



Oil vapour adsorber

AKM 10-95

Dokument-ID: DMN-AKM1-8/R02



Operating instructions

CE 0525

Revision 02—2016 /EN

Declaration of Conformity

**Parker Hannifin Manufacturing Germany GmbH& Co. KG
Gas Separation and Filtration Division EMEA**

**Im Teelbruch 118
D – 45219 Essen Kettwig**

hereby declares with sole responsibility, that the products

**oil vapour adsorber
series AKM 10 bis 95
assembly type: assembly acc. to Art. 4 No. 2b,**

which this declaration refers to, conform to Directive **2014/68/EU** and were subjected to a conformity assessment according to Annex III Modules B + D (for assembly assessment).

The quality assurance system is monitored by the service provider stated below
*Lloyd's Register Quality Assurance GmbH (Kennnummer 0525)
Am Sandtorkai 41, D - 20457 Hamburg.*

The assembly consists of pressure appliances according to the classification list (attached to the technical documentation provided by the manufacturer).

Pressure vessel					
Dryer	Quantity	Allowable pressure (PS)	Volume [l]	Category (PED)	Module
AKM 10	1	16	20	II	B + D
AKM 15	1	16	24	II	B + D
AKM 20	1	16	36	II	B + D
AKM 25	1	16	45	II	B + D
AKM 35	1	16	55	II	B + D
AKM 45	1	16	70	III	B + D
AKM 60	1	16	105	III	B + D
AKM 75	1	16	132	III	B + D
AKM 95	1	16	175	III	B + D

Piping				
Dryer	Allowable pressure (PS)	Dimensions (DN)	Category (PED)	Module
AKM 10	16	DN25	Art.4.3	Art.4.3
AKM 15	16	DN25	Art.4.3	Art.4.3
AKM 20	16	DN25	Art.4.3	Art.4.3
AKM 25	16	DN40	Art.4.3	Art.4.3
AKM 35	16	DN40	Art.4.3	Art.4.3
AKM 45	16	DN40	Art.4.3	Art.4.3
AKM 60	16	DN50	Art.4.3	Art.4.3
AKM 75	16	DN50	Art.4.3	Art.4.3
AKM 95	16	DN65	I	A

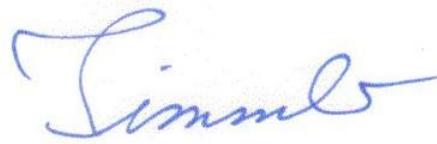
Filter							
Dryer	Filter	Quantity	Allowable pressure (PS)	Volume [l]	Category (PED)	Module	
AKM 10	GL 9	1	16	1,1	Art.4.3	Art.4.3	
AKM 15	GL 9	1	16	1,1	Art.4.3	Art.4.3	
AKM 20	GL 9	1	16	2	Art.4.3	Art.4.3	
AKM 25	GL 11	1	16	2	Art.4.3	Art.4.3	
AKM 35	GL 11	1	16	2	Art.4.3	Art.4.3	
AKM 45	GL 12	1	16	6	I	B+D	
AKM 60	GL 13	1	16	6	I	B+D	
AKM 75	GL 13	1	16	6	I	B+D	
AKM 95	GL 14	1	16	6	I	B+D	

The following standards / technical specifications were used:

- harmonized standards: DIN EN ISO 12100:2011-03

Essen,

19.07.2016



Datum / Date

i. V. Dr. Jürgen Timmler
Leiter Technik und Entwicklung /
Manager Engineering and Development

Machine passport

Type designation	AKM
Order no.	
Order ID	
Build no.	
Vessel no.	
Year of manufacture	

It is the responsibility of the owner,

- to enter for the first time any appliance data not stated above,
- to keep these appliance data up to date.

The above-stated appliance data provide for a clear identification of the adsorber and its components, and significantly facilitate any service measures.

Further important data on the adsorber such as the details on the permissible operating pressure are found on the type plate (for position of the type plate see page 9).

Table of contents

General information.....	7
Manufacturer's details	7
Details on the dryer.....	7
About these operating instructions.....	8
For your own safety.....	9
Signs and hazard areas on the adsorber	9
Intended use of the adsorber	11
General safety notes.....	11
Technical product description	12
Summary drawing.....	12
Function description.....	12
Transportation, installation and storage.....	13
Information on transportation packaging	13
What to do in the case of transport damage occurring?	13
Transporting and installing the adsorber	14
Installing and anchoring	15
Storing the adsorber	16
Installation.....	17
Preconditions for installation	17
Connect piping.....	18
Start-up	19
Requirements for initial start-up	19
Overview of operating and control elements	20
Emergency shutdown	20
Start up adsorber	20
Monitoring adsorber operation	22
Shutdown and restart adsorber	23
Depressurising and shutting down the adsorber	23
Restart.....	23
Maintenance and repair of the adsorber	25
Notes on maintenance	25
Regular maintenance intervals.....	26
Daily maintenance tasks	27
Monthly maintenance tasks.....	27
Notes on further maintenance work	31
Summary of faults.....	33

Index	34
Annex with technical documentation	36
Technical data.....	37
Replacement and wear parts list	38
Technical documentation of the oil indicator	39
Flow diagram.....	43
Dimensional drawing	44

General information

Manufacturer's details

Name and address



*Parker Hannifin Manufacturing Germany GmbH & Co. KG
Gas Separation and Filtration Division EMEA*

Im Teelbruch 118
D-45219 Essen

Phone ++49 (0) 2054 934-0
Fax ++49 (0) 2054 934-164

Internet <http://www.parker.com>

Details on the dryer

Standard equipment

Adsorber, comprising

- 1 single-chamber hollow section vessel, filled with purifying agent
- 1 downstream filter

Associated documents

- Operating instructions (present)
- Technical documentation (see annex)
- Operating manual for installed filters (separate document)

Notes on supplementary documents

Supplementary documents such as operating manuals for options or pertaining components must always be heeded. They contain additional information, e.g. regarding maintenance, and are therefore necessary for safe operation of the plant.

About these operating instructions

These operating instructions contain basic information on the safe use of the adsorber.

Characters and symbols used

- ▶ Work steps that you have to carry out in the sequence stated are marked by black triangles.
- Lists are marked by a small box.

Note:

These notes provide you with hints and information on the safe and efficient handling of machines and devices.

Warning!

These safety notes warn against damage to property and help you to avoid such damage.



Danger!

These danger notes with a grey background warn against personal injury and/or danger to life and limb; danger notes help you to avoid serious or life-threatening situations for yourself and/or third parties.

Target group of these operating instructions

These operating instructions are intended for all persons working on and using the adsorber. We assume that all such persons are specialist personnel, e.g. fitters.

Operating instructions: handling

These operating instructions must be continuously available at the site where the adsorber is used. We recommend to prepare a copy and to keep the same in a safe and freely accessible place next to the adsorber. Keep the original document in a safe place.

