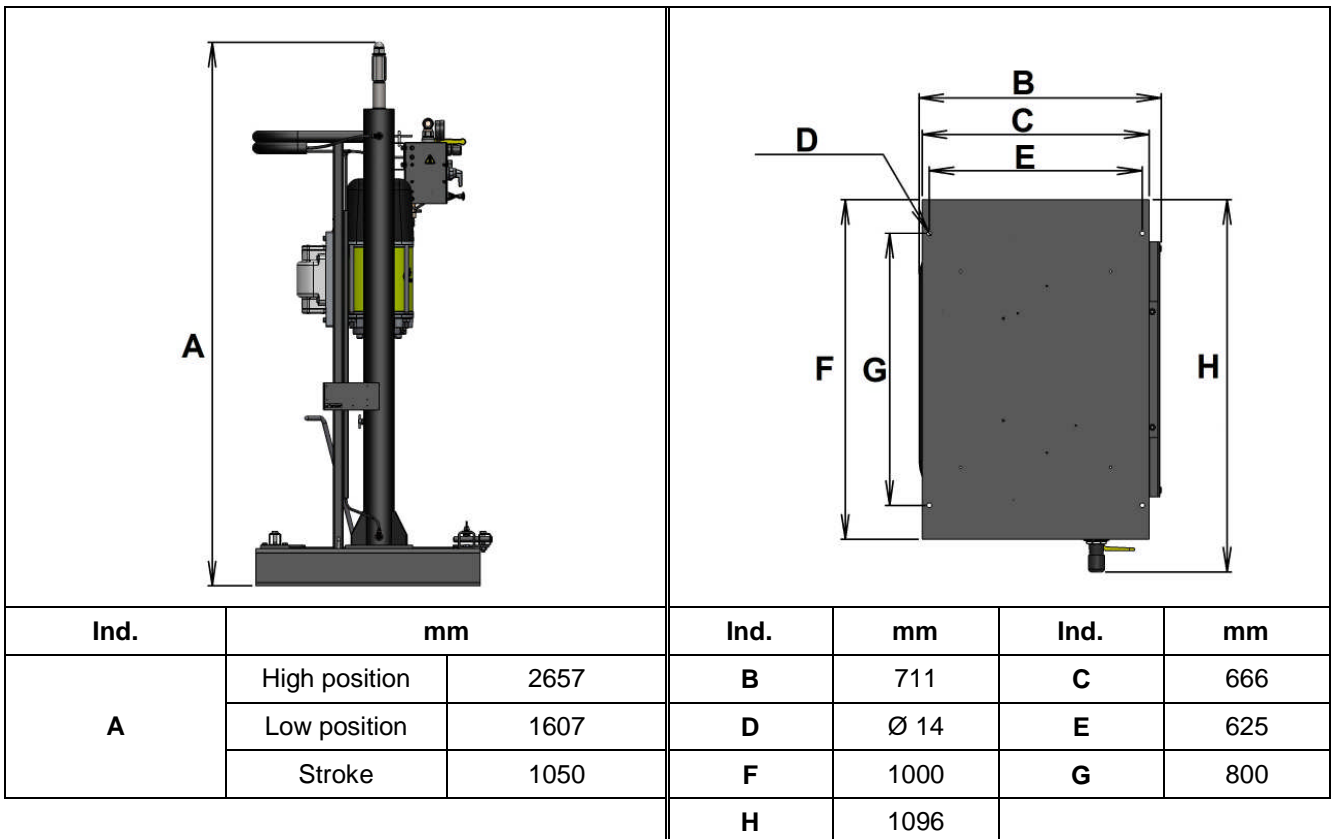
						
						<b>Ind.</b>
<b>A</b>	High position	2657	<b>B</b>	711	<b>C</b>	666
	Low position	1607	<b>D</b>	Ø 14	<b>E</b>	625
	Stroke	1050	<b>F</b>	1000	<b>G</b>	800
			<b>H</b>	1096		

