

SPXFLOW

>Power Team®

SPX Hydraulic Technologies
5885 11th Street
Rockford, IL 61109-3699 USA
powerteam.com

Tech Services: (800) 477-8326
Fax: (800) 765-8326
Order Entry: (800) 541-1418
Fax: (800) 288-7031

ORIGINAL INSTRUCTIONS



MODELS C, D, E, F, & G

AIR HYDRAULIC PUMP

Max. Pressure: See Pump Data Plate

Operating Instructions for:

52431	PA4 SERIES
58356	PA6 SERIES
203641-PF	PA50 SERIES
203641-PF-80	PA60
	PA64

Contents

SAFETY DEFINITIONS	3
SAFETY PRECAUTIONS	4
PREPARATION AND SET-UP.....	5
1. Air Supply Hook-up.....	5
2. Venting the Reservoir	5
3. Hydraulic Connections.....	5
OPERATION	10
1. Priming the Pump	10
2. Pump Operation	12
3. For Pumps With Air Regulators:	13
PREVENTIVE MAINTENANCE	14
1. Lubrication	14
2. Bleeding Air from the System	14
3. Inspecting the Hydraulic Fluid Level.....	14
4. Draining and Flushing the Reservoir	14
5. Refilling the Reservoir	15
6. Periodic Cleaning	15
ACCESSORIES	15
1. Installing An In-line Hydraulic Pressure Gauge	15
2. Installing An In-line Hydraulic Pressure Gauge	16
3. Fire-Resistant Hydraulic Fluid	16
OPERATOR TROUBLESHOOTING GUIDE.....	17
SPX FLOW FACILITIES.....	19
DECLARATION OF CONFORMITY	20

SAFETY DEFINITIONS

Safety symbols are used to identify any action or lack of action that can cause personal injury. Your reading and understanding of these safety symbols is very important.



DANGER

Danger is used only when your action or lack of action will cause serious human injury or death.



WARNING

Warning is used to describe any action or lack of action where a serious injury can occur.

IMPORTANT

IMPORTANT is used when action or lack of action can cause equipment failure, either immediate or over a long period of time.



WARNING

It is the operator's responsibility to read and understand the following safety statements,

- **Only qualified operators should install, operate, adjust, maintain, clean, repair, or transport this machinery.**
- **These components are designed for general use in normal environments. These components are not specifically designed for lifting and moving people, agri-food machinery, certain types of mobile machinery or special work environments such as: explosive, flammable or corrosive. Only the user can decide the suitability of this machine in these conditions or extreme environments. Power Team will supply information necessary to help make these decisions.**

SAFETY PRECAUTIONS



WARNING

All WARNING statements must be carefully observed to help prevent personal injury.

General Operation

- All WARNING statements must be carefully observed to help prevent personal injury.
- Before operating the pump, all hose connections must be tightened with the proper tools. Do not overtighten. Connections should only be tightened securely and leak-free. Overtightening can cause premature thread failure or high pressure fittings to split at pressures lower than their rated capacities.



- Should a hydraulic hose ever rupture, burst, or need to be disconnected, immediately shut off the pump and release all pressure. Never attempt to grasp a leaking pressurized hose with your hands. The force of escaping hydraulic fluid could cause serious injury.
- Do not subject the hose to potential hazard such as fire, sharp surfaces, extreme heat or cold, or heavy impact. Do not allow the hose to be altered or kink, twist, curl, crush, cut, or bend so tightly that the fluid flow within the hose is blocked or reduced. Periodically inspect the hose for wear, because any of these conditions can damage the hose and possibly result in personal injury.
- Do not use the hose to move attached equipment. Stress can damage hose and possibly cause personal injury.



- Hose material and coupler seals must be compatible with the hydraulic fluid used. Hoses also must not come in contact with corrosive materials such as creosote-impregnated objects and some paints. Consult the manufacturer before painting a hose. Hose deterioration due to corrosive materials can result in personal injury. Never paint the couplers.
- Inspect machine for wear, damage, and correct function before each use. Do not use machinery that is not in proper working order, but repair or replace it as necessary.
- Replace worn or damaged safety decals.
- Modification of a product requires written Power Team authorization.
- Use only components with the same pressure rating when assembling a system or machine.

