



# Operation Manual

PRODUCT NAME

**Process Pump**

MODEL / Series / Product Number

**PA5010**

**SMC Corporation**

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# Safety Instructions

These safety instructions are intended to prevent hazardous situations and/or equipment damage.

These instructions indicate the level of potential hazard with the labels of "Caution," "Warning" or "Danger."

They are all important notes for safety and must be followed in addition to International Standards (ISO/IEC)<sup>\*)1</sup>, and other safety regulations.

\*1) ISO 4414: Pneumatic fluid power -- General rules relating to systems.

ISO 4413: Hydraulic fluid power -- General rules relating to systems.

IEC 60204-1: Safety of machinery -- Electrical equipment of machines.(Part 1: General requirements)

ISO 10218-1992: Manipulating industrial robots -Safety.

etc.



## Caution

**Caution** indicates a hazard with a low level of risk which, if not avoided, could result in minor or moderate injury.



## Warning

**Warning** indicates a hazard with a medium level of risk which, if not avoided, could result in death or serious injury.



## Danger

**Danger** indicates a hazard with a high level of risk which, if not avoided, will result in death or serious injury.

## Warning

### 1. The compatibility of the product is the responsibility of the person who designs the equipment or decides its specifications.

Since the product specified here is used under various operating conditions, its compatibility with specific equipment must be decided by the person who designs the equipment or decides its specifications based on necessary analysis and test results.

The expected performance and safety assurance of the equipment will be the responsibility of the person who has determined its compatibility with the product.

This person should also continuously review all specifications of the product referring to its latest catalog information, with a view to giving due consideration to any possibility of equipment failure when configuring the equipment.

### 2. Only personnel with appropriate training should operate machinery and equipment.

The product specified here may become unsafe if handled incorrectly.

The assembly, operation and maintenance of machines or equipment including our products must be performed by an operator who is appropriately trained and experienced.

### 3. Do not service or attempt to remove product and machinery/equipment until safety is confirmed.

1. The inspection and maintenance of machinery/equipment should only be performed after measures to prevent falling or runaway of the driven objects have been confirmed.
2. When the product is to be removed, confirm that the safety measures as mentioned above are implemented and the power from any appropriate source is cut, and read and understand the specific product precautions of all relevant products carefully.
3. Before machinery/equipment is restarted, take measures to prevent unexpected operation and malfunction.

### 4. Contact SMC beforehand and take special consideration of safety measures if the product is to be used in any of the following conditions.

1. Conditions and environments outside of the given specifications, or use outdoors or in a place exposed to direct sunlight.
2. Installation on equipment in conjunction with atomic energy, railways, air navigation, space, shipping, vehicles, military, medical treatment, combustion and recreation, or equipment in contact with food and beverages, emergency stop circuits, clutch and brake circuits in press applications, safety equipment or other applications unsuitable for the standard specifications described in the product catalog.
3. An application which could have negative effects on people, property, or animals requiring special safety analysis.
4. Use in an interlock circuit, which requires the provision of double interlock for possible failure by using a mechanical protective function, and periodical checks to confirm proper operation.



# Safety Instructions

## Caution

### 1. The product is provided for use in manufacturing industries.

The product herein described is basically provided for peaceful use in manufacturing industries. If considering using the product in other industries, consult SMC beforehand and exchange specifications or a contract if necessary.

If anything is unclear, contact your nearest sales branch.

## Limited warranty and Disclaimer/Compliance Requirements

The product used is subject to the following "Limited warranty and Disclaimer" and "Compliance Requirements".

Read and accept them before using the product.

### Limited warranty and Disclaimer

1. The warranty period of the product is 1 year in service or 1.5 years after the product is delivered, whichever is first.\*2)  
Also, the product may have specified durability, running distance or replacement parts. Please consult your nearest sales branch.
2. For any failure or damage reported within the warranty period which is clearly our responsibility, a replacement product or necessary parts will be provided.  
This limited warranty applies only to our product independently, and not to any other damage incurred due to the failure of the product.
3. Prior to using SMC products, please read and understand the warranty terms and disclaimers noted in the specified catalog for the particular products.

\*2) Vacuum pads are excluded from this 1 year warranty.

A vacuum pad is a consumable part, so it is warranted for a year after it is delivered. Also, even within the warranty period, the wear of a product due to the use of the vacuum pad or failure due to the deterioration of rubber material are not covered by the limited warranty.

