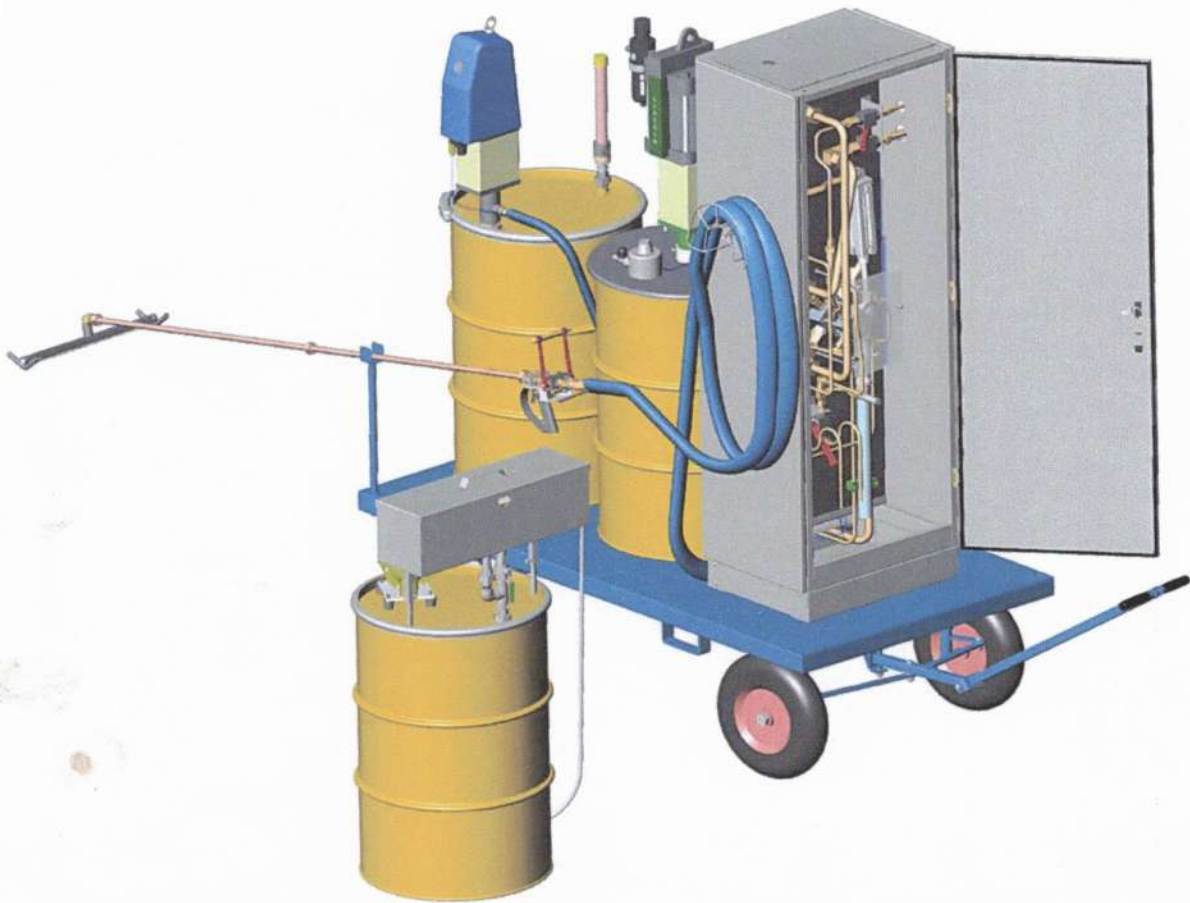




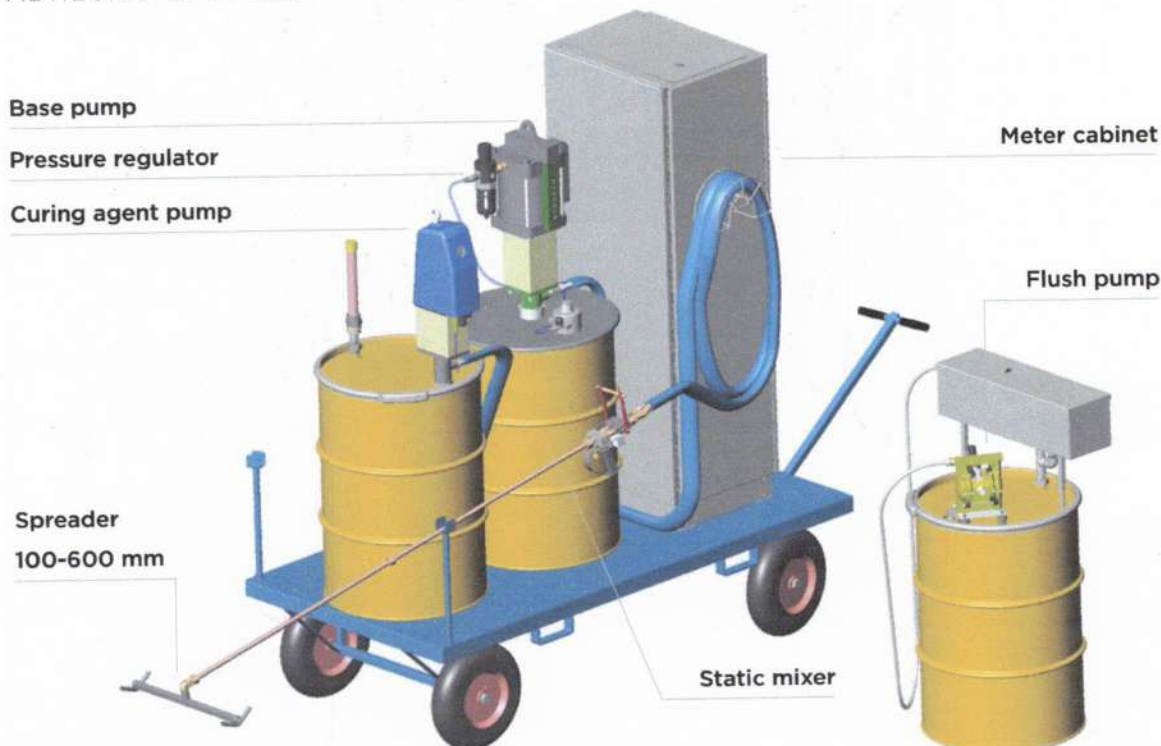
1200M adhesive system

VETACS

ADHESIVE SYSTEMS

Manual application of two component adhesive with Vetacs application system 1200M

The 1200 application system comply with the demand for a very high capacity. It is designed to apply adhesive to large surfaces of sandwich panels. Efficient application of adhesive calls for a perfect match between adhesive and application equipment. With Vetacs you can obtain that perfect match, because we can supply the right equipment for your bonding application.



System 1200M is designed for application of two component Polyurethane adhesive on large surfaces



Capacity at 20°C	7 kg/min. at 4,5 bar
Viscosity	Up to 35000 cps
Mixing ratio	100:25
Pressure ratio	12:1
Compressed air pressure	Nom. 6 bar
Compressed air volume	Approx. 1000 ltr./min.
Standard hose length	10 m
Spreader width	100mm - 600mm
Nozzle configuration	1,5mm - 3mm
Total weight (without drums)	350 kg

System 1200M ensures that the base and curing agent are metered in the correct ratio and are dispensed through a static mixer to a homogeneous mixture.

System 1200 M is based on a robust design with reliability that is proven in practice. This ensures minimum maintenance.

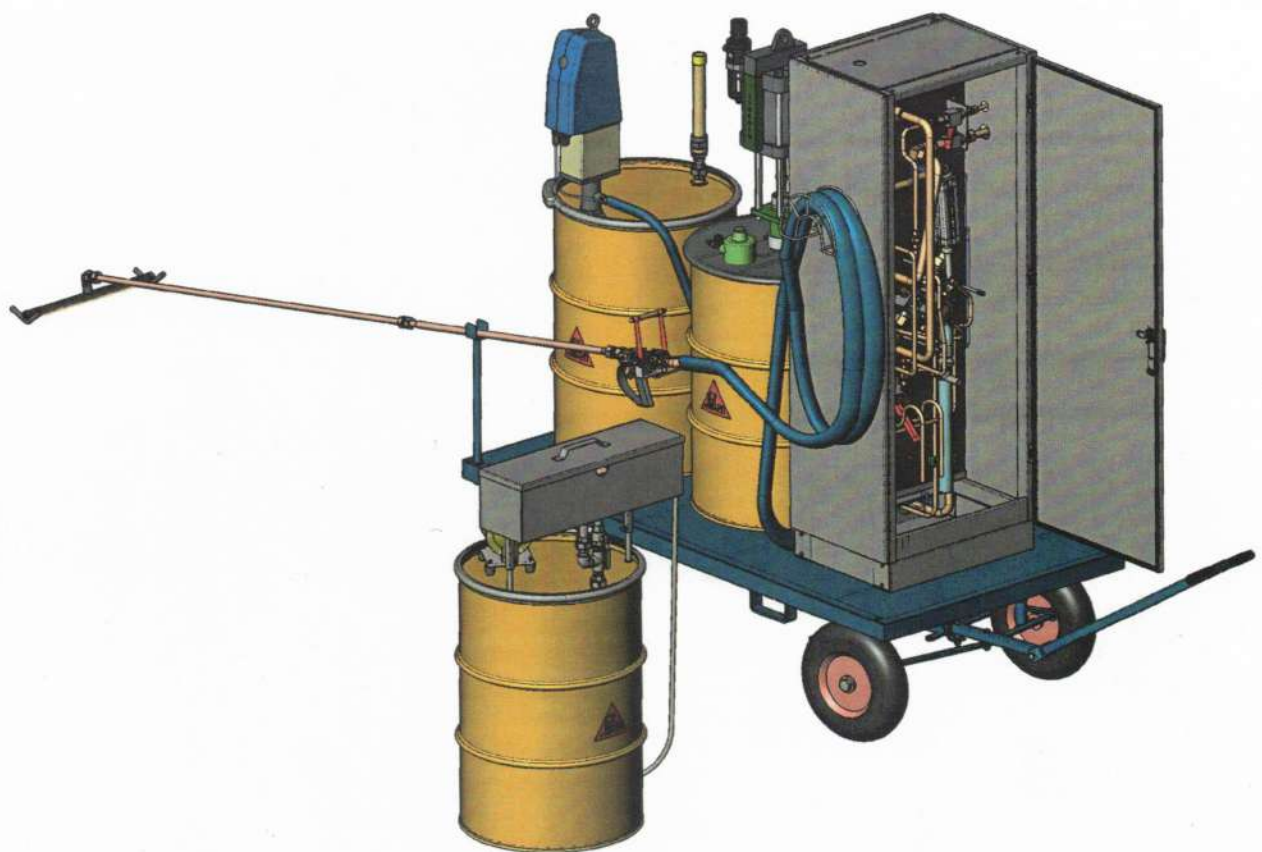
Combined with the Vetacs expertise in industrial bonding applications, System 1200M keeps production moving! This high performance system is easy to operate. It generates high and uniform product quality, simplifies product handling and contributes to an improved working environment!

Additional equipment

For paste like bases a pump with pressure plate can be supplied. For more automated application, contact Vetacs for information.



ISI YOGEV INDUSTRIES Ltd.



User manual for 1200M

Project No.: 21690

Type: 1200M

Serial No.: SM21690

- | | |
|----------|----------------------------------|
| 1 | Declaration of conformity |
| 2 | Safety
Data Sheet |
| 3 | Operating instructions |
| 4 | Maintenance |
| 5 | Pump System |
| 6 | Meter Unit |
| 7 | Mixer Unit / Spreader |
| 8 | Flush System |

EU Declaration of Conformity

Herewith the undersigned manufacturer

ISI YOGEV INDUSTRIES
HATNUFA 7
BEIT SHEAN
ISRAEL

Certifies that the following machine equipment

Adhesive application machine

Type 1200M

Serial n°:
SM21690

Complies with the regulations in the Machinery Directive 98/37/EC
As well as the norm

Date _____



ISI YOGEV INDUSTRIES Ltd.



Health & Safety

Warning!

DO NOT operate the machine without having read the manual first.

DO NOT operate the machine without supervision.

DO NOT start the machine if personnel or obstacles are placed within the working area of the machine.

DO NOT stand on the machine while in operation.

DO NOT exceed the stated maximum working pressure of 7 bar for the air motor or of the lowest rated component in your system.

DO NOT alter or modify any part of this equipment.

DO NOT operate this equipment with combustible gas.

TIGHTEN all fluid and pneumatic connections securely before using this equipment.

ALWAYS read and follow the fluid manufacturer's recommendations regarding fluid compatibility and the use of protective clothing and equipment.

ALWAYS check all equipment regularly and repair or replace worn or damaged parts immediately.

IMPORTANT

Failure to comply to these warnings including misuse, overpressurizing, modifying parts, using incompatible chemicals and fluids, or using worn or damaged parts, may result in equipment damage and/or serious personal injury, fire, explosion, or property damage.



Data Sheet

Application System Type 1200M

Serial No. V07-

METER UNIT:		42000100
• Base Cylinder	7030 B	42006500
• Curing Agent Cylinder	4532 AFPU	42005300
• Shift Valve, Base	BKMX 1/2"	41154900
• Shift Valve, Curing Agent	BKMX 3/8	41128400
• Base Tube	Dia. 25 mm	
• Curing Agent Tube	Dia. 12 mm	
• Base hose from pump to mixercab. 5/8"		41176600
4800-3413-3000		
• Curing Agent hose from pump to mixercab. 3/8" PTFE		41176600
4700-3822-3000		
BASE PUMP:		42000700
• Base pump	84985	42003400
• Air Motor	84808	41173200
• Regulator	W4000	41121000
CURING AGENT PUMP:		42000800
• Pump Type	26200	42005900
• Air Motor	26100	42006000
• Air dryer		42001100
• Silica Gel		42003900



<u>MIXER UNIT:</u>			<u>42000300</u>
•	Adhesive Dispenser	1316B	42000300
•	Mixer Pipe	1M (6 Mixers)	42001400
•	Hydr. Pipe ø18x1,5mm	A3L 1500mm	41186600
•	Hydr. Pipe ø18x1,5mm	A3LE18L 1000mm	41165400
•	Spreader	2K 600mm 2row	42001700
•	Nozzles	2mm	41057700
•	Hydr. Hose 10m	CAB.-Disp. 1/2"-1/4"	41176500

<u>CLEANING FLUSH STATION</u>			<u>42000900</u>
•	Flush pump	Tapflo 1/2	41278900
•	Cleaning box.	6710mm	42001700
•	Air regulator	W1000	41121100
•	Hose	3/8 PTFE x 3000mm	41178600

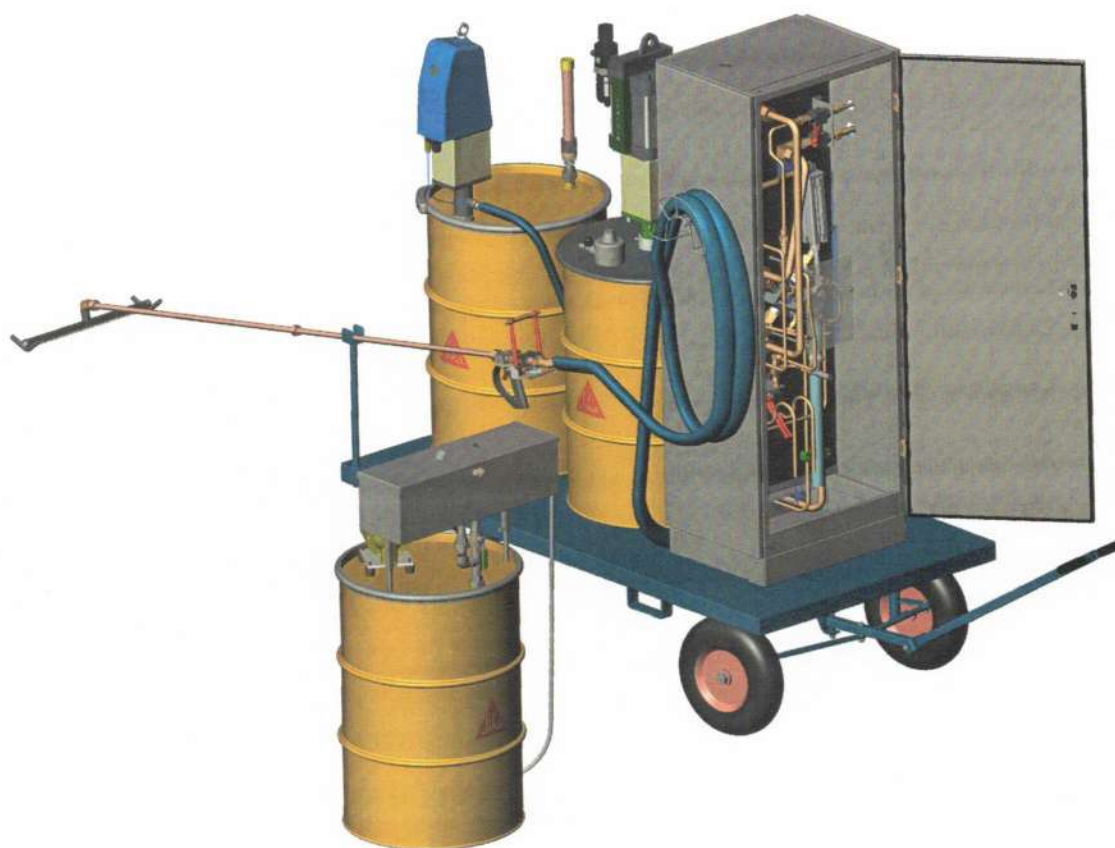
•	<u>GLANOIL</u>	<u>41053100</u>
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•	<u>GREASE RED</u>	<u>41059500</u>
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ISI YOGEV INDUSTRIES Ltd.