- Extrusion unit - THOR 63.106

**Mini twin**



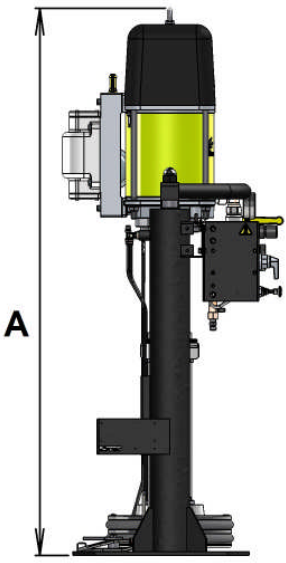
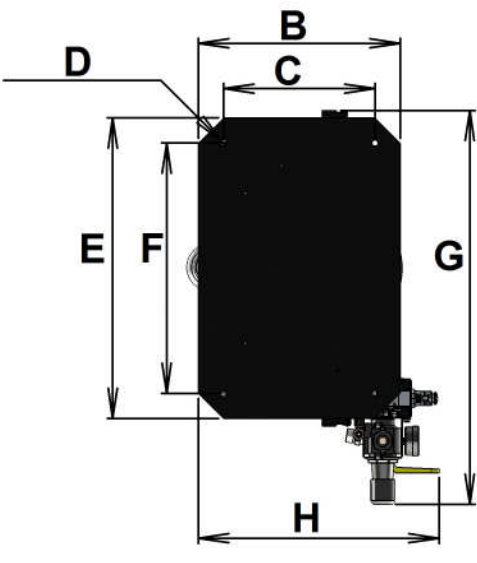
**Twin**



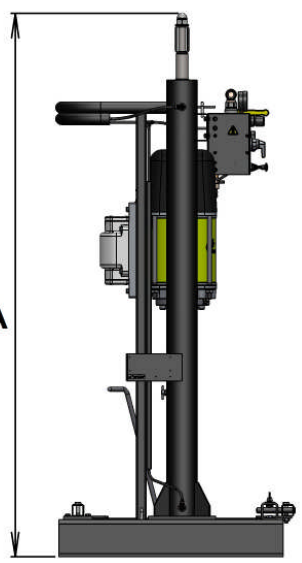
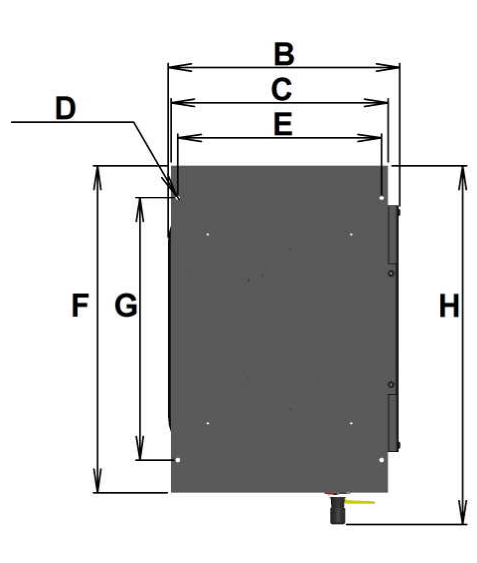


- Extrusion unit - THOR 32.207

**Mini twin**

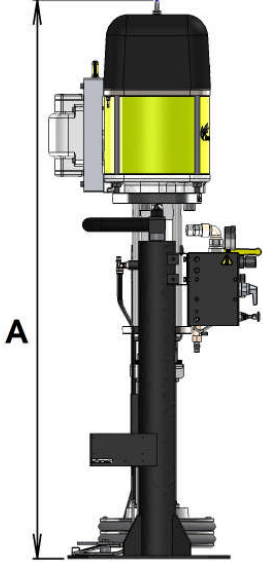
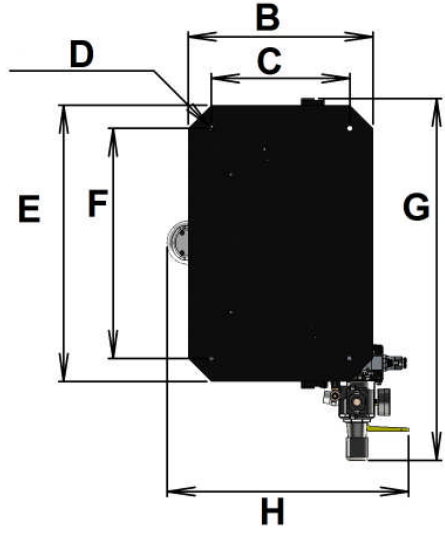
						
						<b>Ind.</b>
<b>A</b>	High position	2032	<b>B</b>	400	<b>C</b>	300
	Low position	1244	<b>D</b>	∅ 12	<b>E</b>	600
	Stroke	788	<b>F</b>	500	<b>G</b>	786
			<b>H</b>	501		