### Compliance Requirements

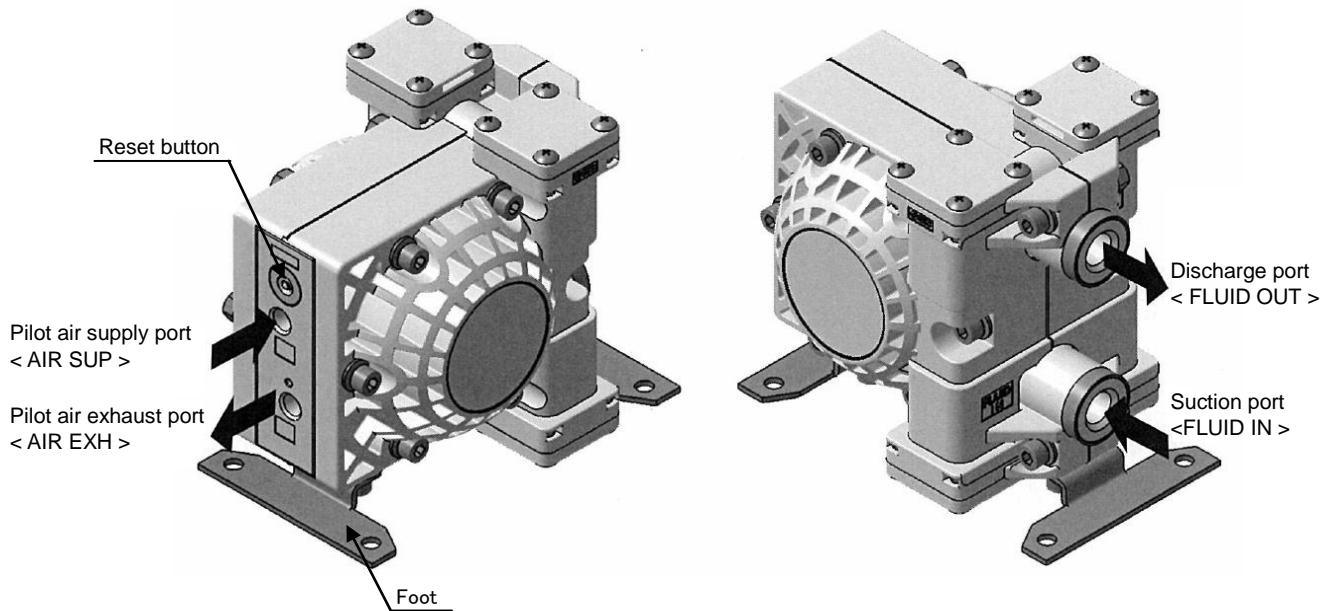
1. The use of SMC products with production equipment for the manufacture of weapons of mass destruction(WMD) or any other weapon is strictly prohibited.
2. The exports of SMC products or technology from one country to another are governed by the relevant security laws and regulation of the countries involved in the transaction. Prior to the shipment of a SMC product to another country, assure that all local rules governing that export are known and followed.

### Return of Product

If the product to be returned is contaminated or is possibly contaminated with substances that are harmful to humans, for safety reasons, please contact SMC beforehand and then employ a specialist cleaning company to decontaminate the product. After the decontamination prescribed above has been carried out, submit a Product Return Request Sheet or the Detoxification/Decontamination Certificate to SMC and await SMC's approval and further instructions before attempting to return the item.

Please refer to the International Chemical Safety Cards (ICSC) for a list of harmful substances. If you have any further questions, please don't hesitate to contact your SMC sales representative.

## Names and functions of parts



Description	Functions
Suction port (FLUID IN)	Sucks the fluid to be transferred. Connect suction piping.
Discharge port (FLUID OUT)	Discharges the fluid taken in the pump. Connect discharge piping.
Pilot air supply port (AIR SUP)	Supplies air of set pressure. Connect the air piping.
Pilot air exhaust port (AIR EXH)	Exhausts pilot air.
Reset button,	Resets the pump when operation is stopped.
Foot	Holds the product.

## Precautions

### 1. Caution on design

#### ⚠ Warning

##### 1. Confirm the specifications.

- Give careful consideration to operating conditions such as the application, fluid and environment, and use the product within the operating ranges specified in this catalog.
- The product is provided for physical, chemical and industrial equipment.

##### 2. Fluids

- When ignitable fluid is used, use a product with metal wetted parts (aluminum, stainless steel). Always take countermeasures against static electricity.
- For the compatibility between the materials composing the product and the fluids, check the compatibility check list. Since the compatibility of the fluid used may vary depending on its type, additives, concentration, temperature, etc., give sufficient consideration when selecting the material.
- For fluids other than those listed on the check list, please consult us. Also, use them within the range of the operating fluid temperatures.
- If foreign matters are mixed in the fluid, these may cause abrasion of the inside of the pump resulting in a problem. Use an appropriate filter (strainer) to remove them. In general, 80 to 100 mesh (150 to 180 µm) filters are recommended.
- When transferring a coagulable liquid, take measures to prevent it from coagulating in the pump.
- Please contact SMC sales office for the use of slurry.
- Take countermeasures to prevent the operating fluid from getting onto the body of the process pump.

##### 3. Water hammer

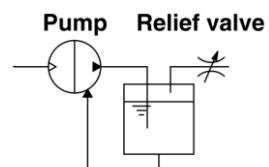
If a valve is operated abruptly etc., a high pressure may be applied due to water hammer. Take measures to prevent pressures higher than specified from being applied.

<Examples of measures>

- Use a water hammer resistant valve to reduce the valve closing speed.
- Use an elastic piping material such as rubber hose or an accumulator to absorb the impact pressure.

##### 4. Liquid seals

To ensure that fluid does not become sealed inside the process pump, when stopping the pump, relieve the discharge pressure inside it. As shown in the figure at right, make a circuit which has a relief valve installed on the system.



##### 5. Fluid pressure supplied to the process pump

Feeding the fluid from the suction side into the pump under pressure, or Drawing it using a negative pressure, will reduce the life of the pump.

##### 6. Ensure space for maintenance.

Secure the space required for maintenance and inspection. Take into consideration also leakage from the product. When transferring a flammable liquid or a liquid that may affect the human body or environment, take measures including fire ban and keeping the area off limits.

##### 7. When the diaphragm is broken, supply air will be mixed with the fluid or the fluid will enter the air switching valve. This may affect the product performance, or the chemical resistance of the components may not be suitable. Countermeasures need to be taken by the customer.