Operating instructions



Machine Type: 1200M



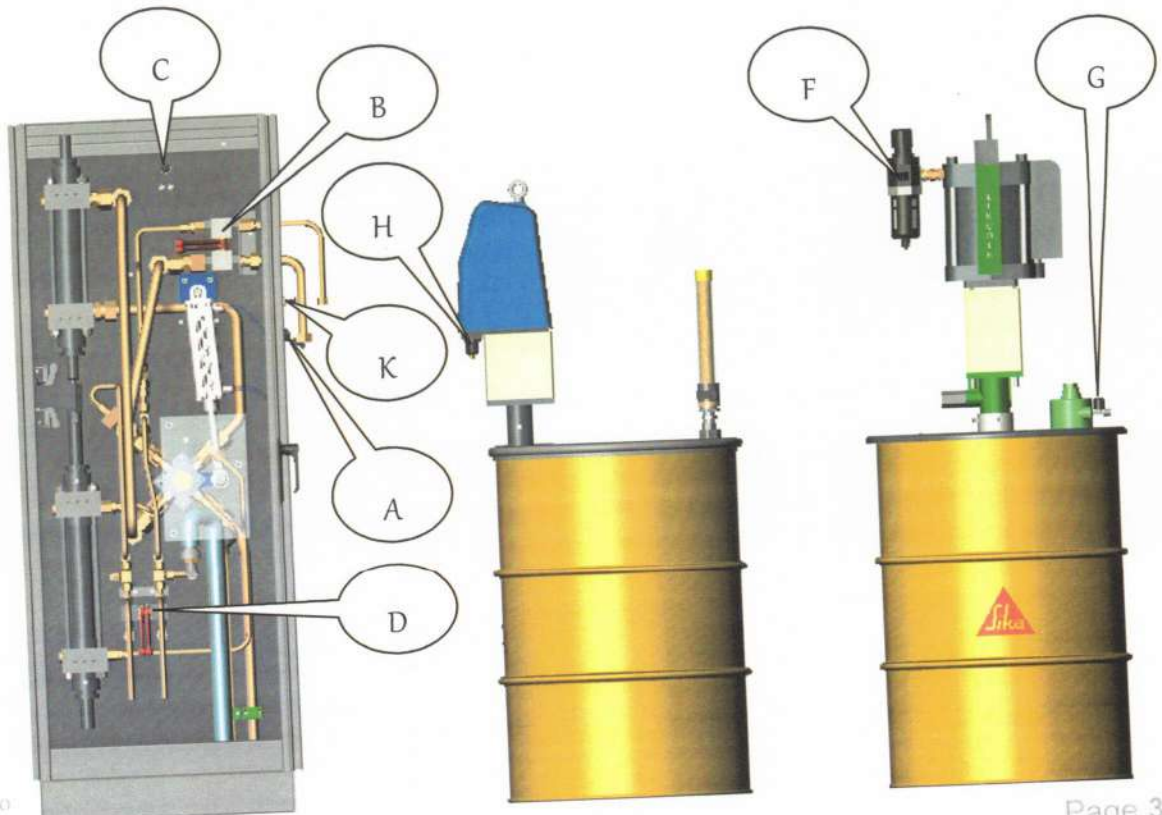
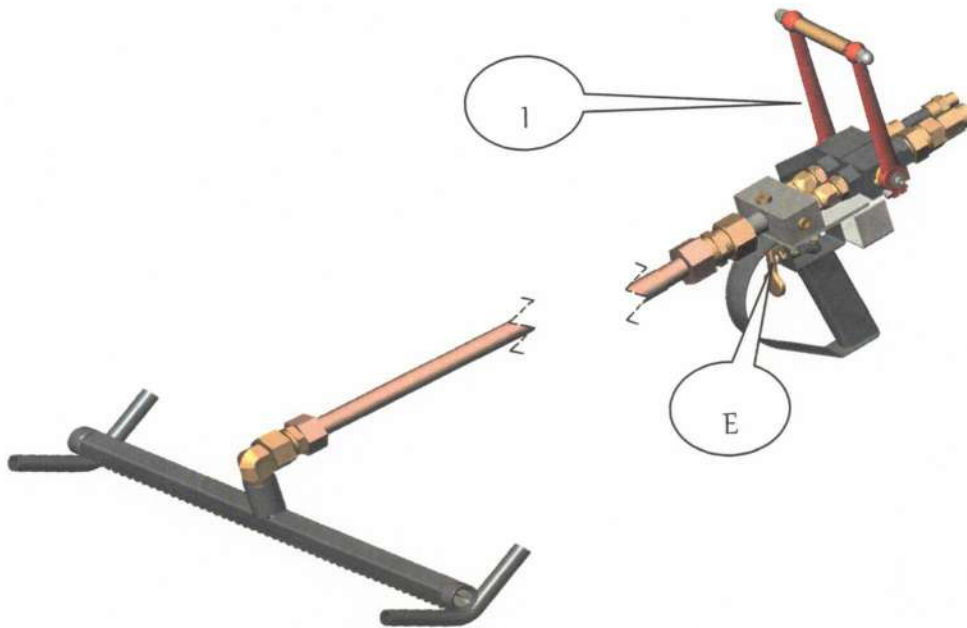
DO NOT operate the machine without having read the Health and Safety section first.

START-UP

1. Connect air supply min. 5 bar, air volume min. 550 lit./min. Hose size ½" to air inlet.
2. Place the base and curing agent pump into the respective drum. Mount the air dryer with silica gel and fill gland cup with **GLANDOIL 41053100** into the Curing Agent / Base pump oil cup.
3. Disengage valve **K**, Turn the pump start valve **A** on.
4. Start the agitator at low speed on the base drum **G**.
5. Close valve **B** and place a 5 l. container under the outlet pipes of the venting valves **D**.
6. Open the venting valve **D** and start the pumps with the valve **C**.
7. Set the curing agent pump **H** at **2,5 bar** and the base pump **F** at **3,5 bar**. Run the machine until air free material is coming out from pipe under **D**. Throttle the venting valve **D** slowly so the air is released from the adhesive.
8. When valve **D** is closed, open mixer valve **B**.
9. Remove the mixer and spreader bar.
10. Turn the pump start valve **A** on, open the shut-off valve **I** on the gun, and pull the mixer gun trigger **E**. Be sure that the materials coming out from the mixer head are air free before assembly the mixer pipe and spreader bar.
11. Make sure that the air is released from the adhesive in Mixer Unit.
12. Test the spreader on a plastic foil and increase the base pump pressure **F** to **4 bar**. The adhesive capacity from the spreader is adjusted with the base pump pressure **F** only. The curing agent pump is **always** on **2,5 bar**.
13. After finishing the work, the mixer pipe and spreader bar must be removed from the mixer head and flushed. See separate instruction for cleaning. Use **SikaForce7260Cleaner** or similar.

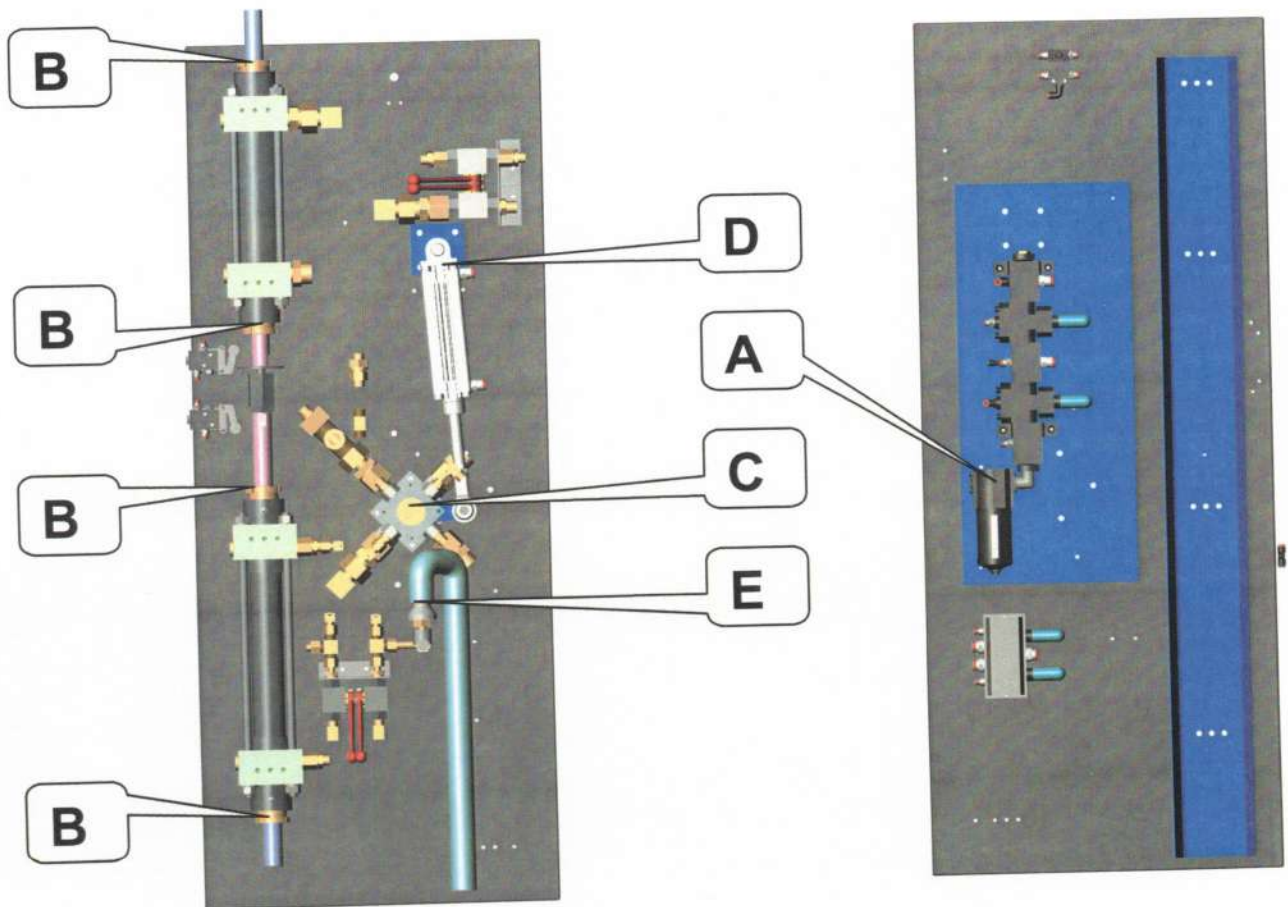


14. Clean the mixer head outlet and cover it with **GREASE RED 41059500**





Maintenance Meter Unit



1. Water Separator

Check that water separator is empty. Drain filter, if not empty

2. Tighten the gland nuts

slightly in order to tighten the packings. Change packings in case of leakage

3. Check shift valve

In case of leakage change packings

4. Check Air Cylinder

In case of leakage change packings

6. Check Lubricating Oil

Top up with Gland oil

A Weekly/Each Monday

B Weekly/Each Monday

C First Monday each month

D First Monday each month

E First Monday each month



Maintenance Curing Agent Pump

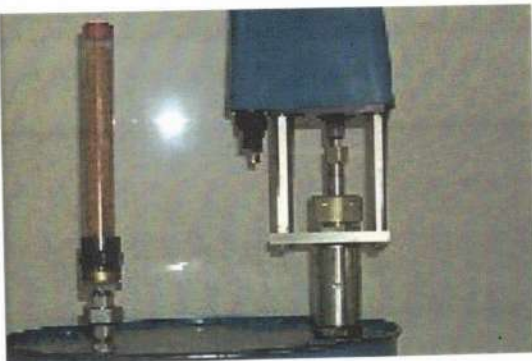
Maintenance, Air motor

No maintenance required. Secure that compressed air is dry. Too much water in the compressed air will wash the lubricant out of the air motor, which will increase potential problems.

Maintenance, Curing Agent pump and Water separator,

- A.** Check granulate in water separator is orange. At discoloration (white), Change silica gel
- B.** Tighten gland cup slightly in order to tighten the packing.
- C.** Gland cup must be topped up with gland oil once a week.

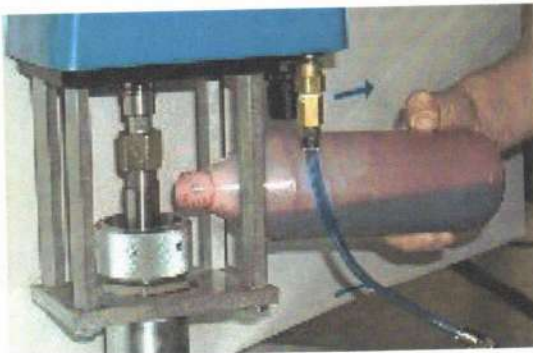
A.



B.



C.





Maintenance Base pump



1. Water Separator

Check that water separator is empty. Drain filter if not empty

A Weekly/Each Monday

- 2. Tighten the gland nut** slightly in order to tighten the packings. Change packings in case of leakage.

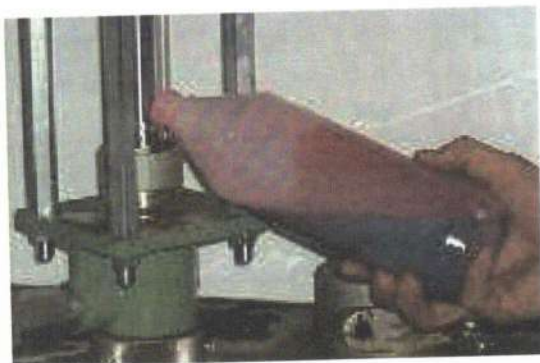
B Weekly/Each Monday

- 3. Check gland oil level** at Base pump
Top up with gland oil

C Weekly/Each Monday



Gland cup must be topped up with gland oil once a week.



Trouble shooting

Problem	Solution
Pump is not pumping	Check that compressed air is connected. Check that valves after the pump are open
Pump is moving, but stops in upper or lower position	Check that power valve is not stuck. Take it out and clean it thoroughly. Lubricate sparingly with light oil.(Pictures A,B & C). Inlet pressure too low. Must be min. 1 bar and max. 8 bar.

A



B



C



Pump is pumping, but no adhesive is coming out	Check that valve from fluid supply is open Check that filter at the pump inlet is not blocked
Pump is pumping, but runs irregularly	Lower valve seat in pump tube is contaminated. Contact Casco for solution.

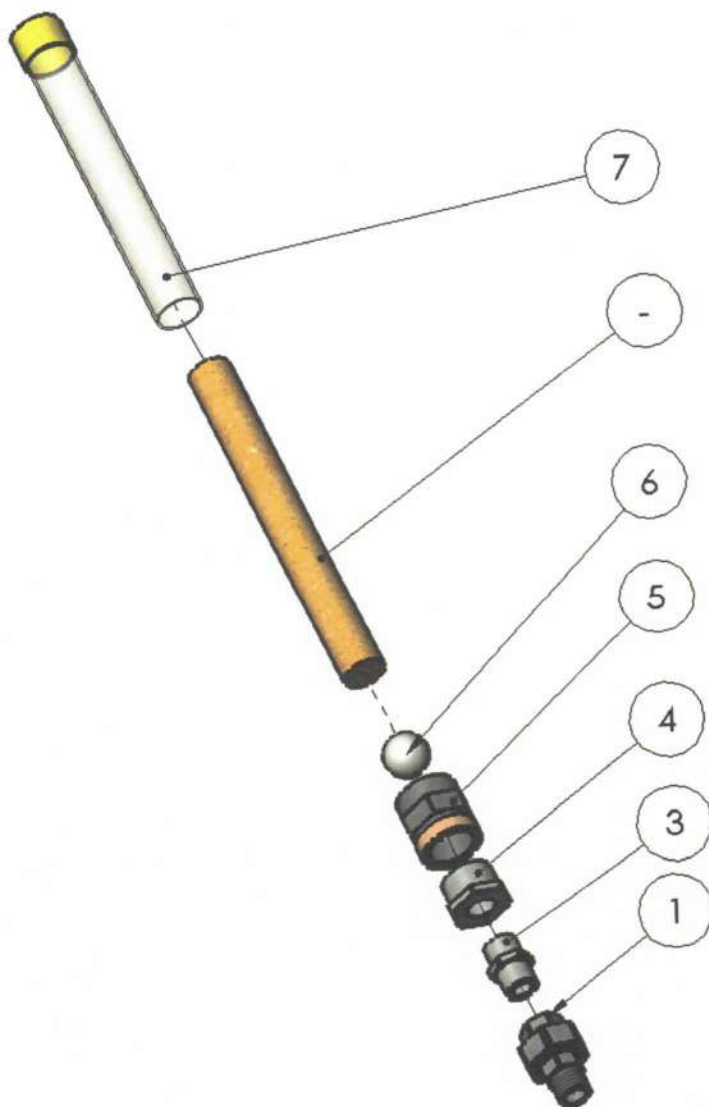


ISI YOGEV INDUSTRIES Ltd.

Pump is leaking adhesive at the gland cup

Gland nut are not tightened sufficiently.
Tighten it hand tight.
Upper packing worn. Contact Casco for
overhaul of pump.

Silicagel

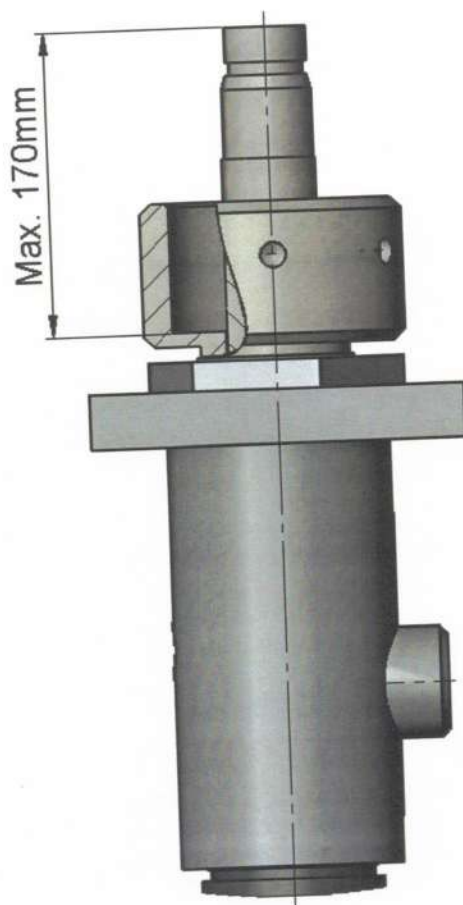


-	1	Silicagel 3/4 Bottle	42003900
7	1	Pipe PVC Transparent f/Silicagel	41230800
6	1	Filt	41209500
5	1	Pvc Fit. Socket	41208900
4	1	GF Fit.Np.Socket Ø11/4-3/4" U-I	41209000
3	1	GF Fit. Nipple Ø3/4" U-U	41230700
1	1	GF Fit. Union Ø3/4" I-U	Article no.
Item no.	Qty.	Description	



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Warning!
Piston Rod must maximum be pulled out 170mm
Going beyond this limit will cause damage of Piston

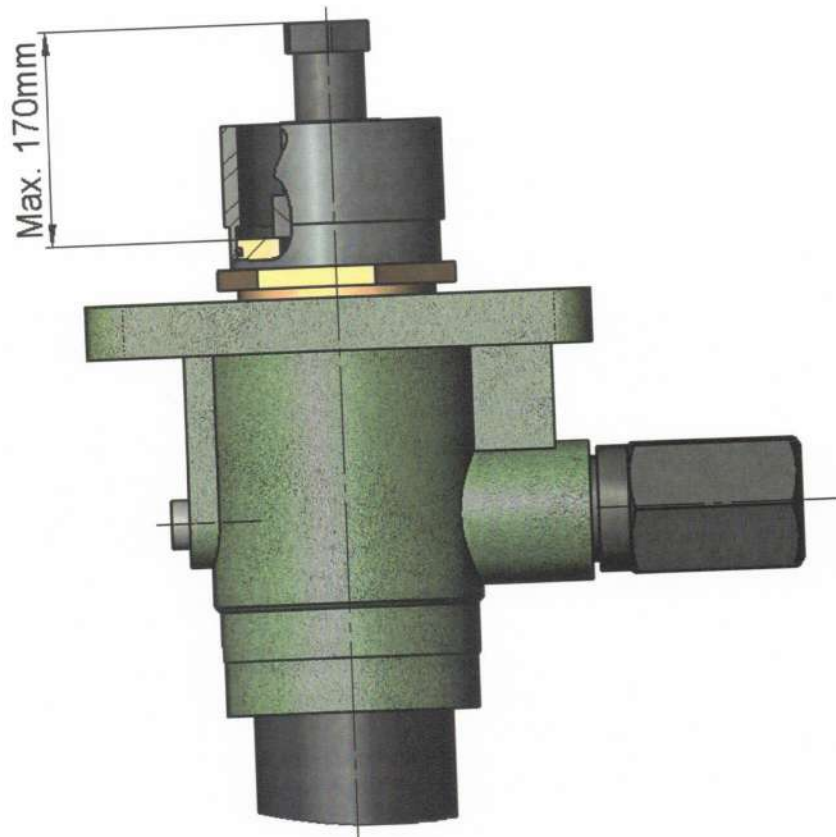


Curing agent pump 26200, Article no.: 42005900



ISI YOGEV INDUSTRIES Ltd.