Pump

- Do not exceed the hydraulic pressure rating noted on the pump nameplate or tamper with the internal high pressure relief valve. Creating pressure beyond rated capacities can result in personal injury.
- Before replenishing the oil level, retract the system to prevent overfilling the pump reservoir. An overfill can cause personal injury due to excess reservoir pressure created when the cylinders are retracted.

Air Supply

- Shutoff and disconnect the air supply when the pump is not in use or before breaking any connections in the system.

AIR HYDRAULIC PUMP

Max. Pressure: See Pump Data Plate

Workstation Sound Pressure Level: 83 dB(A) at Rated capacity

Definition: An air hydraulic pump delivers hydraulic fluid under pressure through the use of compressed air as a power source.

PREPARATION AND SET-UP

1. Air Supply Hook-up

Remove the thread protector from the air inlet of the pump. Select and install the threaded fittings which are compatible with your air supply fittings. The air supply should be 20 CFM (.57 M³/min.) and 100 PSI (7 BAR) at the pump to obtain the rated hydraulic pressure. Air pressure should be regulated to a maximum of 120 PSI (8.3 BAR). Secure your pump fitting to the air supply. See illustrations on following pages.



If improperly used, pressurized equipment can be potentially hazardous. Therefore:

- Hydraulic connections must be securely fastened before building pressure in the system.
- Release all system pressure before loosening any hydraulic connection in the system.

2. Venting the Reservoir

To improve hydraulic fluid delivery and increase usable hydraulic fluid capacity, remove shipping plug and install filler/vent cap before using the pump

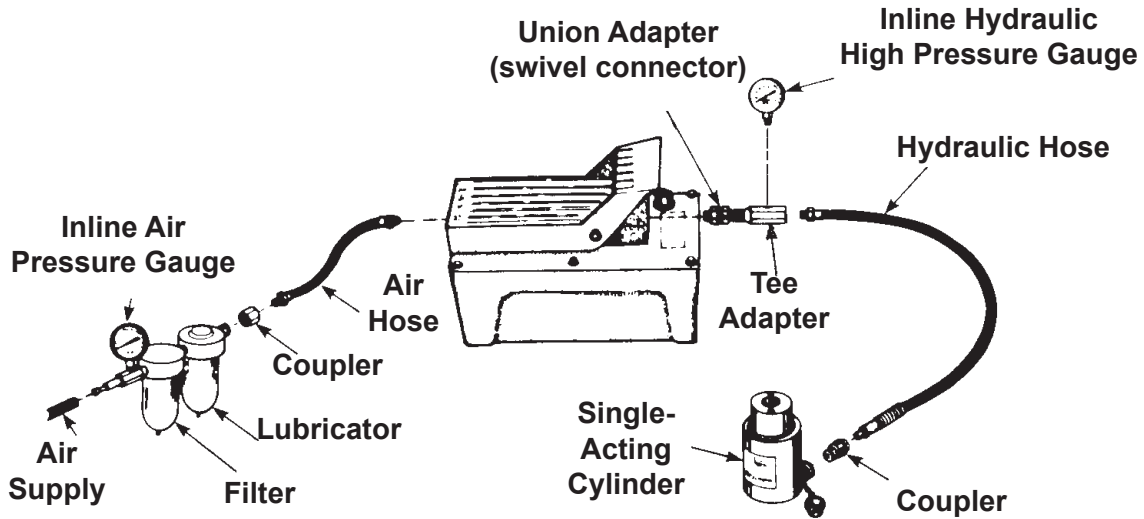
3. Hydraulic Connections

Clean all the areas around the fluid ports of the pump and cylinder. Inspect all threads and fittings for signs of wear or damage and replace as needed. Clean all hose ends, couplers and union ends. Remove the thread protectors from the hydraulic fluid outlets. Connect the hose assembly to the hydraulic fluid outlet and couple the hose to the cylinder. See illustrations below.