##### 8. Use a design which prevents reverse pressure and reverse flow.

If reverse pressure or reverse flow occurs on the discharge side of the process pump, the equipment is liable to become damaged or malfunction. Take safety measures in designing the circuit.

##### 9. Measures against static electricity

Take measures against static electricity as static electricity may occur depending on the fluid. Particularly, when circulating flammable fluid through the pump, be sure to take measures to prevent the occurrence of static electricity.

##### 10. The pump cannot transfer gas. Do not allow it to idle for a long time.

If the pump is operated for a long time without any fluid inside or in a gas-fluid mixed state, the diaphragm may be damaged or the life may be shortened. Do not continue idling except for priming the pump.

## 11. Condensation and freezing of the pilot port

The location around the switching valve and the air exhaust port can cool down quickly due to expansion of the supply air, and this may cause condensation on the piping and the condensation may freeze during operation in winter. Take measures to ensure that water droplets from condensation are not splashed onto any electric parts or equipment.

### Caution

#### 1. Suspension of the pump operation

When operation is stopped exhaust the residual pressure of the air supply port using the 3-port solenoid valve. Stopping the process pump while air is supplied, load is applied to the internal parts and the life will be shortened. If the process pump is stopped consuming the residual pressure, the operation of the switching part of the pilot air in the process pump becomes unstable and may not be restarted. When the operation cannot be restarted, press the reset button.

#### 2. Use the constant pilot air pressure.

The process pump may malfunction and stop when the pilot air pressure fluctuation exceeds 50 kPa.

#### 3. Reverse flow

The check valve inside the process pump does not completely stop reverse flow (the flow from the discharge side to the suction side). For this reason, fluid may sometimes flow from the discharge side to the suction side when the pump is stationary, etc). As a countermeasure, install a 2-way valve or a check valve. However, please note that when a check valve is installed, if the cracking pressure is high, defective suction may occur. (As a guide, the cracking pressure should be 0.02 MPa or less.)

## 2. Mounting

### Caution

#### 1. Read the operation manual before mounting the product.

Read the operation manual carefully and understand the contents before mounting the product. The manual should also be kept where it can be referred to whenever necessary.

#### 2. Confirm the mounting orientation of the product.

Face the foot downward. Fix the pump and the mounting foot with the included screws (tightening torque: 2.5 N·m). Also, secure all specified mounting positions when using the product.

If the propagation of the vibration of the pump is not acceptable, insert vibro-isolating rubber when mounting.

## 3. Piping

### Caution

#### 1. Flush the piping.

Flush and clean the piping before connecting the product. Any dirt or scale and the like left in the piping may cause malfunction or failure.

#### 2. Use fittings with resin threads when connecting piping to the product with resin threads at the ports.

Using fittings with metal threads may cause damage to the ports.

#### 3. Tighten screws with proper tightening torque.

When screwing fittings into the product, tighten them with proper tightening torque as shown below. Looseness can cause problems such as fluid and air leaks, while over tightening can cause damage to threads and parts, etc.

Connection thread	Proper tightening torque (N·m)	Port name
Rc, NPT, G 1/4"	12~14	AIR SUP, AIR EXH
Rc, NPT, G 1/2"	2~2.5	FLUID IN, FLUID OUT
Rc, NPT, G 3/4"	4~5	

## 4. Air Supply

### ⚠ Warning

#### 1. Use clean air.

Do not use compressed air that includes chemicals, synthetic oils containing organic solvents, salinities or corrosive gases, etc., as it can cause damage or malfunction.

#### 2. Pay attention to avoid freezing when operating the product in low temperatures.

The equipment operates while expanding the compressed air. During this time, the temperature inside the product decreases due to adiabatic expansion. If the ambient temperature is low, using compressed air containing a lot of moisture may cause freezing because heat cannot be gained from the surroundings. In this case, take freeze prevention measures by using a membrane air dryer (such as series IDG).

### ⚠ Caution

#### 1. Quality of operating air

- Be sure to use only air filtrated by a micro mist separator (such as series AMD). Use of a super mist separator (such as series AME) is recommended to extend maintenance intervals.
- When dew forming or freezing occur in the process pump, use the membrane air dryer (IDG) and decrease the dew point of supply air.
- If a pump is operated by N<sub>2</sub> gas, etc., the deterioration of the gaskets inside the switching valve will be accelerated and may result in substantially shortening the life span of the product.

#### 2. Compressed air with low dew point

If compressed air with an atmospheric dew point below -40°C is used, the lubrication properties inside the equipment can deteriorate prematurely, affecting the life of the equipment.

When compressed air with an atmospheric dew point below -40°C is used for the operating environment or as supply air, testing under user's operating conditions is recommended.

## 5. Operating environment

### ⚠ Warning

#### 1. Do not use in the following environments, as this can cause failure.

- 1) Locations with an atmosphere of corrosive gases, organic solvents or chemical solutions, and where there may be contact with the same.
- 2) Locations where there is contact with sea spray, water or steam.
- 3) Locations where ultraviolet deterioration or overheating of resin may occur due to direct sunlight.
- 4) Locations near heat sources with poor ventilation (heat sources should be shielded by heat insulating material).
- 5) Locations with impact or vibration.
- 6) Locations with excessive moisture and dust.

#### 2. The product cannot be used under water.

Do not use the product immersing it in water (liquid). Otherwise, liquid will enter the openings inside the product, resulting in malfunction.

#### 3. Depending on the fluid used, a flammable atmosphere may occur. Take measures such as ventilation.

## 6. Maintenance

### ⚠ Warning

#### 1. Perform maintenance after consulting the operation manual.

Obtain the operation manual for the equipment from SMC or our distributor and have sufficient knowledge of the equipment before performing maintenance. Incorrect handling may cause damage or malfunction of the equipment or system.