Warning!
Piston Rod must maximum be pulled out 170mm
Going beyond this limit will cause damage of Piston



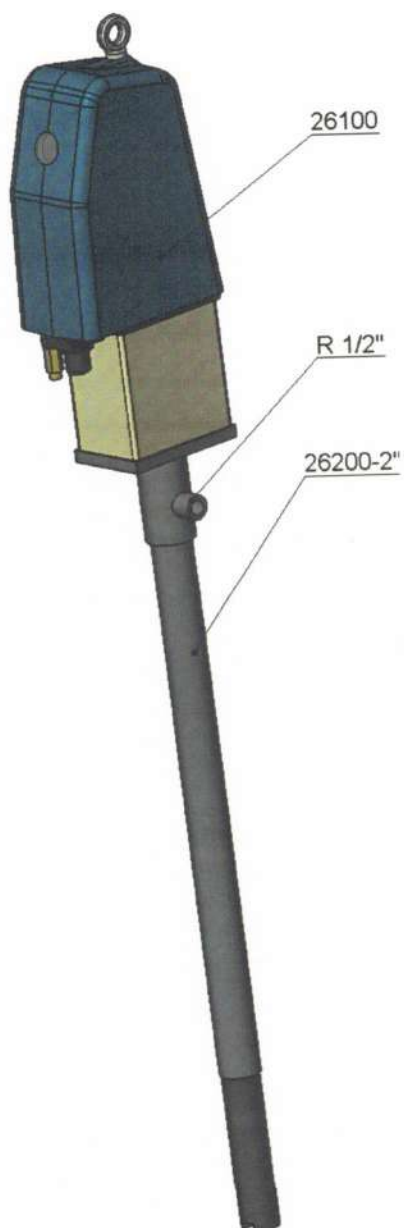
Base pump 84985, Article no.: 42003400



ISI YOGEV INDUSTRIES Ltd.

Air Motor & Pump 2600, Curing Agent

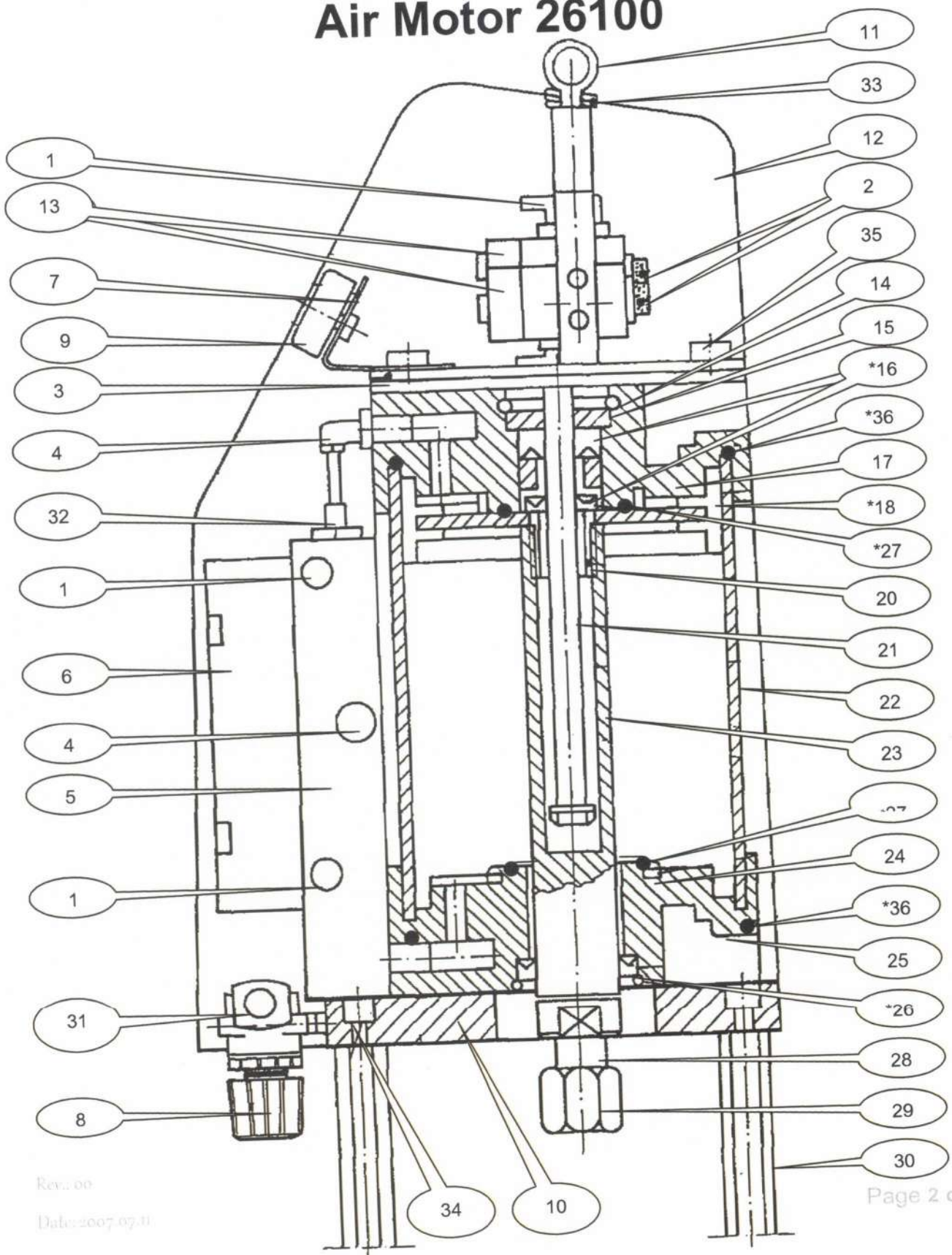
740 pistol



	Air motor	Pump tube	Operating pressure [bar]	Air consumption [l/min]	Max. Adhesive flow [l/min]
	26100	26200-2"	2-5	300	7
Article no	42005100				



Air Motor 26100



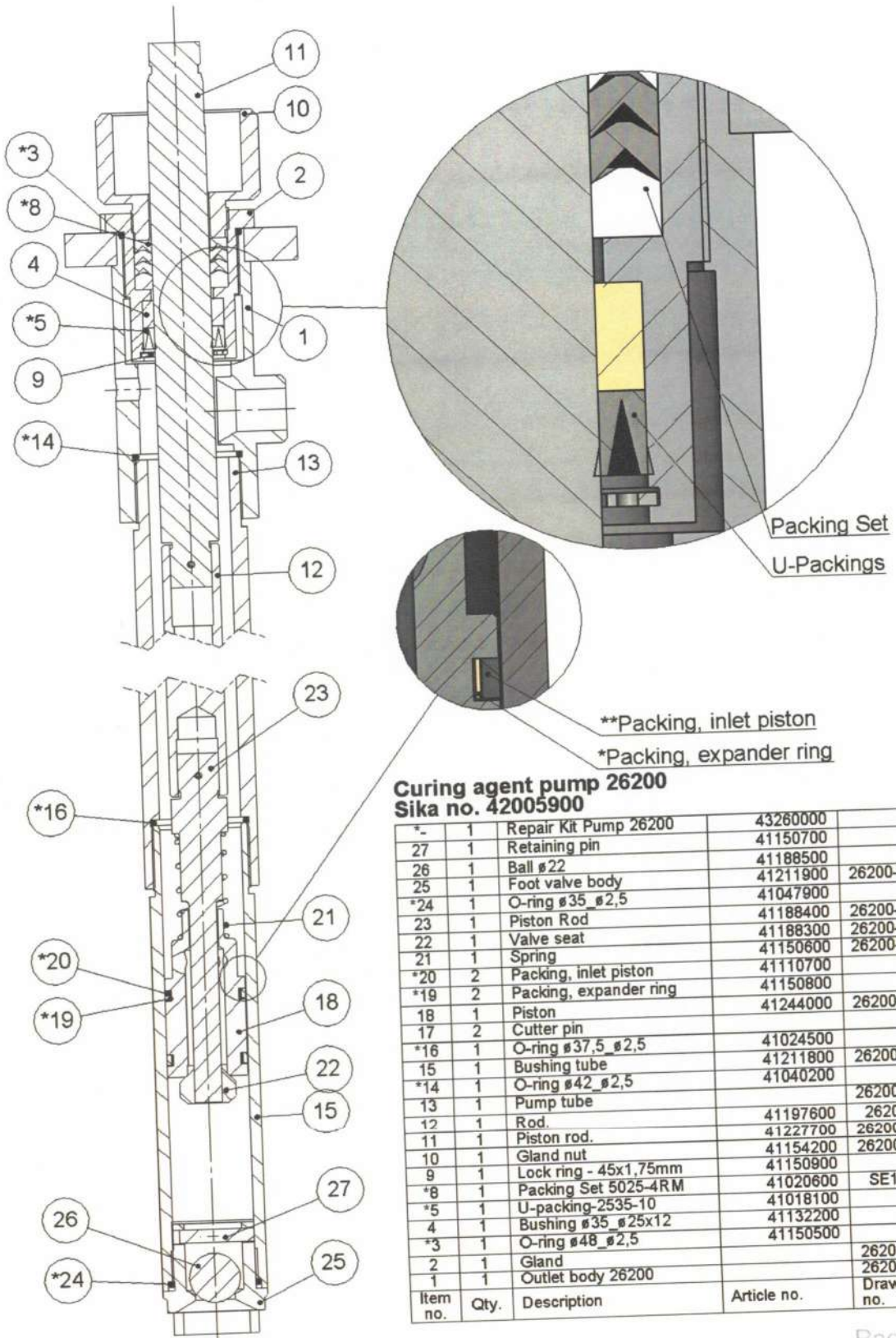


Air Motor 26100

Pos. No.	Pcs.	Description	Part No.	Sika no.
1	1	Coupling	90-418	
2	2	Silencer	2991-1/8"	41221800
3	1	Bracket	26100-019	
4	1	Coupling	90-838	
5	1	Bracket	580-269	41142400
6	1	Main Valve	581-233-100	41261800
7	1	Gauge bracket	26100-035	
8	1	Air regulator	26100-034	41120800
9	1	Gauge	40-1/8"B	
10	1	Motor bracket	26200-025	
11	1	Eye bolt	26100-021	
12	1	Cover	26100-020	
13	2	Control valve	343-005	41156200
14	1	Locking ring	26100-001	41261700**
15	1	Plate	26100-002	**
*16	1	Packing	26100-003	**
17	1	Top cover	26100-013	**
*18	1	Piston unit	26100-012	**
19	1	Packing	26100-004	**
20	1	Bushing	26100-005	**
21	1	Trip rod	26100-006	**
22	1	Cylinder tube	26100-016	**
23	1	Piston rod	26100-007	**
24	2	Ring	26100-014	**
25	1	End cover	26100-015	**
*26	1	Packing	26100-008	**
*27	2	Packing	11083	41077100
28	1	Coupling	15015	41176300
29	1	Nut	26200-024	
30	4	Distance pjece	90-814	
31	1	Coupling	838	
32	1	Coupling	26100-037	
33	2	Packing	M10 x 35	
34	4	Screw	M10 x 25	
35	4	Screw		
*36	1	Packing		41197000
*-	1	Packing kit		

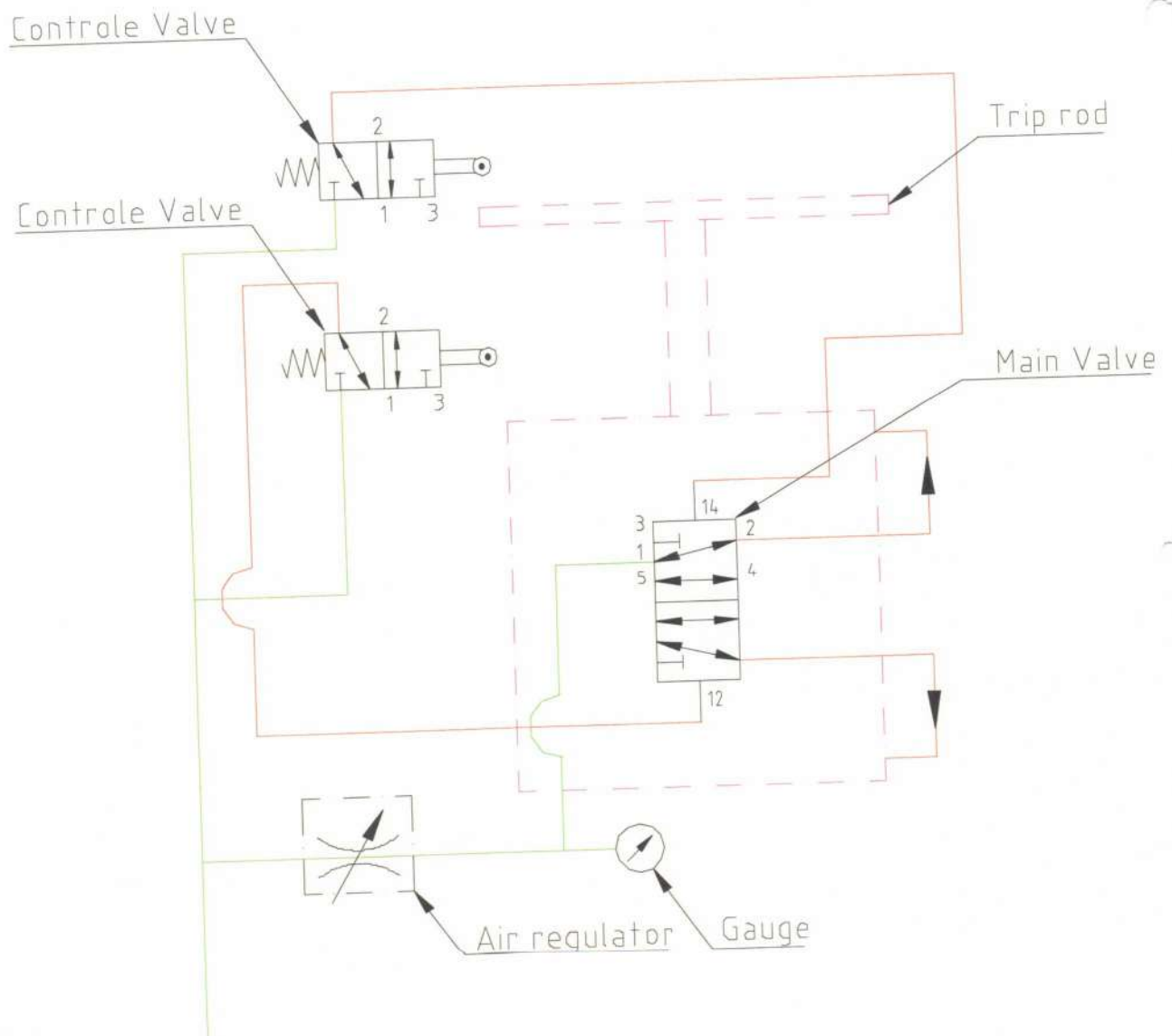


26200 Pump





Pneumatic Diagram Air motor





ISI YOGEV INDUSTRIES Ltd.

Air Motor 84808, Base

LINCOLN
INDUSTRIAL

Models 84803, 84804, 84806, 84808, 86810
3, 4 $\frac{1}{4}$, 6, 8 & 10 IN. AIRMOTORS
Series "B"

OWNERS MANUAL

IT IS THE RESPONSIBILITY OF THE OWNER AND/OR OPERATOR TO PROPERLY USE AND MAINTAIN THIS EQUIPMENT. CAREFULLY READ AND UNDERSTAND THE INSTRUCTIONS AND WARNINGS IN THIS MANUAL BEFORE OPERATING THIS EQUIPMENT.

If the operator is not fluent in English, the instructions and warnings shall be read and discussed in the operator's native language, making sure the operator comprehends the contents.

This equipment complies with OSHA Standards where applicable.

WARNING

DO NOT exceed the stated maximum working pressure of the airmotor or of the lowest rated component in your system.

DO NOT alter or modify any part of this equipment.

DO NOT operate this equipment with combustible gas.

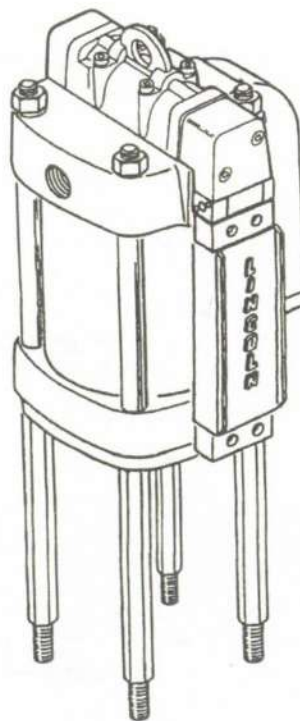
DO NOT attempt to repair or disassemble the equipment while the system is pressurized.

TIGHTEN all fluid connections securely before using this equipment.

ALWAYS read and follow the fluid manufacturer's recommendations regarding fluid compatibility, and the use of protective clothing and equipment.

CHECK all equipment regularly and repair or replace worn or damaged parts immediately.

IMPORTANT: Failure to heed these warnings including misuse, overpressurizing, modifying parts, using incompatible chemicals and fluids, or using worn or damaged parts, may result in equipment damage and/or serious personal injury, fire, explosion, or property damage.



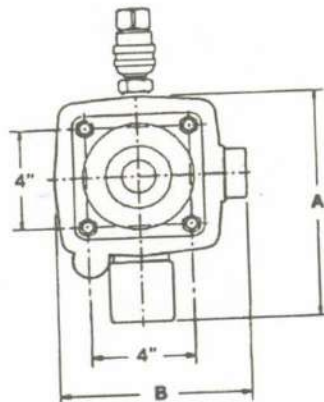
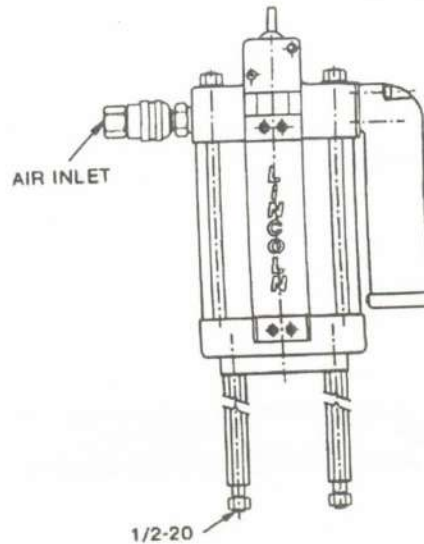
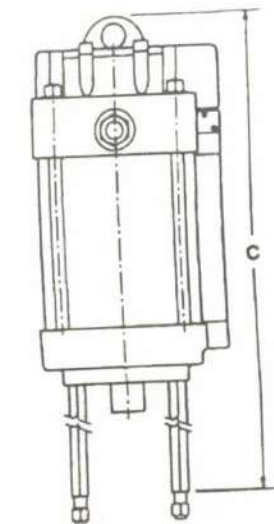
This manual contains IMPORTANT WARNINGS and INSTRUCTIONS. READ AND RETAIN FOR REFERENCE.

LINCOLN
INDUSTRIAL

One Lincoln Way
St. Louis, Missouri 63120-1578
(314) 679-4200

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Printed in U.S.A.

Section -A50
Page - 78F



NOTE:
Use only with 6 in. (152 mm) stroke
Pump Tubes. DO NOT OPERATE
with air contaminated with materials
not compatible with BUNA-N seals.

