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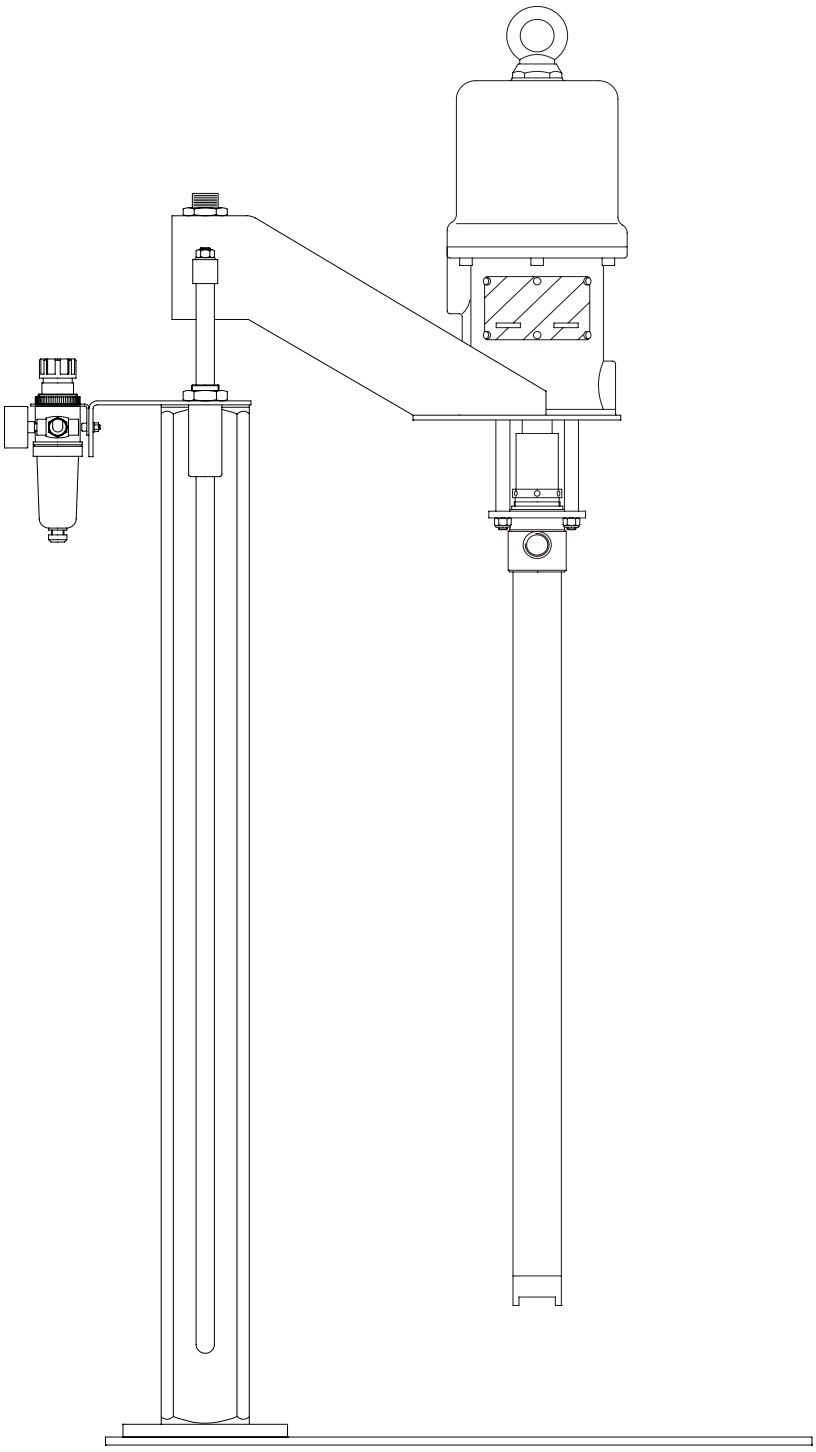
Pneumatic hoist

Single mast for cylindrical 200lt drums



INSTRUCTION MANUALL

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This manual is to be considered as an English language translation of the original manual in Italian. The manufacturer shall bear no responsibility for any damages or inconveniences that may arise due to the incorrect translation of the instructions contained within the original manual in Italian.

Due to a constant product improvement programme, the factory reserves the right to modify technical details mentioned in this manual without prior notice.

Pneumatic hoist

Single mast for 200 litres drums

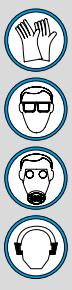
INDEX ..... p. 3
WARNINGS ..... p. 4
A TECHNICAL DATA ..... p. 5
B WORKING PRINCIPLE ..... p. 6
C DESCRIPTION OF THE EQUIPMENT ..... p. 8
D TRANSPORT AND UNPACKING ..... p. 9
E SAFETY RULES ..... p. 9
CONDITIONS OF GUARANTEE p.10
F DANGERS p.10
G USE CORRECT p.11
H SETTING-UP p.11
I WORKING p.11
J FLAT PRESSING PROCEDURE IN THE CASK (FOR EXTRUSION VERSIONS ONLY) p.12
K FLAT-PRESSING EXTRACTION PROCEDURE FROM THE STEM (FOR EXTRUSION VERSIONS ONLY) p.14
L REPLACE OF THE DRUM (FOR EXTRUSION VERSIONS ONLY) p.14
M ROUTINE MAINTENANCE p.14
N FIXING WITH SCREW ANCHORS p.15
O PROBLEMS AND SOLUTION p.16
SPARE PARTS
P ROD PARTS p.18
Q AIR REGULATOR UNIT p.19
R FLAT DISC PRESSING p.20

WE ADVISE THE USE OF THIS EQUIPMENT ONLY BY PROFESSIONAL OPERATORS.
ONLY USE THIS MACHINE FOR USAGE SPECIFICALLY MENTIONED IN THIS MANUAL.

Thank you for choosing a **SAMOA** product.
As well as the product purchased, you will receive a range of support services enabling you to achieve the results desired, quickly and professionally.

WARNINGS

The table below provides the meaning of the symbols used in this manual in relation to using, earthing, operating, maintaining, and repairing of this equipment.

	• Read this operator's manual carefully before using the equipment. • An improper use of this machine can cause injuries to people or things. • Do not use this machine when under the influence of drugs or alcohol. • Do not modify the equipment under any circumstances. • Use products and solvents that are compatible with the various parts of the equipment, and read the manufacturer's warnings carefully. • See the Technical Details for the equipment given in the Manual. • Check the equipment for worn parts once a day. If any worn parts are found, replace them using ONLY original spare parts. • Keep children and animals away from work area. • Comply with all safety standards.
	• It indicates an accident risk or serious damage to equipment if this warning is not followed.
	**FIRE AND EXPLOSION HAZARD** • Solvent and paint fumes in work area can ignite or explode. • **To help prevent fire and explosion:** - Use equipment ONLY in well ventilated area. - Eliminate all ignition sources, such as pilot lights, cigarettes and plastic drop cloths (potential static arc). - Ground equipment and conductive objects. - Use only grounded hoses. - Do not use trichloroethane, methylene chloride, other halogenated hydrocarbon solvents or fluids containing such solvents in pressurized aluminium equipment. Such use can cause serious chemical reaction and equipment rupture, and result in death, serious injury, and property damage. - Do not form connections or switch light switches on or off if the air contains inflammable fumes. • If electrical shocks or discharges are encountered the operation being carried out using the equipment **must be stopped immediately**. • Keep a fire extinguisher at hand in the immediate vicinity of the work area.
	• It indicates wound and finger squashing risk due to movable parts in the equipment. • Tenersi lontano dalle parti in movimento. • Do not use the equipment without the proper protection. • Before any inspection or maintenance of the equipment, carry out the decompression procedure explained in this manual, and prevent any risk of the equipment starting unexpectedly.
	• Report any risk of chemical reaction or explosion if this warning has not been given. • (IF PROVIDED) There is a risk of injury or serious lesion related to contact with the jet from the spray gun. If this should occur, IMMEDIATELY contact a doctor, indicating the type of product injected. • (IF PROVIDED) Do not spray before the guard has been placed over the nozzle and the trigger on the spray gun. • (IF PROVIDED) Do not put your fingers in the spray gun nozzle. • Once work has been completed, before carrying out any maintenance, complete the decompression procedure.
	• It indicates important recommendations about disposal and recycling process of products in accordance with the environmental regulations.
	• Mark any clamps attached to earth cables. • Use ONLY 3-wire extension cords and grounded electrical outlets. • Before starting work make sure that the electrical system is grounded and that it complies with safety standards. • High-pressure fluid from gun, hose leaks, or ruptured components will pierce skin. • **To help prevent injection, always:** - (IF PROVIDED) Engage trigger lock when not spraying. - (IF PROVIDED) Do not put your hand over the spray tip. Do not stop or deflect leaks with your hand, body or other. - (IF PROVIDED) Do not point gun at anyone or at any part of the body. - (IF PROVIDED) Never spray without tip guard. - Do pressure relief if you stop spraying or being servicing sprayer and before any maintenance operations. - Do not use components rated less than sprayer Maximum Working Pressure. - Never allow children to use this unit - (IF PROVIDED) Brace yourself; gun may recoil when triggered. **If high pressure fluid pierces your skin, the injury might look like "just a cut", but it is a serious wound!** **Get immediate medical attention.**
	• It is obligatory to wear suitable clothing as gloves, goggles and face shield. • Wear clothing that complies with the safety standards in force in the country in which the equipment is used. • Do not wear bracelets, earrings, rings, chains, or anything else that may hinder the operator's work. • Do not wear clothing with wide sleeves, scarves, ties, or any other piece of clothing that could get tangled up in moving parts of the equipment during the work, inspection, or maintenance cycles.