#### 2. Perform maintenance work after confirming the safety of the system.

Turn off the compressed air and power supply and exhaust any remaining compressed air in the system before removing the equipment and the compressed air supply/exhaust unit. Discharge the residual liquid or sufficiently displace it as necessary. Also, when reinstalling the equipment or restarting it after replacement, confirm the safety of the product before checking that it operates normally.

### **3. Use appropriate protective equipment.**

When touching the process pump for maintenance, wear protective equipment such as gloves which are compatible with the fluid used. There is a risk of chemical burns.

### **4. Do not disassemble the product, as disassembly will invalidate the product's warranty.**

When disassembly is necessary, please consult with SMC or our distributor.

### **5. Drain discharge**

Operating the system with drain accumulated in the equipment or piping may cause malfunction of the equipment, splash over into the downstream side, or unexpected accident. Periodically discharge drain from components including the air filter.

### **6. Caution when transferring a high-temperature fluid**

The product itself will become hot due to the high-temperature fluid. Since touching the product directly may cause burns, allow sufficient time for the product to cool down when transferring a high-temperature fluid. The measurement of the product temperature is recommended to confirm the safety of the system before performing work.

### **7. The bolts in this product may become loose over time due to creep of the PP housing.**

**Retighten the bolts before operation to prevent fluid or air leakage (refer to the maintenance manual for the required tightening torque).**

## **⚠ Caution**

### **1. Caution when transferring a highly penetrating liquid**

When transferring a liquid that is highly penetrating through fluoropolymer, components of the transfer liquid may enter the openings inside the equipment. Also, they may become attached to the external surface of the equipment. In this case, take the same measures as handling the transfer liquid.

### **2. Service life of diaphragm and maintenance of consumable items**

- If the operating cycle of the process pump exceeds the service life of diaphragm, the diaphragm may be damaged due to deterioration. If it is damaged, the fluid will leak from the pilot air exhaust port and the air will blow out into the liquid circuit. Consider the pump operation (breathing, decline of discharge pressure, etc.) and the reference service life of diaphragm, and replace with new process pump or conduct necessary maintenance as early as possible.
- Items such as check valves, switching valves, pilot valves and manual caps may experience malfunction earlier than the diaphragm depending on the operating conditions. Please replace with new process pump or conduct periodic maintenance.
- When conducting maintenance, obtain the necessary parts indicated in the maintenance parts list (Refer to P.15), and perform work according to the maintenance and operation manuals.

#### **[Calculation of reference service life (days) of diaphragm]**

Reference service life (days) =

$$\frac{A \text{ (amount of discharge per cycle)} \\ \times B \text{ (reference number of cycles in service life)}}{\text{Flow (L/min)} \times \text{Operating time per day (hour)} \times 60 \text{ (min)}}$$

Model	Operating conditions: Method	Diaphragm Material	Amount of discharge per cycle A	Reference number of cycles in service life B	Volume inside pump (wetted part)
PA5010	Automatically operated type	PTFE	Approx. 0.10L	50 million cycles	Approx. 505 mL

### **3. Please understand the following concerning the inability to repair the product.**

To enable the process pump to be used with various fluids, please note that from the aspects of ensuring worker safety and also the facilities, SMC is unable to carry out repair.

## **7. Lubrication**

### **⚠ Caution**

- 1. The pump can be used without lubrication.**
- 2. If lubricating the pump, continue lubrication.**

If lubricating a pump, use turbine oil Class 1 (with no additives) ISO VG32, and be sure to continue lubricating the pump.

## **8. Caution on Handling**

### **⚠ Warning**

- 1. Test before using with the actual equipment.**

Test the pump before using it with the actual equipment. Even if there is no problem in a short-term test, the liquid may penetrate through the fluoropolymer diaphragm causing malfunction in the pump air circuit.

- 2. Storage**

In the case of long-term storage after use, first thoroughly remove the liquid, and clean and dry the inside to prevent deterioration of the pump materials.

- 3. After a long period of non-use, perform a trial run prior to operation.**

- 4. Ensure that the bolts are not loose before operating the process pump. Retighten if necessary.**

- 5. Discharge volume adjustment**

Always connect the discharge volume adjustment valve to the FLUID OUT of the process pump. Adjust the volume by operating the valve.

- 6. When the discharge volume is large (flow speed is high), depending on the fluid type and operating conditions, there will be cavitation, leading to a poor operation or malfunction. Decrease supply air pressure or decrease the discharge volume with a throttle so that cavitation is not generated.**

- 7. Operating environment**

When dangerous fluid is used, take measures to isolate humans from the pump. External leakage of transferred liquid could cause serious injury.

- 8. External leakage of transferred liquid**

There are some cases where the operating fluid will leak outside the pump, for example when the diaphragm reaches the end of its life. Depending on the operating fluid, take measures against external leakage, including installing a drain pan, to avoid adverse effects on humans and equipment.

- 9. Caution for piping of the tube**

Support the piping according to JIS B 8370 when piping the tube. Ensure that tensile force is not applied to the tube..

## Applicable Fluids

### Material and Fluid Compatibility Check List for Process Pumps

- The data below is prepared based on data provided by the material manufacturers.
- SMC assumes no responsibility for the accuracy of the data or for any damages arising from the data.
- The material and fluid compatibility check list provides reference values as a guide only; therefore SMC does not guarantee the application to our product.