SPECIFICATIONS

MODEL	CYLINDER DIAMETER IN. (MM)	EFFECTIVE PISTON AREA IN ² (CM ²)	OPERATING PRESSURE RANGE PSIG (BAR)	OPERATING TEMP. RANGE °C (°F)	MIN. I.D. OF AIR SUPPLY IN. (MM)	AIR INLET	AIR CONS. @ 100 PSIG (7 BAR) SCF/CYCLE (L(N)/CYCLE)
86810	10 (254)	78 (506)	30-100 (2-7)	-30 - +200 (-34 - +93)	3/4 (20)	3/4" NPTF	3.6 (103)
84808	8 (203)	50 (324)	30-100 (2-7)		3/4 (20)	3/4" NPTF	2.6 (75)
84806	6 (152)	28 (182)	30-100 (2-7)		1/2 (12)	3/4" NPTF	1.6 (46)
84804	4 1/4 (108)	14 (92)	30-200 (2-14)		1/2 (12)	1/2" NPTF	1.1 (32)
84803	3 (76)	7 (46)	30-200 (2-14)		3/8 (10)	1/2" NPTF	0.7 (20)
MODEL	MAX. RECOM. SPEED CPM	STROKE LENGTH IN. (MM)	WEIGHT LB. (KG)	SEALS MATERIAL	DIM. A IN. (MM)	DIM. B IN. (MM)	DIM. C IN. (MM)
86810	75	6 (152)	62 (28.1)	BUNA-N and *TEFLON	13-1/4 (337)	11-5/8 (295)	22-3/4 (577)
84808			47 (21.2)		11-1/4 (286)	9-9/16 (243)	22-3/4 (577)
84806			34 (15.5)		9-1/4 (235)	7-3/4 (197)	22-3/4 (577)
84804			26 (11.7)		7-1/2 (191)	6 (152)	23-5/8 (599)
84803			25 (11.3)		7-1/2 (191)	6 (152)	23-5/8 (599)

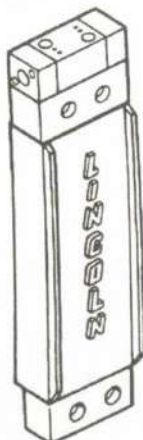
*TEFLON® Seals used with Power Valve Spool (Item 13) and Relay Valve (Item 17).



SERVICE ASSEMBLIES & KITS

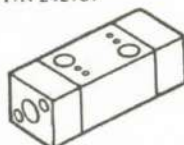
To reduce down-time and take advantage of the modular design of the airmotor, Lincoln recommends using the following Service Assemblies for repair of the airmotor. After removal, the faulty assembly can then be repaired using the corresponding Soft Parts Kit.

1. Pilot Bar Subassembly
P/N 242786 (4-1/4", 6", 8" & 10" Airmotor)
P/N 242799 (3" Airmotor)



2. Soft Parts Kit P/N 84967 for repair of Pilot Bar Subassemblies listed above. (Includes all necessary "O"-rings.)

3. Relay Valve: P/N 242787

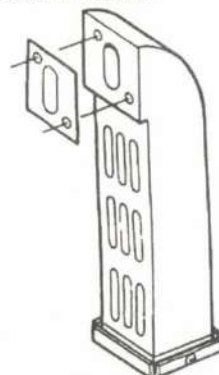


4. Air Signal Valve P/N 241768



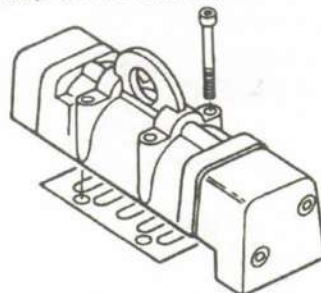
5. Cylinder Tube Soft Parts Kit
(Includes all "O"-rings, piston seal, etc.)
P/N 84789 (10" Airmotor)
P/N 84791 (8" Airmotor)
P/N 84792 (6" Airmotor)
P/N 84793 (4-1/4" Airmotor)
P/N 84794 (3" Airmotor)

6. Muffler with Gasket P/N 242788



7. Muffler Element Kit P/N 84939 for repair of Muffler listed above. (Includes element, felts and gasket.)

8. Power Valve Subassembly
P/N 244800 (10" Airmotor)
P/N 244804 (8" Airmotor)
P/N 244806 (6" Airmotor)
P/N 244808 (3" & 4-1/4" Airmotor)



9. Soft Parts Kit P/N 84968 for repair of Power Valve Subassemblies listed above.

10. Power Valve Spool & Body P/N 244802





WARNING

ALWAYS check equipment for proper operation before each use, making sure safety devices are in place and operating properly. **DO NOT** alter or modify any part of the equipment as this may cause a malfunction and result in serious bodily injury.

BEFORE CONNECTING AIRMOTOR TO AIR LINE

LINCOLN SERIES III AIRMOTORS are fully pneumatic and require a minimum specified size of air supply hose for proper operation. Check specification for minimum ID. of the air supply hose and select corresponding sizes of air controls and accessories for non-restrictive air flow. Lincoln filter, regulator with gauge and lubricators are available as combination units (FRL).

For 3/8" air line - Model 85387-6
For 1/2" air line - Model 85387-8
For 3/4" air line - Model 85387-12

If quick disconnect coupling should be used, install supplied coupler to insure proper airmotor operation.

NOTE: Whenever flammable materials are pumped, ground Airmotor according to Local Codes.

OPERATING PRECAUTIONS

Use Lincoln replacement parts to assure compatible pressure rating.

Heed ALL warnings.

DO NOT OPERATE Airmotor in excess of recommended pressure range.

Disconnect air line and relieve (vent) pressure when Airmotor sits idle for long periods of time and before servicing.



WARNING

ALWAYS read and follow the fluid and solvent manufacturer's recommendations regarding the use of protective clothing and equipment.



WARNING

To reduce the risk of serious bodily injury or property damage. **NEVER** exceed the maximum air or fluid working pressure of the lowest rated system component.

ATTACHING AIRMOTOR TO PUMPTUBE

1. Tightly attach the tie rods (Item 41) to the Airmotor lower casting. Use short threaded end of tie rods.
2. Mount Airmotor on top of pump tube outlet and tightly connect pump tube coupling nut to Airmotor Piston Rod (Item 5).
3. Hand tighten tie rods to the pump tube with four nuts (Item 42) supplied with Airmotor.
4. Connect air supply and slowly cycle pump several times using only enough air pressure to operate pump without stalling.
5. STOP pump on "UP" stroke and tighten four nuts to securely fasten Airmotor to pump tube.

SERVICE AND DISASSEMBLY PROCEDURE



WARNING

Always disconnect air supply to Airmotor and relieve pressure before checking, servicing, or repairing any part of Airmotor.

TOOLS REQUIRED

1. 7/64 (.109) Hex Wrench
2. 5/32 (.156) Hex Wrench
3. 3/16 (.189) Hex Wrench
4. 3/4 (.750) Open End Wrench (for 6" Airmotor)
5. 15/16" (.937) Open End Wrench (for 8" Airmotor)
6. 1/2" (.500) Open End Wrench (for 4-1/4" and 3" Airmotor)
7. 1-1/8" (1.125) Open End Wrench (for 10" Airmotor)
8. Pliers

The modular design of the Airmotor and accessibility of vital operation parts make service available without taking Airmotor out of line or without complete disassembly.

Power Valve

1. Remove four screws (Items 27 & 34) with 3/16" hex wrench (2 on each side).
2. Remove End Caps (Items 10 & 14).

4. Remove Spool Bumpers (Item 9) (One from each end).
5. Remove "O" Ring (Item 11) (One from each end of valve body).
6. Remove four Screws (Item 37) with 3/16" hex wrench and lift valve body (Item 12).
7. Remove Gasket (Item 15) to complete valve disassembly.
8. To REASSEMBLE, REVERSE procedure.

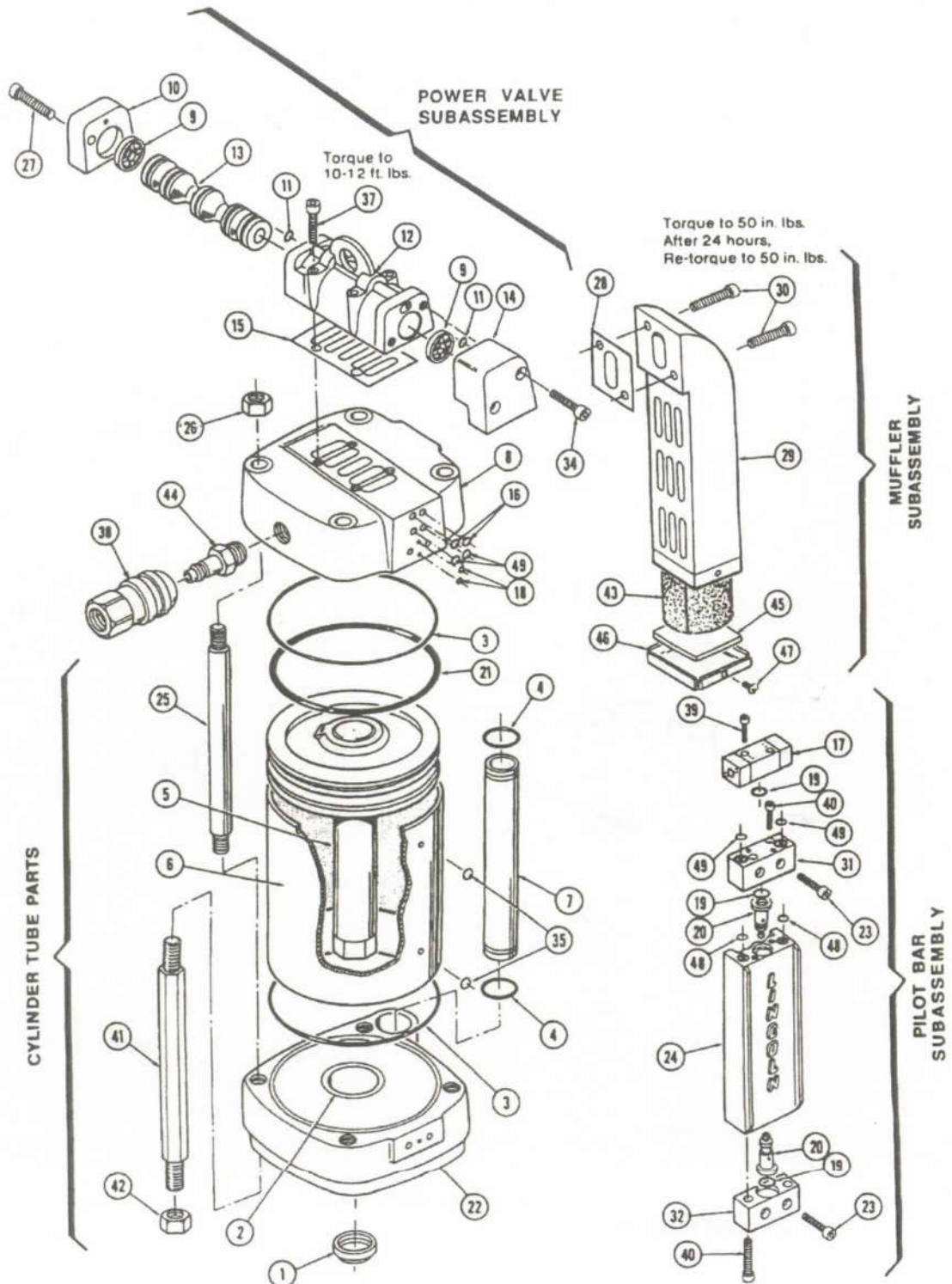
Pilot Bar Subassembly

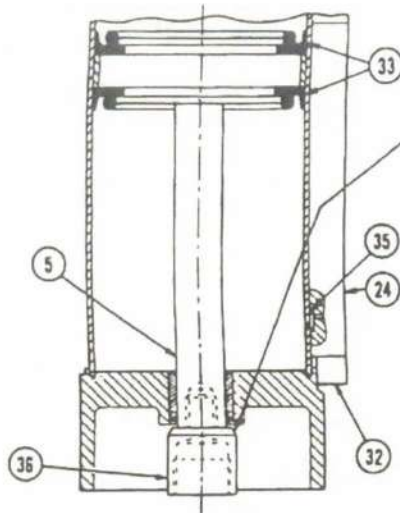
1. Remove four Screws (Item 23) (two on each end) with 3/16" hex wrench and pull out Pilot Bar Subassembly.
2. Remove two Screws (Item 39), with 7/64" hex wrench and lift out Valve Body (Item 17).
3. Remove four Screws (Item 40) (two on each side of Pilot Bar) and lift off Upper Bracket (Item 31) and Lower Bracket (Item 32).
4. Remove Air Signal Valves (Item 20).
5. To REASSEMBLE, REVERSE procedure.

Cylinder Tube and Muffler

1. Remove Air Brakes Subassembly (See previous instructions).
2. Remove two Screws (Item 30) with 3/16" hex wrench and pull off Muffler (Item 29).
3. Remove Gasket (Items 28).
4. Remove four Nuts (Item 26) with open end wrench.
5. Lift upward and remove Upper Casting (Item 8).
6. Remove four Tie Rods (Item 25).
7. Remove Air Tube (Item 7).
8. Lift upward and remove Cylinder Tube (Item 6).
9. Remove Piston and Piston Rod (Item 5).
10. Remove four Connecting Rods (Item 41) with open end wrench.
11. To REASSEMBLE, REVERSE procedure.

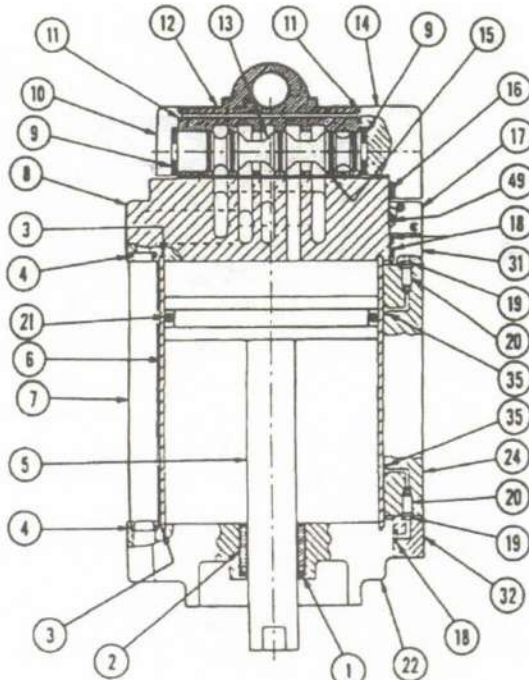
NOTE: Align two holes on the the Cylinder Tube (Item 6) with two holes on the Pilot Bar (Item 24) before tightening Tie Rods (Item 25) so that proper seal with "O-rings is achieved.



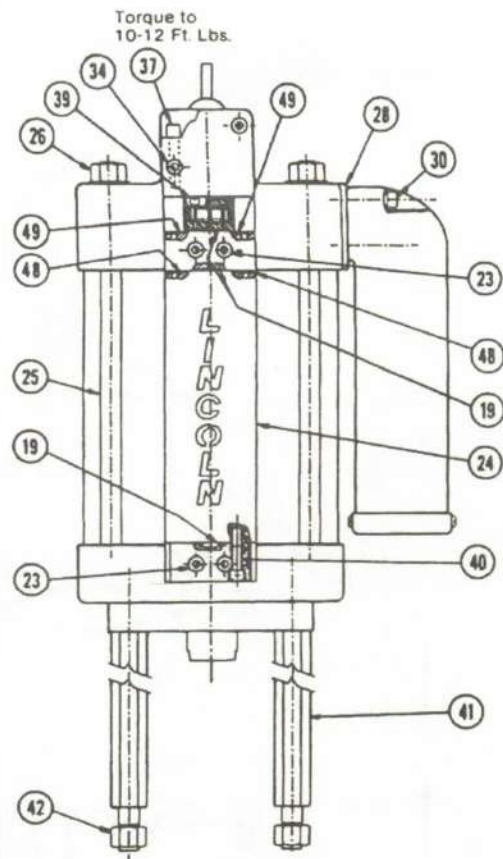


Assemble Adapter to Piston Rod
Using Loctite #242 Blue on threads
Torque to 60-65 Ft. Lbs.