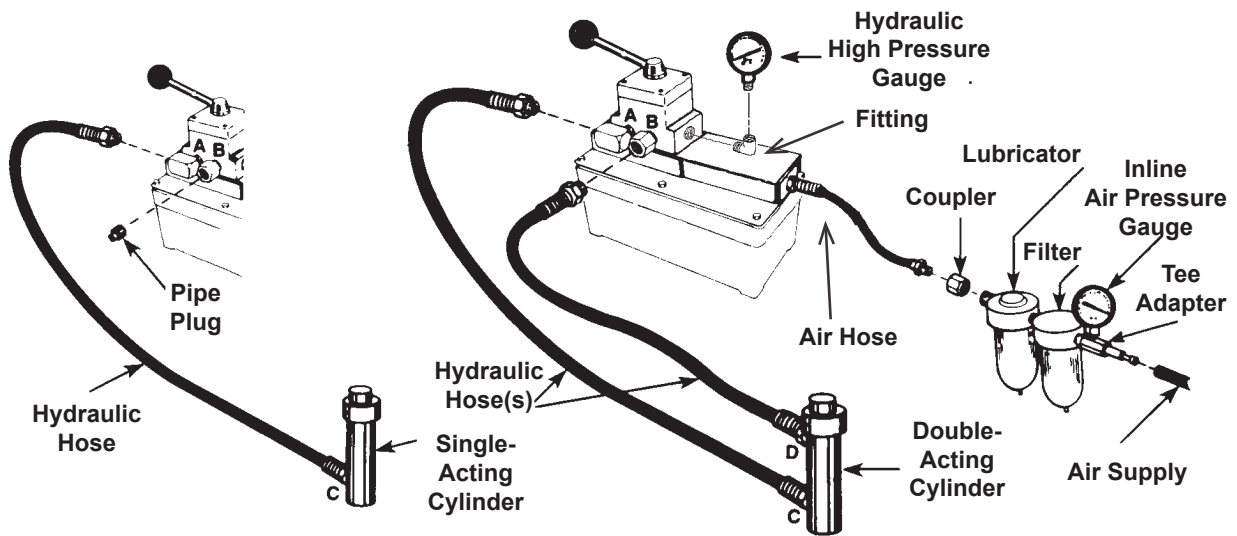
IMPORTANT

Seal all external pipe connections with a high-grade, non hardening thread sealant. PTFE tape may also be used to seal hydraulic connections, provided only one layer of tape is used. Apply the tape carefully, two threads back, to prevent it from being pinched by the coupler and broken off inside the system. Any loose pieces of tape could travel through the system and obstruct the flow of fluid or cause jamming of precision-fit parts.

A. FOR HAND/FOOT OPERATED PUMPS:

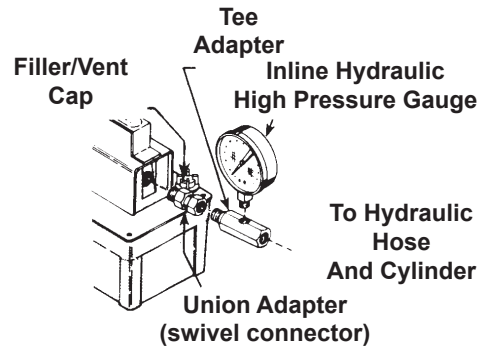
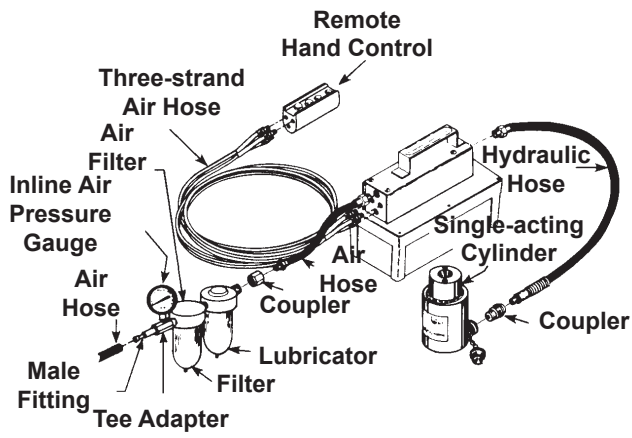


B. FOR MANUAL VALVE OPERATED PUMPS:



This pump is equipped with a two position, 3-way/4-way control valve for operating single- or double-acting hydraulic cylinders and requires attaching the hoses in the following manner: **When using a single-acting cylinder**, attach one end of a hose to port “A” of valve and the end of the hose to the advance port “C” of the cylinder. Then install a pipe plug in valve port “B.” If the hoses are frequently connected and disconnected, quick couplers should be used to prevent wear and tear on the fittings. **When using a double-acting cylinder**, attach one hose to port “A” of valve and the other end of the hose to the advance port “C” of cylinder. Attach the second hose to valve port “B” and the other end of the hose to return port “D” of cylinder.