### ⚠ Caution

1. Select the wetted parts materials according to the transfer liquid you use to determine the model.
  - For the fluid contact area (polypropylene), water, acids, and alkalis are suitable.
  - For the diaphragm material, PTFE is suitable for non-permeating liquids.
  - Use fluids that will not corrode the wetted parts materials.
2. These products are not suitable for medical or food use.
3. The applicability may vary depending on additives. Take note also of additives.
4. The applicability may vary depending on impurities. Take note also of impurities.
5. Examples of transfer liquids are shown below. Since the applicability may vary depending on your operating conditions, be sure to check it by means of experimentation.
6. Compatibility is indicated for fluid temperatures specified for the respective products (60°C or less).
7. These may be penetrated by fluids, and the penetrating fluids may affect parts of other materials.

Table symbols

O: Can be used. ×: Cannot be used. -: Can be used under certain conditions. Please consult us.

Model		PA5010
Body material		PP
Diaphragm material		PTFE
Examples of applicable liquids	Water	<input type="radio"/> Tap water
		— Pure water
	Oil	<input type="radio"/> Turbine oil
		<input type="radio"/> Cutting oil
		<input type="radio"/> Brake oil
	Solvent	— Flux
		— Toluene
		— Methyl ethyl ketone
		— Acetone
		<input type="radio"/> Inert solvent <small>(Note 1)</small>
	Ethyl alcohol	—
	Isopropyl alcohol	—
	Sodium hypochlorite	—
	Acids	<input type="radio"/> <small>(Note 2)</small>
	Alkalies	<input type="radio"/> <small>(Note 2)</small>
Metal corrosive liquid		×
Highly permeating liquid		×
Highly penetrating liquid		×

Note 1) Static electricity may be generated. Take measures to prevent static electricity.

Note 2) Strong acidic chemicals, strong basic chemicals, and hydrofluoric acid are not allowed.

## Specifications

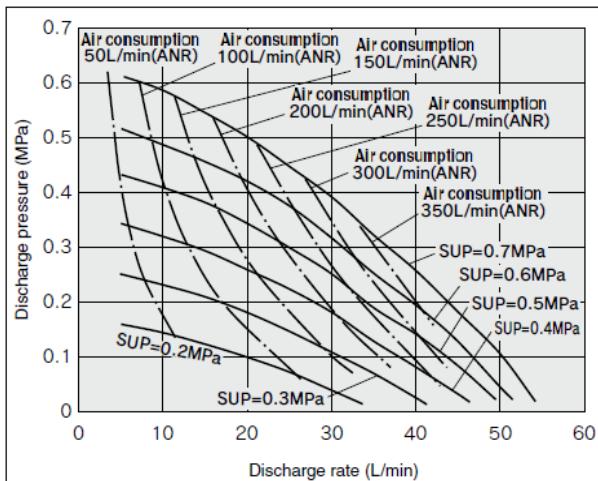
Model		PA5010-□04	PA5010-□06
Actuation		Automatically operated	
Port size	Main fluid suction discharge port	Rc, NPT, G, Female thread	
		1/2"	3/4"
Pilot air supply/exhaust port		Rc, NPT, G 1/4" Female thread	
Material	Body wetted areas	PP	
	Diaphragm	PTFE	
	Check valve	PTFE, PP, PFA	
	Liquid contact seals	FFKM	
Fluid		Refer to P.11 for applicable fluids	
Discharge rate		5 to 53 L/min	5 to 63 L/min
Average discharge pressure		0 to 0.6 MPa	
Pilot air pressure		0.2 to 0.7 MPa	
Air consumption		Refer to P.13 for air consumption	
Suction lifting range	Dry	Up to 2 m (Interior of pump dry)	
	Wet	Up to 6 m (liquid inside pump)	
Noise		78 dB (A) or less (Option: with silencer, AN20)	
Maximum withstand pressure		1.05 MPa	
Diaphragm life *		50 million cycles	
Fluid temperature		0 to 60 °C (No freezing)	
Ambient temperature		0 to 60 °C (No freezing)	
Maximum viscosity		5000 mPa · s	
Weight (kg)		3.0kg	
Mounting orientation		Horizontal (with mounting foot at bottom)	
Packaging		General environment	

\* These are reference values given for rated temperature and tap water and are not guaranteed. Refer to page P.8 for details.

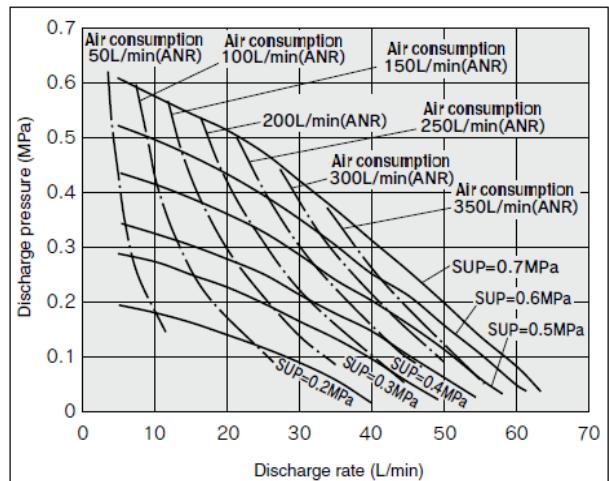
# Performance Curve

## Flow Rate Characteristics

PA5010-□04



PA5010-□06



## Selection from Flow Rate Characteristic Graph

Required specifications example:

Find the pilot air pressure and air consumption of pilot air for a discharge rate of 27 L/min and a discharge pressure of 0.25 MPa. <The transfer fluid is fresh water (viscosity 1 mPa·s, specific gravity 1.0).