MODELS 84803 and 84804



MODELS 84806, 84808, & 86810





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PARTS LIST

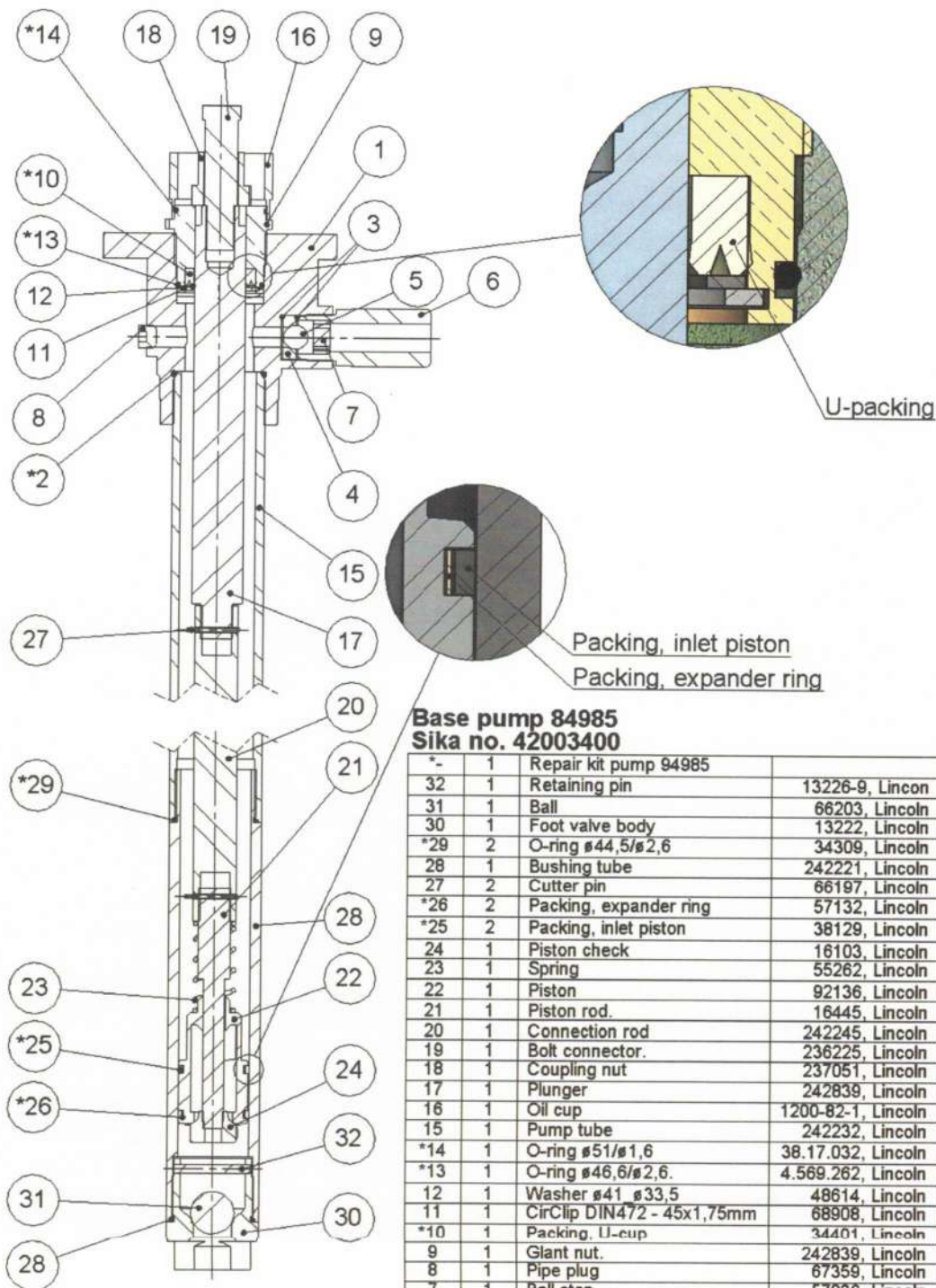
Item No.	Description	Qty.	Model 86810 (10" Dia.)	Model 84808 (8" Dia.)	Model 84806 (6" Dia.)	Model 84804 (4 1/4" Dia.)	Model 84803 (3" Dia.)
1	"U" Cup (Buna-N)	1	(Note #8)	(Note #1)	(Note #2)	(Note #3)	(Note #4)
2	Rod Bearing	1	247296	241732	241732	241733	241733
3	Seal, Cylinder (Buna-N)	2	(Note #8)	(Note #1)	(Note #2)	(Note #3)	(Note #4)
4	"O"-ring (Buna-N)	2	(Note #8)	(Note #1)	(Note #2)	(Note #3)	(Note #4)
5	Piston Rod Assembly	1	247449	241470	241741	241742	241743
6	Cylinder Tube	1	247448	241744	241745	241746	241747
7	Air Tube	1	247336	241748	241748	241749	241749
8	Upper Casting	1	247304	241750	241751	241752	241753
9	Bumper, Valve	2	(Note #7)	(Note #7)	(Note #7)	(Note #7)	(Note #7)
10	Cap, Valve	1	241755	241755	241755	241755	241755
11	"O"-ring (Buna-N)	2	(Note #7)	(Note #7)	(Note #7)	(Note #7)	(Note #7)
12	Body, Valve	1	(Note #9)	(Note #9)	(Note #9)	(Note #9)	(Note #9)
13	Spool, Valve	1	(Note #9)	(Note #9)	(Note #9)	(Note #9)	(Note #9)
14	Cap, Valve	1	247302	241759	241760	241761	241761
15	Gasket	1	(Note #7)	(Note #7)	(Note #7)	(Note #7)	(Note #7)
16	"O"-ring (Buna-N)	2	(Note #7)	(Note #7)	(Note #7)	(Note #7)	(Note #7)
17	Relay Valve	1	242787	242787	242787	242787	242787
18	"O"-ring (Buna-N)	3	(Note #6)	(Note #6)	(Note #6)	(Note #6)	(Note #6)
19	"O"-ring (Buna-N)	3	(Note #6)	(Note #6)	(Note #6)	(Note #6)	(Note #6)
20	Air Signal Valve	2	241768	241768	241768	241768	241768
21	"O"-ring Piston(Buna-N)	1	(Note #9)	(Note #1)	(Note #2)	—	—
22	Lower Casting	1	247303	241773	241774	241775	241776
23	Screw (1/4-20 x 7/8")	4	50526	50526	50526	50526	50526
24	Pilot Bar	1	241778	241778	241778	241778	241778
25	Tie Rod	4	247285	241766	241779	241767	241767
26	Nut	4	247298	51018	51007	51001	51001
27	Screw	2	244995	244995	244995	244995	244995
28	Gasket	1	(Note #5)	(Note #5)	(Note #5)	(Note #5)	(Note #5)
29	Muffler Body	1	241021	241021	241021	241021	241021
30	Screw (1/4-20 x 1 1/2")	2	50051	50051	50051	50051	50051
31	Bracket, Upper	1	241784	241784	241784	241784	241784
32	Bracket, Lower	1	241785	241785	241785	241785	241785
33	Seal, Piston	2	—	—	—	(Note #3)	(Note #4)
34	Screw	2	247299	244993	241783	244994	244994
35	"O"-ring (Buna-N)	2	(Note #6)	(Note #6)	(Note #6)	(Note #6)	(Note #6)
36	Adapter	1	—	—	—	241789	241789
37	Screw (1/4-20 x 2 1/4")	4	244975	244975	244975	244975	244975
38	Coupler	1	662012	655012	655012	655008	655008
39	Screw (6-32)	2	50816	50816	50816	50816	50816
40	Screw (1/4-20)	4	50823	50823	50823	50823	50823
41	Tie Rod	4	241023	241023	241023	241023	241023
42	Nut (1/2-20)	4	236023	236023	236023	236023	236023
43	Muffler Element	1	(Note #5)	(Note #5)	(Note #5)	(Note #5)	(Note #5)
44	Nipple	1	660112	653112	653112	653112	653112
45	End Element	1	(Note #5)	(Note #5)	(Note #5)	(Note #5)	(Note #5)
46	Muffler Plate	1	241027	241027	241027	241027	241027
47	Screw, Self Tapping (10-32)	2	66962	66962	66962	66962	66962
48	"O"-ring (Buna-N)	2	(Note #6)	(Note #6)	(Note #6)	(Note #6)	(Note #6)
49	"O"-ring (Buna-N)	4	(Note #6)	(Note #6)	(Note #6)	(Note #6)	(Note #6)

- NOTES: 1. Included in 84791 Cylinder Tube Soft Parts Kit for Model 84808 (8" Airmotor).
2. Included in 84792 Cylinder Tube Soft Parts Kit for Model 84806 (6" Airmotor).
3. Included in 84793 Cylinder Tube Soft Parts Kit for Model 84804 (4-1/4" Airmotor).
4. Included in 84794 Cylinder Tube Soft Parts Kit for Model 84803 (3" Airmotor).
5. Included in 84939 Muffler Element Kit.
6. Included in 84967 Soft Parts Kit for Pilot Bar Subassembly.
7. Included in 84968 Soft Parts Kit for Power Valve Subassembly.
8. Included in 84789 Cylinder Tube Soft Parts Kit for Model 86810 (10" Airmotor).
9. Included in 244802 Power Valve Spool & Body.



ISI YOGEV INDUSTRIES Ltd.

84985 Pump



Base pump 84985 Sika no. 42003400

*-	1	Repair kit pump 84985		43098500
32	1	Retaining pin	13226-9, Lincon	41243900
31	1	Ball	66203, Lincon	41029200
30	1	Foot valve body	13222, Lincon	41243800
*29	2	O-ring $\varnothing 44,5/\varnothing 2,6$	34309, Lincon	41040200
28	1	Bushing tube	242221, Lincon	
27	2	Cutter pin	66197, Lincon	
*26	2	Packing, expander ring	57132, Lincon	41109400
*25	2	Packing, inlet piston	38129, Lincon	41149800
24	1	Piston check	16103, Lincon	41104600
23	1	Spring	55262, Lincon	41070100
22	1	Piston	92136, Lincon	41115900
21	1	Piston rod.	16445, Lincon	41107400
20	1	Connection rod	242245, Lincon	
19	1	Bolt connector.	236225, Lincon	41102000
18	1	Coupling nut	237051, Lincon	41103000
17	1	Plunger	242839, Lincon	41133200
16	1	Oil cup	1200-82-1, Lincon	41147000
15	1	Pump tube	242232, Lincon	
*14	1	O-ring $\varnothing 51/\varnothing 1,6$	38.17.032, Lincon	41148800
*13	1	O-ring $\varnothing 46,6/\varnothing 2,6$.	4.569.262, Lincon	41186300
12	1	Washer $\varnothing 41 \varnothing 33,5$	48614, Lincon	
11	1	CirClip DIN472 - 45x1,75mm	68908, Lincon	
*10	1	Packing, U-cup	34401, Lincon	41041900
9	1	Glant nut.	242839, Lincon	41106000
8	1	Pipe plug	67359, Lincon	
7	1	Ball stop.	57036, Lincon	
6	1	Outlet body	12017, Lincon	
5	1	Ball	66284, Lincon	41029500
4	1	Outlet Check	11948, Lincon	41080300
3	2	Gasket	31033, Lincon	
*2	1	O-ring $\varnothing 50/\varnothing 2,6$.	34296, Lincon	41096300
1	1	Outlet body	242216, Lincon	
Item no.	Qty.	Description	Supp. id	Article no.



ISI YOGEV INDUSTRIES Ltd.



Models 84981, 84982, 84983, 84984, 84985
POWER-MASTER III DRUM PUMPS
Ball Type Foot Valve

OWNER/OPERATOR MANUAL

It is the responsibility of the Owner/Operator to properly use and maintain this equipment.

The Instructions and Warnings contained in this manual shall be read and understood by the Owner/Operator prior to operating this equipment.

It is the responsibility of the Owner/Operator to maintain the legibility of all Warning and Instruction labels.

The Owner/Operator shall retain this manual for future reference to important Warnings, Operating and Maintenance Instructions.



WARNING

DO NOT operate these pumps with 10" airmotor.

DO NOT exceed the stated maximum working pressure of the airmotor or the lowest rated component in your system.

DO NOT alter or modify any part of this equipment.

DO NOT operate this equipment with combustible gas.

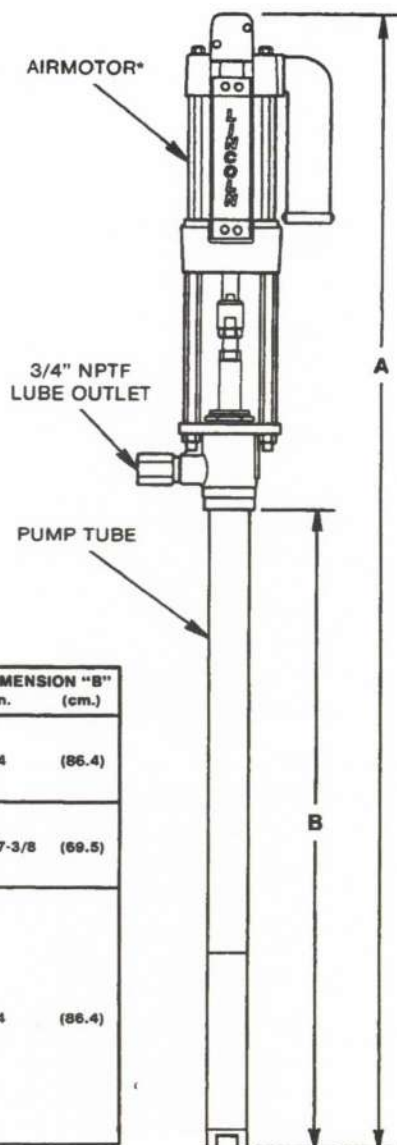
DO NOT attempt to repair or disassemble the equipment while the system is pressurized.

TIGHTEN all fluid connections securely before using this equipment.

ALWAYS read and follow the fluid manufacturer's recommendations regarding fluid compatibility, and the use of protective clothing and equipment.

CHECK all equipment regularly and repair or replace worn or damaged parts immediately.

IMPORTANT: Failure to heed these warnings including misuse, overpressurizing, modifying parts, using incompatible chemicals and fluids, or using worn or damaged parts, may result in equipment damage and/or serious personal injury, fire, explosion, or property damage.



MODEL CHART

PUMP TUBE	PUMP MODEL	AIRMOTOR*	RATIO	MAXIMUM DELIVERY PRESSURE	MAXIMUM AIR PRESSURE	DIMENSION "A" in. (cm.)	DIMENSION "B" in. (cm.)
84985	2061	84808	42:1	4200 psi (294 bar)	100 psi (7 bar)	60 (152.4)	34 (86.4)
	2021	84806	24:1	2400 psi (168 bar)	200 psi (14 bar)	60-7/8 (154.6)	
	2001	84804	12:1	2400 psi (168 bar)			
	2052	84803	6:1	1200 psi (84 bar)			
84984	2065	84808	42:1	4200 psi (294 bar)	100 psi (7 bar)	53-3/8 (135.6)	27-3/8 (69.5)
	2025	84806	24:1	2400 psi (168 bar)	200 psi (14 bar)	54-1/4 (137.8)	
	2005	84804	12:1	2400 psi (168 bar)			
	2055	84803	6:1	1200 psi (84 bar)			
84983	2061-7	84808	42:1	4200 psi (294 bar)	100 psi (7 bar)	60 (152.4)	34 (86.4)
	2021-7	84806	24:1	2400 psi (168 bar)	200 psi (14 bar)	60-7/8 (154.6)	
	2001-7	84804	12:1	2400 psi (168 bar)			
	2052-7	84803	6:1	1200 psi (84 bar)			
84982	2061-8	84808	42:1	4200 psi (294 bar)	100 psi (7 bar)	60 (152.4)	34 (86.4)
	2021-8	84806	24:1	2400 psi (168 bar)	200 psi (14 bar)	60-7/8 (154.6)	
	2001-8	84804	12:1	2400 psi (168 bar)			
	2052-8	84803	6:1	1200 psi (84 bar)			
84981	2061-9	84808	42:1	4200 psi (294 bar)	100 psi (7 bar)	60 (152.4)	34 (86.4)
	2021-9	84806	24:1	2400 psi (168 bar)	200 psi (14 bar)	60-7/8 (154.6)	
	2001-9	84804	12:1	2400 psi (168 bar)			
	2052-9	84803	6:1	1200 psi (84 bar)			

* Refer to Airmotor Owner/Operator Manual, Section A5 Page 78.



A PENTAIR COMPANY

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Re

Date: 2007.06.26

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ATTACHING AIMOTOR TO PUMPTUBE

1. Tightly attach tie rods to the airmotor (use short threaded end of the tie rods).
2. Mount airmotor on top of the pump-tube outlet and tightly connect Coupling Nut (Item 2) to airmotor piston rod.
3. Hand tighten tie rods to the pumptube with four nuts supplied with airmotor.
4. Slowly cycle the pump several times, using just enough air pressure to operate the pump without stalling.
5. Stop the pump on an "up" stroke and tighten the four nuts to securely fasten the airmotor to the pumptube.

OPERATING PRECAUTIONS

- Use Lincoln replacement parts to assure compatible pressure rating.
- **HEED ALL WARNINGS.**
- Be sure material hoses and other components are able to withstand fluid pressures developed by this pump.
- Do not operate pump continuously at speeds in excess of 75 cycles per minute.
- Disconnect air line from pump airmotor when system sits idle for long periods of time.
- **SERVICING:** Before servicing or cleaning pump, or removing fluid hose or gun from a unit that has been used, be sure to disconnect air lines and carefully bleed pressure off of the system.

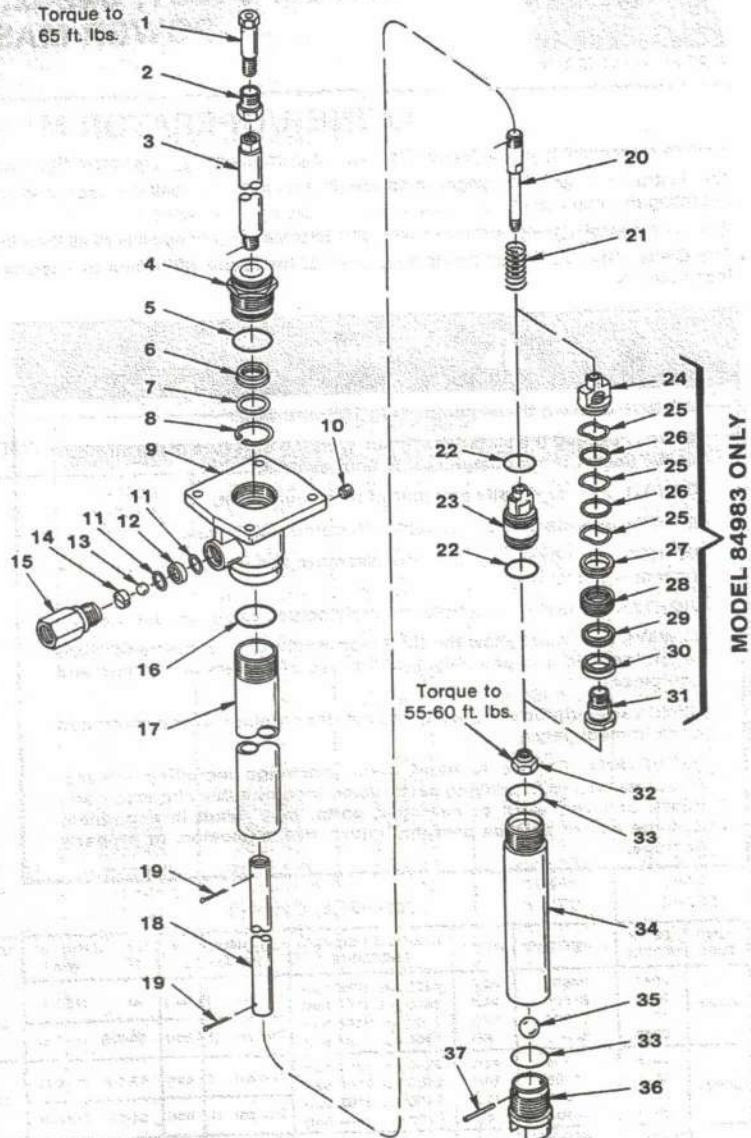


WARNING

PREVENT STATIC SPARKING. If static sparking occurs, fire or explosion could result. Pump, dispensing valve, and containers must be grounded when handling flammable fluids such as petroleum products, paints, lacquers, etc. and wherever discharge of static electricity is hazard.

- Check continuity (a good static wire connection) with an ohmmeter. Place one probe on one hose fitting and the other probe on other hose fitting, continuity or proper grounding through hose is good when a reading is obtained on the ohmmeter.
- **PREVENT FIRES.** When pumping, flushing or recirculating volatile solvents, the area must be adequately ventilated.
- Keep solvents away from heat, sparks and open flames. Keep containers closed when not in use.

Torque to 65 ft. lbs.



Torque to 55-60 ft. lbs.



CAUTION

DO NOT allow pump to operate when out of material.

PUMP PRIMING

To begin operation, the pump has to be primed with the pumped material. The Power-Master III pump is a double acting (pumps material on "up" & "down" stroke) positive displacement reciprocating pump and as such intakes material only on the "up" stroke.

To prime pump, open output line (material valve) and slowly open air supply valve until pump starts. Allow pump to cycle very slowly until all air is pushed out of lines and material fills up pump and lines. Close output line (material shut-off valve) - pump should stall against pressure.

Note: Pumps are factory tested with light oil and some of it is left in to protect pump parts during storage and transportation. To prevent contamination of material to be pumped, flush pump before using.



DISASSEMBLY

Tools Required

- 2-1/8" Dia. Strap Wrench
- 7/8" Hex Wrench
- 2-1/4" Hex Wrench
- 1-3/8" Hex Wrench
- Retaining Ring Pliers (Internal)
- 5/8" Hex Wrench
- 1" Hex Wrench

Procedure

1. Remove Foot Valve Body (Item 36) from Bushing Tube (Item 34).
2. Slide Retaining Pin (Item 37) from Foot Valve Body (Item 36) and remove Ball (Item 35).
3. Unscrew Bushing Tube (Item 34) and slide off of Piston (Item 23).
4. Remove Bolt Connector (Item 1) from Plunger (Item 3).
5. Pull Piston (Item 23) to remove Plunger (Item 3), Connecting Rod (Item 18) and Piston Assembly from Pump Tube (Item 17).
6. Remove Pump Tube (Item 17) from Outlet Body (Item 9).
7. Remove O-ring (Item 16) from Outlet Body (Item 9).
8. Remove Gland Nut (Item 4) from Outlet Body (Item 9).
9. Remove Outlet Body (Item 15) from Outlet Body (Item 9).
10. Remove Ball (Item 13), Check Seat (Item 12) and Gaskets (Item 11) from Outlet Body (Item 9).
11. Remove Retaining Ring (Item 8), Packing Washer (Item 7) and U-cup (Item 6) from Gland Nut (Item 4).
12. Remove Piston Check (Item 32) from Piston Rod (Item 20).
13. Remove Piston (Item 23) and Spring (Item 21) from Piston Rod (Item 20).
14. Remove Cotter Pins (Item 19) from Connecting Rod (Item 18).
15. Remove Piston Rod (Item 20) and Plunger (Item 3) from Connecting Rod (Item 18).
16. To re-assemble pump, reverse disassembly procedure. (Refer to illustration for torque specifications.)