C. FOR REMOVE CONTROLLED PUMPS:



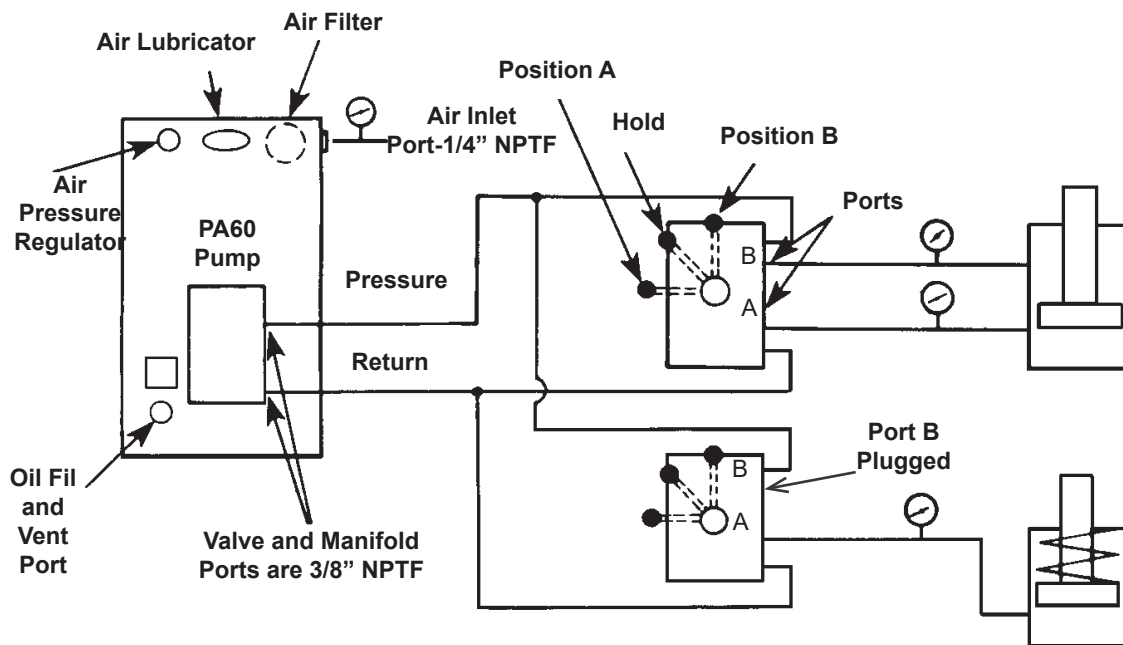
D. FOR TANDEM PUMPS:

(1) With Remove Valve -

- (a) Connect the pump to a remove 3-way/4-way valve.
- (b) Connect the fluid line from the fluid pressure port on the manifold to the pump pressure port on the valve.
- (c) Connect the fluid line from the fluid return port on the manifold to the pump return port on the valve.
- (d) Connect the cylinder(s) to the valve.

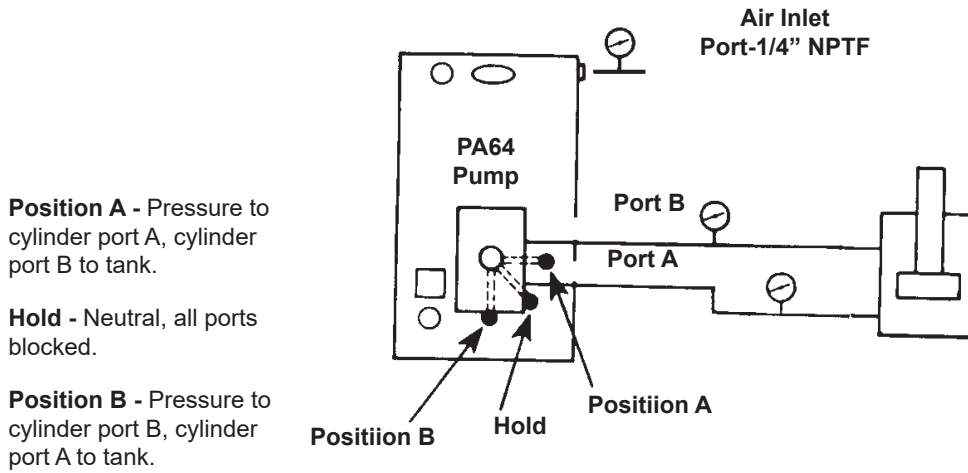
IMPORTANT

On all single pressure line applications, plug one port on the valve.