For your own safety

The adsorber has been built in accordance with the state of the art and the recognized technical safety regulations. Nevertheless, there is a risk of personal injury and damage to property when the adsorber is used, if

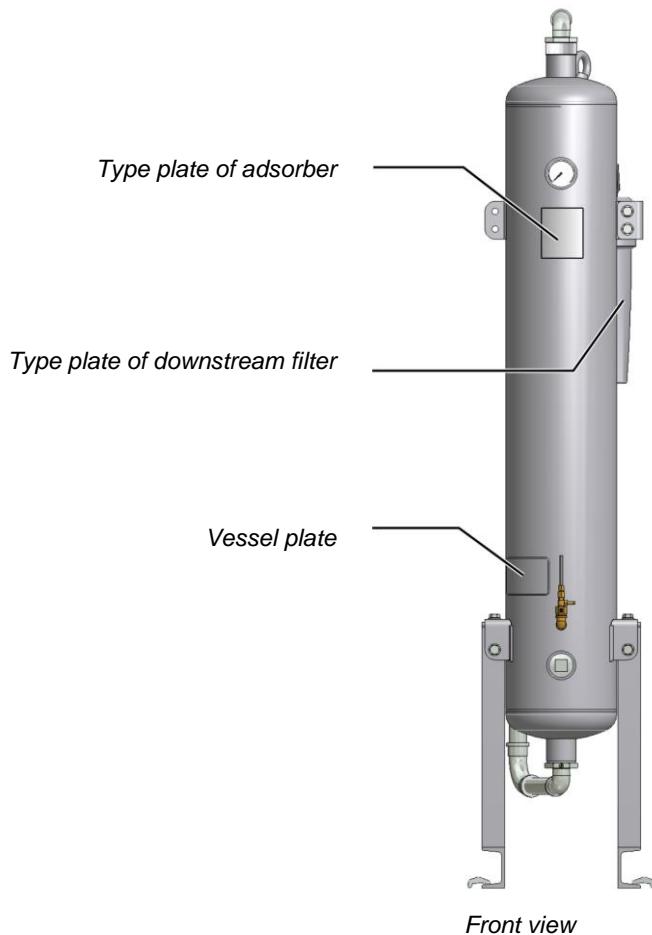
- it is operated by non-qualified personnel,
- not used within its intended design specifications,
- is repaired or maintained incorrectly.

Note:

For your own safety and to prevent machine damage, please note the information and safety notes in these operating instructions when working with the adsorber.

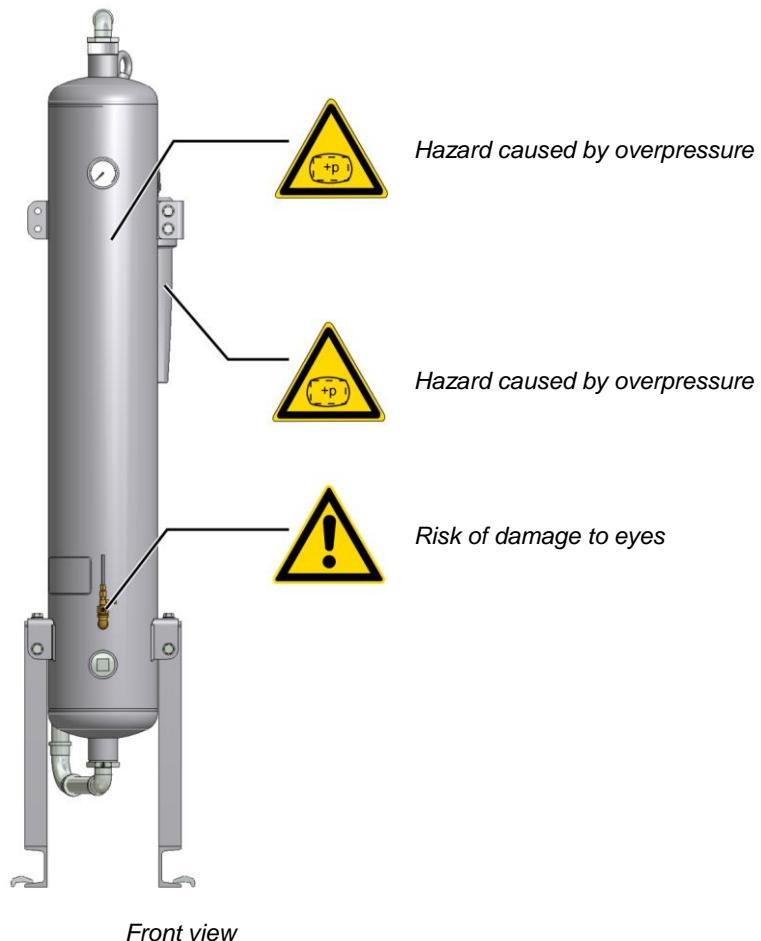
Signs and hazard areas on the adsorber

Signs and labels



Please note these signs on the dryer. Keep them complete and always legible.

Hazard areas on the adsorber



Front view

Hazard area	Symbol in operating instructions
Warning against overpressure The entire adsorber is under pressure. Before commencing any work, the plant must be depressurised.	
Risk of damage to eyes If not properly secured, the indicator tube might be propelled out of its holder! When the needle valve is opened, the indicator tube is secured by a union nut. If the union nut is not properly tightened, or if the oil indicator has been interfered with, there is a risk that the tube might be propelled by the air flow so that it is shot out of its holder. When working at the oil indicator, always wear protective goggles.	

Intended use of the adsorber

The adsorber is exclusively intended for purifying compressed air. Depending on the defined input conditions, it purifies compressed air for industrial use.

The adsorber is designed for compressed air, which is free from aggressive water, oil, and solid matter constituents.

As standard, the adsorber is intended to be sited within a building and protected against the weather.

The adsorber may be operated only in accordance with the data on the type plate and in accordance with the contractual conditions.

Suspected misuse

The adsorber must not be misused as a climbing aid! Pipes, valves, and similar fittings have not been designed for such loads. They could fracture, tear off, or become damaged in another way.

General safety notes

Personnel qualification

Only authorized and qualified specialist personnel may be tasked with the work on the adsorber described in these operating instructions.

Conversions and modifications

Without prior approval by the manufacturer, no conversions and modifications must be made to the adsorber! Any non-approved modifications may restrict the operational safety of the adsorber and cause damage to property or personal injury.

Handling of purifying agents

The purifying agents used do not pose any risk to health. However, when filling and emptying the vessel, increased dust generation may occur. Please comply with the following instructions:

- When handling purifying agents, always wear a dust mask and eye protection!

Disassembly and disposal



Hazard due to a sudden release of pressure!

Never remove any parts of the adsorber, or manipulate the same in any way, for as long as the plant is still pressurised! A sudden escape of pressure may cause serious injuries.

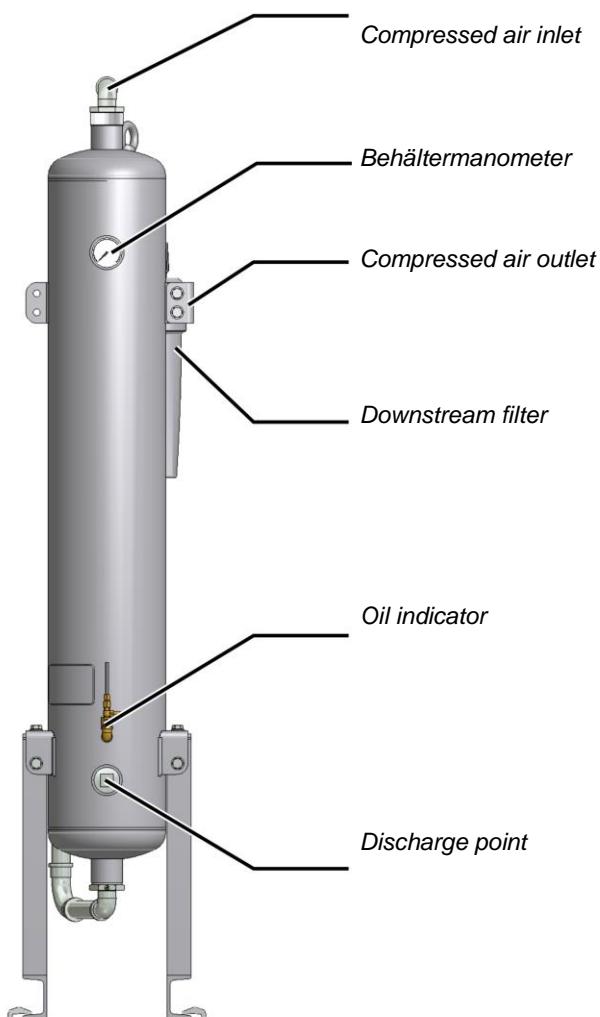
Before carrying out any work on the adsorber, first depressurise the plant.

- Dispose all parts of the adsorber, the purifying agents and all other operating materials in an environmentally safe way and in accordance with all current statutory regulations.

