



**Rexarc Acetylene Compressor
Preventive Maintenance Schedule
Model L and Model R**

WARNING

BEFORE PROCEEDING WITH MAINTENANCE ON THE COMPRESSOR, IT **MUST** BE STOPPED AND ISOLATED ELECTRICALLY AND MECHANICALLY WITH VISIBLE WARNING NOTICES DISPLAYED

IN ADDITION, ALL INTERNAL PRESSURE MUST BE RELEASED AND THE COMPRESSOR ISOLATED FROM THE RECEIVER

INERT COMPRESSOR WITH NITROGEN

NEVER ATTEMPT TO STRAIGHTEN BADLY BENT PIPEWORK OR RE-USE DAMAGED UNION FITTINGS.

TAMPERING WITH SAFETY VALVES IS DANGEROUS AND INVALIDATES THE GUARANTEE.

NEVER TIGHTEN ANY FITTING WHEN IT IS UNDER PRESSURE

USE NON-SPARKING TOOLS

General

This schedule must cater for a wide variety of operating duties, ambient conditions and methods of control. Periods are given in this manual allow for the worst combination and are also based on preventive maintenance rather than operation until failure occurs. This schedule is also representative of actions to be taken and does not represent instructions on how to perform each action. Refer to the Operators Manual for the compressor being services for details on service instructions.

It is useful to tabulate pressure, temperatures, oil used, etc., against hours run, as this provides a detailed record of the machine condition. It can also give an indication of impending problems.



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Hourly

Drain oil condensate from high pressure driers

Drain water from condensate moisture traps (3 stages + fore cooler)

Verify pressures of each stage of compression

Verify oil pressures

Verify crankcase pressure. It should be the same as the suction pressure. If it is 3 to 6 PSI greater the compressor rings are worn and need to be replaced

Daily

Drain any moisture separated inside the oil filter sight glass before starting

Drain a small amount of oil from the compressor drain to remove moisture before starting

Verify oil level in crankcase and top up if necessary (ISO 68 oil)

Purge compressor whenever oil is added

Verify cooling water temperature is within operating range
Typically between 70 and 76 F (21 to 24.5 C)

Verify stage pressures:

Stage	Model L	Model R
1	40 to 50 psi (2.75 to 3.45 bar)	45 to 55 psi (3.1 to 3.8 bar)
2	150 to 190 psi (10.34 to 13.1 bar)	165 to 190 psi (11.4 to 13.1 bar)
3	350 PSI (24.1 bar)	350 psi (24.1 bar)



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Verify Oil Pump Pressure:

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Internal Oil Pump	27 to 37 psi (1.9 to 2.55 bar)	N/A
External Oil Pump	20 to 30 psi (1.4 to 2 bar)	20 to 30 PSI (1.4 to 2.0 bar)

Weekly

Check for oil or gas leaks inside the cooling tank, rectify if necessary.

Verify correct operation of all valves and controls.

Monthly

Drain water from compressor cooling tank

Verify cooling tank anodes are at least 1/4" (6.35 mm)

Clean compressor cooling tank and compressor with pressure washer or hose*

***If using pressure washer, locate compressing/motor outside building.**

Refill compressor cooling tank with fresh water

Annually

Replace cooling tank anodes (if haven't been replaced during monthly checks)

Lubricate compressor motor



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Recommended Preventive Maintenance Schedule and Compressor Service Kits
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Service Kit #: Model L										
N/A	SK-L1000	SK-L2000	SK-L3000	RB-L4000						
Service Kit #: Model R										
N/A	SK-R1000	SK-R2000	SK-R3000	RB-R4000						
Run Hours										
200 400 600 800	1,000	2,500	3,000	10,000						
X	X	X	X	X	1		Change crankcase oil – Every 200 hrs			
X	X	X	X		2		Change oil filter element	Filter Element – 1-25-0860		
				X	3		Gasket	Gasket – 1-25-0654	1	
				X	4		Remove 1 st stage valve and cover	O-ring-valve to Cover, Outlet – 1-01-0338 & 1-25-0886	1	
				X				O ring-valve to Cover, Suction – 1-25-0887 & 1-25-0889	1	
				X	5	+4	Replace 1 st stage valve & cover	Valve – 2-25-0189L, Suction & 2-25-0190L, Outlet	1 ea.	
				X			Check condition of 1 st stage cylinder	Gasket – 1-25-0879		
				X	6		Remove 1 st stage cylinder	Gasket– cyl. To c/case 1-25-0927L	1	
				X	7	+4	Check 1 st stage piston	1 st stage piston – 1-25-0987	1	



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							assembly		
				X	8		Remove 2 nd stage valve & cover	Washer -valve to cover – 1-07-0047M	1
				X				Head gasket– 1-25-0876	1
				X	9	+8	Replace 2 nd stage valve	Valve 2-25-0110	1



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N/A	SK-L1000	SK-L2000	SK-L3000	RB-L4000					
Service Kit #: Model R					Task	Preparatory Task	Task Description	Parts Provided	Qty
N/A	SK-R1000	SK-R2000	SK-R3000	RB-R4000					
Run Hours					Task	Preparatory Task	Task Description	Parts Provided	Qty
200	400	600	800	10,000					
				X			Check condition of 2 nd stage cylinder	Head gasket - 1-25-0876	
				X	10	+8	Remove 2 nd stage cylinder	Gasket – cyl. to case 1-25-0927L	1
				X	11	+8	Replace 2 nd stage piston rings, piston pin & Snap rings	Ring set – 1-25-0507	1
				X				Piston pin – 1-25-0526L	1
				X				Snap ring – 1-25-0525	2
				X	12	+3	Check crankshaft/con rod assy	Crank/Rod Assy – 1-25-0512L	1
				X	13		Clean 1 st stage separator condensate trap		
				X	14		Clean 2 nd stage separator condensate trap		
				X			Clean 3 rd stage condensate trap		
		X		X	15		Replace or Recertify 1 st safety relief valve	Contact Rexarc for replacement /recertification service	



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		X		X	16		Replace or Recertify 2 nd stage safety relief valve	Contact Rexarc for replacement /recertification service	
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N/A	SK-L1000	SK-L2000	SK-L3000	RB-L4000					
Service Kit #: Model R					Task	Preparatory Task	Task Description	Parts Provided	Qty
N/A	SK-R1000	SK-R2000	SK-R3000	RB-R4000					
Run Hours					Task	Preparatory Task	Task Description	Parts Provided	Qty
200	400	600	800	10,000					
		X		X			Replace or Recertify 3 rd stage safety relief valve	Contact Rexarc for replacement /recertification service	
				X	17		Replace pressure gauges on 1 st , 2 nd , and 3 rd stage	1-04-0015, 1-04-0016, 1-04-0019	3
X	X	X	X	X	18		Check belt tension & condition of all ancillaries		
				X			Replace belt set	Set of 3 – 2-25-0125	1