(2) With Pump Mounted Valve-

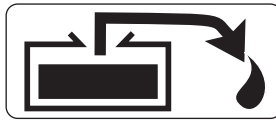
- (a) Connect the ports of the pump valve to cylinder(s). When port "A" is pressurized, port "B" becomes the return. When port "B" is pressurized, port "A" becomes the return.
- (b) Place the valve into the "A" or "B" position in order to pressurize the cylinder(s) or start the pump.



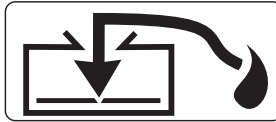
OPERATION

PICTOGRAM DEFINITIONS

Activating the pump with the pedal end marked with this pictogram, the flow of fluid is directed out of the reservoir.







Activating the pump with the pedal end marked with this pictogram, the flow of fluid is directed to the reservoir.

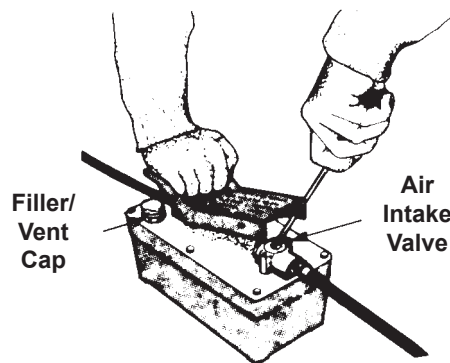


1. Priming the Pump


Under certain circumstances it may be necessary to prime the pump unit. To accomplish this, perform the following procedure:

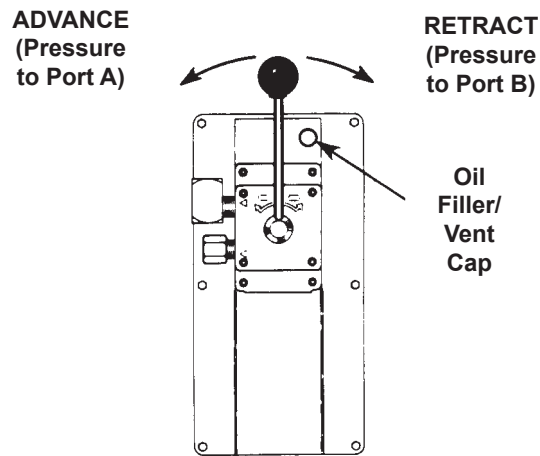
A. For Hand/Foot Operated Pumps:

- (1) Press the release end of the pedal while holding down the air intake valve with a flathead screwdriver. The air intake valve is located directly under the pedal in the area marked . The valve is depressed simultaneously with the  area of the pedal during priming.
- (2) Allow the pump to cycle approximately 15 seconds.
- (3) Remove the screwdriver, and press the  end of the pedal once more..
- (4) If the cylinder extends or pressure builds, the pump has been successfully primed. If the pump does not respond, repeat the procedure, jogging the air intake valve while holding the pedal in the  position.






B. For Manual Valve Operated Pumps:

Disconnect the hose end at the advance port of the cylinder. Direct the hose end into a suitable container or back into the pump reservoir. Shift the valve to the ADVANCE position and depress the end of the foot pedal inscribed with . Allow the pump to cycle until fluid begins to flow freely into the container or reservoir. Reconnect the hose end to the cylinder advance port. Shift the valve to the ADVANCE position and reactivate the pump. If the cylinder extends or builds pressure, the pump has been successfully primed. If not, refer to the Trouble-shooting Guide of these instructions.



C. For Remote Controlled Pumps:

Depress the  AND  buttons on the remote hand control simultaneously and allow the pump to cycle for approximately fifteen seconds. Release both buttons and then depress the  button once more. If the cylinder extends or pressure builds, the pump has been successfully primed. If the pump does not respond repeat the procedure. If pump still does not respond, tip pump upside down and repeat procedure.

D. For Tandem Pumps:

- (1) Connect the fluid line to the pressure port and keep the return port plugged. Place the other end of the fluid line in the pump filler hole.




NOTE

If the fluid lines are connected to a remote valve, shift the valve into the center position and plug both cylinder ports on the valve. This lets fluid circulate through the valve and back to the pump reservoir; thereby allowing the pump to prime.