TROUBLESHOOTING

Problem	Possible Cause	Solution
Pump does not operate.	Restricted or inadequate air supply.	Check air supply pressure and air hose diameter (see Airmotor manual for minimum air supply hose diameter).
	Obstructed material output.	Check output line for restrictions.
Erratic or accelerated operation.	Pump is not primed.	Prime pump (see "Pump Priming" instructions).
	Insufficient material supply.	Refill material supply.
	Material is too heavy for priming.	Lower output with material valve. Increase pressure to pressure primer (if in use). Check for inlet restrictions.
Pump operates on "down" stroke only (missing "up" stroke).	Worn or damaged Piston O-rings (Item 22) or Piston Check (Items 23 & 32).	Check and replace if needed.
Pump operates on "up" stroke only (missing "down" stroke).	Worn or damaged Inlet Check (Items 35 & 36).	Check and replace if needed.
	Insufficient material supply. Pump is not intaking enough material to dispense on both strokes.	Check inlet for restrictions. Lower output with material valve.
Pump is operating but not dispensing material.	Inlet Check (Items 35 & 36) is not seating or is damaged.	Check and replace if needed.

ACCESSORIES AND PACKING KITS

86214 Gland Protection Sleeve - To increase life of gland seal.

86213 Lube Cup - For solvent, to prevent material from drying on pump rod.

84502 Teflon Packing Kit - For Models 84981, 84982, 84984 & 84985.

86221 Viton Packing Kit - For Models 84981, 84982, 84984 & 84985.

16177 Foot Valve Adapter - Converts pump inlet to 1-1/2" NPTF Female.

84112 Pump Piston Replacement - With Leather V-packings (standard on Model 84983).

PUMP REPAIR KITS:

86219 - Includes soft parts for Models 84983*, 84984 & 84985.

86220 - Includes soft parts for Models 84981 & 84982.

86222 - Piston rebuild kit for Model 84983*.

*Model 84983 requires Kits 86219 & 86222 for rebuild.



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SPECIFICATIONS

Pump stroke - 6 in. (152 mm)

Output per cycle - 11.9 cu. in. (195 cc)

Max. recommended speed (continuous) - 75 cycles/min.

Approx. cycles per gallon (liter) - 20 (5)

Output at 75 cycles/min. - 3.9 gpm (14.6 liter/min.)

Wetted part materials:

84985 - Steel, Brass, Copper, Polyurethane, Nitrile

84984 - Steel, Brass, Copper, Polyurethane, Nitrile

84983 - Steel, Brass, Copper, Polyurethane, Leather, Teflon, Nitrile

84982 - Chrome Plated Steel, Stainless Steel, Brass, Polyurethane, Nitrile

84981 - Stainless Steel, Polyurethane, Nitrile, Teflon

PARTS LIST

ITEM NO.	DESCRIPTION	QTY.	PART NUMBER				
			Model 84981	Model 84982	Model 84983	Model 84984	Model 84985
1	Bolt Connector	1	236225	236225	236225	236225	236225
2	Coupling Nut	1	237051	237051	237051	237051	237051
3	Plunger	1	242840	242839	242839	242839	242839
4	Gland Nut	1	242844	242843	242843	242843	242843
5	O-ring	1	(Note #2)	(Note #2)	(Note #1)	(Note #1)	(Note #1)
6	U-cup Packing	1	(Note #2)	(Note #2)	(Note #1)	(Note #1)	(Note #1)
7	Packing Washer	1	(Note #2)	(Note #2)	(Note #1)	(Note #1)	(Note #1)
8	Retaining Ring	1	(Note #2)	(Note #2)	(Note #1)	(Note #1)	(Note #1)
9	Outlet Body	1	242223	242223	242216	242216	242216
10	Pipe Plug	1	----	----	67359	67359	67359
11	Gasket	2	----	----	(Note #1)	(Note #1)	(Note #1)
12	Outlet Check	1	----	----	11948	11948	11948
13	Ball	1	----	----	66285	66285	66285
14	Ball Stop	1	----	----	57036	57036	57036
15	Outlet Body	1	----	----	12017	12017	12017
16	O-ring	1	(Note #2)	(Note #2)	(Note #1)	(Note #1)	(Note #1)
17	Pump Tube	1	242228	242228	242232	242235	242232
18	Connecting Rod	1	242243	242243	242245	242244	242245
19	Cotter Pin	2	(Note #2)	(Note #2)	(Note #1)	(Note #1)	(Note #1)
20	Piston Rod	1	16445-9	16445-8	16445	16445	16445
21	Spring	1	55292	55292	55262	55262	55262
22	O-ring	2	(Note #2)	(Note #2)	----	(Note #1)	(Note #1)
23	Piston	1	14611-9	92136-8	----	92136	92136
24	Piston Rod Guide	1	----	----	14994	----	----
25	Wave Washer	3	----	----	(Note #3)	----	----
26	Washer	2	----	----	(Note #3)	----	----
27	Male Adapter	1	----	----	14993	----	----
28	Leather V-packing	4	----	----	(Note #3)	----	----
29	Teflon V-packing	1	----	----	(Note #3)	----	----
30	Female Adapter	1	----	----	14861	----	----
31	Piston Nut	1	----	----	14859	----	----
32	Piston Check	1	16103-9	16103-8	16103	16103	16103
33	O-ring	2	(Note #2)	(Note #2)	(Note #1)	(Note #1)	(Note #1)
34	Bushing Tube	1	242215	242220	242221	242221	242221
35	Ball	1	68785	68649	66203	66203	66203
36	Foot Valve Body	1	13222-9	13222-9	13222	13222	13222
37	Retaining Pin	1	13226-9	13226-9	13226-9	13226-9	13226-9

NOTES:

1. Included in 86219 Pump Repair Kit.
2. Included in 86220 Pump Repair Kit.
3. Included in 86222 Piston Repair Kit.

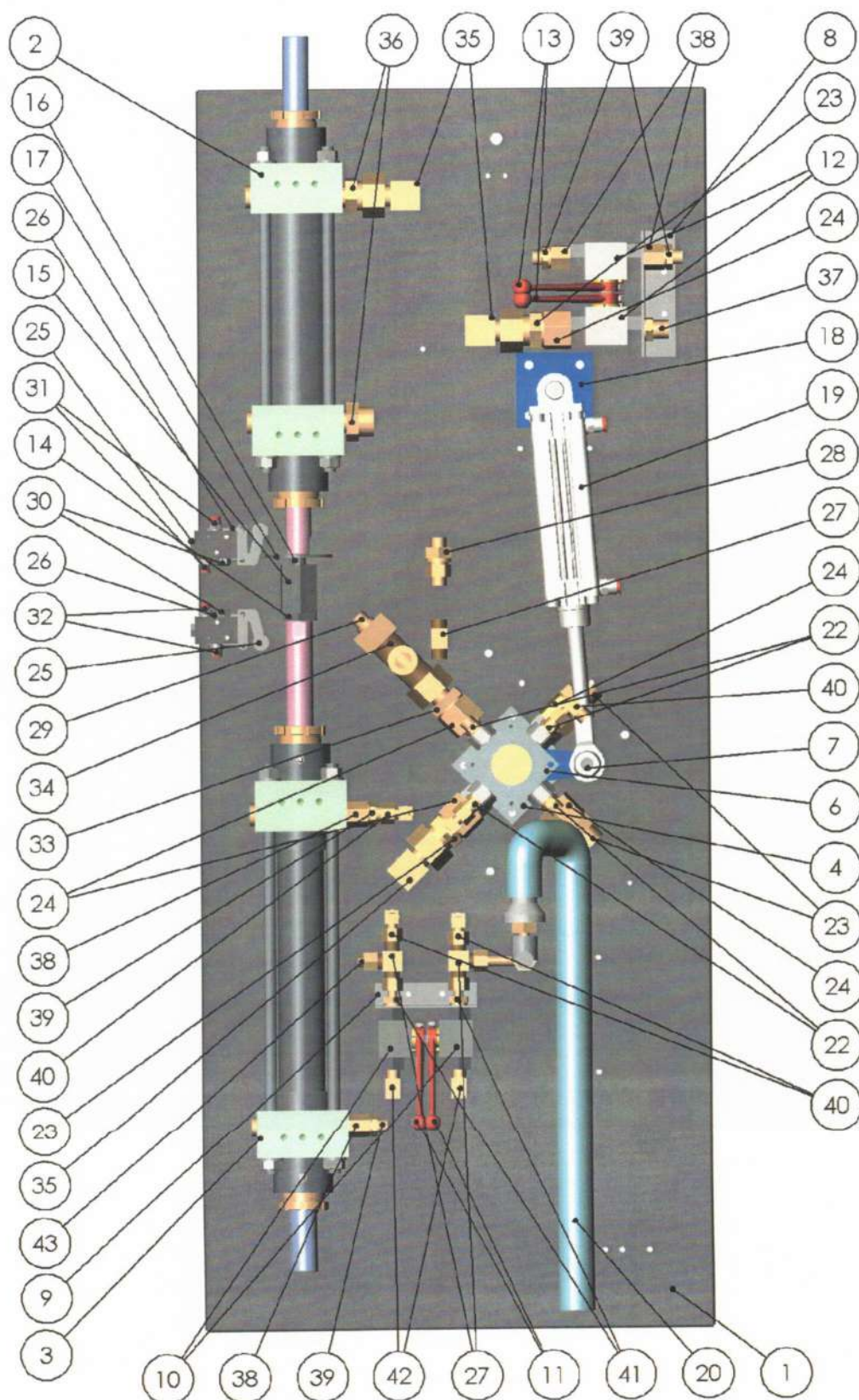
RETAIN THIS INFORMATION FOR FUTURE REFERENCE

When ordering replacement parts, list Part Number, Description, Model Number and Series Letter.

LINCOLN provides a Distributor Network that stocks equipment and replacement parts.



Meter Panel, front



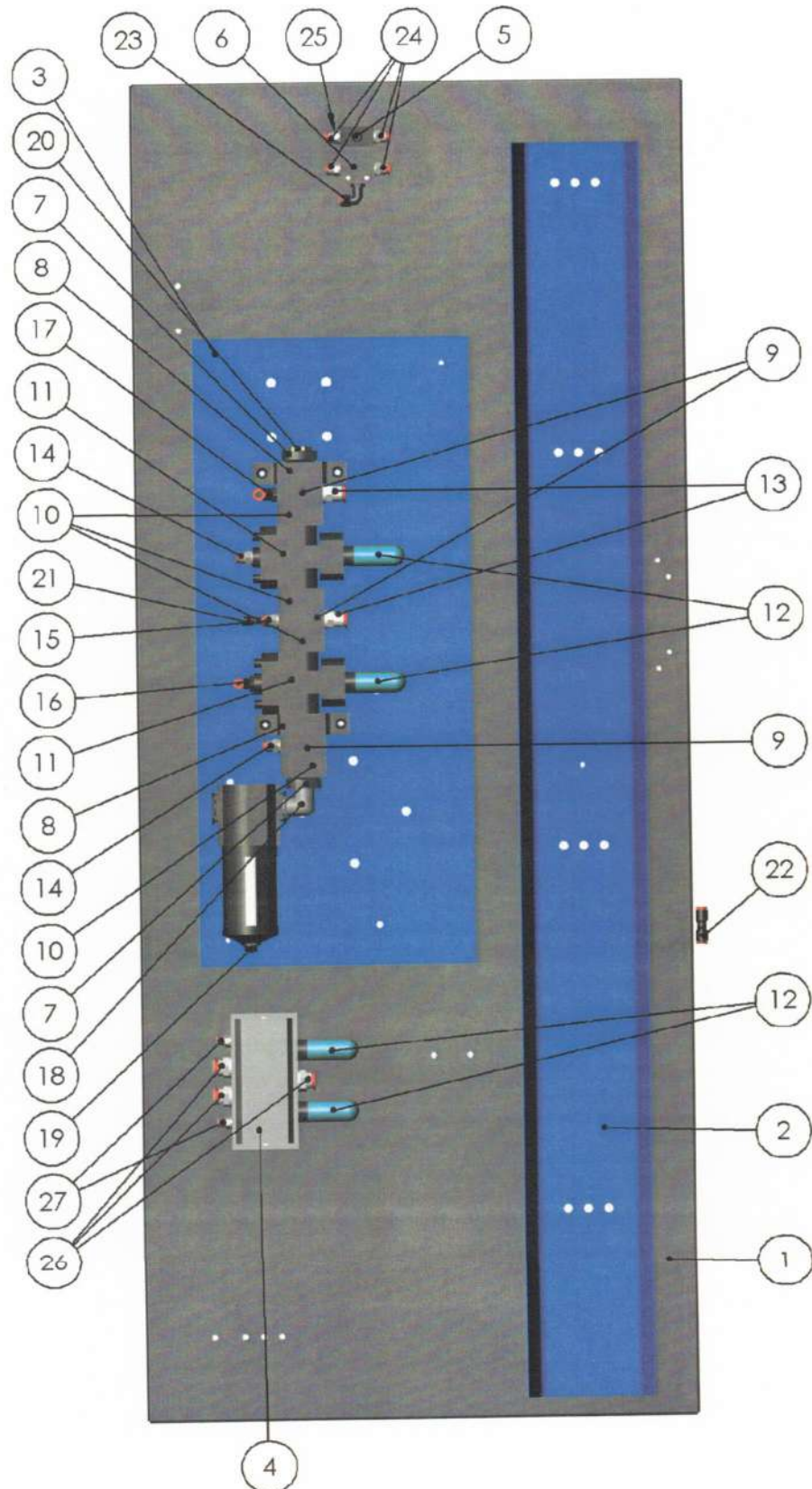


Meter Panel 1200H:

Item no.	Qty.	Description	Supp. id	Article no.	Drawing no.
1	1	Assembly plate for dosagem Unit 1200		41194000	SE100017
2	1	Base Cylinder 7030 B		41180100	SE100018
3	1	Curing Agent Cylinder 4532 AFPU		41154900	SE100020
4	1	Hydr. valve Ball 4 Way $\phi 1/2"$	BKMX 1/2"		
5	3	Distance $\phi 10 \times 50$			
6	1	Hydr. valve Ball 4 Way $\phi 3/8"$	BKMX 3/8"	41128400	SE10019
7	1	Arm for valve.			1200-3A
8	1	Mount for valve02			1200-203
9	1	Mount for valve01			1200-202
10	2	Hydr. Valve Ball Block $\phi 3/8$	BK 3/8"	41140400	
11	2	Hydr. Valve Handel $\phi 3/8$		41248400	
12	2	Hydr. Valvddde Ball Block $\phi 1/2"$	BK 1/2"	41154100	
13	2	Hydr. Valve Handel $\phi 1/2"$		41248500	
14	1	1200-45 coupling			1200-45
15	1	1200-46 mutter.			1200-46
16	1	1200-47-socket			1200-47
17	1	1210-2 Washer			1210-2
18	1	Cylinder bracket			
19	1	$\phi 50$ DV VDMA cylinder	PRA/182050/M/125		
20	1	Ventilation			
21	1	Window			
22	4	Hydr. Fit. Stra. Union $\phi 12-3/8"$ I-U		41237100	
23	4	Hydr. Fit. Stra. Union $\phi 25-1"$ I-U		41261100	
24	5	Highp. Fit. Nip. Socket $\phi 1-1/2"$ I-U		41261400	
25	2	G1/8 mek. akt. valve 3/2	S/666/8		
26	2	Mount for switch			
27	3	T-connection $\phi 12$	G 12 l.		
28	1	Hydr. Valve Non-Return 1Bar $\phi 12$		41180500	
29	1	Hydr. Fit. Reduction $\phi 25-12$ mm U-I		41261500	
30	2	G1/8 Filter	M/1511		
31	2	Pneu fit.strat. Union $\phi 6-1/8"$	C02250618		
32	2	Pneu fit.strat. Union $\phi 4-1/8"$	C02250418		
33	1	Hydr. Fit. Stra. Union $\phi 25-1"$ U-U		41261300	
34	1	T-connection $\phi 25$		41136600	
35	3	Angel $\phi 25$		41261200	
36	2	Hydr. Fit. Stra. Union $\phi 25-1"$ I-U		41261100	
37	1	Hydr. Fit. Stra. Union $\phi 15-1/2"$ I-U	A15LR1/2"WD		
38	4	Highp. Fit. Nip. Socket $\phi 1/2-1/2"$		41163400	
39	4	Hydr. Fit. Stra. Union $\phi 12-1/2"$ I-U		41255800	
40	5	Hydr. Fit. Adj. Elbow $\phi 12$ I-U		41204600	
41	2	Screw with shaft $\phi 12-3/8"$	VA 12 R1	41182800	
42	2	Angel $\phi 12-3/8"$	B 12 RLX		
43	1	Plug $\phi 12$	STO 12		



