

Circulation and Return Tube Kits

309852E

ENG

For recirculation of polyurethane materials from proportioner to 55 gal. (200 liter) fluid supply drums.

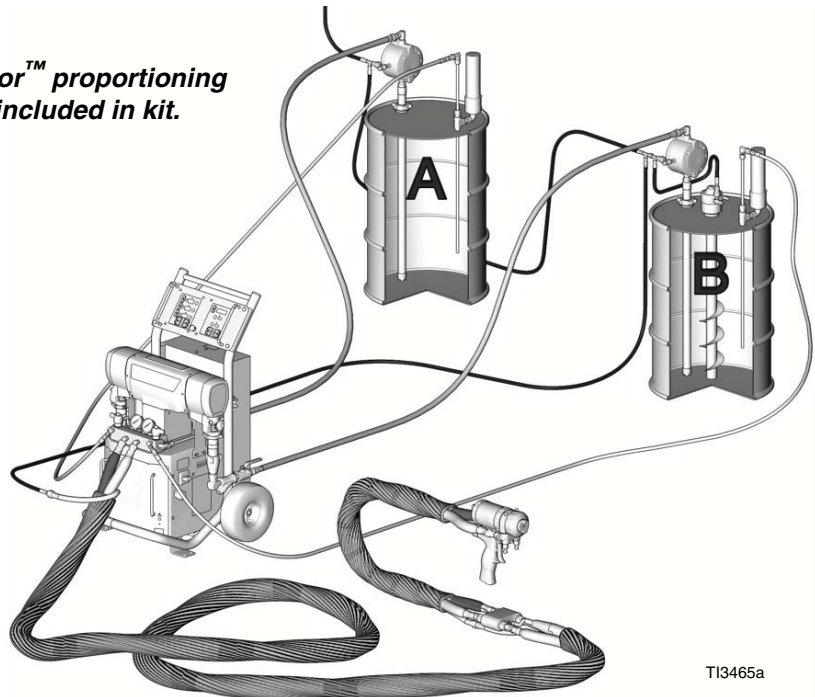
4000 psi (27.6 MPa, 276 bar) Maximum Fluid Working Pressure

Description	Carbon Steel	Stainless Steel
Return Tube Kit	246477	24D106
Circulation Kit	246978	
Circulation Kit With Moisture-Lok Hose	24E379	24D107

**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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Return Tube Kit



The Return Tube Kit can be installed singly or as a pair. Two are included in the 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

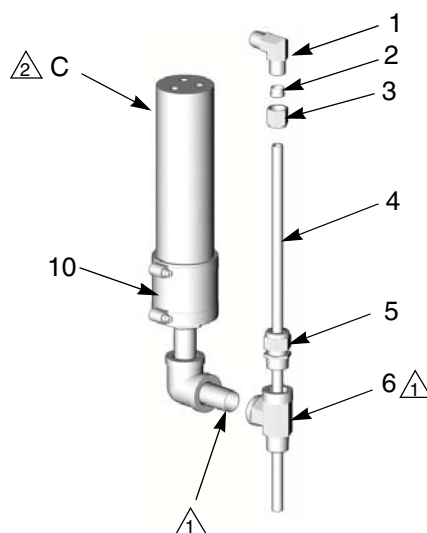


To reduce the risk of serious injury including fluid injection, use high pressure return hoses rated to withstand the maximum working pressure of the proportioner. See proportioner operation manual.