- (2) Attach air line with shut-off valve to the pump.
- (3) Open the air valve. Pump will begin to reciprocate, and fluid will advance through the hose or fluid line and return to the pump reservoir. Allow the pump to cycle approximately 15 seconds.
- (4) Plug the manifold pressure port, or shift the valve to pressurize the circuit. If the pump builds pressure, it has been successfully primed.

2. Pump Operation




A. For Hand/Foot Operated Pumps:

- (1) To extend the cylinder, depress the pedal on the end marked .
- (2) To hold the cylinder in position, release the end of foot pedal marked with  to deactivate the pump.
- (3) To retract the cylinder, depress the pedal on the end marked .

B. For Remote Controlled Pumps:

- (1) To extend the cylinder, depress the button on the remote hand control marked .
- (2) To hold the cylinder in position, release the  button.
- (3) To retract the cylinder, depress the button on the remote hand control marked .

C. For Manual Valve Operated Pumps:

- (1) To extend the cylinder, shift the valve handle to the advance position and depress the end of the foot pedal inscribed with  to activate the pump.
- (2) To hold the cylinder in position, release the end of foot pedal inscribed with  to deactivate the pump.
- (3) To retract the cylinder, shift the valve handle to the retract position and depress the end of the foot pedal inscribed with  to activate the pump.

3. For Pumps With Air Regulators:

- A. Open the air shut-off valve (if so equipped) or connect the air quick coupler (if so equipped).

NOTE

Under certain circumstances the pump may need to be primed before operation. Refer to the method described in the section entitled “Priming the Pump Unit.”

- B. Slowly turn the air regulator control on unit clockwise to increase pressure, counterclockwise to decrease pressure. As air is admitted to the pump unit, it will begin to deliver fluid to the system. Continue to slowly turn the air regulator control clockwise until gauge reads the maximum hydraulic pressure rating as stated on the pumps data plate. A maximum hydraulic pressure reading should be obtained if air pressure is approximately 100 PSI (7 BAR).
- C. Cycle the system several times by manually shifting or the push button (if so equipped). Set the air regulator to obtain the desired hydraulic pressure. When decreasing pressure, shift the valve after each adjustment before measuring actual hydraulic pressure.
- D. Shut off and disconnect air supply to the pump and shift pump valve or push button (if so equipped) two times to release all system pressure. Check fluid level with hydraulic system retracted. The pump is now ready for operation.

NOTE

The hydraulic pressure is increased or decreased by adjusting the air inlet pressure at the regulator.

- E. On two stage pumps, the air pressure regulator that is mounted on the pump controls only the output from the high pressure stage. The output of the low pressure stage of the pump is determined by the air line pressure coming from the remote regulator. A remote regulator is required to control the air pressure from the air line. The independent functioning of the low and high pressure stages of this pump can best be described as follows. At the minimum air line pressure of 40 PSI (3 BAR), the low pressure stage of the pump will deliver 480 PSI (33 BAR) hydraulic pressure (with the pump regulator turned counterclockwise to prevent air pressure from activating the high pressure stage of the pump.) At the minimum air line pressure of 40 PSI (3 BAR) the high pressure stage of the pump will deliver 4,000 PSI (275 BAR) hydraulic pressure (with the pump regulator turned clockwise to allow air pressure to reach the high pressure stage.) Always remember that the pump regulator must be turned fully counterclockwise when the pump is used to produce 1,200 PSI (83 BAR) or less.

PREVENTIVE MAINTENANCE

IMPORTANT

- **Any repair or servicing that requires dismantling the pump must be performed in a dirt-free environment by a qualified technician.**
- **Dispose of machine and fluids properly.**

1. Lubrication

For Hand/Foot, Manual Valve, and Remote Control Operated Pumps:

If the pump is operated on a continuous duty cycle for extended periods, the manufacturer recommends installing an automatic air line oiler in the air inlet line as close to the pumping unit as possible. Set the unit to feed approximately one drop of oil per minute into the system. Use SAE grade oil, 5W to 30W

For Tandem Pumps:

These models have an integral air pressure regulator, air filter and lubricator. Set the lubricator to feed one drop of oil per minute to the system. Use SAE grade oil, 5W to 30W. For servicing the air regulator, lubricator and filter system, see the operating and service instructions provided.

2. Bleeding Air from the System

During the first moments of operation or after prolonged use, a significant amount of air may accumulate within the hydraulic system. This entrapped air may cause the cylinder to respond slowly or behave in an unstable manner. To remove the air, run the system through several cycles (extending and retracting the cylinder) free of any load. The cylinder must be at lower level than the pump to allow air to be released through the pump reservoir.

