

Circulation and Return Tube Kits

309852 rev.B

***For recirculation of polyurethane materials from Reactor™
Proportioner to 55 gal. (200 liter) fluid supply drums.***

4000 psi (27.6 MPa, 276 bar) Maximum Fluid Working Pressure

Part No. 246477 Return Tube Kit

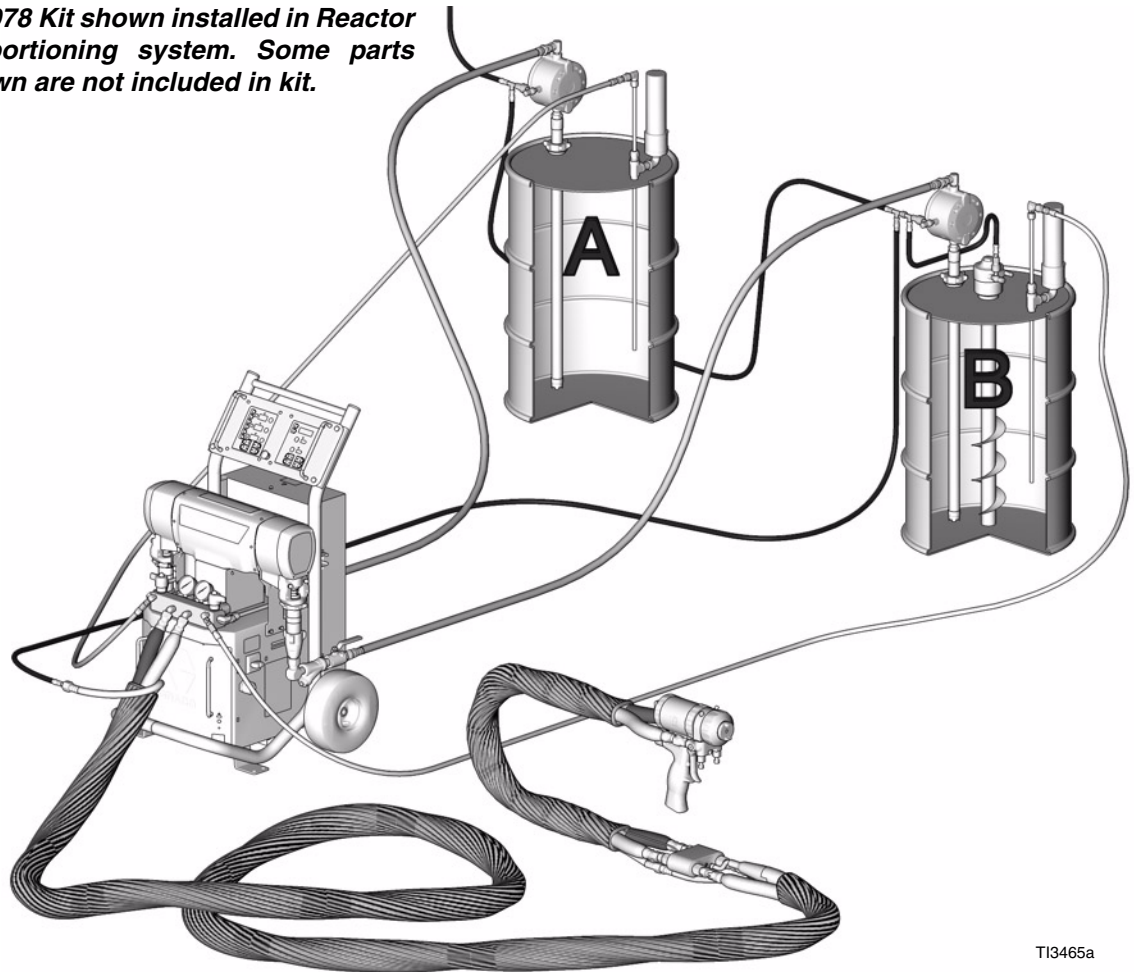
Part No. 246978 Circulation Kit



Important Safety Instructions

Read all warnings and instructions in this manual.
Save these instructions.

***246978 Kit shown installed in Reactor
proportioning system. Some parts
shown are not included in kit.***




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PROVEN QUALITY. LEADING TECHNOLOGY.

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246477 Return Tube Kit

 The 246477 Return Tube Kit can be installed singly or as a pair. Two are included in the 246978 Circulation Kit, page 3.

1. Keep A and B components separate

CAUTION

To prevent cross-contamination of fluid, mark A component (ISO) connections with red tape. Mark B component (RES) connections with blue tape. Do not interchange or cross-connect A component and B component parts.

2. Assemble return tube kit

Remove dryer carriage (C). Using awl or similar tool, punch a few small holes in each end of carriage. Reinstall carriage.

Remove large fitting included with dryer (10). It is not needed for this application.

Apply thread sealant (8) to threads. Assemble return tube kit as shown at right.

3. Install kit in drum

Open drum port. Lower kit into drum. Screw tee (6) into drum port to secure. Use bushing (5) to adjust position of tube (4) in tank.