A TECHNICAL DATA

PNEUMATIC HOIST 200	
Max air pressure	7 Bar (102 PSI)
Air inlet diameter	3/8" GAS (F) BAYONET
WEIGHT	110 Kg
Drum type	Cylindrical - 200 litri
Drum inner diameter (D)	572mm
Maximum drum height (E)	990mm
Length (A)	850
Height (B)	1465/2566
Width (C)	640

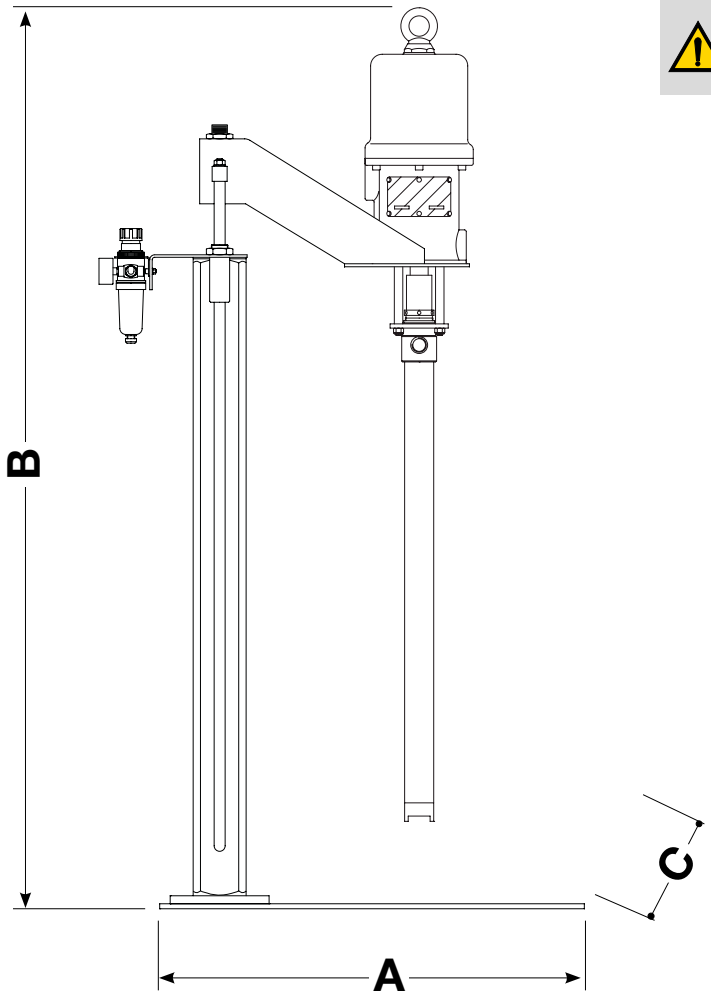
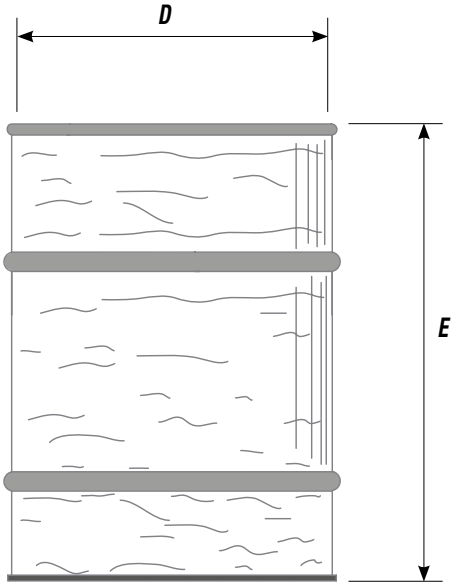


Fig. 3

Use EXCLUSIVELY with standard cylindrical 200lt drums. DO NOT USE with other drums.



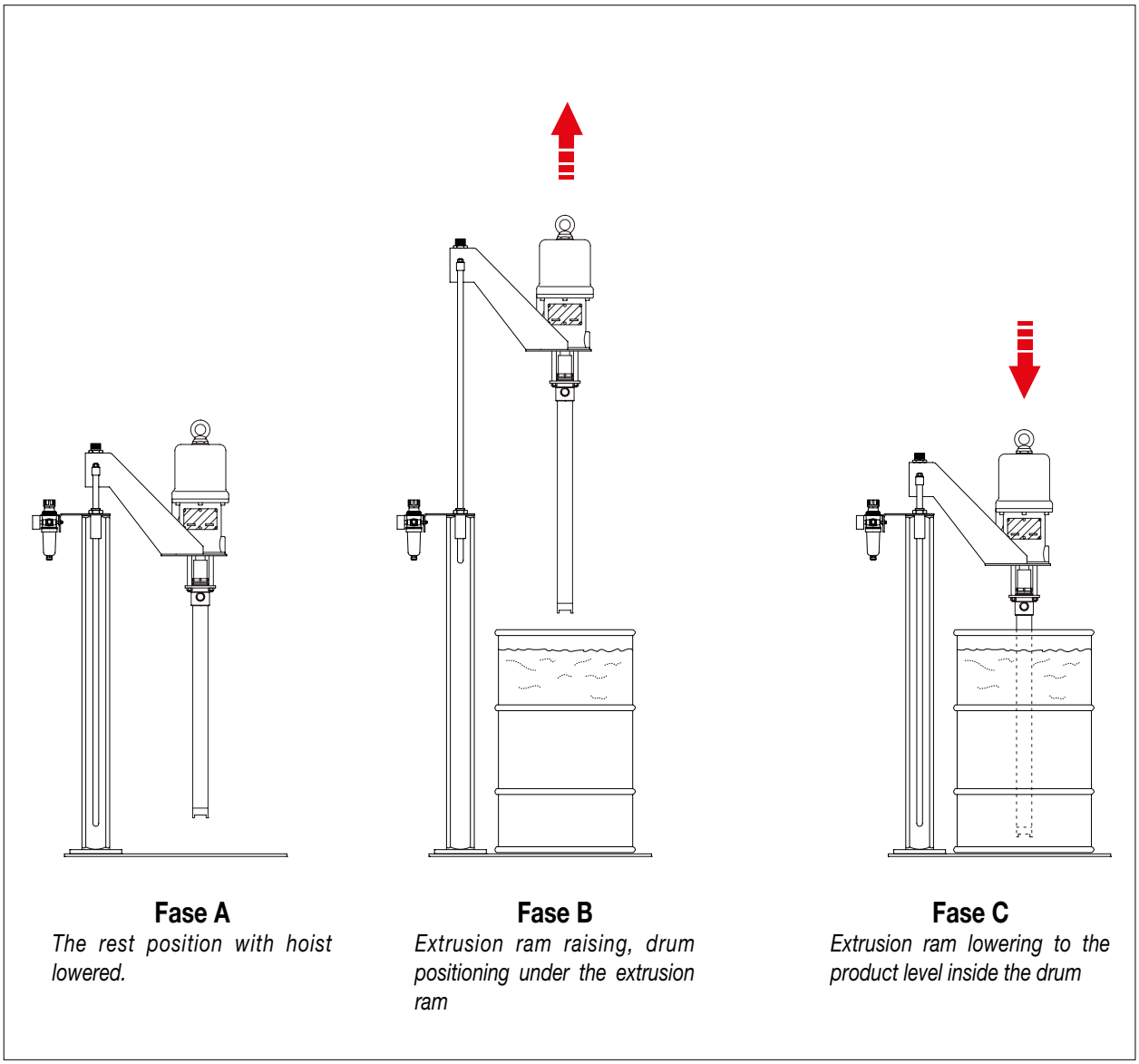
B WORKING PRINCIPLE

Transfer version

This type of double-effect single column extrusion ram allows for *Nova, Omega, Vega, Ghibli* series pneumatic piston transfer pump elevation.
Extrusion ram use allows for pump suction unit driving during the product suction phase directly inside 200-litre drums.

This system allows for the safe, clean transfer of material for use from the storage container directly into the application area. This safe, reliable system allows empty drums to be replaced with new drums in just a few minutes.