3. Inspecting the Hydraulic Fluid Level

Check the fluid level in the reservoir after every 10 hours of use. Drain and replenish the reservoir with Power Team hydraulic fluid after every 300 hours of use approximately.

For pumps with a 105 cubic inch (1.7 l) reservoir capacity:

The fluid level should be 1/2 inch (12.7 mm) from the filler/vent cap with all cylinders retracted.

For pumps with a 2 gallon (7.6 l) reservoir capacity:

The fluid level should be 1-3/4 inch (44.5 mm) from the filler/vent cap with all cylinders retracted.

4. Draining and Flushing the Reservoir

IMPORTANT

Wipe the pump exterior completely clean before attempting this procedure.

- A. Remove the screws that fasten the pump assembly to the reservoir. Remove the pump assembly from the reservoir. Do not damage the gasket, filter or safety valve.**
- B. Drain the reservoir of all fluid and refill half full with clean hydraulic fluid. Rinse the filter clean.**
- C. Place the pump assembly back onto the reservoir, and secure with two of the machine screws assembled in opposite corners of the housing.**

- D. Run the unit for several minutes. Use the same method described in the section titled “Priming the Pump Unit.”
- E. Drain and clean the reservoir once more.
- F. Refill the reservoir with Power Team hydraulic fluid and replace the pump assembly (with gasket) on the reservoir and install the screws. Torque the screws as follows: For 105 cubic inch (1.7 l) reservoirs, torque to 25 to 30 inch pounds (2.8 to 3.4 N•m); for 2 gallon (7.6 l) reservoirs, torque to 35 to 45 inch pounds (4.0 to 5.0 N•m)

IMPORTANT

Drain and clean the other hydraulic system components (hoses, cylinders, etc.) before reconnecting them to the pump. This will prevent contaminated fluid from entering the pump again.

G.

5. Refilling the Reservoir

If additional fluid must be added to the reservoir, use only Power Team hydraulic fluid (215 SSU @ 100° F [38° C]). Clean the entire area around the filler plug before adding fluid to the reservoir. Remove the filler plug, and insert a clean funnel with filter. The cylinder must be fully retracted and the air supply disconnected when adding the fluid to the reservoir.

6. Periodic Cleaning

IMPORTANT

The greatest single cause of failure in hydraulic pumps is dirt. Keep the pump and attached equipment clean to prevent foreign matter from entering the system.

A routine should be established to keep the pump as free from dirt as possible. All unused couplers must be sealed with thread protectors. All hose connections must be free of grit and grime. Any equipment hooked up to the pump should also be kept clean. Use only Power Team hydraulic fluid in this unit and change as recommended (every 300 hours).

ACCESSORIES

Gauges and accessories may not be included with the pump. However, a hydraulic gauge is strongly recommended whenever the pump is used!



WARNING

- The gauge must be of the proper rating for the pressure used!
- Use only Power Team approved accessories, hydraulic fluid, and repair parts!

1. Installing An In-line Hydraulic Pressure Gauge

- A. Remove the male fitting from the air filter and install a tee adapter, with gauge, between the hose and air filter.
- B. Install male fitting into the tee adapter and securely clamp the hose to the male fitting.

2. Installing An In-line Hydraulic Pressure Gauge

- A. Remove the thread protector from the hydraulic outlet port and inspect the threads and fittings for signs of wear.
- B. Install a tee adapter, with gauge, between the hose coupling and the pump hydraulic outlet port.
- C. Tighten all connections securely! DO NOT OVERTIGHTEN HOSE CONNECTIONS.

3. Fire-Resistant Hydraulic Fluid

Flame Out 220™ fire-resistant hydraulic fluid is compatible with all Power Team hydraulic equipment. The use of this fluid does not require the changing of seals in any Power Team pump or cylinder and is available through your local Power Team distributor.

OPERATOR TROUBLESHOOTING GUIDE

If this guide does not resolve your pump problem, contact an authorized hydraulic service center or a company headquarters listed in **POWER TEAM FACILITIES**.

