



Series PA□

Product Specific Precautions 1

Be sure to read before handling.

Refer to front matter 41 for Safety Instructions.

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.

2. Fluids

- 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.

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

Provide a relief valve in the system to prevent it from becoming a liquid-sealed circuit.

5. Fluid pressure

Do not pressurize or decompress the fluid supplied.

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

If reverse pressure or flow occurs, this can cause equipment damage or malfunction, etc. Take safety measures in designing the circuit.

8. Measures against static electricity

Take measures against static electricity as static electricity may occur depending on the fluid.

9. Cannot be used for transferring gases.

If transferring gases, the product cannot provide sufficient transfer volume as it should due to the nature of compression. Besides, as the operational cycle is too short, unexpected malfunctions may occur within short periods of time. Therefore, do not operate the product for a long period of time with no liquid inside or with gas-liquid mixing.

10. Condensation and freezing of the pilot port

For the automatically operated type, 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 the process pump is started or stopped by the pilot air for the automatically operated type, use a 3-port solenoid valve to discharge the residual pressure. If the pump should stop while consuming the residual pressure, the built-in pilot air switching unit may become unstable and unable to be restarted. If it cannot be restarted, press the reset button.
- For the air operated type, combine an exhaust center 5-port solenoid valve or a 3-port solenoid valve for residual pressure release and a 4-port solenoid valve for driving the pump to discharge the residual pressure inside the pump when stopping it. If the pump is pressurized during suspension, its life will become shorter.

2. Use the constant pilot air pressure.

The automatically operated type of some models adopts an air spring for the built-in air control circuit, and the pump may malfunction and stop when the pilot air pressure fluctuation exceeds 50 kPa.

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Product Specific Precautions 2

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Mounting

⚠ Caution

1. Read the instruction manual before mounting the product.

Read the instruction 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. Open the sealed package inside a clean room.

Products specified for clean room are sealed and double packaged inside a clean room. We recommend that the inner package should be opened inside a clean room or clean environment.

3. Confirm the mounting orientation of the product.

Since the mounting orientation varies depending on the product, check it in the instruction manual or the specifications herein.

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.

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.

PA3000, PA5000, PAX1000

Connection thread	Proper tightening torque (N·m)
Rc, NPT, G, NPTF 1/4	12 to 14
Rc, NPT, G, NPTF 3/8	22 to 24
Rc, NPT, G, NPTF 1/2	28 to 30
Rc, NPT, G, NPTF 3/4	28 to 30

PAX1000

Connection thread	Proper tightening torque (N·m)
M5	1/6 turn after tightening by hand
Rc, NPT, G, NPTF 1/8	2 to 3

PA3300, PAP3300, PAF3000, PAF5000

Connection thread	Proper tightening torque (N·m)
Rc, NPT, G, NPTF 1/8	0.4 to 0.5
Rc, NPT, G, NPTF 1/4 (PAF3000)	0.8 to 1
Rc, NPT, G, NPTF 1/4	1.5 to 2
Rc, NPT, G, NPTF 3/8	2 to 2.5
Rc, NPT, G, NPTF 3/4	4 to 5

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.
- If a pump is operated by dried air and N₂ 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.

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. Compressed air with low dew point

Using super dry air as the fluid may affect the reliability (service life) of the equipment, because the lubrication characteristics inside the equipment will deteriorate. Please consult with SMC when using it.



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Product Specific Precautions 3

Be sure to read before handling.

Refer to front matter 41 for Safety Instructions.

Maintenance

⚠ Warning

1. Perform maintenance after consulting the instruction manual.

Obtain the instruction 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. Do not disassemble the product, as disassembly will invalidate the product's warranty.

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

4. 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.

5. 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.

6. Caution when a temperature history cycle is applied.

When a temperature history (heat cycle) is applied for Series PAF3000/5000, the resin thread may extend. Additionally tighten with the specified torque (M3: 0.11 to 0.12 N-m) to prevent liquid leakage.

⚠ 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.

Maintenance

⚠ Caution

2. Service life of diaphragm and maintenance of consumable items

- Regular maintenance is required for items including diaphragms, check valves, switching valves, pilot valves and manual caps.
- 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 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 conduct periodic maintenance.
- When conducting maintenance, obtain the necessary parts indicated in the maintenance parts list (see page 931), and perform work according to the maintenance and instruction manuals.

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

<Automatically operated type>

Reference service life (days) =

A (amount of discharge per cycle) x B (reference number of cycles in service life)

$\frac{\text{Flow (L/min)} \times \text{Operating time per day (hour)} \times 60 \text{ (min)}}{\text{Reference service life (days)}}$

<Air operated type>

The amount of discharge per cycle for the air operated type varies depending on the piping resistance. Therefore, calculate the service life (days) using the operating frequency of a solenoid valve.

Reference service life (days) =

B (reference number of cycles in service life)

$\frac{\text{Operating frequency of solenoid valve (Hz)} \times 60 \text{ (sec)} \times \text{Operating time per day (hour)} \times 60 \text{ (min)}}{\text{Reference service life (days)}}$

Model	Operating method	Diaphragm material	Amount of discharge per cycle A	Reference number of cycles in service life B	Volume inside pump (wetted part)
PA3□10	Automatically operated type	PTFE	Approx. 0.04 L	100 million cycles	Approx. 75 mL
PA3□20					
PA3□13	Air operated type	PTFE	Approx. 0.022 L*	50 million cycles	
PA5□10	Automatically operated type	PTFE	Approx. 0.10 L	50 million cycles	Approx. 315 mL
PA5□20					
PA5□□3	Air operated type	PTFE	Approx. 0.09 L*		
PA (P) 3310	Automatically operated type	PTFE	Approx. 0.025 L	50 million cycles	Approx. 85 mL
PA (P) 3313					
PAX1000	Automatically operated type	PTFE	Approx. 0.021 L	50 million cycles	Approx. 90 mL
PB1011	Solenoid valve driving	PTFE	Approx. 0.004 L	20 million cycles	Approx. 9 mL
PB1013					
PAF3410	Automatically operated type	PTFE	Approx. 0.054 L	50 million cycles	Approx. 105 mL
PAF3413					
PAF5410	Automatically operated type	PTFE	Approx. 0.130 L	50 million cycles	Approx. 100 mL
PAF5413					

* The amount of discharge per cycle for the air operated type is indicated assuming no piping resistance.

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Product Specific Precautions 4

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Lubrication

Caution

- 1. The pump can be used without lubrication.**
Do not lubricate the air operated type, the PAF series.
- 2. If lubricating the pump, continue lubrication.**
If lubricating a pump other than the air operated type or the PAF series, use turbine oil Class 1 (with no additives) ISO VG 32, and be sure to continue lubricating the pump.

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.**