\* If the total lifting height is required instead of the discharge pressure, a discharge pressure of 0.1 MPa corresponds to a total lift of 10 m.

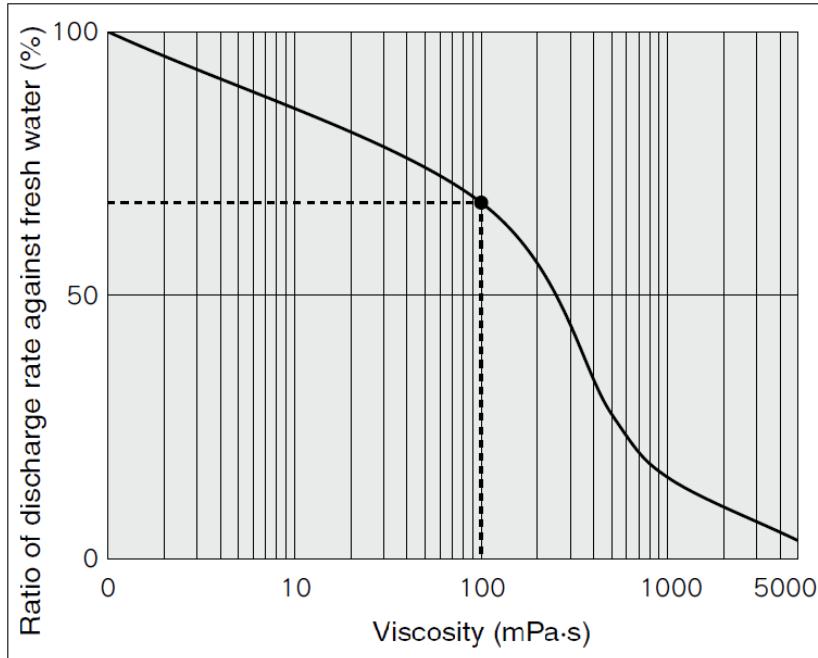
Selection procedures:

1. First mark the intersection point for a discharge rate of 27 L/min and a discharge pressure of 0.25 MPa.
2. Find the pilot air pressure for the marked point. In this case, the point is between the discharge curves (solid lines) for SUP = 0.4 MPa and SUP = 0.5 MPa, and based on the proportional relationship to these lines, the pilot air pressure for this point is approximately 0.46 MPa.
3. Next find the air consumption rate. Since the marked point is below the curve (long dashed short dashed line) for 200 L/min (ANR), the maximum rate will be about 200 L/min (ANR).

## ⚠ Caution

1. These flow rate characteristics are for fresh water (viscosity 1 mPa·s, specific gravity 1.0).
2. The discharge rate differs greatly depending on properties (viscosity, specific gravity) of the fluid being transferred and operating conditions (lifting range, transfer distance), etc.
3. Use 0.75 kW per 100 L/min of air consumption as a guide for the relationship of the air consumption to the compressor.

## Viscosity Characteristics



### Selection from Viscosity Characteristic Graph

Required specifications example:

Find the pilot air pressure and pilot air consumption for a discharge rate of 12 L/min, and a viscosity of 100 mPa·s.

Selection procedures:

1. First find the ratio of the discharge rate for fresh water when viscosity is 100 mPa·s from the graph above. It is determined to be 68%.
2. Next, in the required specification example, the viscosity is 100 mPa·s and the discharge rate is 12 L/min. Since this is equivalent to 68% of the discharge rate for fresh water,  $12 \text{ L/min} \div 0.68 = 17.6 \text{ L/min}$ , indicating that a discharge rate of 17.6 L/min is required for fresh water.
3. Finally, find the pilot air pressure and pilot air consumption based on selection from the flow characteristic graphs.

### **Caution**

Viscosities up to 5000 mPa·s can be used.

Viscosity and dynamic viscosity are obtained by the formulas below.

