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The operating instructions for the metering pump and accessories must be kept within easy reach.

2. Scope of delivery

The metering pump and any enclosed accessories must be unpacked with care so that small parts do not remain unnoticed in the packaging. The parts delivered must be checked immediately against the delivery note and any discrepancies investigated without delay.

1. Technical data

REKOSKR		2	5	8	20	30	40	60	75	125	180	220	295	420	570	725	
max. pressure [bar]	Plastic	10														7	5
	Stainless steel	200			190	130	95	70	50	30	20	16	12	10	7	5	
Flow rate at	[l/h]	2,2	5	9	20	31	40	56	75	125	180	220	295	420	570	725	
max. pressure	[ml/stroke]	0.38	0.85	1.5	3.4	5.3	6.8	9.4	12.5	21.2	30.5	37.7	50	71.3	96.5	122	
Piston dia.	[mm]	4	6	8	12	15	17	20	23	30	36	40	46	55	64	72	
Stroke freq.	1/min	100															
Suction head	[mbar]	120															
Motor rating	[kW]	0.55 kW															
Weight [kg]	Metering head	Plastic	2									3			4		
		Stainless steel	7									10			15		
	Single gear	manual	25									26			27		
		ATE/ATP	37									38			39		
	Duplex gear	manual	32									34			36		
		ATE/ATP	49									51			53		

3. Installation

When planning, installing and operating a system, the metering pump must be selected with due regard to the local regulations. This applies to the choice of suitable pump materials, the handling of the chemicals and the electrical installation. The technical data of the pump listed above must also be taken into account and the system dimensioned accordingly (e.g. loss of pressure when dimensioning the line with regard to nominal width and length).

The planning engineer and user are responsible for ensuring that the entire system with integrated metering pump is designed in such a way that leaking chemicals due to a failure of wear parts (e.g. worn packing) or ruptured tubing do not cause any permanent damage to system parts and buildings. If there is a large danger potential of the chemical plant the installation must be designed in such a way as to prevent unnecessarily high consequential damage even if the metering pump fails. We therefore recommend to install leakage monitors and containment tanks.

Note: Due to their design piston pumps are not leakage-free. This must be taken into account when planning the process and the system.

Metering pumps are designed according to the highest quality standards and have a long service life. Despite this, some parts are subject to wear caused by operation (e.g. piston, packing, valve

seats, valve balls). Regular visual inspection is therefore necessary to ensure reliable longterm operation. The metering pump must be installed so that it is readily accessible to operating and maintenance personnel. It should be serviced regularly to avoid downtimes.

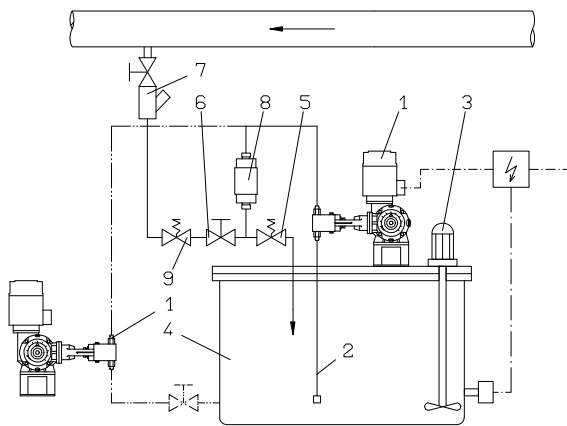
Supplementary fittings are recommended to increase the metering accuracy and functional reliability. Such fittings include backpressure valves, relief valves, leakage monitors and low-level warning devices as shown in the following installation example.

Suitable tools must always be used to work on plastic connecting parts. Undue force must never be applied as otherwise the parts may be damaged or destroyed. Plastic parts (particularly those made of PVC) can be screwed and unscrewed more easily if the thread has been lubricated with Vaseline or silicone grease.

Note: The compatibility of the Vaseline or grease with the metered chemical must always be checked first. The ambient temperature of the pump must not exceed 40 °C. Radiated heat from devices and heat exchangers must be shielded so that the metering pump can still dissipate its own heat. Direct sunlight must be avoided. A canopy roof must be provided to protect the pump against the weather when installed outdoors.

The metering pump must be installed with suction and discharge valves in an upright position. It must be bolted onto suitable ground to ensure stability. The system piping must not apply any forces to the connections and valves of the metering pump. The pump must be interlocked electrically and hydraulically to prevent accidental metering after the process has ended.