PROBLEM	CAUSE	SOLUTION
Pump reciprocates but no fluid delivery (cylinder will not extend)	1. Low fluid level.	1. Add fluid as instructed in Preventive Maintenance section.
	2. Pump not primed.	2. Prime pump as instructed in Operation section.
	3. Fluid intake filter contaminated.	3. Remove reservoir and clean intake filter and reinstall.
Low fluid delivery (cylinder extends slowly)	1. Inadequate air supply	1.
	a. Check air input supply.	a. Should be 20 CFM (.57 M3/min.) minimum.
	b. Contamination, check air side of pump (plugged air inlet screen).	b. Clean and reassemble.
	2. Hydraulic failure	2.
	a. Check the fluid inlet filter for contamination.	a. Remove reservoir and clean intake filter and reinstall.
	b. Air in hydraulic system.	b. Bleed the system as described in the Preventive Maintenance section.
Pump will not build to maximum pressure (no visible leakage)	1. Check the air supply.	1. 100 PSI (7 BAR) is required to obtain maximum pressure.
	2. Pressure regulator improperly adjusted (if so equipped).	2. Adjust according to instructions in Operation section.
Pump builds pressure but will not hold system pressure.	1. Check the hydraulic connections and other system components for leakage, including 3 way/4 way valve (if so equipped).	1. Refit or repair as needed.
Pump will continue to run slowly even after desired pressure is reached.	1. Output pressure equal to or higher than relief valve setting.	1. Normal operation.
	2. Defective 3-way/4-way valve or other components leaking.	2. Repair or replace.
Excess oil spray from muffler.	1. Air lubricator is set too rich (if so equipped).	1. Set at one drop per minute.

POWER TEAM FACILITIES & CONTACT

North America Headquarters

5885 11th Street
Rockford, IL 61109
USA

Customer Service/Order Entry

Tel: +1 800 541 1418
Fax: +1 800 288 7031

Send P.O's to: info@powerteam.com

Technical Services

Tel: +1 800 477 8326
Fax: +1 800 765 8326

European Headquarters

Albert Thijsstraat 12
6471 WX Eygelshoven
The Netherlands
Tel: +31 45 567 8877

infoeurope@powerteam.com

SEA Headquarters

20 Pioneer Crescent #06-01
West Park BizCentral
Singapore 628555
Tel: +65 6264 4366
Fax: +65 6265 9133

infoasia@powerteam.com

China Headquarters

7F Treasury Building
1568 Huashan Road
Shanghai, 200052 China
Tel: +86 21 2208 5888
Fax: +86 21 2208 5682

infochina@powerteam.com

Australia Headquarters

SPX Flow Technology Australia Pty Ltd
Quad 2, 6 Parkview Drive
Homebush Bay NSW 2127
Tel: +61 02 9763 4900
Fax: +61 02 9763 7888

ft.aus.cs@spxflow.com

India Headquarters

SPX Flow Technology (India) Pvt. Limited
Survey No. 275
Odhav, Ahmedabad - 382 415
Tel: +91-99099-85454
+91-97277-19950

india@powerteam.com



www.spxflow.com

SPX Flow Customer Service:

 **(800) 541-1418**

EC DECLARATION OF CONFORMITY

We declare under our sole responsibility that our Air - driven Pump Model:

*** PA6 - series**

to which this declaration relates are in conformity with the following:

<u>EN, EN-ISO, ISO standards</u>	<u>Title</u>
Per the provisions of the Machinery Safety Directive	2006/42 EC
EN_ISO 12100	Safety of machinery, basic concepts, general principles for design, risk assessment & risk reduction
EN 4413	Hydraulic Fluid Power – general rules and safety requirements for systems & their components
EN 4414	Pneumatic Fluid Power – general rules and safety requirements for systems & their components
Per the provisions of the Noise Emission in the Environment by Equipment for Use Outdoors Directive	2000/14 EC
EN_3200L0014	Noise emission in the environment for use outdoors
ISO 3744	Sound Power Level Measurements

measured sound power level on an equipment representative for this type : 94 dB(A)
guaranteed sound power level for this equipment : 95 dB(A) or less

SPX Hydraulic Technologies
5885 11th Street
Rockford, IL 61109-3699
United States of America

We hereby declare that the equipment specified under * conforms to the above quoted European Community Directive(s) and Standard(s) as per the currently valid revision. SPX Hydraulic Technologies is certified and registered to ISO 9001: 2015.

SPX Hydraulic Technologies
Andreas J. Klemm
SPX Hydraulic Technologies
Albert Thijssstraat 12
NL-6471 WX Eygelshoven
The Netherlands

The Netherlands January 16th, 2019



Andreas J. Klemm, PhD