Below shows the main steps of the working principle of the hoist transfer version



Fase A
The rest position with hoist lowered.

Fase B
Extrusion ram raising, drum positioning under the extrusion ram

Fase C
Extrusion ram lowering to the product level inside the drum

Fig. 1

Extrusion version

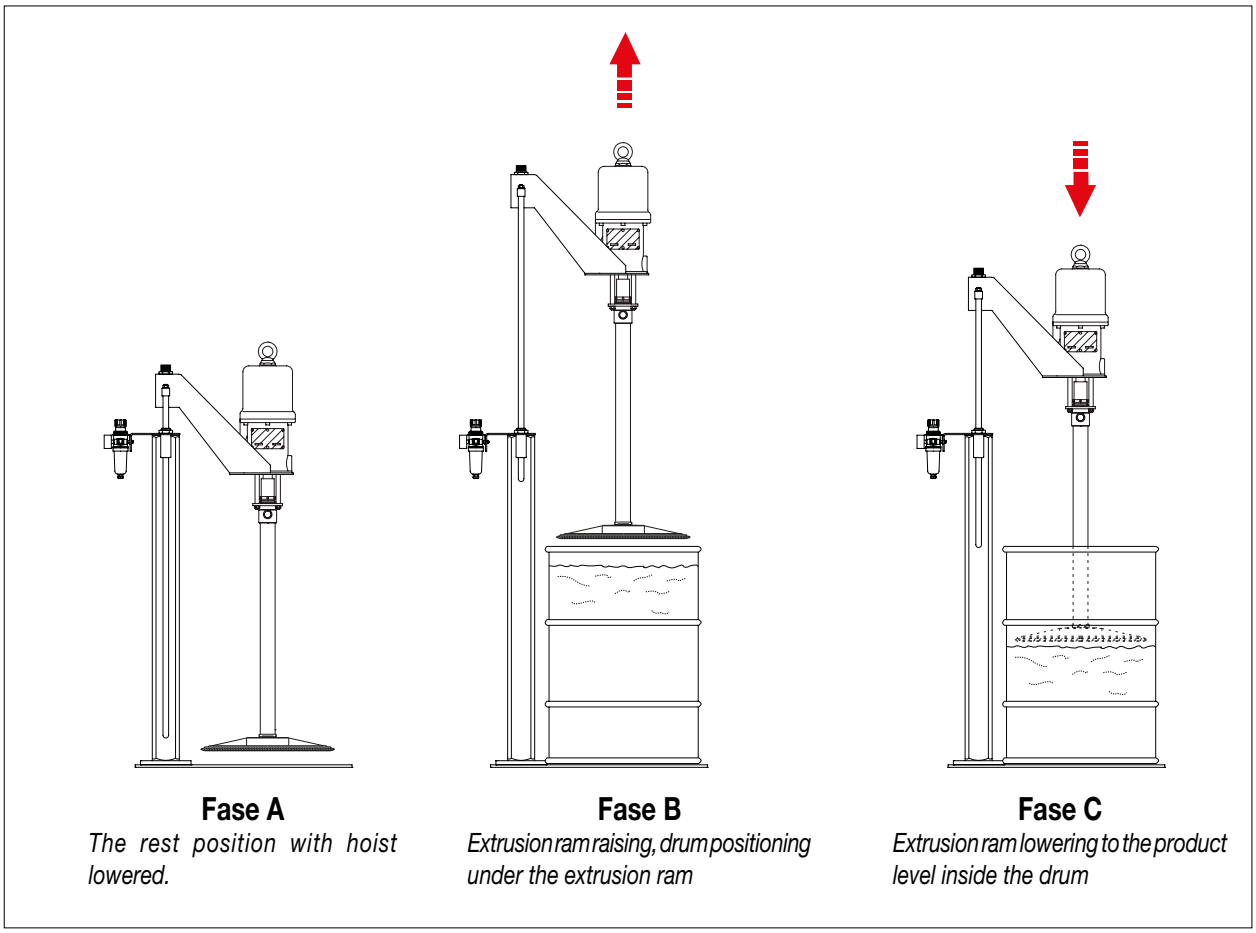
A follower plate is installed on the pump suction unit base (*for extrusion versions*) to compress material, thus ensuring continuous flow during use.

Pneumatic piston pumps are able to transfer highly viscous products as they "flow" naturally toward the suction mouth thanks to the follower plate and to the plate suction valve, thus preventing the pump from starting to cavitate with subsequent defusing. They are suitable for pumping highly viscous products.

The follower plate is equipped with a series of special anti-oil rubber, high strength flat or toroidal gaskets, thus ensuring perfect protection of the product contained in the drum from any contamination with dust or moisture and also preventing drying caused by contact with air.

The extrusion arm is able to automatically compensate follower plate descent during product use.

Below shows the main steps of the working principle of the hoist extrusion version



Fase A

The rest position with hoist lowered.

Fase B

Extrusion ram raising, drum positioning under the extrusion ram

Fase C

Extrusion ram lowering to the product level inside the drum

Fig. 2

C DESCRIPTION OF THE EQUIPMENT

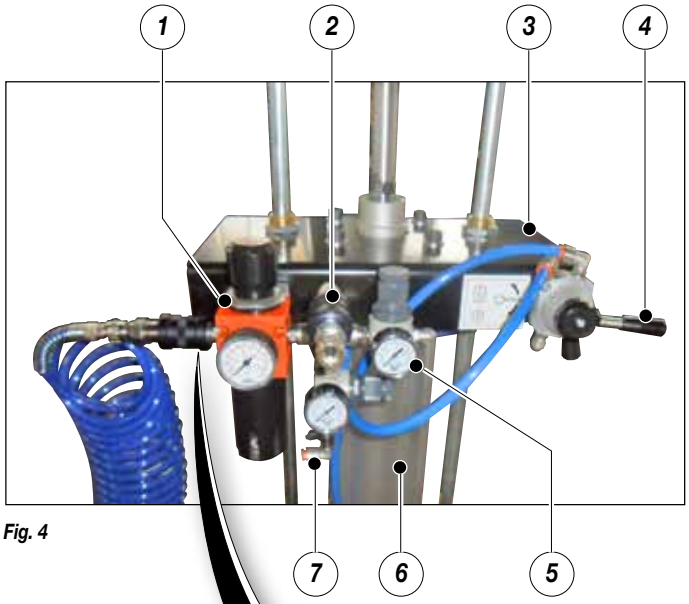


Fig. 4

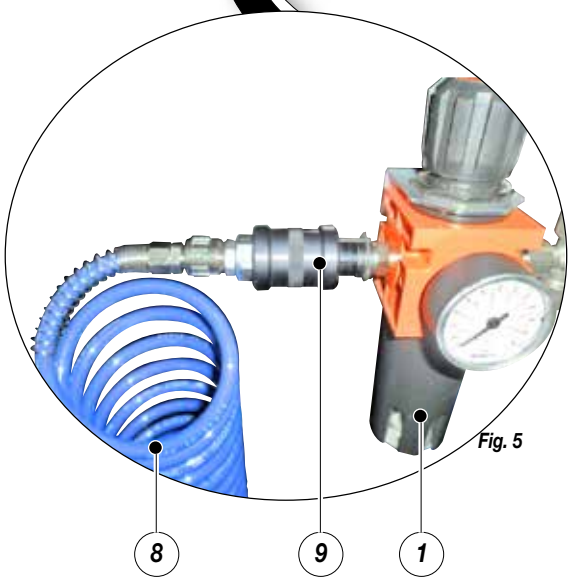


Fig. 5

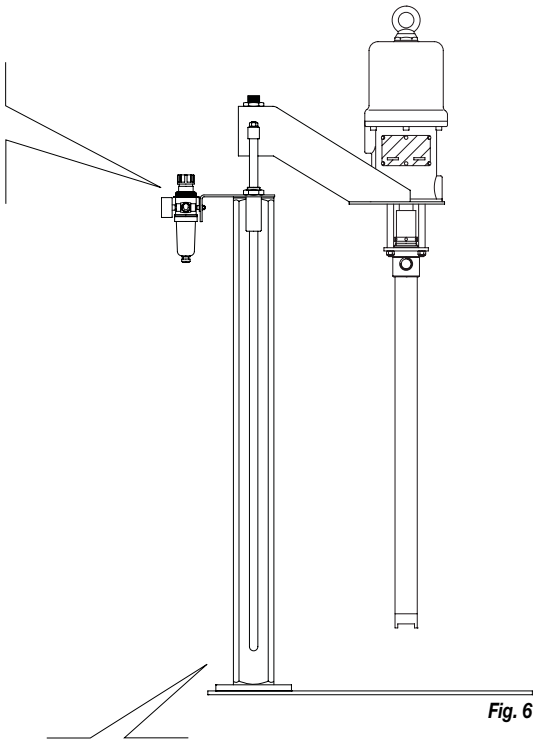


Fig. 6

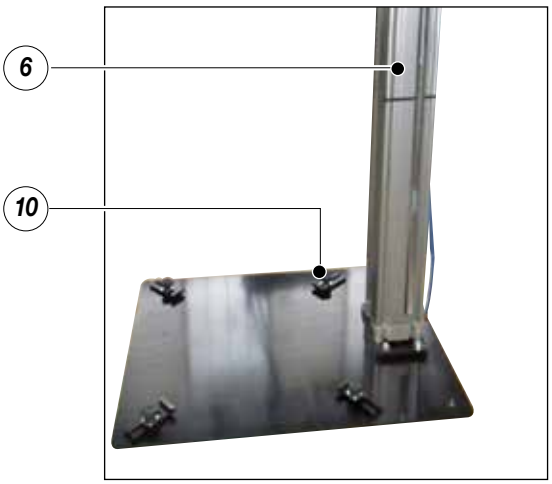


Fig. 7

POS.	Description
1	Pneumatic pump regulator filter
2	Air inlet with bayonet connection
3	Command unit support bracket
4	Up/down drive lever
5	Up/down pressure regulator
6	Extrusion ram lifting cylinder