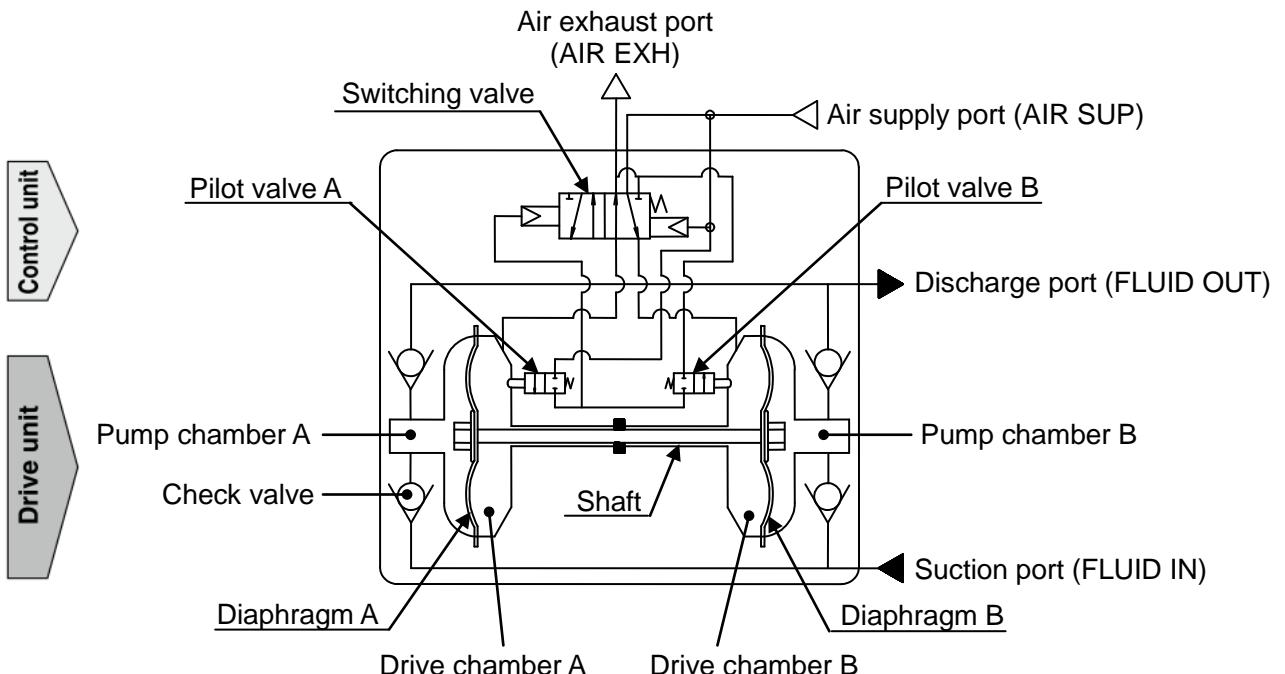
$$\text{Dynamic viscosity } \nu [\text{m}^2/\text{s}] = \frac{\text{Viscosity } \mu [\text{Pa}\cdot\text{s}]}{\text{Density } \rho [\text{kg}/\text{m}^3]}$$

Viscosity and dynamic viscosity are obtained by the formulas below.

$$\text{Dynamic viscosity } \nu [\text{cSt}] = \frac{\text{Viscosity } \mu [\text{mPa}\cdot\text{s}]}{\text{Density } \rho [\text{g}/\text{cm}^3]}$$

$$*1 \text{ [mPa}\cdot\text{s]} = 1 \text{ [cP]}$$

# Working Principle



## Control unit

1. When air is supplied, it passes through the switching valve and enters drive chamber B.
2. Diaphragm B moves to the right, and at the same time diaphragm A also moves to the right pushing pilot valve A.
3. When pilot valve A is pushed, air acts upon the switching valve, drive chamber A switches to a supply state, and the air which was in drive chamber B is exhausted to the outside.
4. When air enters drive chamber A, diaphragm B moves to the left pushing pilot valve B.
5. When pilot valve B is pushed, the air which was acting upon the switching valve is exhausted, and drive chamber B once again switches to a supply state. A continuous reciprocal motion is generated by this repetition.

## Drive unit

1. When air enters drive chamber B, the fluid in pump chamber B is forced out, and at the same time fluid is sucked into pump chamber A.
2. When the diaphragm moves in the opposite direction, the fluid in pump chamber A is forced out, and fluid is sucked into pump chamber B.
3. Continuous suction and discharge is performed by the reciprocal motion of the diaphragm.

# Maintenance Parts

- ⚠️** - It is not recommended to disassemble the process pump. However, if this is necessary, be sure to follow the instructions in the maintenance procedure.  
 - When carrying out this work, wear appropriate protective equipment.

Description	PA5010
Diaphragm kit	KT-PA5-831
Check valve kit	KT-PA5-836
Switching valve parts kit	KT-PA5-37
Pilot valve kit	KT-PA5-38
Manual cap assembly kit	KT-PA5-45

# Piping and Operation

## ⚠ Caution

Mounting posture of the pump is set with the mounting foot facing downward. Air to be supplied to the air supply port <AIR SUP> should be cleaned and filtered through AF filter, etc. Air with foreign matter or drainage etc. will have negative effects on the built-in directional control valve and will lead to malfunction. When air needs additional purification, use a filter (AF series), and a mist separator (AM series) together. Maintain the proper tightening torque for fittings and mounting bolts, etc. Looseness can cause problems such as fluid and air leaks, while over tightening can cause damage to threads and parts, etc.

### Starting and Stopping

- Refer to circuit example (1)
1. Connect air piping to the air supply port <AIR SUP> and connect piping for the fluid to be transferred to the suction port <FLUID IN> and the discharge port <FLUID OUT>.
  2. Using a regulator, set the pilot air pressure within the range of 0.2 to 0.5 MPa. Then, the pump operates when power is applied to the 3 port solenoid valve of the air supply port <AIR SUP>, the sound of exhaust begins from the air exhaust port <AIR EXH> and fluid flows from the suction port <FLUID IN> to the discharge port <FLUID OUT>. At this time, the throttle on the discharge side is in an open state. The pump performs suction with its own power even without priming. (Dry state suction lifting range: up to 2 m) To restrict exhaust noise, attach a silencer (AN20-02: option) to the air exhaust port <AIR EXH>.
  3. To stop the pump, exhaust the air pressure being supplied to the pump by the 3 port solenoid valve of the air supply port <AIR SUP>. The pump stops even when the throttle on the discharge side is closed. But the pressure supply to the pump should be exhausted quickly.