4. Install circulation kit, page 3


WARNING




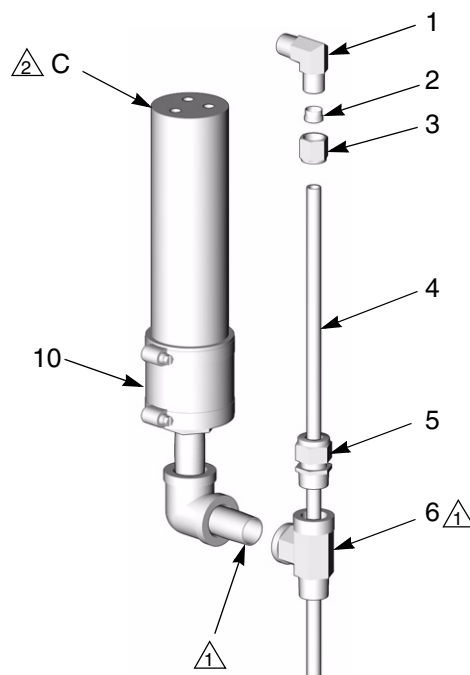
To reduce the risk of serious injury including fluid injection, use high pressure return hoses rated to withstand the maximum working pressure of the Reactor. See Reactor operation manual.

Ref.

No.	Part No.	Description	Qty
1	117532	ELBOW, 90°; 1/2 in. (13 mm) OD tube x 1/2 npt(m)	1
2	117453	FERRULE, tube; sst	1
3	117454	NUT, tube, flareless	1
4	15C514	TUBE; sst; 1/2 in. (13 mm) OD; 4 ft (1.2 m)	1
5	117811	BUSHING, strain relief; 3/4 npt(m)	1
6	111337	TEE, street; 3/4 npt (mxf) run; 3/4 npt(f) branch	1
8	110110	SEALANT, pipe; 6 ml	1
10	246640	DRYER, desiccant	1

 Apply thread sealant (8) to threads.

 Punch holes in ends of carriage (C).



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246978 Circulation Kit

1. Install two return tube kits, page 2

CAUTION

To prevent cross-contamination of fluid, mark A component (ISO) connections with red tape. Mark B component (RES) connections with blue tape. Do not interchange or cross-connect A component and B component parts.

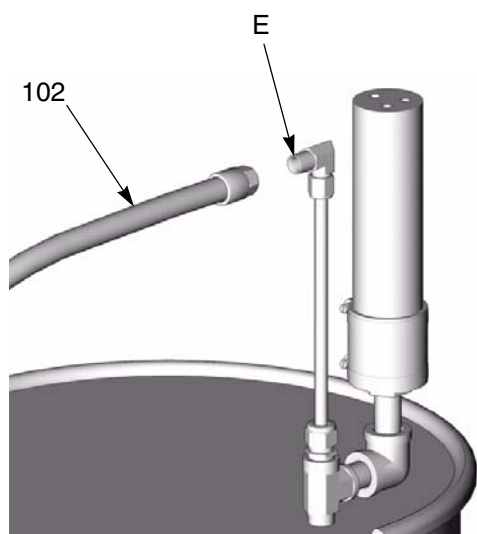
2. Connect circulation kit

Remove fittings from elbows (A, B) at Reactor fluid manifold. Screw reducing nipples (104) into elbows. Connect one end of hoses (102) to each nipple.

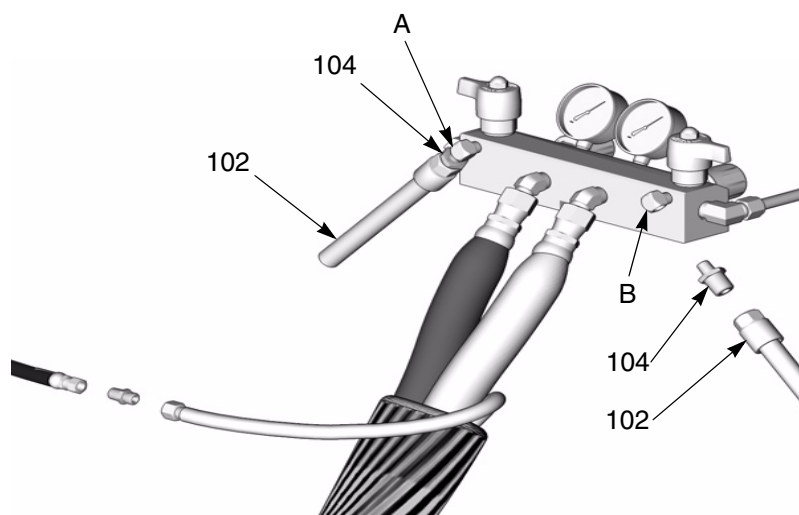
Connect other end of A side hose (102) to elbow (E) of A component return tube kit. Repeat for B side hose.

Ref.

No.	Part No.	Description	Qty
101	246477	KIT, return tube; see page 2	2
102	H45010	HOSE, fluid; nylon; 1/2 in. (13 mm) ID; 1/2 npsm(fbe); 10 ft (3.05 m);	2
104	162449	NIPPLE, reducing; 1/2 x 1/4 npt	2



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