POS.	Description
7	Available air outlet
8	Pneumatic pump air delivery
9	Open/close valve for air supply to pneumatic pump
10	Terminal with drum locking handwheel on the base plate

D TRANSPORT AND UNPACKING

- The packed parts should be handled as indicated in the symbols and markings on the outside of the packing.
- Before installing the equipment, ensure that the area to be used is large enough for such purposes, is properly lit and has a clean, smooth floor surface.
- The user is responsible for the operations of unloading and handling and should use the maximum care so as not to damage the individual parts or injure anyone. To perform the unloading operation, use only qualified and trained personnel *(truck and crane operators, etc.)* and also suitable hoisting equipment for the weight of the installation or its parts. Follow carefully all the safety rules. The personnel must be equipped with the necessary safety clothing.
- The manufacturer will not be responsible for the unloading operations and transport to the workplace of the machine.
- Check the packing is undamaged on receipt of the equipment. Unpack the machine and verify if there has been any damage due to transportation. In case of damage, call immediately the manufacturer and the Shipping Agent. All the notices about possible damage or anomalies must arrive timely within 8 days at least from the date of receipt of the plant through Registered Letter to the Shipping Agent and to **the manufacturer.**

The disposal of packaging materials is a customer's competence and must be performed in accordance with the regulations in force in the country where the plant is installed and used.It is nevertheless sound practice to recycle packaging materials in an environment-friendly manner as much as possible.

E SAFETY RULES

- THE EMPLOYER SHALL TRAIN ITS EMPLOYEES ABOUT ALL THOSE RISKS STEMMING FROM ACCIDENTS, ABOUT THE USE OF SAFETY DEVICES FOR THEIR OWN SAFETY AND ABOUT THE GENERAL RULES FOR ACCIDENT PREVENTION IN COMPLIANCE WITH INTERNATIONAL REGULATIONS AND WITH THE LAWS OF THE COUNTRY WHERE THE PLANT IS USED.
- THE BEHAVIOUR OF THE EMPLOYEES SHALL STRICTLY COMPLY WITH THE ACCIDENT PREVENTION AND ALSO ENVIRONMENTAL REGULATIONS IN FORCE IN THE COUNTRY WHERE THE PLANT IS INSTALLED AND USED.

Read carefully and entirely the following instructions before using the product. Please save these instructions in a safe place.

The unauthorised tampering/replacement of one or more parts composing the machine, the use of accessories, tools, expendable materials other than those recommended by the Manufacturer can be a danger of accident. The Manufacturer will be relieved from tort and criminal liability.

- KEEP YOUR WORK PLACE CLEAN AND TIDY. DISORDER WHERE YOU ARE WORKING CREATES A POTENTIAL RISK OF ACCIDENTS.
- ALWAYS KEEP PROPER BALANCE AVOIDING UNUSUAL STANCE.
- BEFORE USING THE TOOL, ENSURE THERE ARE NOT DAMAGED PARTS AND THE MACHINE CAN WORK PROPERLY.
- ALWAYS FOLLOW THE INSTRUCTIONS ABOUT SAFETY AND THE REGULATIONS IN FORCE.
- KEEP THOSE WHO ARE NOT RESPONSIBLE FOR THE EQUIPMENT OUT OF THE WORK AREA.
- **NEVER** EXCEED THE MAXIMUM WORKING PRESSURE INDICATED.
- **NEVER** POINT THE SPRAY GUN AT YOURSELVES OR AT OTHER PEOPLE. THE CONTACT WITH THE CASTING CAN CAUSE SERIOUS INJURIES.
- IN CASE OF INJURIES CAUSED BY THE GUN CASTING, SEEK IMMEDIATE MEDICAL ADVICE SPECIFYING THE TYPE OF THE PRODUCT INJECTED. **NEVER** UNDERVALUE A WOUND CAUSED BY THE INJECTION OF A FLUID.
- ALWAYS DISCONNECT THE SUPPLY AND RELEASE THE PRESSURE IN THE CIRCUIT BEFORE PERFORMING ANY CHECK OR PART REPLACEMENT OF THE EQUIPMENT.
- NEVER MODIFY ANY PART IN THE EQUIPMENT. CHECK REGULARLY THE COMPONENTS OF THE SYSTEM. REPLACE THE PARTS DAMAGED OR WORN.
- TIGHTEN AND CHECK ALL THE FITTINGS FOR CONNECTION BETWEEN PUMP, FLEXIBLE HOSE AND SPRAY GUN BEFORE USING THE EQUIPMENT.
- ALWAYS USE THE FLEXIBLE HOSE SUPPLIED WITH STANDARD KIT.

- THE USE OF ANY ACCESSORIES OR TOOLING OTHER THAN THOSE RECOMMENDED IN THIS MANUAL, MAY CAUSE DAMAGE OR INJURE THE OPERATOR.
- THE FLUID CONTAINED IN THE FLEXIBLE HOSE CAN BE VERY DANGEROUS. HANDLE THE FLEXIBLE HOSE CAREFULLY. DO NOT PULL THE FLEXIBLE HOSE TO MOVE THE EQUIPMENT. NEVER USE A DAMAGED OR A REPAIRED FLEXIBLE HOSE.

The high speed of travel of the product in the hose can create static electricity through discharges and sparks. It is suggested to earth the equipment. The pump is earthed through the earth cable of the supply.
The gun is earthed through the high pressure flexible hose.
All the conductors near the work area must be earthed.

- NEVER SPRAY OVER FLAMMABLE PRODUCTS OR SOLVENTS IN CLOSED PLACES.
- NEVER USE THE TOOLING IN PRESENCE OF POTENTIALLY EXPLOSIVE GAS.

Always check that the product is compatible with the materials composing the equipment *(pump, spray gun, flexible hose and accessories)* with which it can come into contact. Never use paints or solvents containing Halogen Hydrocarbons *(as the Methylene Chloride)*. If these products come into contact with aluminium parts can provoke dangerous chemical reactions with risk of corrosion and explosion.

Avoid approaching too much to the pump piston rod when the pump is working or under pressure. A sudden movement of the piston rod can cause wounds or finger squashing.

IF THE PRODUCT TO BE USED IS TOXIC, AVOID INHALATION AND CONTACT BY USING PROTECTION GLOVES, GOGGLES AND PROPER FACE SHIELDS.

TAKE PROPER SAFETY MEASURES FOR THE PROTECTION OF HEARING IN CASE OF WORK NEAR THE PLANT.

CONDITIONS OF GUARANTEE

The conditions of guarantee do not apply in the following situations:
- improper washing and cleaning of components causing malfunction, wear or damage to the equipment or any of its parts;
- improper use of the equipment;
- use that does not conform with applicable national legislation;
- incorrect or faulty installation;
- modifications, interventions and maintenance that have not been authorised by the manufacturer;
- use of non-original spare parts or parts that do not correspond to the specific model;
- total or partial non-compliance with the instructions provided.

THESE INSTRUCTIONS REFER TO THE CORRECT USE OF THE PNEUMATIC RAM. IN ADDITION, READ CAREFULLY THE INSTRUCTIONS CONTAINED IN THE MANUALS RELEVANTSTO THE DIFFERENT COMPONENTS (PNEUMATIC PUMP, DELIVERY GUN, ETC.) WHICH CAN BE USED WITH THE RAM.

F DANGERS

MOVING PARTS OF EQUIPMENT

All moving parts, such as the Group of rising and falling pressure plate may cause damage to the upper extremities.

- Do not approach with hands for the moving parts during operation of the equipment.
- During the ascent and descent of the hoist keep hands pressing plate and the rim of the container material.
- Keep hands away from pump during operation material priming piston and compressed air is supplied to the unit whenever.
- Before performing any maintenance or repair, disconnect the compressed air supply and arrange for decompression of the pump and of the hoist to the rest position (***see diagram 1 phase A***).