Meter Panel, back

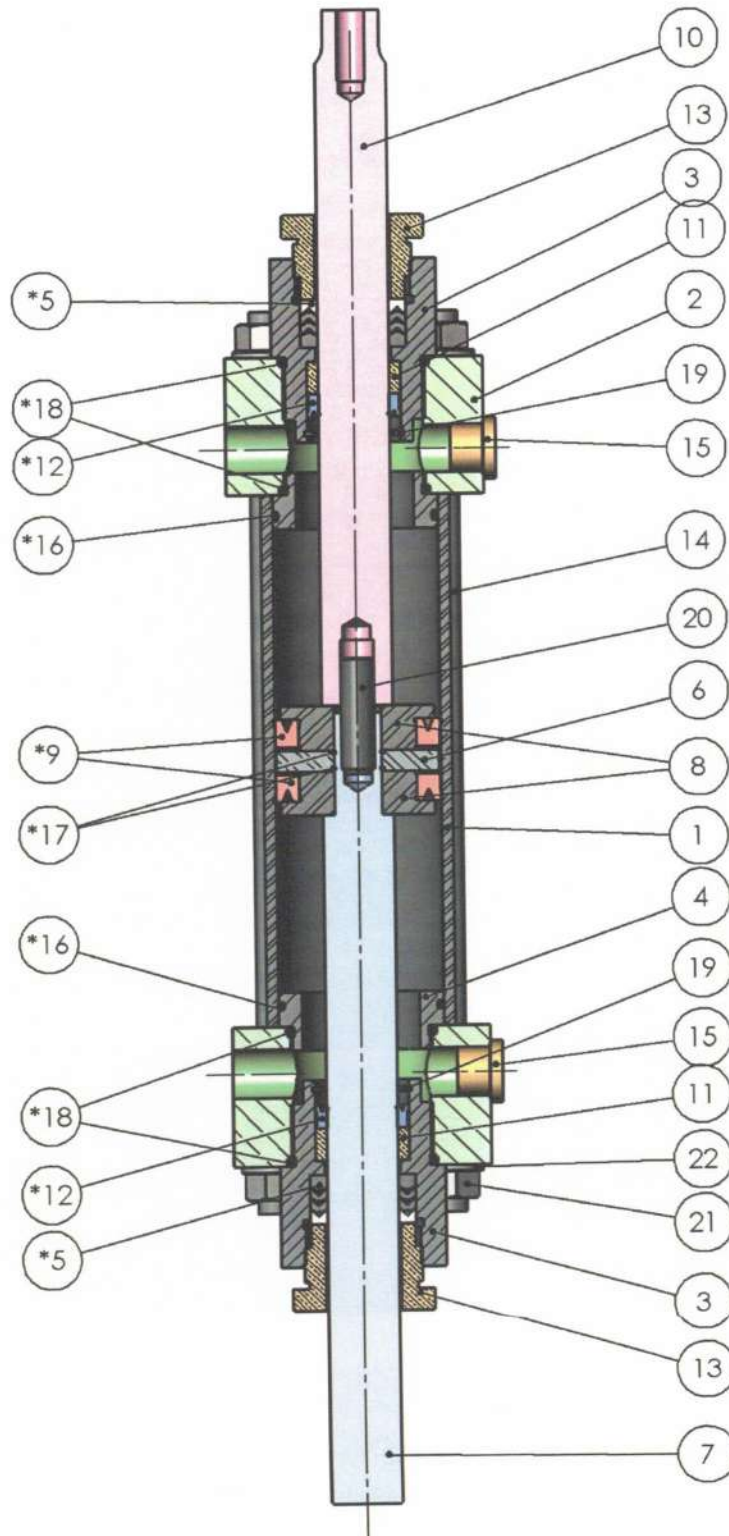


**Meter Panel 1200H:**

Item no.	QTY.	Description	Supp. id.	Article no.
1	1	Assembly plate for dosagem Unit 1200		
2	1	Strengthening profile		
3	1	Back plate		
4	1	ISO3 luft akt. valve 5/2	SXP0575-170-00 & M/P 19138	
5	1	G1_8 man. akt. valvel 3/2 with spring	03042402	
6	1	T65C1800 Shuttle valve	T65C1800	
7	2	End cab	4315-11	
8	2	Mount	4314-52	
9	3	1/4" Distribution block	4316-06	
10	4	Mount	4314-51	
11	2	Solenoid operated controle valve 3-2	P74C-NGA-NNN	
12	4	Silencer 1_2	M/S4	
13	2	Pneu fit.strat. Union ø12 -1/4"	S02251228	
14	2	Pneu fit.strat. Union ø6 -1/4"	C02250628	
15	1	Pneu fit.strat. Union ø08-1/4"	C02250828	41229200
16	1	90 Angel Ø6 x 1/4"	C02470628	
17	1	90 Angel Ø8 x 1/4"	C02470828	
18	1	Angel 1/2"	150400048	
19	1	1/2" filter 25my	F74G-4GN-AP2	
20	1	Plug 1/2"		
21	1	Hose Adaptor 8-6		
22	1	Y-connection ø6	C00820604	
23	1	90 Angel Ø6 x 1/8"	C02470618	
24	4	Pneu fit.strat. Union ø6 -1/8"	C02250618	
25	1	G1/8 Filter	M/1511	
26	3	Pneu fit.strat. Union ø12 -1/2"	S02251248	
27	2	Pneu fit.strat. Union ø4 -1/8"	C02250418	



Base Cylinder



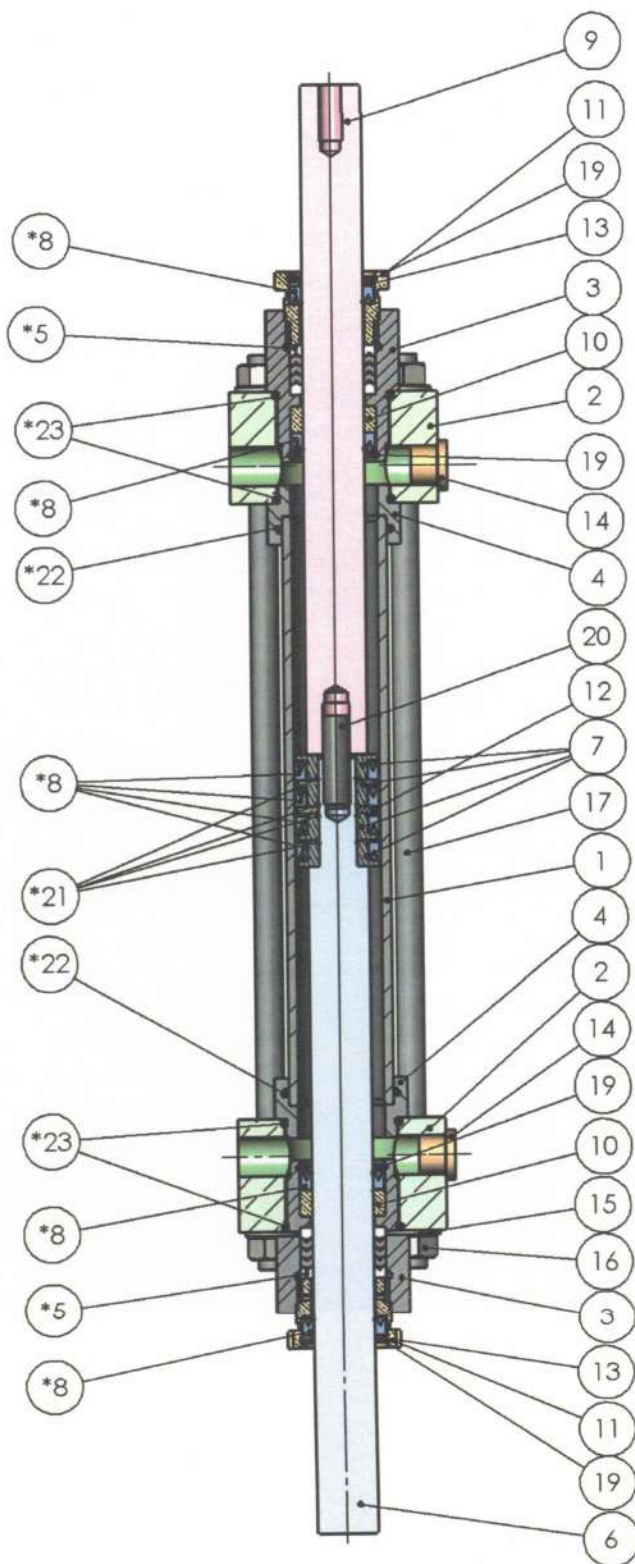
**Base Cylinder 7030 B:**

Article no. 41194000

Item no.	Qty.	Description	Article no.	Drawing no.
1	1	Piston Pipe, base		7025-5
2	2	Piston block 1/2"	41211600	1210-AD
3	2	Glander house, base		7030-3B
4	2	Piston flange, base		7025-4
*5	2	Packing Set 5030-4	41020700	SE10106
6	1	Piston, base	41276000	7025-7
7	1	Piston rod #1, base		7030-1B
8	2	Shock piston, base	41275900	7025-6
*9	2	Packing Set 7050-12	41020500	
10	1	Piston rod #2, base		7030-8B
11	2	Bushing, base		3040-17
*12	2	Packing 3040-10	41017100	
13	2	Mutter	41148700	
14	4	Stud bolt M14x390_HRC 39	1210-4	
15	2	Plug 1/2"	41242700	
*16	2	Packing O-Ring 6450-3	41023500	
*17	2	Packing O-Ring 18.77x1.78	41150200	
*18	4	Packing O-Ring 5717-353	41023400	
19	2	DIN 472 Circlip for Bore $\varnothing 40 \times 1,75$		
20	1	DIN 916 Screw M14x50 HRC 45	41266900	
21	8	DIN 934 nut M14		
22	8	DIN 125 Washer M14		
*--	1	Repair Kit, Base Cylinder 7030B	43703000	



Curing Agent Cylinder



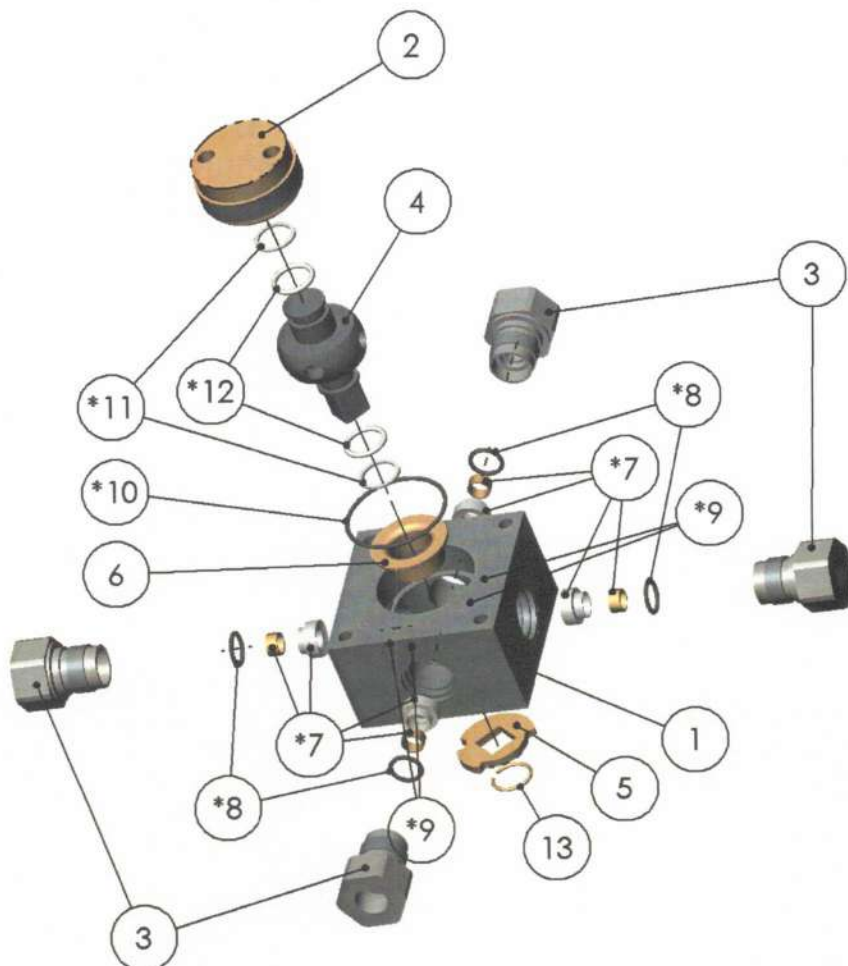
**Curing Agent Cylinder 4532 AFPU:**

Article no. 41180100

Item no.	Qty.	Description	Article no.	Drawing no.
1	1	Piston Pipe, hardener		4532-7F
2	2	Piston block 1/2"	41211600	1210-AD
3	2	Glander house, hardener	41291000	4532-03
4	2	Piston flange, hardener		4540-04
*5	2	Packing Set 4532-5RM	41026300	SE10110
6	1	Piston rod #1, Curing Agent	41211100	4532-101F
7	4	Shock piston, hardener	41211400	4530-16
*8	8	Packing 3040-10PU	41016200	
9	1	Piston rod #2, Curing Agent	41211000	4532-6F
10	2	Bushing, hardener	41290900	4532-14
11	2	Mutter	41291100	
12	1	Shock washer	41211500	4530-17
13	2	Washer	41291200	4532-4
14	2	Plug 1/2"	41242700	
15	8	DIN 125 Washer M14		
16	8	DIN 934 nut M14		
17	4	Stud bolt M14x490_HRC 39	1210-4F	
18	2	Nippel for Grease - M6		
19	4	DIN 472 Circlip for Bore ø45x1,75	41233200	
20	1	DIN 916 Screw M14x50 HRC 45	41266900	
*21	4	Packing O-Ring 18.77x1.78	41150200	
*22	2	Packing O-Ring 54.50x3	41023100	
*23	4	Packing O-Ring 5717-353	41023400	
*_	1	Repair Kit, Hardener Cylinder 4532	43453200	



Shift Valve 3/8"



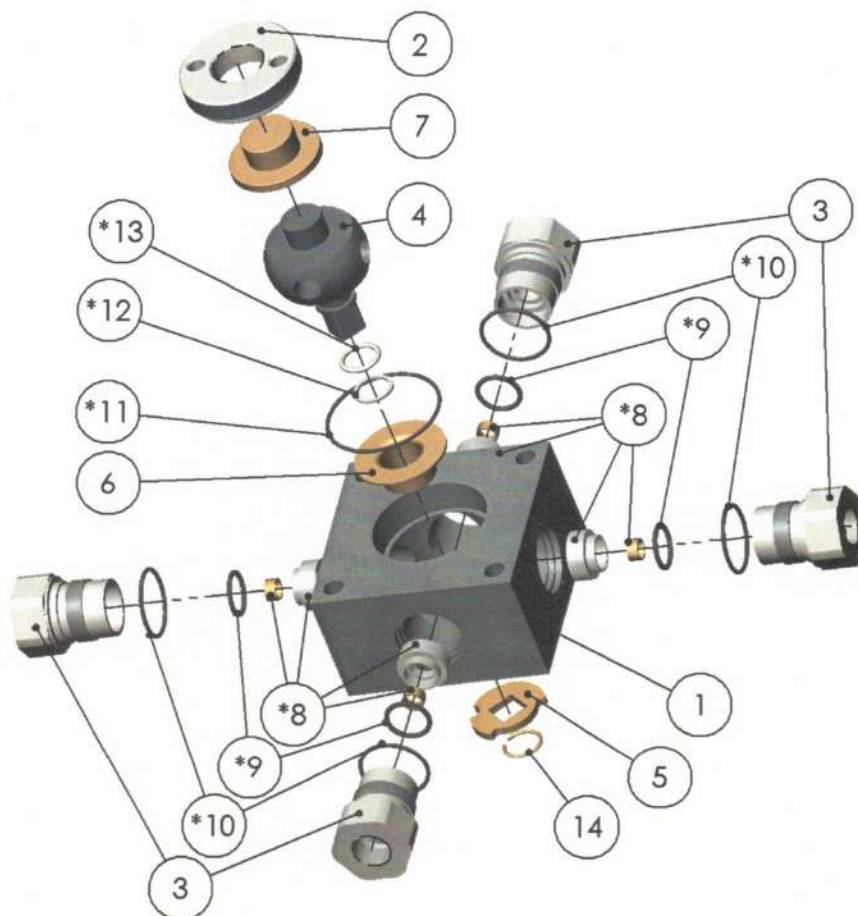
Hydr. valve Ball 4 Way $\phi 3/8"$

Article no. 41128400

Item no.	Qty.	Description	Drawing no.
1	1	4 Way valve 3/8"	82201
2	1	Cover	82203
3	4	Stub	82226
4	1	Ball	82224
5	1	Spec. washer	94854
6	1	Bushing	
*7	4	Packing stub	82219
*8	4	Packing O-Ring	55004
*9	4	Packing O-Ring	55904
*10	1	Packing O-Ring	
*11	2	Packing, PTFE	54028 PU
*12	2	Packing O-Ring	54028 PU
13	1	Seegerring	56452
*--		Repair Kit, BKMx 610	43061000



Shift Valve 1/2"



Hydr. valve Ball 4 Way $\phi 1/2"$

Article no.

41154900

Item no.	Qty.	Description	Drawing no.
1	1	4 Way valve 1/2"	82401
2	1	Cover	82403
3	4	Stub	82426
4	1	Ball	82524
5	1	Spec. washer	94854
6	1	Bushing	
7	1	Bushing	
*8	4	Packing stub	82413
*9	4	Packing O-Ring	55858
*10	4	Packing O-Ring	55816
*11	1	Packing O-Ring	
*12	1	Packing, PTFE	54028 PU
*13	1	Packing O-Ring	54028 PU
14	1	Seegerring	56452
15	4	Bushing	82219
*--		Repair Kit, BKMx 613	43061300

Rev.

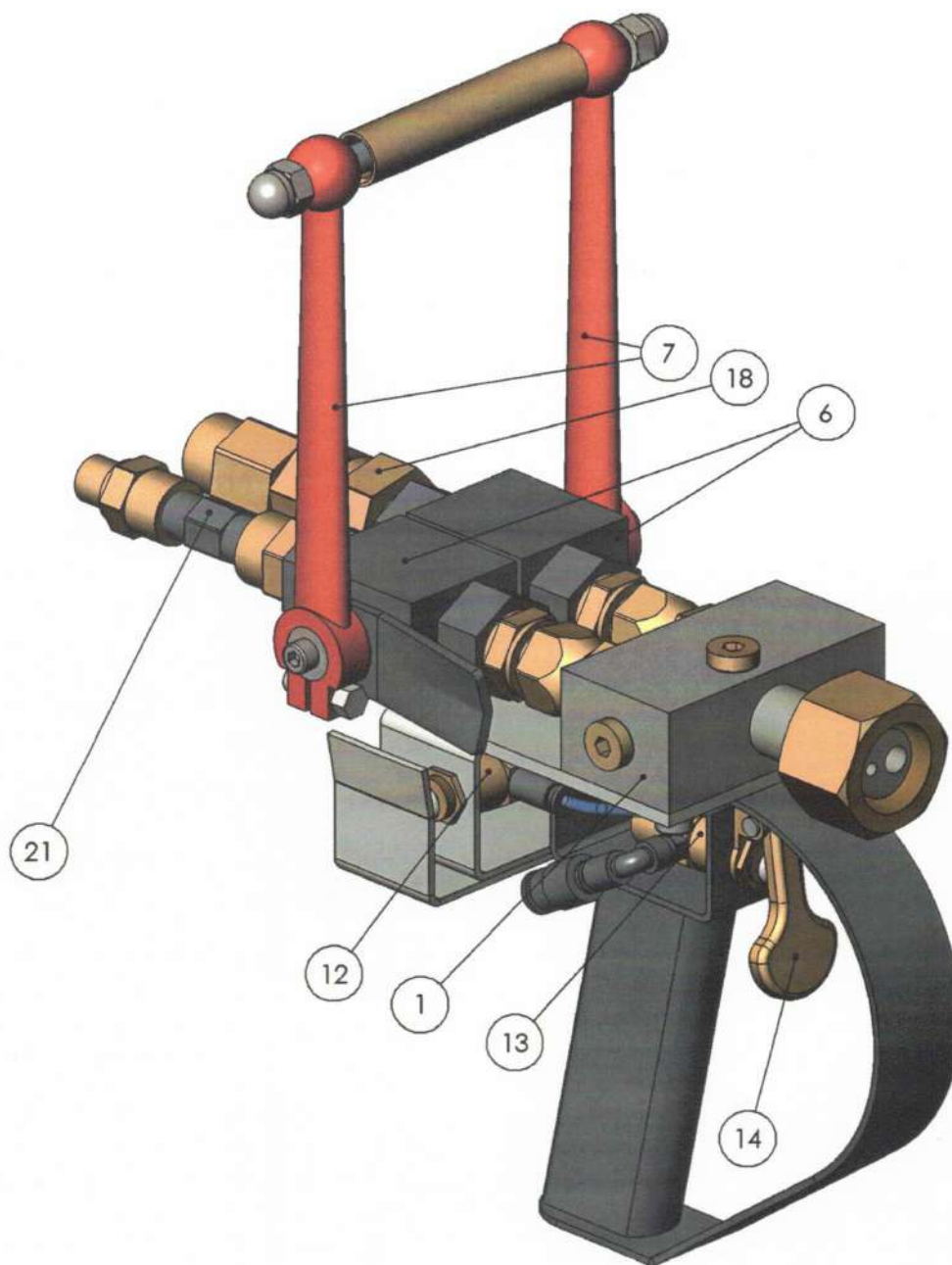
Date: 2007/07/01

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ISI YOGEV INDUSTRIES Ltd.