Technical product description

Summary drawing

Front view



Function description

The pre-dried compressed air is fed into the adsorber, where oil vapour and other contaminants are removed from the compressed air, which is then made available for industrial use.

Before the compressed air is fed into the adsorber, it flows through upstream filters where dust and dirt as well as oil and water droplets are removed. The installed upstream filters therefore help extend the service life of the purifying agent.

The installed downstream filters clean the compressed air from purifying agent abrasions before it is fed into the compressed air system.

Transportation, installation and storage



Danger due to incorrect transportation!

The dryer must be transported by authorized and qualified specialist personnel only. During transportation all applicable national regulations for accident prevention must be complied with. Otherwise there is a risk of personal injury.

Always adhere to the stickers and notes on the packaging of the adsorber!

- Only use suitable and technically perfect lifting gear with a sufficient carrying capacity.
- During transportation the adsorber must be carefully secured against falling over.

The manufacturer will not be liable for any damage caused by incorrect storage or incorrect transportation. Please note therefore the following instructions as well as the storage instructions on page 16.

Information on transportation packaging

Depending on the type of transportation, the adsorber is delivered in different types of packaging:

- All transportation types: the apertures of the adsorber are closed off by means of plugs.
- In addition, when transportation is effected by air: the adsorber is packaged in a wooden box.
- In addition, when transportation is effected by ship: the adsorber is packaged in a film material and in a wooden box.

If the packaging is undamaged

- ▶ The undamaged packaging should be removed only at the final installation site, as it offers protection against any weather influences.

What to do in the case of transport damage occurring?

- ▶ Check whether only the packaging or the adsorber itself were damaged.
- ▶ Inform the haulier immediately in writing of any damages.
- ▶ Contact the manufacturer urgently in order to report the damage.

Warning!

A damaged adsorber must not be taken into operation! Damaged components may lead to functional faults and possibly cause further damage.

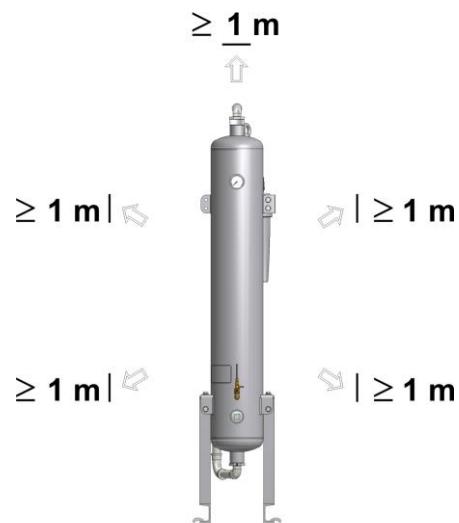


Transporting and installing the adsorber

Requirements for the installation site

The conditions at the installation site have a large influence on the functional capacity of the adsorber and the service life of the purifying agent. In order to ensure a mode of operation, which is as continuous as possible, and low maintenance, the installation site must meet the following requirements:

- The installation site must be located within a building. Protect the adsorber against moisture.
- The ambient temperature must not drop below +1,5 °C (34, 7 °F).
- The installation area must be level and firm. It must have the necessary carrying capacity for the weight of the adsorber. The weight of the adsorber is specified in the technical data section of the annex.
- The adsorber should be installed with sufficient spacing at the top, sides and rear, in order to be able to carry out maintenance work and change the purifying agent without any hindrances (see figure).



Necessary spacing at the top
and sides = min. 1 m

If in doubt, the installation site must be inspected by specialists. If you have any queries in this regard, please contact the manufacturer.

Transportation using lifting or forklift trucks



Warning against damage to property!

The adsorber is delivered lying on its side on a transportation pallet. At the top it is protected by a carton. Top and sides have not been designed for mechanical loads.

Therefore do not place any load onto the top face. Do not stack.

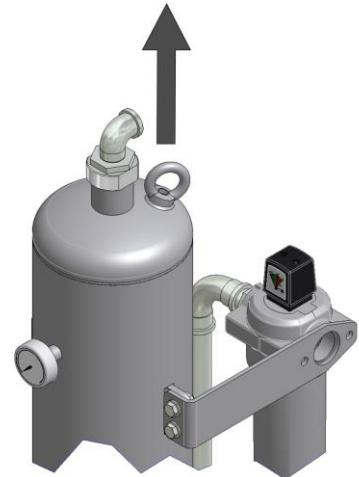
Therefore, always transport the dryer on a lifting or forklift truck.

- ▶ Secure the dryer on the lifting or forklift truck against sliding movements.
- ▶ Transport the dryer to its installation site.

Installing and anchoring

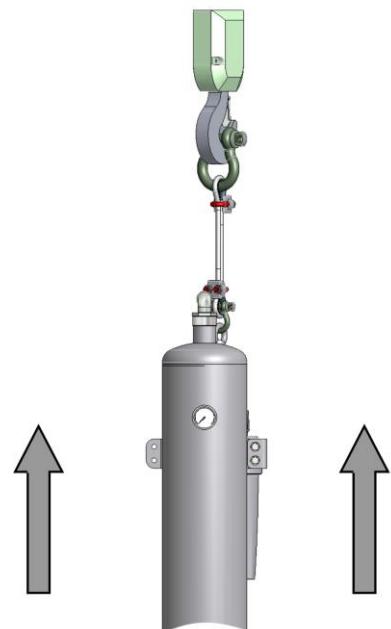
Installing by crane

- ▶ Remove the packaging of the dryer.
- ▶ Attach suitable lifting gear to the transport lugs of the vessels (see figure).



Transport lugs on pressure vessel

- ▶ Place dryer in an upright position, and position the same at its installation site (see figure).



Aufstellen mit Kran

Anchoring the dryer

- ▶ Use suitable attachment material to anchor the dryer to the floor.
- ▶ In the case of vibrating floors: place the dryer on suitable vibration dampers.

Storing the adsorber

If the adsorber is to be stored for an extended period of time, the storage location must meet the following conditions:

- The adsorber must not be stored in the open air.
- The storage room must be dry.
- The storage room must be free from dust or the adsorber must be covered by a protective sheet.
- The storage room must have an ambient temperature of at least +1 °C.

In order to store the adsorber proceed as follows:

- ▶ Take adsorber out of operation as described on page 23.
- ▶ Ensure that the compressed air inlet valve installed by the owner, and the installed compressed air outlet valve installed by the owner, are both closed, and that the adsorber is depressurised.
- ▶ Disconnect adsorber from the compressed air system.
- ▶ Plug the inlet aperture and the outlet aperture of the adsorber to protect against any possible contamination.
- ▶ If possible cover adsorber with a protective sheet.

The adsorber can now be stored for long periods.

Note:

If you wish to take the adsorber back into service after an extended period of storage, please proceed as described for its first commissioning and start-up (see page 21).

Store purifying agents

- ▶ Do not store purifying agents in the open air.
- ▶ Protect purifying agents against humidity.

Installation



Only authorized and qualified specialist personnel may carry out work on pipes.

As soon as the adsorber has been set up at its installation location, you can install the compressed air infeed and outlet lines.

Preconditions for installation

For a correct installation the following preconditions must be met on the part of the owner.

- Connections and lines for the infeed and outfeed of compressed air must be provided.
- The compressed air must be pre-dried before it reaches the adsorber. If the input air is not sufficiently dry, a suitable upstream filter equipped with an automatic condensate trap must be installed. The upstream filter must have a separation efficiency of $0.01\mu\text{m}$ (according to a residual oil content of 0.01 mg/m^3). Please note that, despite the use of an upstream filter, the service life of the purifying agent is reduced.
- A compressed air inlet valve and a compressed air outlet valve as well as a relief valve must be installed by the owner, so that the adsorber can be installed and maintained in a depressurised condition (see also the installation example on page 18).
- All pipes, couplings, and connections must have the correct diameter and match the operating pressure.



Hazard caused by exceeding the limit values!