Ref. No.	Description	Return Tube Kit		Qty
		(CS) 246477	(SST) 24D106	
1	ELBOW, 90°; 1/2 in. (13 mm) OD tube x 1/2 npt(m)	117532	16C635	1
2	FERRULE, tube; sst	117453	117453	1
3	NUT, tube, flareless	117454	16C636	1
4	TUBE; sst; 1/2 in. (13 mm) OD; 4 ft (1.2 m)	15C514	15C514	1
5	BUSHING, strain relief; 3/4 npt(m)	117811	117811	1
6	TEE, street; 3/4 npt (mx) run; 3/4 npt(f) branch	111337	16C637	1
8	SEALANT, pipe; 6 ml	110110	110110	1
10	KIT, accessory, desiccant dryer	247616	247616	1

1 Apply thread sealant (8) to threads.

2 Punch holes in ends of carriage (C).



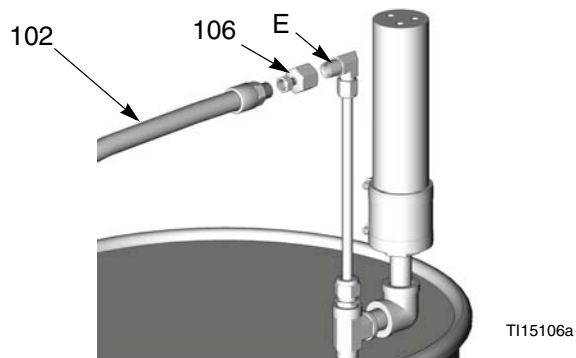
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Circulation Kit

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 the proportioner fluid manifold. Only used with 24697

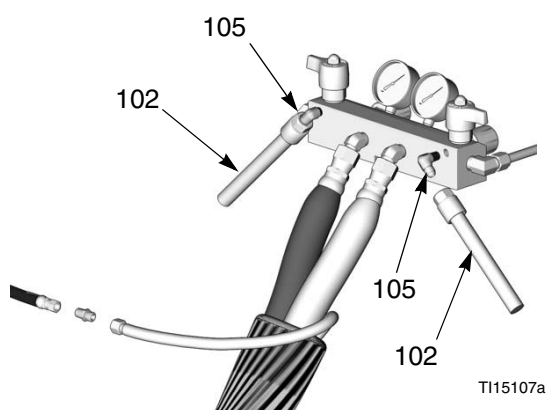
For 246978: Screw reducing nipples (104) into elbows. Connect one end of hoses (102) to each nipple.

For 24E379 and 24D107: Connect elbows (105) to the proportioner fluid manifold. Connect fitting (106) to return tube. Connect one end of hoses (102) to each elbow.

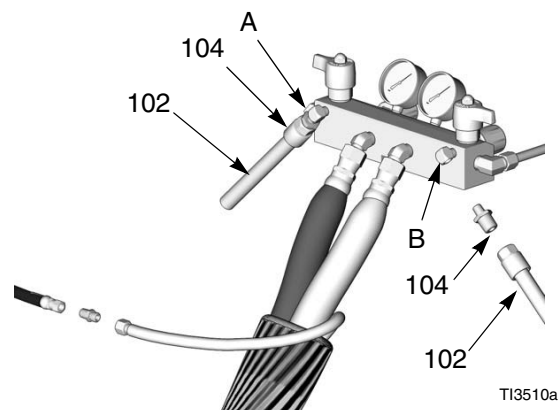
Connect other end of A side hose (102) to elbow (E) of A component return tube kit. Repeat for B side hose.

Ref. No.	Part No.	Description	Qty
101		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
	◆ 262176	HOSE, B; 1/4 in. (6.35 mm) ID; (10 ft (3.05 m))	2
	★ 262239	HOSE, B; 1/4 in. (6.35 mm) ID; (10 ft (3.05 m))	2
104	† 162449	NIPPLE, reducing; 1/2 x 1/4 npt	2
105	◆ 122311	FITTING, elbow; 9/16-18 JIC 06 x 1/4 npt	2
	★ 122786	FITTING, elbow; 9/16-18 JIC 06 x 1/4 npt	2
106	◆ 124151	FITTING, 9/16-18 JIC 06 x 1/2 npt	2
	★ 124152	FITTING, 9/16-18 JIC 06 x 1/2 npt	2
† 246978 Circulation Kit only.			
◆ 24E379 Circulation Kit only.			
★ 24D107 Circulation Kit only.			

24E379 and 24D107 Circulation Kit



246978 Circulation Kit



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Original instructions. This manual contains English. MM 309852

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