Mixer Unit



Item no.	Qty.	Description	Article no.
1	1	Mixerhead 1308-160 Complet	42004600
6	2	Hydr. Valve Ball Block ø3/8	41140400
7	2	Hydr. Valve Handel ø3/8	41248400
12	1	Pneu. Valve Manuel Botten 3/2-M5	41154600
13	1	Pneu. Valve Manuel Botten 3_2-M5	41154600
14	1	Trigger	41155400
18	1	Valve Non-Return 1Bar ø3/8"-3/8"	42004900
21	1	Valve Non-Return 1Bar 1/4"	41001900



Spreader

Types of spreaders:

Length	Type.	SIKA no.	Type	SIKA no.	Type.	SIKA no.	Type.	SIKA no.
100mm	301-100	41055100	302-100	-	311-100	-	312-100	-
150mm	301-150	-	302-150	-	311-150	-	312-150	-
200mm	301-200	41055500	302-200	-	311-200	-	312-200	-
250mm	301-250	41055700	302-250	-	311-250	-	312-250	-
300mm	301-300	41055900	302-300	-	311-300	-	312-300	-
350mm	301-350	41056100	302-350	41056200	311-350	-	312-350	-
400mm	301-400	41056300	302-400	41268200	311-400	41190500	312-400	41190600
450mm	301-450	41056500	302-450	41056600	311-450	41184600	312-450	41190700
500mm	301-500	41056700	302-500	41056800	311-500	41184700	312-500	41189100
550mm	301-550	41057000	302-550	41057100	311-550	41188400	312-550	41212400
600mm	301-600	41057200	302-600	41057300	311-600	-	312-600	41152500

Types of Nozzles:

Inside dia.	SIKA no.
ø 1,5mm	41057600
ø 2mm	41057700
ø 2,5mm	41057800
ø 3mm	41057900

Types hydr. Pipes:

Length	SIKA no.
1000mm	41165400
1500mm	41186600

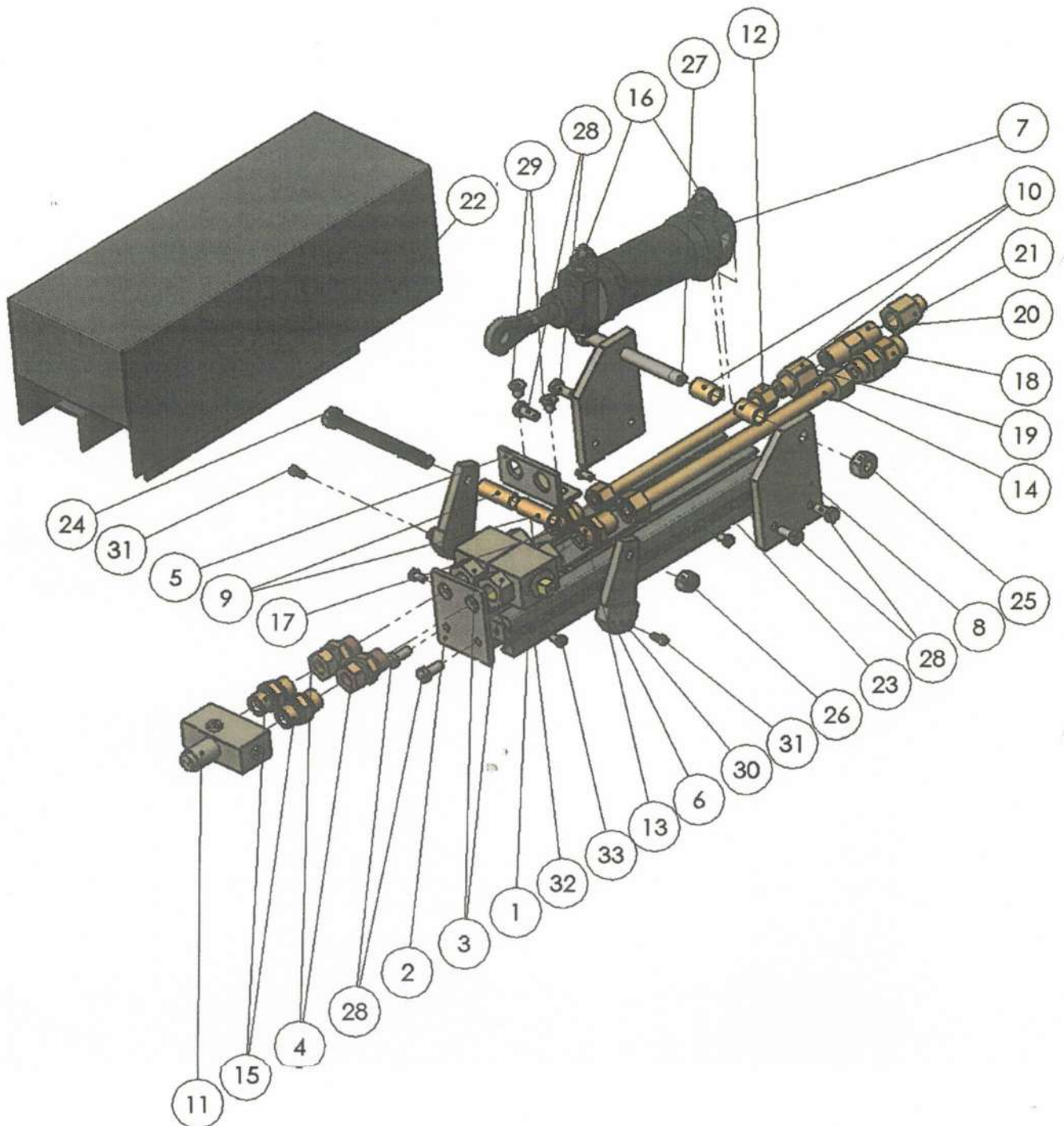
Mixing pipes

Length	SIKA no.
1000mm	42001400
500mm	42002700





Mixer Unit 1308E





ISI YOGEV INDUSTRIES Ltd.

32	4	Lock nut XCAN M6		
31	2	DIN 125 Washer ø5,3		
30	2	DIN 912 Socket Screw M5x12		
29	2	DIN 7991 Socket Count. Screw M8x12		
28	6	DIN 931 Hex screw M8x20		
27	1	DIN 931 Hex screw M14x130		
26	1	DIN 982 Lock nut M12		
25	1	DIN 982 Lock nut M14		
24	1	DIN 931 Hex screw M12x130		
23	6	Lock nut XCAN M8	41177100	
22	1	Cover for mixerunit type 1300	41134100	
21	1	Socket 3/8" bsp x 1/2" bsp	41254400	
20	1	Valve Non-Return 1Bar 1/2"-1/2"	41176200	
19	1	Hydr. Fit. Stra. Union Ø12-1/2" I-I	41237200	
18	1	Valve Non-Return 1Bar ø15-ø15	41254100	
17	1	Hydr. Fit. Stra. Union Ø12-1/2" I-U	41255800	
16	2	Pneu. Fit. adj. elbow ø8-3/8"	41401000	
15	2	Highp. Fit. Nipple Ø1/2-1/2" U-U	41186400	
14	1	Pipe Hydraulic Ø15 x 1,5x300	41187100	
13	1	Hydr. Fit. Stra. Union Ø15-1/2" I-U		
12	1	Pipe Hydraulic Ø12 x 1,5x240	41214000	
11	1	Mixerhead 1300-2024 Complet, 1/2"with nut	42004400	
	1	Mixerhead 1308-160 Complet, 1/2"	42004600	
10	2	Distance ø18-ø16x26		
9	2	Distance ø15-ø13x44		
8	2	Sideplate	41270200	1300-102
7	1	Cylinder 1305100002 100MM	41181400	
6	2	Ventilarm	41183300	1200-209
5	1	Vinkelprofile	41270300	1300-106
4	2	Highp. fit. Stra. Union 1/2 - 1/2 U_I	41178900	
3	2	Hydr. Valvddde Ball Block Ø1/2"	41154100	
2	1	Bracket	41270100	1300-105
1	1	Base 44x88	41285300	
Item no.	Qty.	Description	Article no.	Drawing no.



Cleaning and Service Application System 1200

CLEANING

It is necessary to clean the spreader and the static mixer with solvent at regular intervals.

1. Use an appropriate solvent, e.g. Sika Force[®]-7260 from a 200 litre drum.

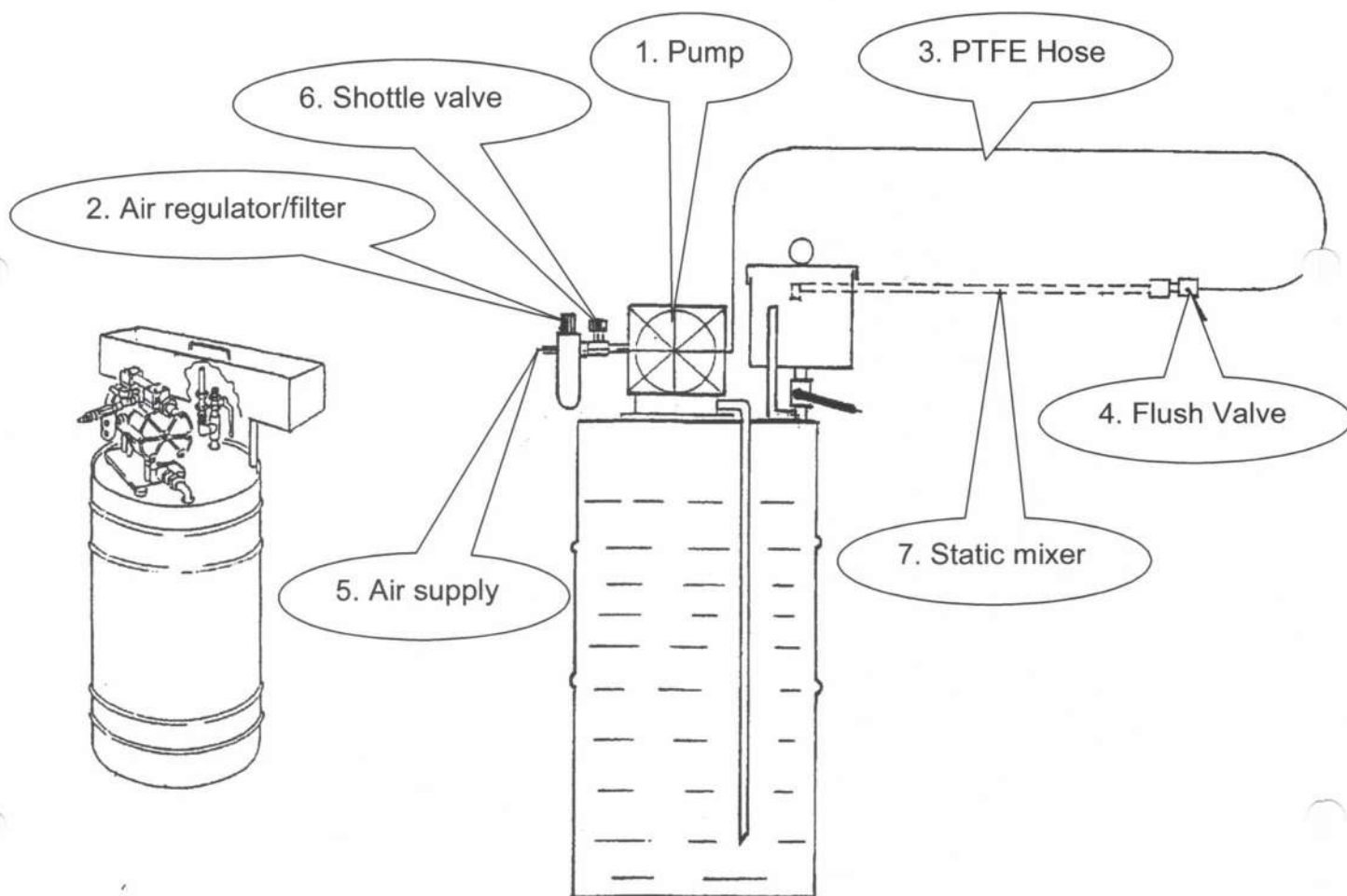
NOTE: USE PROTECTION EQUIPMENT ACCORDING TO DATA SHEET
See sec.2

2. Connect hoses to mixer unit
3. Set air pressure to pump connection **5.** - min. 5 bar and max. 7 bar.
4. Open valve **4.**
5. Fasten the nozzle to the Flushing box on the solvent drum
6. Open valve **6.** and increase pump pressure with regulator **2.**
7. Let the solvent circulate for about 20 minutes
8. Open and close valve **4.** a couple of times in order to have maximum effect
9. Change solvent when contaminated

Service

1. Lubricate the piston rod of the application valves with a few drops of oil and activate the valve after lubricating
2. Change spreader and static mixer when required

Flush System Tapflo T25



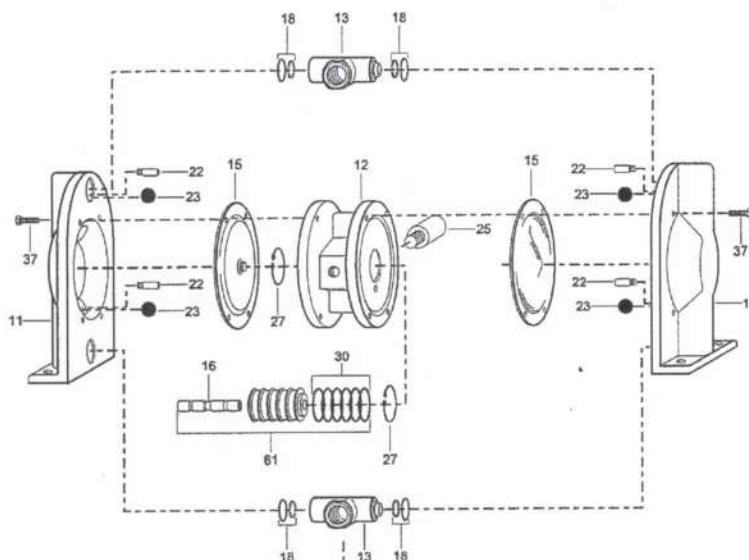
Flush System

1	Air Pump	41278900
2	Regulator	41121100
3	PTFE Hose 3/8" x 3000	41178600
4	Flush Valve	42001200

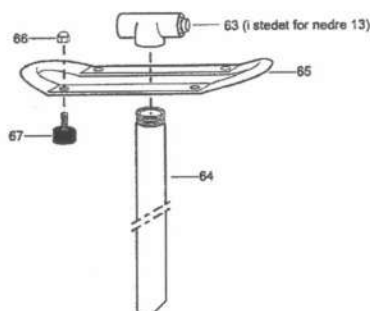
Spare Parts

Membranes	41287100
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Spar parts T25



Dele til fadpumpe (TD25)

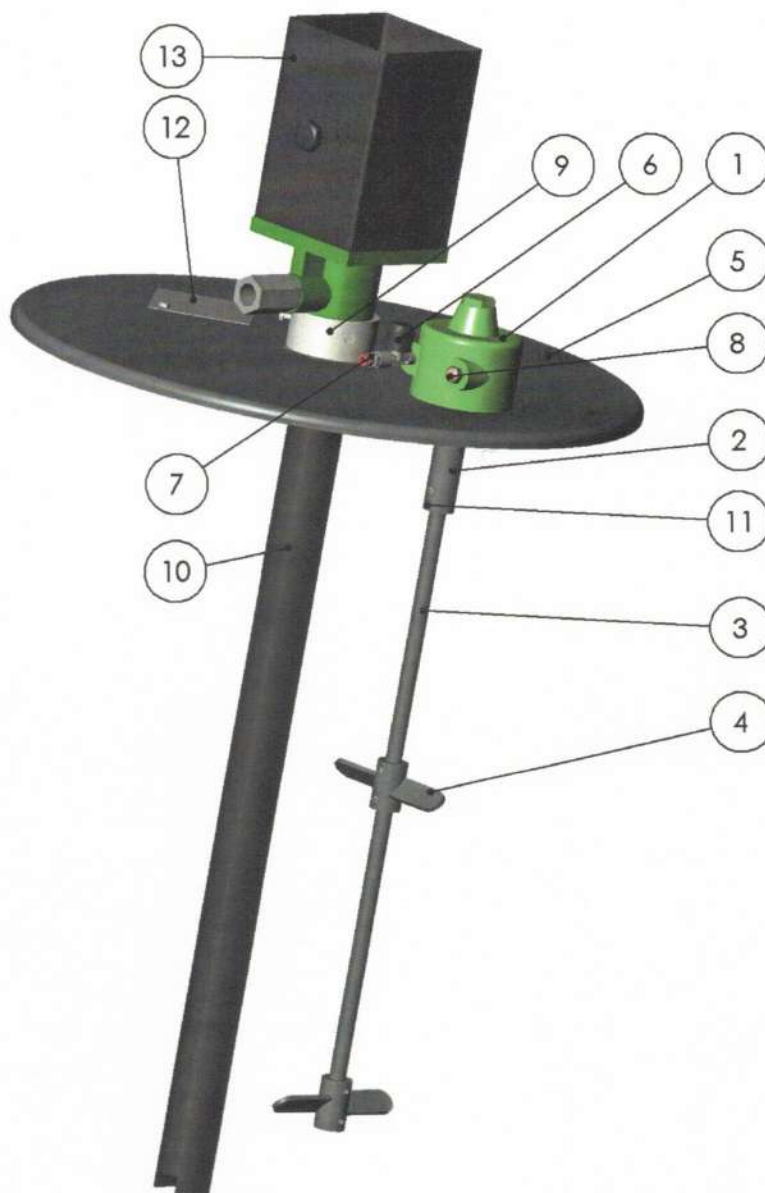


Pos	Beskrivelse	Materiale	Antal	Artikel Nr.
11	Pumpehus	Alu	2	6-025-11
12	Centerblok	Alu	1	6-025-12
13	Til-/afgang	Alu	2	6-025-13
15	Membran	EPDM	2	6-020-15
		PTFE		6-020-15-1
		NBR		6-020-15-3
18	O-ring/pakning (til-/afgang)		4	6-025-18
22	Ventilkugle stop	AISI 316	4	6-025-22
23	Ventilkugle	EPDM	4	6-025-23
		PTFE		6-025-23-1
		NBR		6-025-23-3
		PU (polyurethane)		6-025-23-4
		AISI 316		6-025-23-5
		Ceramic		6-025-23-7

Pos	Beskrivelse	Materiale	Antal	Artikel Nr.
25	Lyddæmper	PP	1	6-050-25
27	Seegerring	Phosph. br.	2	6-020-27
30	O-ring	NBR	6	6-020-30
37	Skrue	Stål	8	6-025-37
61	Luftventil (luftmotor) komp.		1	6-020-61
63	Fad indgang	Alu	1	6-025-63
64	Sugerør	Alu	1	6-025-64
65	Håndtag	AISI 316	1	6-020-65
66	Metrik, lukket	AISI 316	4	6-025-66
67	Gummifod	NBR	4	6-020-17



Base Mixer



Item no.	Qty.	Description	Supp. id	Article no.
1	1	Pneu Motor 7bar 1,25kW 1/4" NPT	4AM-NRV-22B Gast	41120400
2	1	Coupling for shaft		41176400
3	1	Shaft		41225500
4	2	Propel		41001700
5	1	Productive sheet		41179800
6	1	Pneu. valve 2820 1/4"		41263500
7	1	Pneu fit.strat. Union ø6 -1/4"	C02250628	
8	1	G1/4" Filter	M/1511	
9	1	Bushing		41167500
10	1	Base pump	84985	42003400
11	8	Set Screw M6x8, DIN914		
12	1	Lid		41212800
13	1	Cover for pump		41282000