A safety device must be provided in order to protect against the maximum permissible operating pressure from being exceeded.

The safety device must be installed so that the adsorber is reliably protected from exceeding the maximum permitted operating pressure even when the temperature of the compressed gas increases.

The data required to meet these preconditions are contained in the technical documentation attached in the annex.



Warning!

If the above preconditions are not complied with, a safe operation of the adsorber cannot be assured. Also, the functionality of the adsorber may be detrimentally affected.

Connect piping

In order to ensure that the adsorber operates optimally, the adsorber must be assembled into the compressed air system free of all stresses.

- ▶ Ensure before connection that all infeed and outfeed compressed air lines and valves are clean and undamaged.
- ▶ Check the bolt connections and retighten if necessary, as they could have worked loose during transportation.
- ▶ Remove plugs on the pressure inlet and outlet.

All piping must be free from any stress and tension whatever!

Pipes subject to stress may burst due to the load placed on them during operation. This may cause damage to property and personal injury.



- ▶ Use steel pipes to connect the adsorber to the compressed air system.

The following figure shows an installation example.

Compressed air system	Item	Component
1	1	Entry, compressed air
2	2	Compressed air inlet valve, owner end
3	3	Upstream filter (option)
4	4	Adsorber
5	5	Downstream filter (option)
6	6	Relief valve, owner end
7	7	Compressed air outlet valve, owner end
8	8	Outlet, compressed air
9	9	Bypass line (option)
10	10	Valve in bypass line (option)
11	11	Bypass filter (option)
12	12	Valve, outlet bypass filter (option)

Example of an installation with bypass line

- ▶ The feeding connection lines are to be installed at a slight incline in the direction of the adsorber.
- ▶ One shutdown valve each (2, 7) is to be installed at the compressed air inlet and outlet ends of the adsorber.
- ▶ A relief valve (6) is to be installed after the adsorber.
- ▶ If you fit a bypass line (9) with additional shutdown valve:
Fit the line such that, when carrying out maintenance work on the adsorber, the line system can continue to be supplied with compressed air.

Start-up



Hazard due to a sudden release of pressure!

Never remove any parts of the adsorber, or manipulate the same in any way, for as long as the plant is still pressurised! A sudden escape of pressure may cause serious injuries.

Before carrying out any work on the adsorber, first depressurise the plant.



Flush adsorber to remove residual moisture!

Prior to startup and after changing the activated charcoal, the adsorber must be flushed with pre-dried compressed air for at least 48 hours.

The flushing process allows any remains of cleaning agents (VOCs - volatile chlorinated hydrocarbons) and residual moisture to vaporise out of the adsorber.

- Carry out all prescribed tests and checks.
- Before start-up, ensure that no tools or other foreign parts have been left lying in a part of the adsorber where they might pose a hazard to the adsorber being started up.

Requirements for initial start-up

For the first start-up the following preconditions must have been met:

- The pipe system is free from
 - scales
 - thread abrasions
 - welding beads and
 - other contaminations.
- All shutdown valves
 - of the compressed air inlet and outlet valves installed by the owner
 - of the relief valve installed by the owner
 - in the bypass line (if available)
 are closed.
- The adsorber is correctly sited and installed.

Checks before start-up

Ensure that

- all pipe and bolt connections on the adsorber have been retightened,
- no pipes chafe against body edges,
- all mountings are perfectly secure,
- the needle valve of the oil indicator is closed,
- owner-end and pressurised parts such as safety valves or other devices are not blocked up by dirt or paint,
- all compressed air system parts which are pressurised (valves, hoses etc.) are free from wear symptoms and defects.

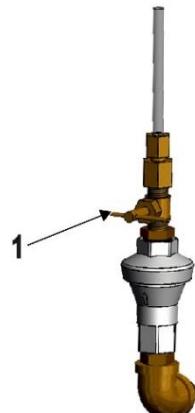
Overview of operating and control elements

Oil indicator

The adsorber is equipped with an oil indicator. The indicator allows for periodic measuring of the residual oil concentration in the purified compressed air.

The residual oil content should only be measured at set intervals, and the needle valve (1) at the indicator should be closed during normal operation.

For detailed instructions on the measuring procedure for residual oil, please refer to the respective section in the maintenance instructions, page 27.



Oil indicator

Emergency shutdown

In the event of an emergency, shut down the adsorber as described in section *Depressurising and shutting down the adsorber*, on page 23.

Start up adsorber



Hazard due to a sudden release of pressure!

Never remove any parts of the adsorber, or manipulate the same in any way, for as long as the plant is still pressurised! A sudden escape of pressure may cause serious injuries.

Before carrying out any work on the adsorber, first depressurise the plant.

- Only operate the adsorber within the permissible limits. By operating the adsorber in conditions for which it has not been designed, functional faults may be caused.
- Check the adsorber regularly for externally visible damage and defects. Any changes, even in its operating behaviour, must be reported immediately to the competent office or person.
- Depending on the size of the adsorber and the compressed air network and the respective legal requirements in your country, it may be necessary to perform initialisation according to the directive for pressure equipment.
- In the event of an emergency or if a safety-relevant disruption occurs (e.g. escaping compressed air, defective component) immediately close and depressurise the respective system section. The unit may only be restarted after all defects have been eliminated.

Open compressed air supply

For start-up, please proceed in the sequence shown here.

- ▶ Ensure that the compressed air inlet and outlet valves as also as the relief valve installed by the owner are closed (see installation example on page 18).
- ▶ Ensure that the compressed air system upstream of the adsorber is pressurised. If necessary, pressurise (switch on compressor).



Slowly open compressed air inlet valve!

Avoid sudden pressure build-up in any circumstance! If pressure builds up too fast, this may cause damage to the adsorber. Therefore, the compressed air inlet valve must always be opened quite slowly!

- ▶ Slowly open the compressed air inlet valve, installed by the owner, upstream of the adsorber.

Open compressed air outlet line



Slowly open compressed air outlet valve!

Avoid a sudden drop in pressure in any circumstance! If pressure drops too fast, this may cause damage to the adsorber. Therefore, the compressed air outlet valve must always be opened quite slowly!

- ▶ Slowly open the compressed air outlet valve installed by the owner. Observe the vessel pressure gauge of the pressurised vessel. The pressure should not drop below the operating pressure (if poss.). If necessary, keep the compressed air outlet valve in a slightly open position until the compressed air system downstream of the adsorber has filled up completely; only then should the valve be opened fully.

The adsorber has then been taken into operation within the compressed air system.

In the event of a fault

In the event of an emergency or if a safety-relevant disruption occurs (e.g. escaping compressed air, defective component), immediately close and depressurise the respective system section. Then proceed as follows:

- ▶ Look up possible cause of the fault, and how to remedy the same, in the table on page 33.
- ▶ Remedy fault.
- ▶ Repeat the start-up procedure.

Monitoring adsorber operation



- Only operate the adsorber within the permissible limits (see type plate). By operating the adsorber in conditions that go beyond the defined values, the adsorber is subjected to loads for which it has not been designed. This may cause functional defects.
- Check the adsorber regularly for externally visible damage and defects. Any changes, even in its operating behaviour, must be reported immediately to the competent office or person.
- In the event of an emergency, immediately close and depressurise the respective system section. (see also chapter **Depressurising and shutting down the adsorber**, page 23). The unit may only be restarted after all defects have been eliminated.

The adsorber operates fully automatically. However, you should carry out the regular checks described in the chapter *Maintenance and repair of the adsorber*.

Shutdown and restart adsorber

In the following cases, the adsorber must be fully shut down and depressurised:

- In the event of an emergency or malfunction
- For maintenance work
- For dismantling



Risk of injury from escaping compressed air!

Never remove any parts of the adsorber, or manipulate the same in any way, as long as the unit is pressurised! Suddenly escaping compressed air might cause serious injuries.

Prior to any work, release all pressure from the unit.

Depressurising and shutting down the adsorber

Close compressed air feed line

- ▶ Close the compressed air inlet valve installed by the owner.