GROUNDING

During operation of the pump can create conditions of electrostatic energy.

- **before using the pump you must provide for the grounding connection.**
- **the pump is equipped with a special terminal and its grounding wire (1).**

Fig. 8

G USE CORRECT

The single column pneumatic extrusion ram is suitable for operations with 200-litre drums.

- The stem must be correctly positioned between the two columns and securely attached to the base plate using the clamps.
- The stem must not be deformed or damaged.
- The pumps installed on the hoist are piston and are suitable for pumping highly viscous products (*up to 2 million cps*).
- Use products that are chemically compatible with the pump parts that are in contact with the product to be pumped. Contact the manufacturer before using products other than those provided for in the contract of sale.
- The pressure of the compressed air supply must be between 3 ÷ 6 bar.

NOTE

Any other use of the equipment not provided for in the contract of sale is declared improper.

ATTENTION

Make sure there is sufficient space in height when the hoist is in the highest position.

H SETTING-UP

The operator will have to arrange an environment suitable to the plant before installing as indicated here below:

- An area wide enough to allow the drum loading an unloading and routine maintenance operatiions.
- Ensure there is a sufficient space in height to enable the ram lifting and an easy access to the air regulation groups.
- For the pneumatic ram feeding, use a tube with an internal diameter no lower than 10 mm

Install a condensate filter and a shut-off valve type ON-OFF on the air supply line to the ram.

- Make sure the air governors to the pump and ram are closed (*turn counterclockwise the control knob to close them*)
- Make sure the air delivery valve to the shovel plate is closed.
- Make sure the air delivery pipe to the pneumatic pump is connected to the ram and to the pump.
- Make sure the air delivery pipe to the shovel plate is connected to the ram and to the shovel plate.

I WORKING

Check all the fittings for the connection of the different components (*pump, flexible hose, gun, etc..*) before using the equipment.
Avoid approaching too much to the ram during the ascent and descent functions.

- Open the air supply to the ram.

- Turn the lifting control lever upwards (*see the illustration*).
- Acting on the air governor to the ram, gradually increase the feeding pressure to the pneumatic cylinder till the ram starts lifting. Let the ram reaches its maximum height.

NOTE

*The pneumatic cylinder's speed can be regulated acting on the adjustable silencer (**1**) loceted on the ram control lever (see illustration)*

- Remove the cover from the 200 litres drum to be used.

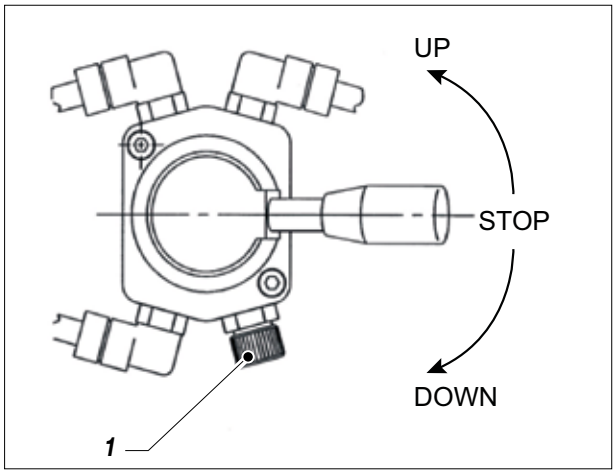


Fig. 9 - Pneumatic cylinder's speed regulation

Check if there are any dents on the drum, they could block the shovel plate of the ram inside the drum.

- Place the drum on the ram's plate.
- Turn the control lever downwards till the shovel plate lowers near the upper edge of the drum.
- Stop the descent of the ram by turning the control lever to the drum correctly so as it is in axis with the shovel plate.
- Center the drum correctly so as it is in axis with the shovel plate (*when installed*).
- Resume the extrusion ram descent, inserting the pump or the follower plate (*where installed*), inside the drum.
- Open the bleeder valve placed on the shovel plate, (*when installed*).
- Open the ari passage valve of the shovel plate.
- Allow the compressed air flow into the pump acting on the air pressure to the minimum valve necessary to a continuous working.
- The pump will start working and them will stop when all the chamber of the product is full. The pump will start working again any time the trigger of the gun is pushed or the delivery valve is open.
  In case of difficult suction of the pump, slowly open the bleeder valve placed on the shovel plate and close it when some product comes out from the vent (*for any possible working problem, follow the instructions described in the section "problems and solutionsi"*).

Never let pump idle for a long period: it could damage the pneumatic motor and ruin the seals.

J FLAT PRESSING PROCEDURE IN THE CASK

(FOR EXTRUSION VERSIONS ONLY)

Check all the fittings for connection of the various components (pump, hose, gun etc.), before using the appliance.

Avoid approaching too much to the hoist during lifting and lowering

- Open the primary air supply to the hoist.
- Turn the valve knob (**1**) upward.
- By turning the adjustment knob (**2**) to increase gradually the supply pressure of the hoist until it starts to rise. (to increase the pressure, turn the knob (**2**) clockwise).
- Let the hoist reaches its highest position.
- Remove the cover from the frame by 200 litres that you intend to use.

Check that the stem does not present excessive bruising, these can cause the pressure plate of the hoist with an automatically inside the drum.

- Broaden centering clamps (**4**)and fit the drum 200 liters on the base plate of the hoist;
- Turn the two-way valve (**1**) downwards by pressing down the pot near the top edge of the frame. Stop the descent of the hoist by turning the knob (**1**) valve into the intermediate position;
- Centre correctly the stem so that it is aligned with the pressing plate;
- Open the bleed valve (**3**) placed on the plate pressing;
- turn the knob (**1**) bi-directional valve down letting the pressure plate in the trunk. Close the bleed valve (**3**). Secure centering clamps (**4**) at the edges of the frame.
- The two rear terminals once established are no longer removed.
- Will remain as a reference for the centring of the blanks later.
- Open the slide valve (**7**) on the air regulator toward the pump.
- Using the knob (**6**) air regulator increase the pump feeding pressure to the minimum necessary for the operation of the same.

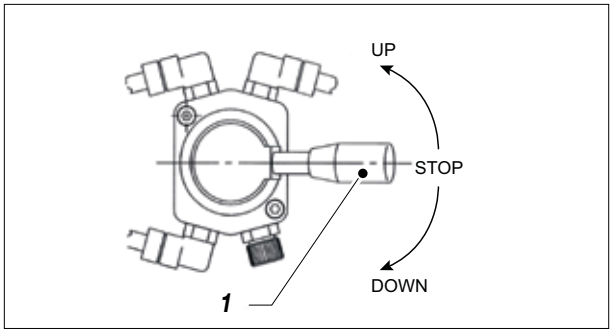


Fig. 10

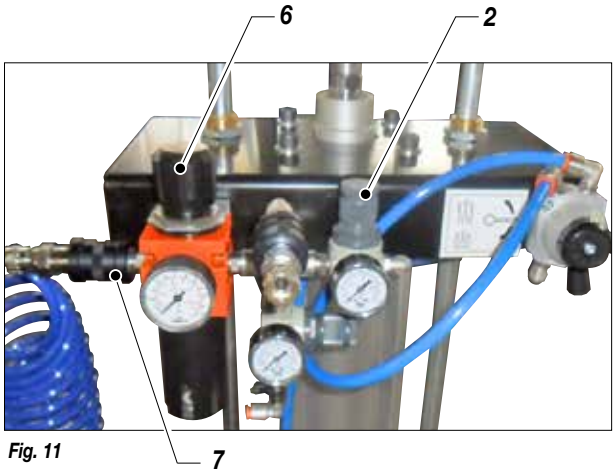


Fig. 11

(To increase the pressure, turn the knob (**6**) clockwise). The pump will operate and will stop when the entire room of the product will be full. The pump will start again to work whenever you open the delivery valve (or gun).

- If the pump is having difficulty in suction of the spray, slowly open the bleed valve ((**3**) placed on the plate pressing and close it as soon as you will get the product from the relief valve.

During use of the hoist-way valve knob (*1*) is usually left to the middle position.
The weight of the equipment will facilitate the descent of the hoist gradually decrease the level of the material.
In the presence of very dense knob can be left turned down so as to compress with more force the product.
Avoid approaching too much to the hoist during lifting and lowering.
When you try to check out the pot blowing from the stem, this could get out of the shot: pay close attention to your hands and getting away with the head from moving parts.
Keep in mind that the hoist is always pushing. Once the gasket goes into the stem, blocking plate pressure-pump could move quickly until you reach the product surfaces. Pay close attention to your hands and getting away with the head from moving parts.