Installation example



Legend

1	REKOS KR	MB 1 08 02
2	Suction line	MB 1 22 01
3	Electric agitator	MB 1 36 03
4	Tank	MB 1 20 01
5	Relief valve	MB 1 25 01
6	Diaphragm shutoff valve	MB 1 24 01
7	Injection nozzle	MB 1 23 01
8	Pulsation dampener	MB 1 27 01
9	Backpressure valve	MB 1 25 01

4. Electrical connection of the pump

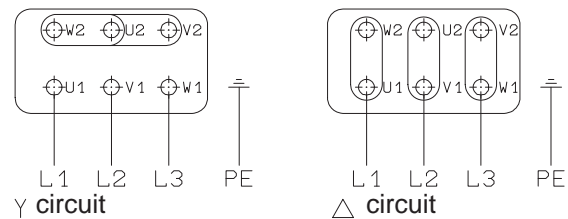
- The electrical connection of the metering pump must be in accordance with the local regulations and may only be carried out by qualified personnel.
- The cable type and cross-section of the power supply cables must be selected according to the motor data.
- The cable bushing to the motor terminal box must be made correctly. We recommend the use of compression glands with strain relief.
- The required protection class must be ensured by correct installation of the electrical connections.

Electrical connection data

Pump size	Voltage [Volt]	Power [kW]	Current [A]
...KR 725	400/230 50 Hz	0.55	1.50/2.60
...KR 725	400/230 60 Hz	0.55	1.25/2.20
...KR 725	440/254 60 Hz	0.55	1.25/2.20
...KR 725	400/230 50 Hz	0.75	2.00/3.50
...KR 725	400/230 60 Hz	0.75	1.75/3.05
...KR 725	440/254 60 Hz	0.75	1.70/3.10

Wiring diagram of the drive motor

- 3-phase supply



- Special version

Other electrical versions can be found in the separate circuit diagrams.

- Electric servomotor ATE

The technical data and connection diagrams can be found on page BW 1 08 02 / 7-10.

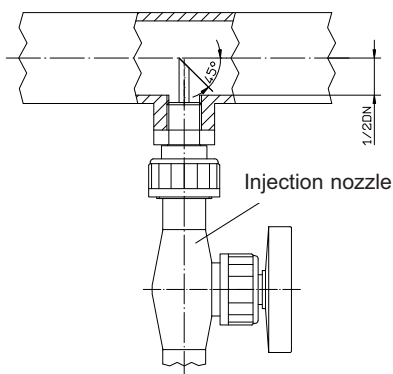
5. Safety instructions

- ⇒ The safety rules applicable on site must be observed when working on metering plants (e.g. use of personal protective equipment).
- ⇒ Before starting any work on the metering pump and system, all mains lines must be disconnected and secured against reconnection. The metering lines must be connected before reconnecting the power supply in order to prevent any chemical still in the metering head from being expelled.
- ⇒ Important: The piston area must remain open for checking, which may be dangerous if accessed directly. Maintenance work in the piston area may only be carried out if the pump is switched off.

- ⇒ The metering head of the pump and the system connections and lines may be under pressure. Working on the metering pump requires special safety precautions and may only be carried out by instructed, qualified personnel.
- ⇒ Before startup, all screwed connections must be checked for correct tightness and, if necessary, must be tightened up using appropriate tools.
- ⇒ If connections at the metering head are unscrewed during operation for venting or other reasons, leaking chemical must be removed correctly and completely. This is the only way to avoid the danger of physical injury and corrosion at the metering pump. Leaking chemical may also affect the pump housing.
- ⇒ When changing the chemical, check whether the materials used for the metering pump and the other plant parts are chemically resistant. If there is the danger of a chemical reaction between different media, thorough cleaning first is mandatory.
- ⇒ To operate the pump mount the fan shell in order to ensure sufficient cooling of the motor.

6. Installation of injection nozzle

Injection nozzles are fitted with either spring-loaded ball valve or tube valve to prevent any return flow. Injection from bottom to top is recommended to allow air bubbles to escape and to be carried away so that precipitations are avoided. The experience with the chemical to be metered and its properties must be taken into account.