Disconnect adsorber from compressed air system

- ▶ Close the compressed air outlet valve installed by the owner.
- ▶ If available, open bypass line.

Depressurise adsorber

- ▶ Open relief valve installed by the owner.
- ▶ Check the depressurisation: The pressure gauge indicates “0 bar”.

Restart

- ▶ Commission adsorber as described on page 21.

After the purifying agent has been replaced

The newly filled purifying agent contains minute dust particles that can block the downstream filter (option) or other components. We therefore recommend to complete the following steps before you restart the adsorber, in order to protect your equipment:

- ▶ Open relief valve (installed by the owner) downstream of the adsorber, or
- ▶ Remove the housing base and the filter element from the downstream filter.
- ▶ Ensure that the compressed air outlet valve (installed by the owner) is closed.



Wear eye protection and dust mask due to increased dust generation!
Blowing out might lead to increased generation of dust.
In order to avoid any eye irritations, wear protective goggles!
In order to avoid any dust inhalation, wear dust mask!

Restart the adsorber:

- ▶ Pressurise the adsorber as described in section *Open compressed air supply*, page 21.

Check that

- compressed air outlet valve (installed by the owner) is closed, and
- relief valve is open, or
- if there is a downstream filter, its housing is open.

Then proceed as follows:

- ▶ Operate the adsorber for approx. thirty minutes, blowing the dust particles off from the relief valve or, if available, from the downstream filter.

Then again depressurise the adsorber:

- ▶ Close the compressed air inlet valve installed by the owner.

Then close blow-out point and commission the adsorber:

- ▶ Close relief valve installed by the owner, or
- ▶ Reassemble the downstream filter and commission the adsorber (see the operating manual of the filter for the reassembly).
- ▶ Pressurise the adsorber as described in section *Open compressed air supply*, page 21.
- ▶ Check that the vessel and, if available, the downstream filter are leak tight.

Maintenance and repair of the adsorber

In order to allow maintenance work on the adsorber to be carried out efficiently and without danger for maintenance personnel, you should comply with the following instructions.

Notes on maintenance



Warning!

Maintenance tasks may be carried out only by authorized and qualified specialist personnel, and only with the plant in a switched off and depressurised condition.

Note:

In order to ensure perfect maintenance and reliable operation we recommend that you conclude a maintenance contract

When exchange or replacement parts are ordered, always state the adsorber type and the build no. of the adsorber. These data are found on the type plate of the adsorber.

- Carry out all maintenance work only when the plant has been shut down and depressurised!
- Bolt connections must be undone with care! Note ram pressure values! Otherwise emerging media may cause personal injury.
- Never carry out any manipulations on a hollow profile vessel or modify the same in any way!
- Following maintenance work, always check all flange and bolt connections for leakage and secure seating.
- Never use pipes and fittings as steps or holding points! The components might fracture, or the distortions which occur may cause internal damage on the adsorber. There is a risk of injury by slipping off the components, components breaking off, and expanding compressed air!
- Never leave tools, loose parts or cloths at or on the adsorber.
- Only use replacement parts that are suitable for the relevant function and meet the technical requirements stipulated by the manufacturer. This is always the case, if you use original replacement parts only.

Regular maintenance intervals

Note:

If a vessel has been depressurised and the pressure remains above 0 bar, the vessel is pressurised by what is known as ram pressure. This might be due to contamination of the dust sieve spent purifying agent To prevent such malfunctions, regularly service the adsorber as described below.

The table provides an overview of the maintenance work to be carried out. The following pages describe some of these tasks. Maintenance work requiring the adsorber to be largely disassembled is not described. We recommend to have this work to be performed by authorised specialists.

Component	Maintenance task to be carried out	Maintenance interval					siehe Seite
		daily	monthly	6 Monate	12 Monate		
Complete adsorber	Carry out visual and function checks.	●					27
Oil indicator	Measure the residual oil content and the residual capacity of the purifying agent.		●				27
Purifying agent	Replace after maximum 12 months. If the fed compressed air is humid, the maintenance interval is reduced to 6 months.			(●)	●		32
Downstream filters	Please see the enclosed operating instructions for the attached filters. Maintenance work has to be carried out as specified in this document						

When carrying out any maintenance work, comply with the following safety instructions:



Danger!

There is a very considerable risk of personal injury, when carrying out work on the pressurised adsorber.

Before commencing any maintenance tasks always shut down the adsorber as described on page 23, *Depressurising and shutting down the adsorber!*

Daily maintenance tasks

Carry out visual and function check on the complete adsorber

- ▶ Check adsorber for external damage or unusual noise generation.
- ▶ Duly eliminate any defects found.

Clean adsorber

- ▶ Remove any loose dust by means of a dry cloth, and, if required, also by means of a moist and well wrung cloth.
- ▶ Clean the surfaces with a moist well wrung cloth.

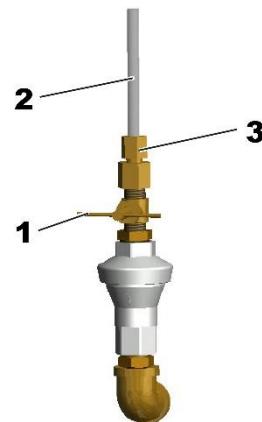
Monthly maintenance tasks

Measuring of residual oil content

The adsorber is equipped with an oil indicator. The indicator allows for periodic measuring of the residual oil concentration in the purified air.

It is recommended to measure the residual oil content every month, using the oil indicator; this allows the operator to determine the absolute residual oil content in the air and the available capacity of the purifying agent.

The measuring principle is as follows: For the duration of the measurement, the needle valve (1) is opened so that a pressure-reduced partial flow of purified compressed air is fed through the indicator tube (2). The indicator tube is secured by means of a union nut (3).



Oil indicator

Any residual oil contained in the air leads to a change of colour of the scale segments of the tube, whereby a higher concentration leads to more segments being coloured.

The change of colour is irreversible; after completion of the measurement, the indicator tube must thus be replaced. It is therefore useful to close the needle valve between measurements.

To measure the residual oil concentration, proceed as described below. A template of the measuring log used for this procedure is included in the appendix.



Risk of damage to eyes! If not properly secured, the indicator tube might be propelled out of its holder!

When the needle valve is opened, the indicator tube is secured by a union nut. If

- the union nut is not properly tightened, or
- if the oil indicator has been interfered with,

there is a risk that the tube might be propelled by the air flow so that it is shot out of its holder.

When working at the oil indicator, always wear protective goggles.

Prior to opening the needle valve, check that the union nut at the indicator tube is properly tightened.

Measuring procedure

- ▶ Prepare measuring log and hold it ready.
- ▶ Check union nut holding the indicator tube and retighten, if necessary.
- ▶ At the indicator tube, mark the highest segment with a colour change, using a suitable pen.
- ▶ Open needle valve by turning its handle anticlockwise. Write down start date and time of the measurement.
- ▶ Leave needle valve open for the desired duration of measurement (e.g. 5 hours).
- ▶ Subsequently, close the needle valve. Write down end time of measurement.
- ▶ At the indicator tube, mark the highest segment with a colour change, using a suitable pen. Write down the number of scale segments that have changed colour since the start of the measurement.

