



EXTRUSION UNITS

THOR

TROUBLESHOOTING GUIDE

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

The equipment is manufactured under the ATEX agreement and should not be modified. KREMLIN REXSON will not be held responsible for any failure to comply with that instruction.

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

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



CAUTION :

Before any intervention on the equipment, shut off the air supply and follow the general safety instructions. Open the drain or the gun to depressurize the gun. The ram must be in the low position.

FAULTS	CAUSES	SOLUTIONS
Pump does not start or stops	Air supply Packings of fluid section are stuck Frosting (motor) Nozzle is clogged	Check air pressure Clean or replace Defrost and lubricate using oil. Clean it.
The pump cycles continuously (drain valve closed)	No starting up Lack of material Valve is blocked	Check feeding pressure Add material Clean or replace
The pump piston goes down faster than it goes up	Leakage from the suction valve	Clean the suction valve. Replace it if necessary.
The pump piston goes up faster than it goes down	Leakage from the exhaust valve	Clean the exhaust valve. Replace it if necessary.
The pump goes down rapidly half way, then resumes normal speed	Pump improperly drained Leakage from the suction valve	Open the drain valve until material starts coming out regularly. Then, close the drain valve. Check the suction valve. Replace it if necessary.
The pump operates but provides an irregular flow rate	Air in the chamber Bad tightness of the valves Leakage during the exhaust Muffler clogged up	Check the fittings Clean Check the motor piston seals; change them if necessary Clean or change the muffler
Motor piston locked	Defective sensor (s) Defective control distributor Defective power distributor	Adjust the sensor (s). Change it (them) if necessary. Check the operating of the control distributor. Change it if necessary. Check the operating of the power distributor. Change it if necessary.

FAULTS	CAUSES	SOLUTIONS
Important leakage during the exhaust	Distributor seals incorrectly mounted Defective power distributor	Check the seals; replace them if necessary Check the operating of the power distributor. Change it if necessary.
Leakage from the cupel seals	Cupel not tightened Fluid section seals incorrectly mounted Material / seal not compatible Seals damaged	Tight the cupel Check the seals. Change them if necessary Check the material / seal compatibility Change the seals
Cupel seals quickly damaged	Lack of lubrication Material / seal not compatible Seals damaged	Check cupel has lubricant. Clean it and fill the cupel if necessary. Check the material / seal compatibility Change the seals
The ram does not go up any more	Insufficient air supply Lever of the distributor in the middle position	Increase air pressure Check the connection Move the lever of the distributor upwards to make go up the unit
The ram does not down up any more	Insufficient air supply Lever of the distributor in the middle position	Increase air pressure Check the connection Move the lever of the distributor downwards to make down the unit
Ram goes up / goes down intermittently	Seals damaged	Change the seals
Air leakage from the piston rod	Seals damaged	Change the seals