**Twin**

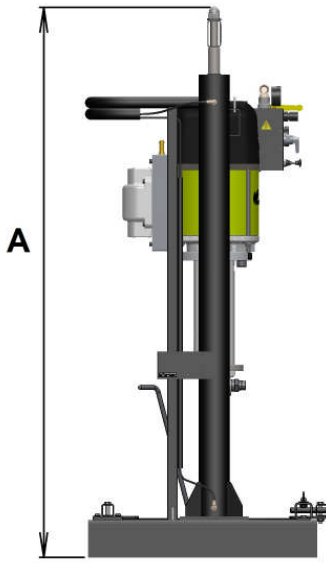
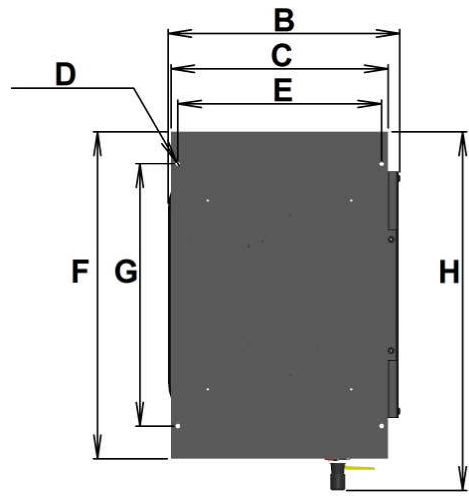
						
						<b>Ind.</b>
<b>A</b>	High position	2657	<b>B</b>	711	<b>C</b>	666
	Low position	1607	<b>D</b>	∅ 14	<b>E</b>	625
	Stroke	1050	<b>F</b>	1000	<b>G</b>	800
			<b>H</b>	1096		

- Extrusion unit - THOR 53.216

**Mini twin**

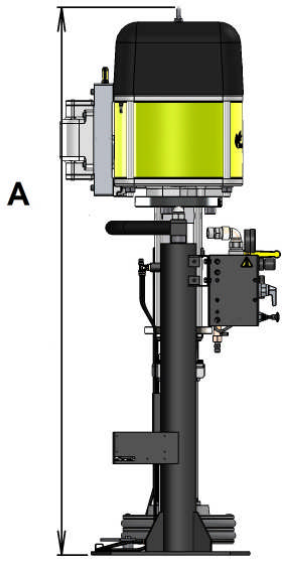
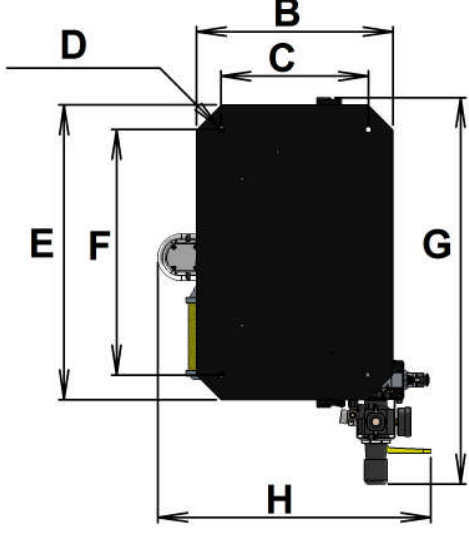
						
						<b>Ind.</b>
<b>A</b>	High position	2172	<b>B</b>	400	<b>C</b>	300
	Low position	1384	<b>D</b>	∅ 12	<b>E</b>	600
	Stroke	788	<b>F</b>	500	<b>G</b>	786
			<b>H</b>	524		