Evaluation of measurement: determining the absolute residual oil content

To evaluate the test results, please refer to the table below:

Duration [h]	Number of first-ever coloured scale units							
	0.2	0.4	0.6	0.8	1.0	1.2	1.4	1.6
4	0.58	1.15	1.70	2.25	2.80	3.40	3.95	4.40
4.5	0.55	0.95	1.45	1.90	2.45	2.85	3.55	3.95
5	0.45	0.86	1.35	1.79	2.25	2.70	3.20	3.65
5.5	0.43	0.81	1.17	1.65	2.00	2.40	2.85	3.35
6	0.40	0.78	1.15	1.45	1.79	2.25	2.60	2.85
6.5	0.35	0.72	1.12	1.35	1.70	2.20	2.35	2.75
7	0.32	0.62	0.95	1.17	1.60	1.90	2.25	2.58
8.5	0.27	0.58	0.87	1.15	1.20	1.55	1.85	2.10
10	0.22	0.45	0.65	0.95	1.15	1.35	1.55	1.85
12.5	0.18	0.37	0.57	0.70	0.85	1.08	1.25	1.45

Duration [h]	Number of first-ever coloured scale units							
	0.2	0.4	0.6	0.8	1.0	1.2	1.4	1.6
16.5	0.13	0.27	0.45	0.57	0.65	0.80	0.90	1.08
25	0.09	0.18	0.30	0.38	0.45	0.60	0.65	0.75
33	0.07	0.12	0.19	0.30	0.32	0.42	0.50	0.55
50	0.045	0.090	0.130	0.180	0.225	0.300	0.350	0.400
56	0.040	0.080	0.110	0.155	0.195	0.275	0.300	0.350
63	0.036	0.070	0.105	0.145	0.180	0.225	0.275	0.300
72	0.032	0.062	0.095	0.128	0.155	0.190	0.245	0.275
84	0.025	0.052	0.085	0.105	0.130	0.155	0.180	0.225
100	0.020	0.042	0.068	0.088	0.110	0.135	0.155	0.180
125	0.015	0.035	0.053	0.075	0.088	0.108	0.130	0.145
166	0.008	0.028	0.040	0.055	0.068	0.085	0.095	0.108
250	0.006	0.015	0.025	0.037	0.045	0.055	0.065	0.070
500	0.002	0.007	0.012	0.018	0.02	0.025	0.032	0.035
1000	0.001	0.003	0.005	0.007	0.008	0.012	0.014	0.018

Table for the determination of the residual oil content in [ppm] at 7 bar operating pressure

Note:

The evaluation is based on a pressure-reduced partial flow that is fed into the indicator tube at a pressure of 7 bar operating pressure.

For adsorbers with an operating pressure of less than 7 bar, please refer to the respective table in the appendix (for 4, 5 or 6 bar operating pressure).

- Determine the concentration in the above table, based on the duration of the measurement and the number of scale segments with colour change.

Example

Duration of measurement in [h]	5.0
Number of scale segment with colour change	1.0
Residual oil concentration in [ppm]	2.25

- Write down the residual oil concentration in ppm, parts per million] in the measuring log.
- To determine the residual oil content in [mg/m³], multiply the above value by a factor 1.2. Write down this value in the measuring log.

Determining capacity reduction of purifying agent

To establish the remaining capacity of the purifying agent, you must carry out measurements of the same duration at fixed intervals.

- ▶ Choose a measuring interval (e.g. 4 weeks) and a duration of measurement (e.g. 4 hours).
- ▶ Determine the maximum admissible residual oil concentration in [mg/m³] for your specific application. Divide this value by 1.2 in order to obtain the maximum admissible residual oil concentration in [ppm].
- ▶ Refer to the table on page 29 and determine the corresponding number of scale segments with colour change.

Example

Maximum admissible residual oil concentration in [mg/m ³]	3.4
Maximum admissible residual oil concentration in [ppm]	2.83
Duration of measurement in [h]	4.0
Maximum admissible number of scale segments with colour change (across entire measuring sequence)	1.0

If there are no additional segments with colour change at the end of the measuring procedure, the purifying agent is working at full capacity.

As its capacity is reduced over time, the number of scale segments with colour change in the tube is increased.

If the established maximum admissible number of segments with colour change is reached, the purifying agent must be replaced (see also page 32).

If all scale segments in the indicator tube show a colour change, the indicator tube is spent and must be replaced as described below.

Replacing indicator tube



Risk of damage to eyes! If not properly secured, the indicator tube might be propelled out of its holder!

When the needle valve is opened, the indicator tube is secured by a union nut. If

- the union nut is not properly tightened, or
- if the oil indicator has been interfered with,

there is a risk that the tube is propelled by the air flow so that it is shot out of its holder.

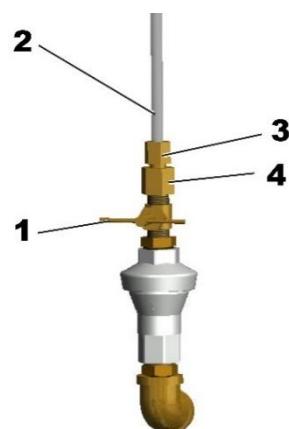
When working at the oil indicator, always wear protective goggles.

Prior to removing the indicator tube, ensure that the needle valve is closed and that the tube is not under pressure!

The colour change of the tube segments (2) is irreversible. When all segments have changed colour, the indicator tube must be replaced.

Prior to removing the tube:

- ▶ Ensure that the needle valve (1) is closed and that the indicator tube (2) is not under pressure. To close the needle valve, turn its handle clockwise.



Oil indicator

To remove the indicator tube:

- ▶ Loosen the reducer (4) below the union nut (3), using an appropriate tool.
- ▶ Dispose of spent indicator tube and reducer according to the application regulations.

To install new indicator tube:

- ▶ Screw indicator tube into the reducer, applying a non-locking thread seal.
- ▶ Check the union nut (3) and the reducer (4) to ensure that they are properly tightened.

To check tube:

- ▶ Open the needle valve (1) for a short time and check screw connections for tightness.

Notes on further maintenance work



Flush adsorber to remove residual moisture!

Prior to startup and after changing the activated charcoal, the adsorber must be flushed with pre-dried compressed air for at least 48 hours.

The flushing process allows any remains of cleaning agents (VOCs - volatile chlorinated hydrocarbons) and residual moisture to vaporise out of the adsorber.



Wear eye protection and dust mask due to increased dust generation!

When emptying/filling purifying agent, increased dust generation might occur.

In order to avoid eye irritations, wear protective goggles!

In order to avoid any dust inhalation, wear dust mask!



Risk of falls!

The adsorber must not be used as a climbing aid! The components have not been designed for such loads and could fracture.

Only use approved climbing aids when disassembling the top plate.

Renew drying agent

The active surface of the purifying agent can be reduced by oil residue and other contaminants. The purifying agent must therefore be replaced once every 12 months (after approx. 8,500 operating hours). If the compressed air is insufficiently dried before it reaches the adsorber (see technical data in the appendix), the service life of the purifying agent can be considerably shortened. In this case, the agent must be replaced every 6 months (after approx. 4,000 operating hours).

Pressure vessel inspection

In accordance with national regulations, a pressure vessel inspection may be prescribed to be carried out at regular intervals by an independent supervisory office.

For an inspection of the pressure vessel, the purifying agent must be removed. When inspecting the pressure vessel, it is recommended to check the condition of all fittings such as e.g. sieve bottom and dust sieve, including gaskets. If necessary, these fittings must be cleaned or renewed.

In the event of comprehensive maintenance or repair tasks, contact the manufacturer.

Identify and eliminate faults

Summary of faults

Faults on the adsorber become noticeable e.g. due to unusual noises and ram pressures.

The following table shows who is allowed to remedy a fault: the owner's specialist personnel or the manufacturer's service engineer.