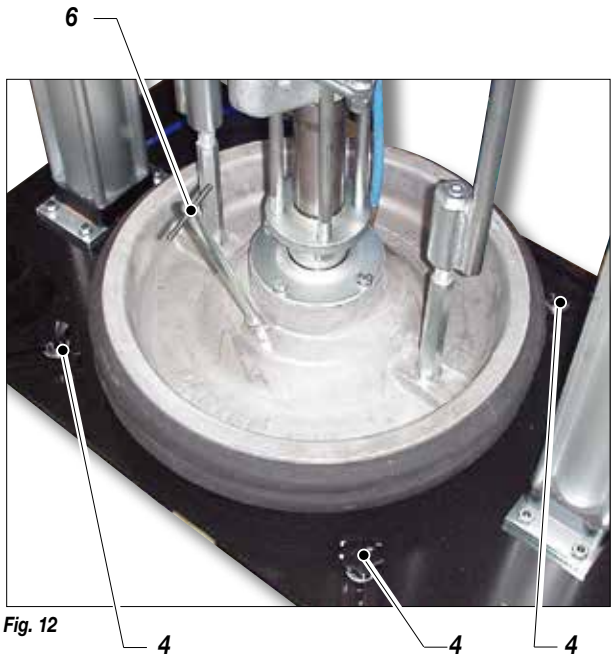


Fig. 12

K FLAT-PRESSING EXTRACTION PROCEDURE FROM THE STEM

(FOR EXTRUSION VERSIONS ONLY)

To extract the pump and pressure plate from the frame, proceed as follows:

- Make sure that the regulator ***(1)*** air inlet in the stem is at 0 bar and open the stopcock ***(2)*** against the regulator it self.

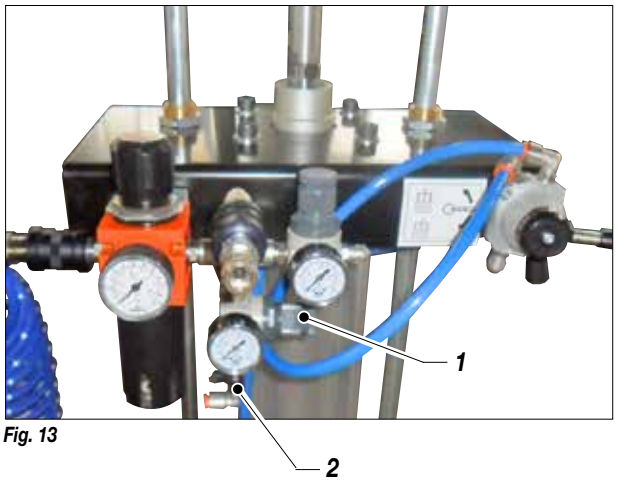


Fig. 13

- Open the air inlet valve stem ***(3)***.

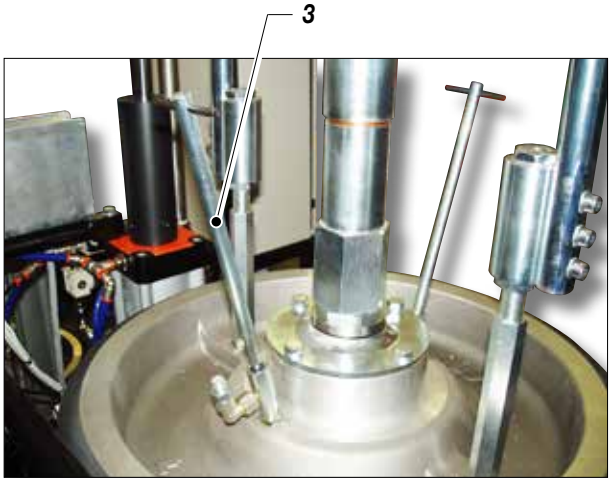


Fig. 14

- Turn the knob (**4**) upward.

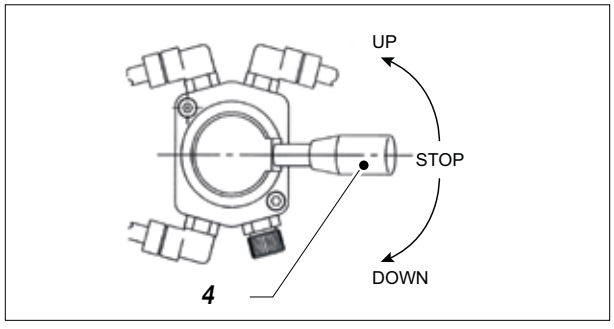


Fig. 15

- Slowly increase the air pressure using the regulator ***(1)*** for lifting.

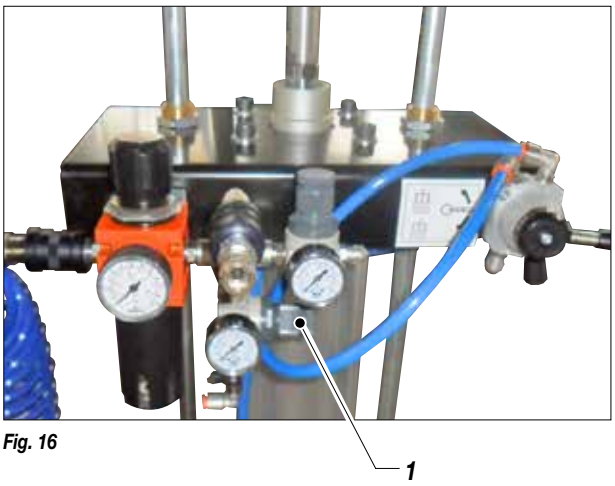


Fig. 16

NOTE

The pump may have sudden movements during the escape from the stem. Keep away from moving parts.

L REPLACE OF THE DRUM

(FOR EXTRUSION VERSIONS ONLY)

- Close the air supply to the pump and release pressure in the plant before replacing the drum.
- Turn the lifting control lever upwards.
- Gradually open the air delivery valve to the shovel plate in order to facilitate the extrection of the shovel plate from the drum.
- Let the ram reach its maximum height.
- Remove the empty drum and replace it with a full one.

M ROUTINE MAINTENANCE

- Periodically check the extrusion ram air supply. Make sure that the air is always clean and lubricated.
- Periodically check if the gaskets of the shovel plate are worn.
- Follow the instructions on the maintenance of the pneumatic pump contained in the user's manual..

Always close the air compressed supply and release pressure in the circuit before performing any check or maintenance operation of the pump.

N FIXING WITH SCREW ANCHORS

If you need to fix by using steel anchors for concrete and masonry you must follow the following procedures:

- Check the floor leveling and if necessary to shim mounting elements in order to achieve perfect alignment of the components;
- Holes must be the same size as those in the base plate. It is possible to fix the base plate whose existing holes can be used as a guide to drill the floor with precision in a single operation;
- The depth of the holes drilled in the concrete of no importance for the expansion of the gusset and does not affect his estate provided that it is made of a puncture with minimum depth sufficient to allow the full roll-out of the plug;
- Insert the expansion bolts by tightening until completely locking.

Recheck the correct level.

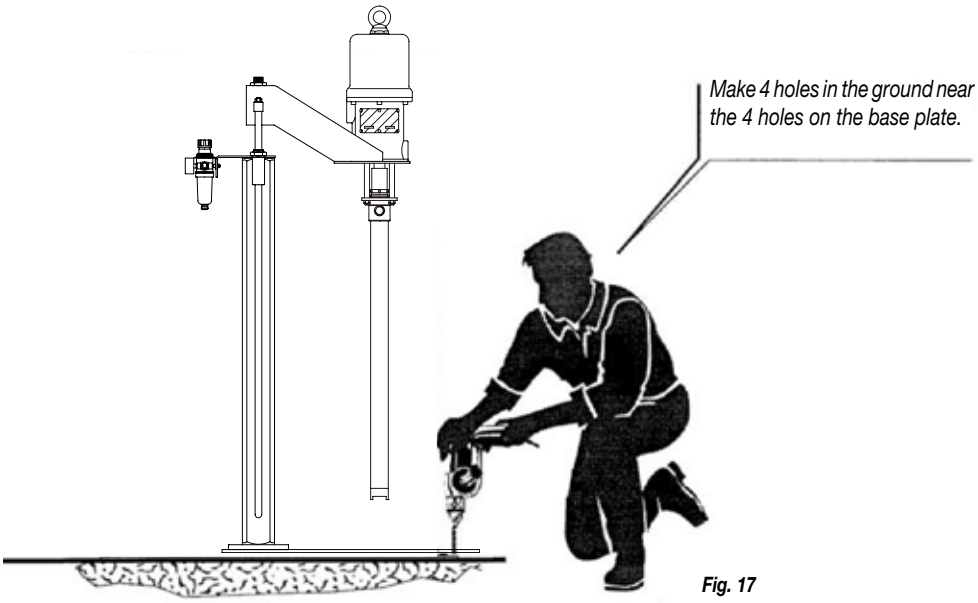
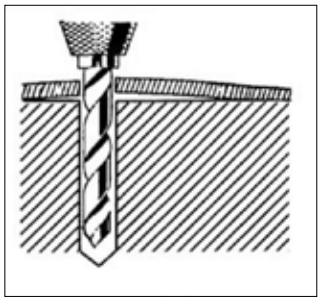
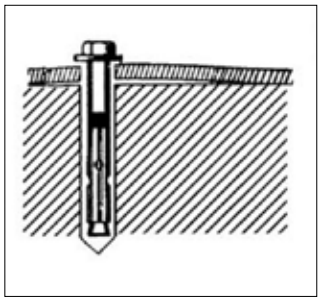


