

# Standard Powder Transfer Pump Kit



**WARNING:** Allow only qualified personnel to perform the following tasks. Follow the safety instructions in this document and all other related documentation.

## Description

The standard powder transfer pump is primarily used to unload powder coatings from bulk containers. The transfer pump uses  $\frac{3}{4}$ -in. powder transfer hose.

## Installation

See Figure 1.

1. Install the guide tube (13) into the powder container.
2. Slide the feed tube (12) into the guide tube.
3. Push the transfer pump onto the feed tube using a slight twisting motion.
4. Connect the  $\frac{1}{4}$ -in. air hose (1) to a regulated air source.
5. Connect  $\frac{3}{4}$ -in. powder transfer hose to the throat holder (9). Use a hose clamp to secure the hose to the throat holder.
6. If necessary, install a short length of spiral wrap around the transfer hose where it connects to the throat holder. This will prevent the transfer hose from kinking or cutting off the flow of powder.

**NOTE:** For best results, the powder transfer hose should be no longer than 7.5 meters (25 feet) and rise over its length no more than 2.7 meters (9 feet).

## Operation



**WARNING:** All conductive equipment in the spray area must be grounded. Ungrounded or poorly grounded equipment used in the spray area can become electrically charged. This charge can deliver a severe shock or create sparks hot enough to cause a fire or explosion.

Operation	Consumption	@ Air Pressure
Normal	186.9 cubic liters/minute (6.6 scfm)	2.75 bar (40 psi)
Maximum	277.4 cubic liters/minute (9.8 scfm)	4.1 bar (60 psi)
<b>NOTE:</b> The normal air pressure is given as an average starting point. Adjust the operating air pressure higher or lower to achieve the desired powder delivery volume.		

## Maintenance

### Daily

See Figure 1.

1. Pull the air hose (1), check valve (2) and nozzle (3) assembly out of the pump body (5).
2. Disconnect the powder transfer hose from the throat holder (9).
3. Pull the pump off the feed tube (12).



**WARNING:** Always blow out the transfer hose from the pump end. Make sure that the booth exhaust fan is on or the feed hopper is vented to the booth.

4. Blow out the pump and transfer hose with low-pressure compressed air.

### Periodic

Disassemble the transfer pump and clean its parts following these guidelines:



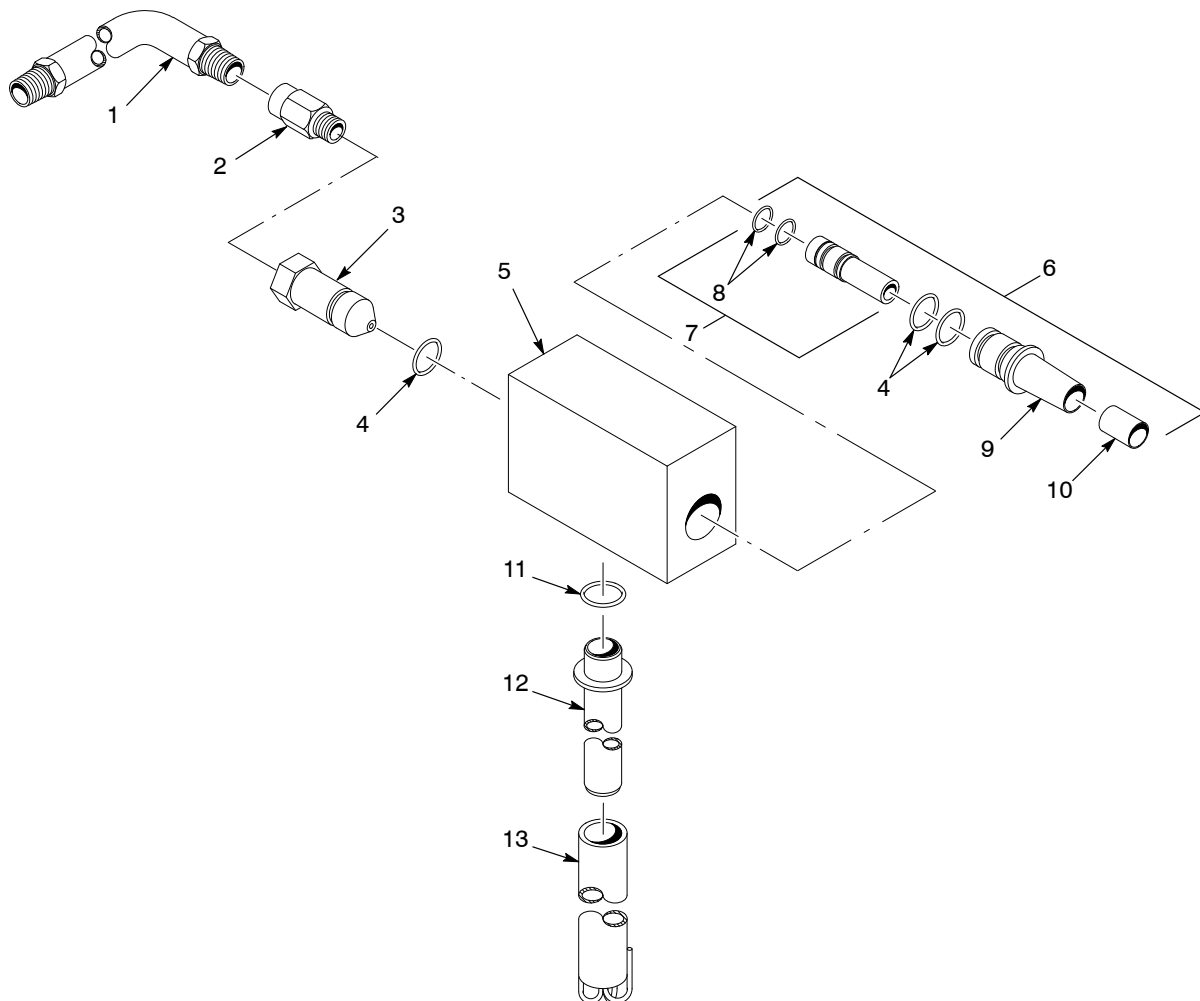
**WARNING:** Do not scrape impact-fused powder off the pump parts with any sharp metal tools. Powder will build up in any scratches on the powder contact surfaces, causing impact fusion and pump clogging.