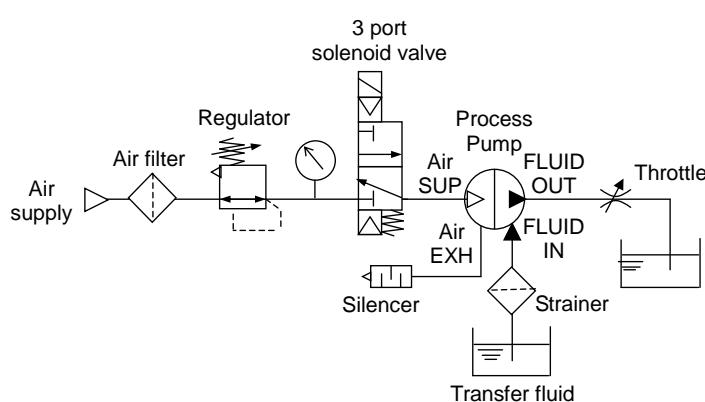
### Discharge Flow Rate Adjustment

1. To adjust the flow rate from the discharge port <FLUID OUT>, use the throttle connected to the discharge side. Refer to circuit example (1). Note that this product cannot be used as a fixed quantity liquid dispense pump.
2. When operating with a discharge flow rate below the specification range, provide a by-pass circuit from the discharge side to the suction side to ensure the minimum flow rate inside the process pump. With a discharge flow rate below the minimum flow rate, the process pump may stop due to unstable operation. Refer to circuit example (2). (Minimum flow rates: 5 L/min)

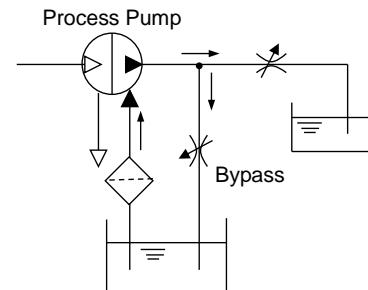
### <Reset Button>

When the pump stops during operation, press the reset button. When the reset button needs to be pressed frequently, replacement of the product or maintenance of the switching valve is necessary.

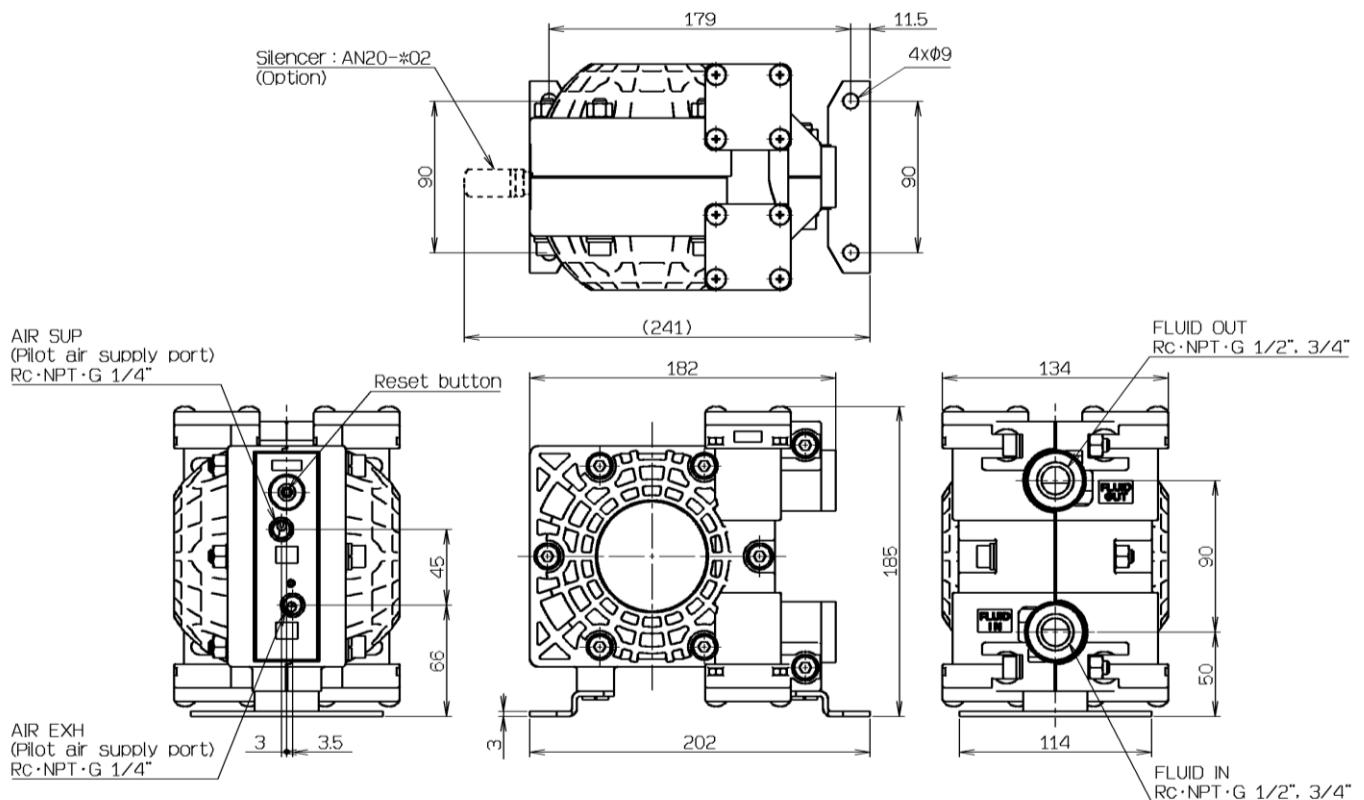
Circuit example (1)



Circuit example (2)



## Dimensions



Revision
19-Feb-2021 Initial release

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NOTE: Specifications are subject to change without prior notice and any obligation on the part of the manufacturer.  
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