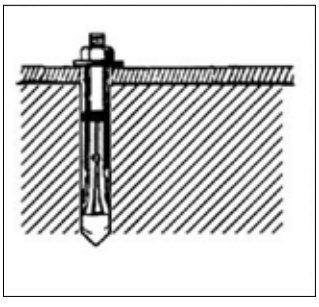
Fig. 17



Drill



Insert the dowel



Screw the dowel

O PROBLEMS AND SOLUTION

Problem	Cause	Solution
• The pump does not start	• Feed air not sufficient	• Increase feed air pressure to the ram.
	• Outlet product line clogged.	• Clean. Disconnect the outlet product pipe. Feed pump at minimum pressure and check if the pump starts without the outlet pipe.
	• Dried product inside the pumping element.	• Disassemble the pumping group and clean (*see the instruction manual of the pump*).
	• Pneumatic motor blocked in the cycle reversal position.	• Decrease the feed air pressure to the pump. • Manually reset the pneumatic motor (*see the instruction manual of the pump*).
	• Parts failure of the pneumatic motor	• Disassemble the motor and check (*see the instruction manual of the pump*).
• Accelerated working and no pressure of the pump	• There is no product	• Replace the drum with a new one
	• The pump suck air	• Open the bleeder valve on the shovell plate and the bleeder valve on the pump. • Check the bleeder delivery valve to the shovel plate is closed. If not, close the valve.
	• Feed air not sufficient	• Increase the feed air pressure.
	• Pumping rod gaskets worn	• Replace the lower gaskets (*see the instrucion manual of the pump*).
	• Suction valve worn or partially clogged.	• Clean and/or replace if necessary the worn parts (*see the instrucion manual of the pump*).

Problem	Cause	Solution
• The pump works, but not sufficient flow of product	• Outlet valve worn or partially clogged. • Suction valve worn or partially clogged. • Outlet product line clogged. • The feed air pressure is too low.	• Clean and/or replace if necessary the worn parts (*see the instruction manual of the pump*). • Clean or replace the worn parts (*see the instruction manual of the pump*). • Clean. Disconnect the outlet product pipe. Feed pump at minimumpressure and check if delivery increases the outlet pipe. • Increase feed air pressure to the ram.
• The ram does not lift	• The feed air is not sufficient • The control lever is not turned to the left. • The shovel plate is blocked on the drum.	• Increase feed air pressure to the ram. • Turn the lever to the left. • Gradually open the bleeder delivery valve to the shovel plate so as to facilitate coming out of the drum.
• Leakage of material from the edges of the drum	• Shovel plate gaskets worn • The feed air pressure of the pneumatic cylinder is too high	• Replace the gaskets. • Reduce air pressure.

Always close the compressed air supply and release the pressure in the plant before performing any check or replacement of parts of the pump.

P ROD PARTS

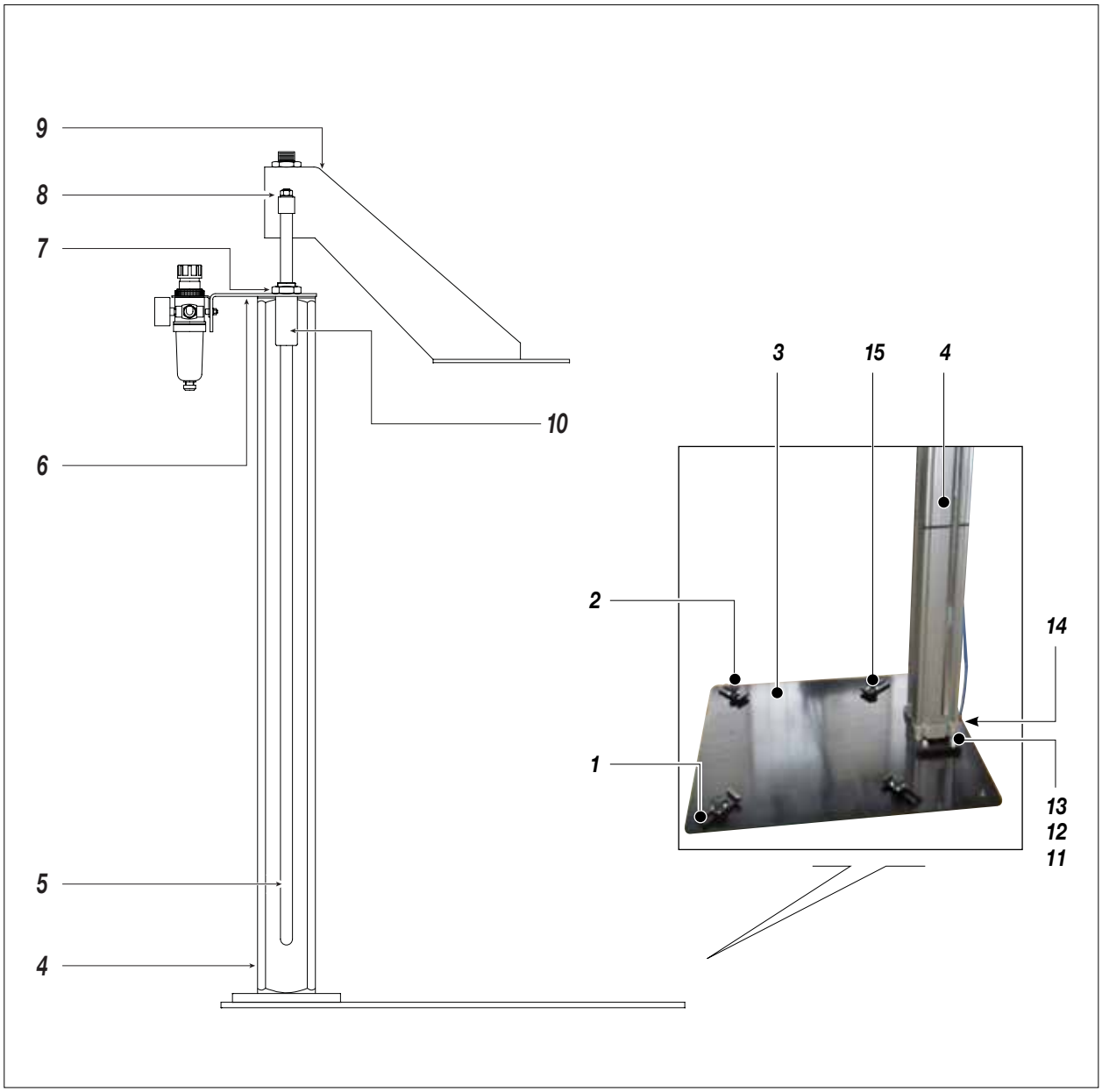


Fig. 19

Pos.	Code	Description	Qty.
1	510036	Short terminal	2
	510035	Long terminal	2
2	510037	Handwheel	4
3	510511	Extrusion ram plate	1
4	510105	Pneumatic cylinder	1
5	510513	Guide rod	2
6	510512	Stirrup	1
7	96842	1° gas nut	2

Pos.	Code	Description	Qty.
8	81010	M12 Nut	2
9		Pump support	1
10	510429	Rod guide bushing	2
11	81083	Washer	4
12	95158	M10 Nut	4
13	510003	VTSPE Screw	4
14	19186/1	Revolving elbow	2
15	95153	Washer	4