7. Startup

1. All the work described in the section "Installation" must be carried out before starting the metering pump. The safety instructions must also be observed.
2. The metering pump is switched on via a control system to be installed externally.
3. The manual or electrical capacity adjustment must be set to maximum stroke to improve priming. During first priming no backpressure should be applied. For this purpose we recommend to install a relief valve on the discharge side of the metering pump.
4. A previously installed priming aid must be filled with chemical first. If the pump is not priming, remove the discharge valve and fill water or chemical (if not dangerous!) into the metering head. Remount valve and start priming.
5. If a venting facility is available as separate unit, open it and wait until liquid flows out. Then close it again. In the case of effervescent liquids allow the liquid to flow out permanently (approx. 1 drop for 1...3 strokes).
6. When correct operation is achieved, set to required output by means of the adjusting knob or remote adjustment. For first approximation refer to the values shown in the "Technical data" table. Depending on the installation and the chemicals used, these values may differ and must be checked under operating conditions.
7. The manufacturer of the metering equipment is not responsible for damages due to excessive or low flow rates resulting from faulty pump settings or incorrect and insufficient installation of peripheral fittings.

8. Maintenance

Lubrication

The piston metering pump REKOS KR is designed for easy maintenance. The gear of the pump is lubricated with gear oil of viscosity class ISO-VG460 according to DIN 51519 (corresponds to SAE 140 as defined by DIN 51512). The initial filling provided should be replaced after approx. 5000 hours of operation or 1 year, whichever comes first. The oil should then be changed every 10,000 hours of operation or 2 years, whichever comes first. The capacity equals 0.7 liters for the single gear and approx. 0.9 litres for the duplex gear. The amount of gear oil actually required can be read off from the oil gauge: the oil is filled up to the middle of the viewglass.

Replacing the piston

Proceed as follows to replace a defective metering piston or worn packing:

1. The chemical contained in the metering line must be drained to depressurize the metering line. Please observe the aforementioned safety instructions for this purpose.
2. The head is removed using an appropriate tool: Unscrew the attachment screws of the metering head, loosen the gland stud. The metering head is then removed in axial direction from the holder. Slight rotations of the head make dismantling easier.
3. The piston can now be unscrewed from the piston rod and replaced by a new one, if necessary.
4. To change the packing, the gland stud must be unscrewed. The defective packing is removed using a packing worm. Alternatively, a hook can be used to remove the old packing.
5. After cleaning the packing area, the new packing rings are fitted with offset joints and the gland studs fastened sturdily.
Caution: The seal material must be compatible with the application and with the chemical.
6. The metering head is now pushed in alignment with the piston and the holding flange and fixed with the attachment screws after it has reached its final position. Make sure that the valves are positioned vertically.
7. The gland stud is tightened carefully to start the bedding-in process of the new packing. For this purpose the pump is run dry first without connection to the medium. After some strokes the gland is retightened.
8. After connecting the metering lines the pumps is started as described in the 'Startup' section. Continue to prestress the gland stud until a minimum leakage occurs. If prestressing is too strong, the return movement of the piston might be restrained. In this case slightly loosen the gland stud again.

9. Troubleshooting

TYPE OF FAULT	POSSIBLE CAUSE	RECOMMENDED ACTION
Metering not delivering.	Valves leaking.	Clean and remove air from valves (see also startup of pump). Tighten screw connections.
	Valves installed incorrectly.	Reassemble valves. Ensure that the valve balls of suction and discharge valves are located above the valve seats.
	Suction filter, foot valve or suction line leaking or blocked.	Clean and seal suction line.
	No stroke movement.	Return spring broken. Replace spring – Consider density of medium! Suction lift too high.
Pump delivering too little or irregularly.	Valves blocked or leaking.	Clean and reseal valves.
Pump delivering too much.	Pressure on suction side too high (pump siphoning).	Install backpressure valve in discharge line.
Major leakage at piston.	Packing not tightened sufficiently.	Tighten gland stud carefully.
	Piston has longitudinal grooves due to normal wear.	Replace piston and packing. See also section 8, maintenance.
	Excessive wear due to abrasive medium.	Use aramid seal instead of PTFE seal.
Pump very noisy.	Defective rolling bearing.	Replace roller bearing.
	No oil or too little oil in gearing.	Refill oil, as described in section "maintenance".
Motor hums but and does not start.	Wrong connection.	Check electrical wiring.
	Pressure too high.	Check process.

If the problem cannot be corrected on the basis of the above data, return the pump to the factory or contact our Technical Sales Service for further measures. Repairs will be carried out immediately.