Table of possible faults

Fault	Possible cause	Remedy	Spec. personnel	Service engineer
Excessive dam pressure	Dust sieve is contaminated.	Clean or renew dust sieve.	●	●
Vessel pressure is too low	Excessive differential pressure on the upstream filter (option).	Check differential pressure on the upstream filter, if nec. renew filter element.	●	
No pressure build up	The compressed air system upstream of the adsorber is not pressurised.	Check whether the compressed air system upstream of the adsorber is pressurised. Remove any faults.	●	
Excessive compressed air consumption	Leakage.	Check screw and flange connections and reseal, if necessary. Check condensate trap at the upstream filter (option); clean, if necessary.	●	●

Index

A

Address, manufacturer	7
Adsorber	
maintenance interval	26

B

Bolt connections	18
Build no.	25, 38
Bypass line	18

C

Compressed air	11
Connection lines	18
Conversions	11

D

Danger notes	
Danger!	8
Danger warning, maintenance	26
Date of manufacture	4
Documentation, technical	36
Dust generation	11, 24, 31
Dust mask	11

E

Example for installation	18
Eye protection	11

F

Fabrication no.	4
Flow diagram	43

H

Hazard areas	10
--------------------	----

I

Installation area	14
Installation example	18
Installation site, requirements	14

L

lifting gear	13
Limits, permissible	20, 22

M

Machine damage, prevention	9
Machine passport	4
Maintenance	
drying agent	32
Maintenance contract	25
Maintenance, danger warnings	26
Misuse	11
Misuse, suspected	11
Modifications on the adsorber	11

N

Notes	
hints	8

O

Oil indicator	
maintenance interval	26
Operating instructions	7
safe place	8
safety notes	9
target group	8
Operating overpressure	
minimum, maximum	37
Operating pressure	
permissible	4
safety device	17
Original replacement parts	25
Overpressure, hazard	10

P

Packaging	13
Personnel qualification	9, 11
Pressure build-up	
sudden	21
Pressure vessel	25
purifying agent	
handling	11
Purifying agent	
maintenance interval	26
Purifying agents	
storage	16

R

Regulations for accident prevention	13
Replacement parts	25

S

Safety notes.....	9
general.....	11
Warning!	8
Safety valves.....	17, 19
Shutdown valves	18
Shutting down.....	23
Specialist personnel	8, 17
Standard equipment	7
Start-up, requirements.....	19
Storage room	
requirements.....	16
Supply lines	17

T

Target group.....	8
Transport damage	13
transport lugs.....	15
Type plate.....	9

U

Use, intended	11
Use, safe	8

V

vibration dampers	15
Visual inspection.....	27

Annex with technical documentation

This annex comprises the following information and technical documentation:

- Technical data
- Replacement and wear parts list
- Technical documents of the oil indicator
- Flow diagram
- Dimensional drawing

Technical data

Operating Range

Site Selection	frost-free indoor installation in a non-hazardous environment
Ambient temperature	1,5 to 50 °C
Compressed air inlet temperature	25 to 50 °C
max. operating overpressure	16 bar _e
operating overpressure, minimal	5 bar _e
Medium	Compressed air and gaseous nitrogen
Fluid group (acc. to Pressure Equipment Directive)	2

Performance data

Model	Volumetric flow in m ³ /h	Nominal pipe	Downstream filter	Nominal Pressure in bar(e)	Nominal temperature in °C
AKM 10	105	1	GL9ZLDH	16	50
AKM 15	145	1	GL9ZLDH	16	50
AKM 20	200	1	GL9ZLDH	16	50
AKM 25	255	1 1/2	GL11ZLDH	16	50
AKM 35	350	1 1/2	GL11ZLDH	16	50
AKM 45	420	1 1/2	GL12ZLDH	16	50
AKM 60	620	2	GL13ZLDH	16	50
AKM 75	750	2	GL13ZLDH	16	50
AKM 95	940	2 1/2	GL14ZLDH	16	50

¹ m³/h, relating to 1 bara and 20 °C at the compressor suction capacity. Subsequently compressed to 7 bar_e and 35°C inlet temperature to the adsorber; relative humidity < 20 %.

² In accordance with DIN ISO 228 (BSP-P);

Purifying agent

vessel 1	100 % Activated Carbon
----------	------------------------

Dimensions

Please heed to the dimensional drawings and the according table containing dimensions and weight on page. 45

Replacement and wear parts list

Note:

When exchange or replacement parts are ordered, always state the adsorber type and the build no. of the dryer. These data are found on the type plate.

Service-Kits

Order ID	For model	Maintenance interval	Scope of delivery
CP3025ZL	AKM 10 bis AKM 20	12 months	Perforated plates and filter element
CP3040ZL	AKM 25 bis AKM 35	12 months	Perforated plates and filter element
CP4040ZL	AKM 45	12 months	Perforated plates and filter element
CP4050ZL	AKM 60 bis AKM 75	12 months	Perforated plates and filter element
CP4065ZL	AKM 95	12 months	Perforated plates and filter element
P02/ZR	AKM 10 bis AKM 95	When necessary	Indicator tube for oil indicator

Activated carbon packs

Type	Order-ID.	Required quantity	Description
AKM 10	DESPAC10AK	1x	
AKM 15	DESPAC3AK	1x	
	DESPAC10AK	1x	
AKM 20	DESPAC3AK	2x	
	DESPAC10AK	1x	
AKM 25	DESPAC3AK	1x	Activated carbon packs of different sizes. It may be necessary to combine several packs of different sizes to fill the vessel completely with activated carbon. In order to chose the correct amount of activated carbon packs, please heed to the table on the left.
	DESPAC10AK	2x	
AKM 35	DESPAC10AK	3x	
AKM 45	DESPAC3AK	1x	
	DESPAC10AK	3x	
AKM 60	DESPAC10AK	5x	
AKM 75	DESPAC10AK	7x	
AKM 95	DESPAC10AK	9x	

Technical documentation of the oil indicator

Measuring log

Number of measurement _____

Date of measurement _____

Adsorber no. _____

Completed by _____

Measured data

Start of measurement _____

End of measurement _____

Duration of measurement _____ [h]

Number of first-ever coloured scale units _____

Evaluation

Evaluation table according to measuring pressure = _____ [bar]

From table: Residual oil content in
[ppm] = _____
x 1.2

Residual oil content in
[mg/m³] = _____

Evaluation tables for determination of the residual oil content

At 4 bar operating pressure

Duration/[h]	Number of first-ever coloured scale units							
	0.2	0.4	0.6	0.8	1.0	1.2	1.4	1.6
4	1.00	1.95	2.90	3.85	4.90	5.95	6.75	7.50
4.5	0.90	1.75	2.55	3.40	4.35	5.10	6.10	6.80
5	0.80	1.55	2.35	3.10	3.90	4.70	5.50	6.20
5.5	0.75	1.40	2.15	2.80	3.55	4.25	5.00	5.80
6	0.70	1.30	1.95	2.60	3.30	3.85	4.60	5.10
6.5	0.65	1.20	1.80	2.35	3.00	3.60	4.25	4.80
7	0.60	1.10	1.70	2.25	2.75	3.30	3.85	4.50
8.5	0.50	0.95	1.40	1.85	2.30	2.75	3.25	3.65
10	0.40	0.80	1.18	1.55	1.95	2.30	2.70	3.10
12.5	0.31	0.70	1.00	1.30	1.55	1.85	2.20	2.50
16.5	0.24	0.50	0.70	1.00	1.25	1.40	1.65	1.90
25	0.155	0.310	0.500	0.700	0.800	1.000	1.100	1.300
33	0.120	0.240	0.380	0.500	0.620	0.750	0.850	1.000
50	0.075	0.155	0.230	0.310	0.400	0.500	0.600	0.700
56	0.065	0.135	0.210	0.280	0.350	0.420	0.500	0.600
63	0.058	0.125	0.185	0.250	0.305	0.355	0.420	0.500
72	0.050	0.095	0.160	0.195	0.270	0.310	0.380	0.420
84	0.040	0.090	0.140	0.185	0.225	0.280	0.310	0.370
100	0.036	0.075	0.118	0.155	0.195	0.230	0.275	0.310
125	0.030	0.059	0.090	0.125	0.155	0.185	0.230	0.250
166	0.020	0.048	0.064	0.090	0.118	0.135	0.155	0.185
250	0.012	0.030	0.048	0.059	0.075	0.090	0.095	0.125
500	0.005	0.012	0.020	0.030	0.036	0.048	0.055	0.059
1000	0.002	0.005	0.010	0.012	0.015	0.020	0.025	0.030

Table for the determination of the residual oil content in [ppm] at 4 bar operating pressure