Q AIR REGULATOR UNIT

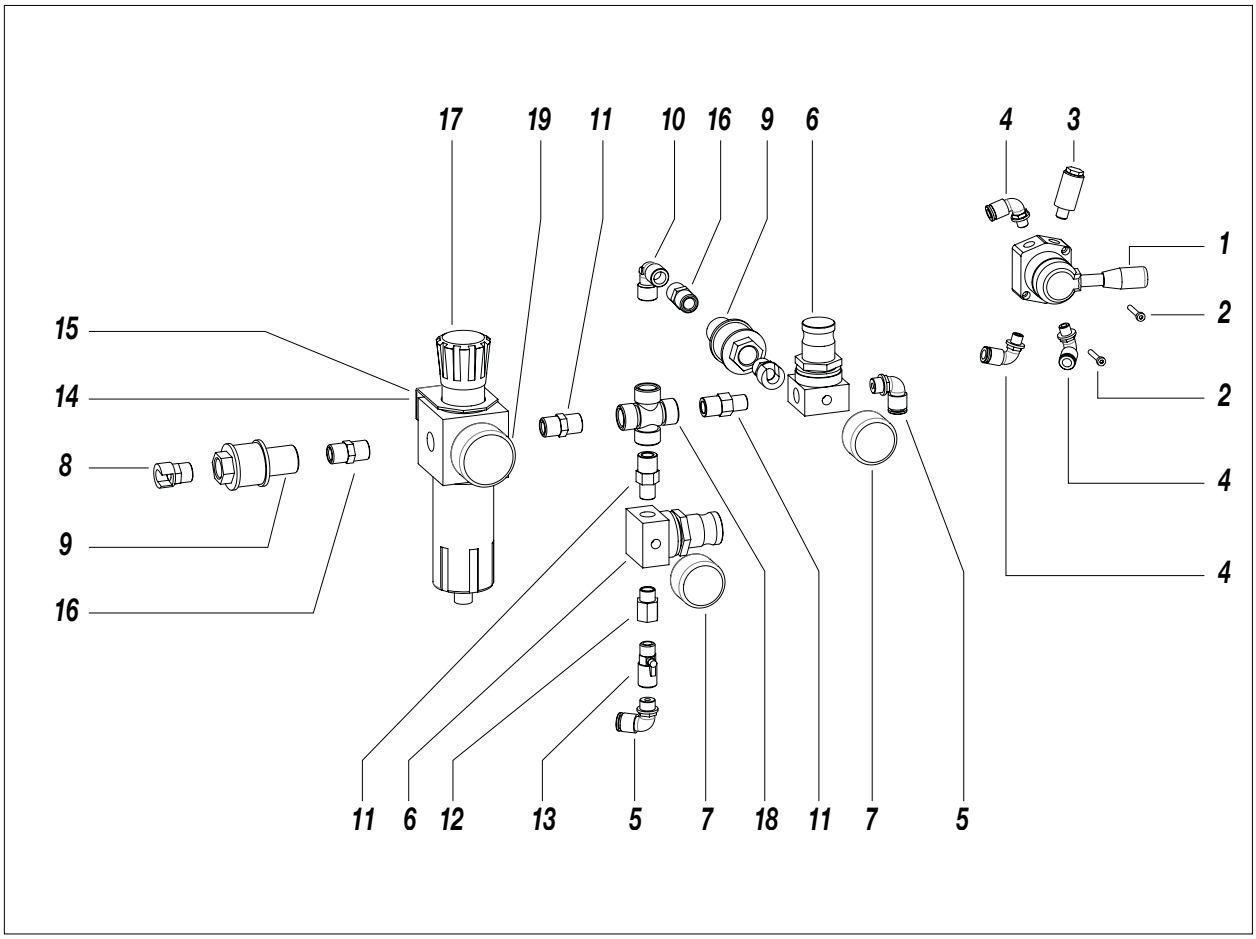


Fig. 20

Pos.	Code	Description	Qty.
1	510420	GPA 1/4 Valve	1
2	9274+	Screw TCE M4x22 +	2
	5114	M4 Nut	2
3	8054	Silencer 1/4	1
4	8123	Elbow 1/4 hose d10	1
5	8063	Elbow 1/4 hose d8	3
6	3344	Regulator 1/4	2
7	8167	Manometer	2
8	10103	Bayonet connection 3/8”	2
9	22057	Slide valve 3/8	2

Pos.	Code	Description	Qty.
10	91102	Elbow M-F 3/8	1
11	35560	Adapter M-M 1/4 - 3/8 CON	2
12	22027	Extension M-F	1
13	4004	Ball valve 1/4	1
14	900662	Screw TE M6x16	2
15	91026	M6 Nut	2
16	91020	Adapter M-M 3/8 CON-CON	3
17	91107	Group FR 3/8	1
18	3348	Cross adapter F 3/8	1
19	96259	Manometer	1

R FLAT DISC PRESSING

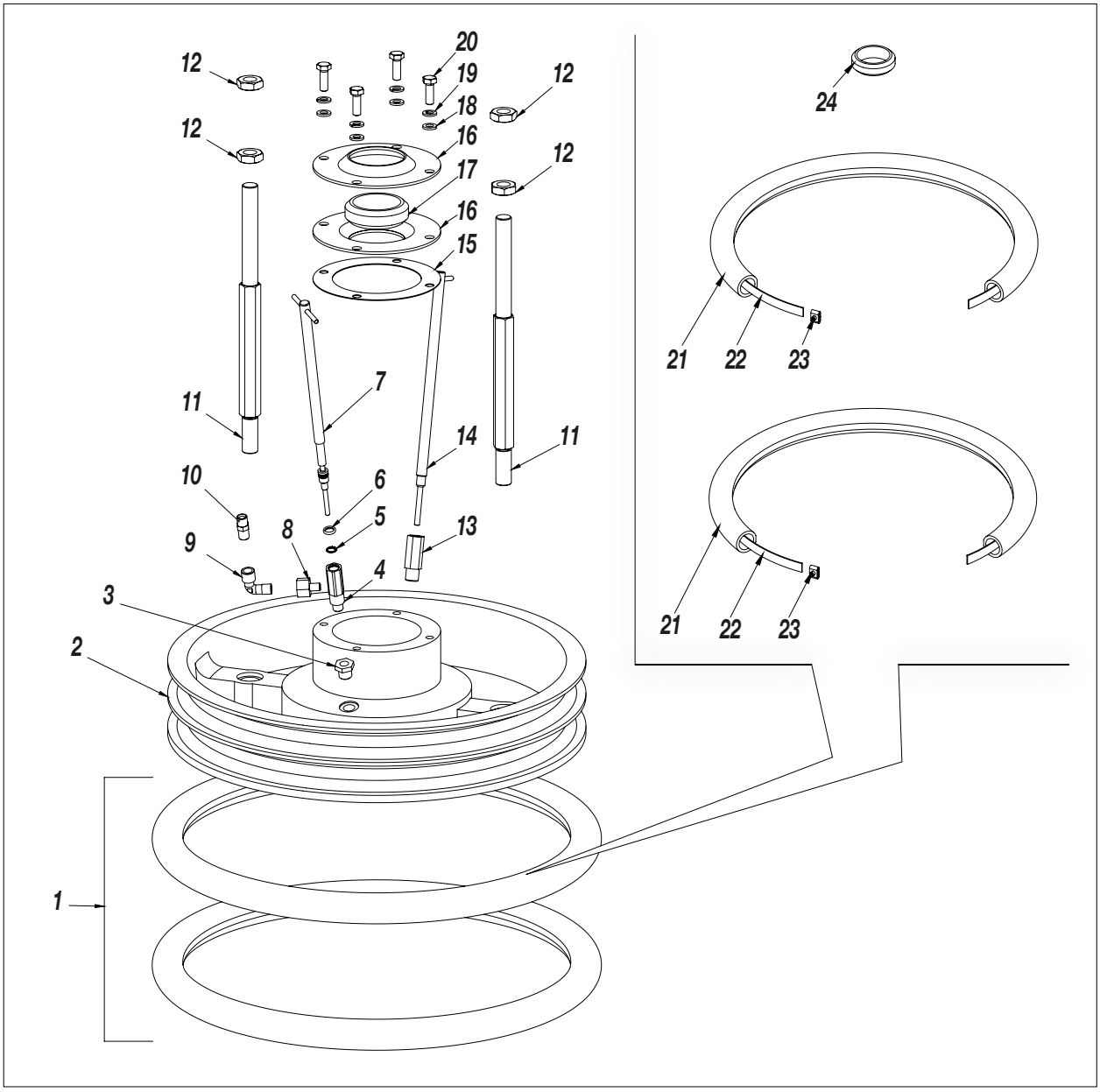


Fig. 21

Pos.	Code	Description	Qty.
1	510702/1	Flat gaskets blowing	2
2	510700	Flat disc pressing	1
3	5258	3/8-1/4 reduction	1
4	18573	Drain hose	1
5	918571	Snap ring int. Uni7437-13	1
6	12572	Or 2037	1
7	18572	Auction	1
8	22066	1/8 conical reduction m-f-1/4	1
9	5255	Elbow 1/4 m-f	1
10	96208	Nipple with 1/4-cyl	1
11	510010	Threaded Screw For Fixing Plate	2
12	95007	Nut M20	4

Pos.	Code	Description	Qty.
13	510059	Drain Rod Sleeve	1
14	510780	Complete auction	1
15	510005	Upper Seal	1
16	510006	Ringpressing Disk	2
17	510008	Ring	1
18	81083	Washer D10	4
19	85096	Grower Washer	4
20	95156	Screw Te Uni 5739 M10x30	4
21	510702	Gasket For Pressure Plate	2
22	510054	Steel tape 3/4 ''	2
23	510004	Screw Clip 3/4 '' With Wheat	2
24	510005	Upper Seal	1

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