**Twin**

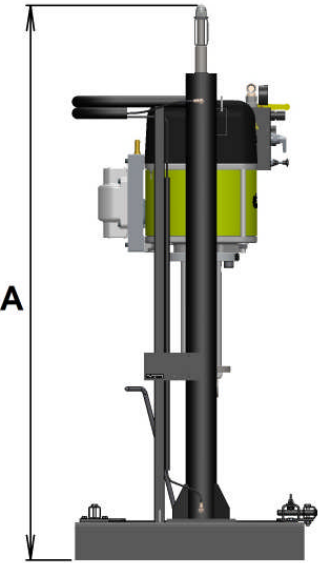
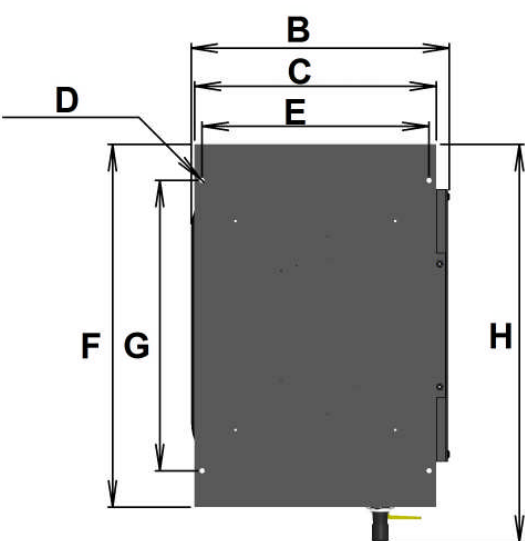
						
						<b>Ind.</b>
<b>A</b>	High position	2657	<b>B</b>	711	<b>C</b>	666
	Low position	1607	<b>D</b>	∅ 14	<b>E</b>	625
	Stroke	1050	<b>F</b>	1000	<b>G</b>	800
			<b>H</b>	1096		

- Extrusion unit - THOR 82.216

**Mini twin**

						
						<b>Ind.</b>
<b>A</b>	High position	2172	<b>B</b>	400	<b>C</b>	300
	Low position	1384	<b>D</b>	∅ 12	<b>E</b>	600
	Stroke	788	<b>F</b>	500	<b>G</b>	786
			<b>H</b>	557		

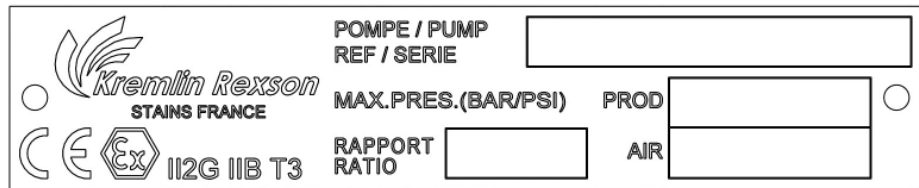
**Twin**

						
						<b>Ind.</b>
<b>A</b>	High position	2657	<b>B</b>	711	<b>C</b>	666
	Low position	1607	<b>D</b>	∅ 14	<b>E</b>	625
	Stroke	1050	<b>F</b>	1000	<b>G</b>	800
			<b>H</b>	1096		

▪ DESCRIPTION OF THE LABEL MARKING

• LABEL MARKING OF THE PUMP

Marking according to the ATEX and Machines directives



<b>KREMLIN REXSON</b>	Manufacturer brand
<b>CE</b>	European Conformity
<b>Ex II 2 G</b>	II : group II 2 : class 2 Surface equipment meant to an area in which there is an explosive atmosphere with an excessive mixture of air, gases and vapours, which can occasionally build up during normal operation. G : gas
<b>IIB T3</b>	IIB : Gas group for the equipment category T3 : Maximum surface temperature : 200°C / 392°F
<b>POMPE / PUMP</b>	Pump version
<b>REF.</b>	Pump part number
<b>SERIE</b>	Number given by KREMLIN REXSON. The 2 first numbers indicate the manufacturing year.
<b>MAX. PRES. (BAR/PSI)</b>	
<b>PROD</b>	Maximum material pressure
<b>AIR</b>	Maximum air pressure
<b>RAPPORT / RATIO</b>	Pump pressure ratio

• LABEL MARKING OF THE RAM

Marking according to the ATEX and Machines directives



<b>KREMLIN REXSON</b>	Manufacturer brand
<b>CE</b>	European Conformity
<b>Ex II 2 G c</b>	II : group II 2 : class 2 Surface equipment meant to an area in which there is an explosive atmosphere with an excessive mixture of air, gases and vapours, which can occasionally build up during normal operation. G : gas c : Protection by constructional safety
<b>REF.</b>	Unit part number
<b>SERIE</b>	Number given by KREMLIN REXSON. The 2 first numbers indicate the manufacturing year.
<b>MAX. PRES. (BAR/PSI)</b>	Maximum pressure

- LABEL MARKING OF THE FOLLOWER PLATE



<b>KREMLIN REXSON</b>	Manufacturer brand
<b>REF.</b>	Follower plate part number
<b>SERIE</b>	Number given by KREMLIN REXSON. The 2 first numbers indicate the manufacturing year.