- Use low-pressure compressed air and lint-free cloths.
- If necessary, remove the O-rings and wipe the parts clean with a non-toxic solvent such as alcohol. Solvents will damage the O-rings.
- Inspect all parts and replace any that are worn or damaged.

# Parts

See Figure 1.

Item	Part	Description	Quantity	Note
—	248681	SERVICE KIT, pump, powder, transfer	1	
1	247815	• HOSE, air, 1/4-in. ID x 6 ft	1	
2	1017408	• VALVE, check, 1/4-in. NPT	1	
3	244643	• NOZZLE, air, 0.100-in. dia	1	
4	942106	• O-RING, silicone, conductive, 0.750 x 1.000 in.	3	
5	244641	• BODY, pump, 1.00-in. dia, leg	1	
6	307439	• THROAT, with holder	1	
7	118835	• • THROAT, venturi, high flow, with O-rings	1	
8	940142	• • • O-RING, silicone, 0.500 x 0.625 x 0.063 in.	2	
9	307435	• • HOLDER, throat	1	
10	118832	• • TUBE, wear, holder, high flow	1	
11	942146	• O-RING, silicone, 1.000 x 1.250 in.	1	
12	247821	• TUBE, feed, drum truck	1	
13	247822	• TUBE, guide, drum truck	1	



1400725A

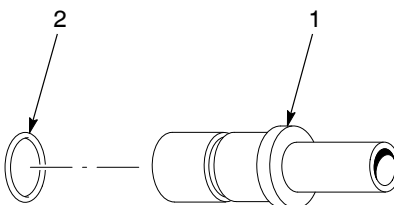
Figure 1 Standard Powder Transfer Pump Parts

## Old-Style Throats

The old-style throats were used in place of the new-style throat and throat holder assembly, part 307439. For better grounding, order part 307439.

See Figure 2.

Item	Part	Description	Quantity	Note
1	244642	THROAT, venturi, transfer, PTFE	1	
1	226713	THROAT, venturi, transfer, Tivar	1	
2	942106	O-RING, silicone, conductive, 0.750 x 1.000 in.	1	A
NOTE A: Each optional throat uses one O-ring, part 942106. The O-ring must be ordered separately.				



1400726A

Figure 2 Old-Style Throats

Issued 9/02

Original copyright date 1991. Nordson and the Nordson logo are registered trademarks of Nordson Corporation.

Tivar is a registered trademark of Poly-Hi Corporation.