At 5 bar operating pressure

Duration/[h]	Number of first-ever coloured scale units							
	0.2	0.4	0.6	0.8	1.0	1.2	1.4	1.6
4	0.80	1.55	2.35	3.15	3.90	4.80	5.55	6.25
4.5	0.72	1.40	2.10	2.75	3.50	4.25	4.90	5.60
5	0.62	1.25	1.85	2.50	3.15	3.75	4.40	5.00
5.5	0.56	1.18	1.72	2.30	2.90	3.45	4.00	4.60
6	0.53	1.05	1.55	2.10	2.60	3.15	3.70	4.25
6.5	0.50	0.95	1.45	1.95	2.45	2.80	3.40	3.90
7	0.48	0.90	1.35	1.80	2.30	2.70	3.15	3.60
8.5	0.40	0.75	1.10	1.50	1.75	2.25	2.55	2.85
10	0.35	0.62	0.95	1.25	1.55	1.85	2.20	2.50
12.5	0.25	0.52	0.76	1.00	1.25	1.52	1.75	2.00
16.5	0.185	0.400	0.560	0.800	0.950	1.180	1.300	1.560
25	0.125	0.250	0.410	0.520	0.620	0.760	0.900	1.000
33	0.090	0.185	0.280	0.400	0.510	0.560	0.650	0.800
50	0.060	0.125	0.180	0.250	0.350	0.410	0.450	0.520
56	0.050	0.110	0.165	0.230	0.280	0.370	0.420	0.440
63	0.047	0.095	0.150	0.195	0.245	0.300	0.390	0.425
72	0.040	0.085	0.130	0.170	0.210	0.260	0.320	0.390
84	0.035	0.075	0.110	0.150	0.175	0.230	0.260	0.300
100	0.030	0.060	0.090	0.125	0.165	0.180	0.225	0.250
125	0.020	0.050	0.076	0.097	0.125	0.155	0.170	0.190
166	0.012	0.037	0.055	0.076	0.090	0.115	0.128	0.155
250	0.008	0.020	0.037	0.050	0.060	0.076	0.085	0.097
500	0.005	0.008	0.012	0.020	0.030	0.037	0.042	0.050
1000	0.002	0.005	0.006	0.008	0.010	0.012	0.015	0.020

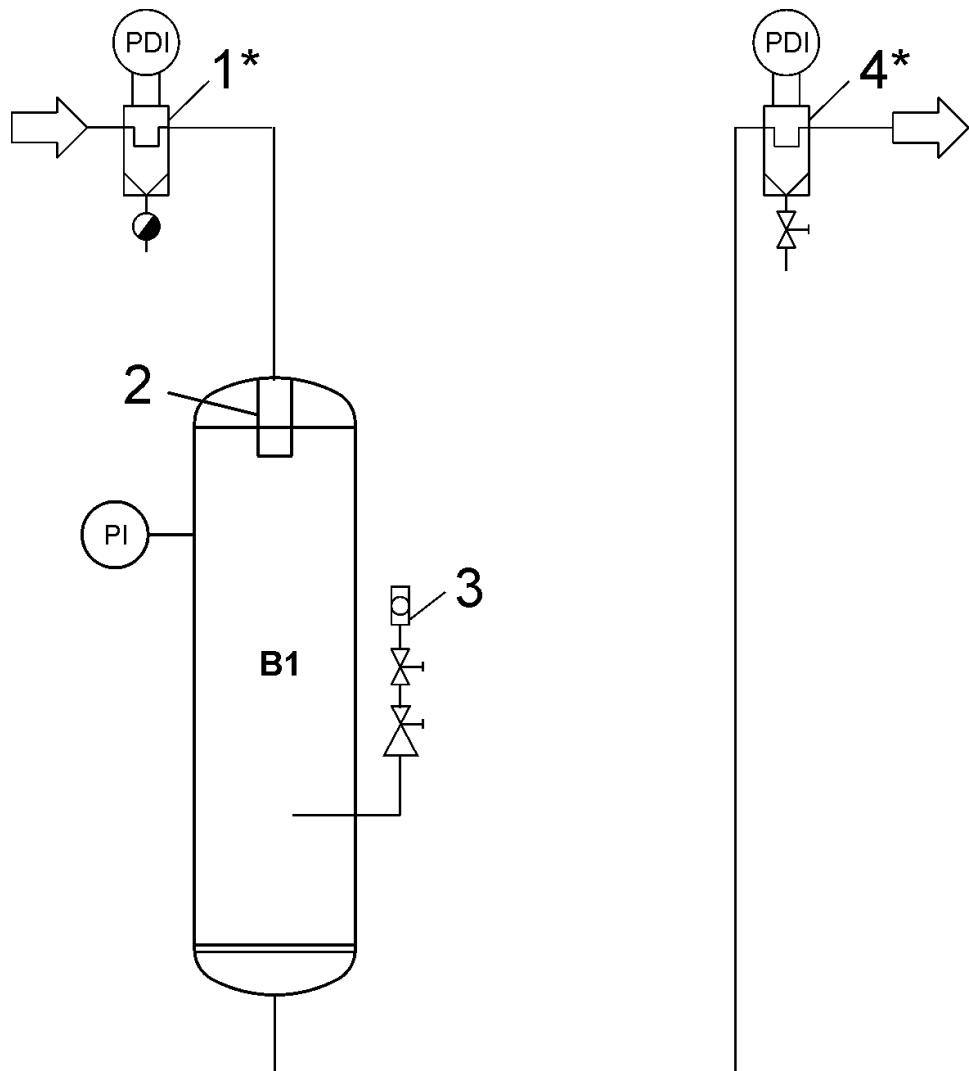
Table for the determination of the residual oil content in [ppm] at 5 bar operating pressure

At 6 bar operating pressure

Duration/[h]	Number of first-ever coloured scale units							
	0.2	0.4	0.6	0.8	1.0	1.2	1.4	1.6
4	0.65	1.30	1.95	2.60	3.25	3.85	4.75	5.40
4.5	0.62	1.20	1.70	2.20	2.80	3.55	4.10	4.75
5	0.52	1.05	1.55	2.10	2.60	3.25	3.70	4.25
5.5	0.48	0.95	1.32	1.90	2.35	2.75	3.50	3.80
6	0.44	0.90	1.30	1.70	2.10	2.60	3.0	3.55
6.5	0.40	0.82	1.25	1.60	2.00	2.40	2.70	3.50
7	0.39	0.70	1.10	1.40	1.85	2.20	2.60	2.90
8.5	0.35	0.62	0.92	1.15	1.45	1.80	2.10	2.45
10	0.27	0.52	0.81	1.05	1.30	1.55	1.80	2.10
12.5	0.21	0.42	0.55	0.85	1.05	1.29	1.48	1.65
16.5	0.16	0.35	0.49	0.55	0.81	0.95	1.08	1.20
25	0.10	0.21	0.35	0.48	0.52	0.55	0.70	0.85
33	0.07	0.16	0.22	0.35	0.40	0.49	0.60	0.66
50	0.05	0.10	0.17	0.21	0.27	0.35	0.38	0.48
56	0.04	0.09	0.16	0.20	0.22	0.27	0.34	0.38
63	0.036	0.082	0.120	0.165	0.210	0.250	0.280	0.355
72	0.035	0.070	0.110	0.160	0.200	0.210	0.270	0.280
84	0.033	0.065	0.090	0.120	0.160	0.200	0.210	0.250
100	0.025	0.050	0.070	0.100	0.120	0.160	0.200	0.210
125	0.018	0.035	0.060	0.075	0.100	0.120	0.150	0.180
166	0.014	0.032	0.038	0.060	0.075	0.090	0.110	0.125
250	0.008	0.020	0.033	0.036	0.050	0.060	0.070	0.075
500	0.002	0.008	0.012	0.018	0.025	0.033	0.034	0.035
1000	0.001	0.002	0.005	0.008	0.010	0.012	0.015	0.018

Table for the determination of the residual oil content in [ppm] at 6 bar operating pressure

Flow diagram

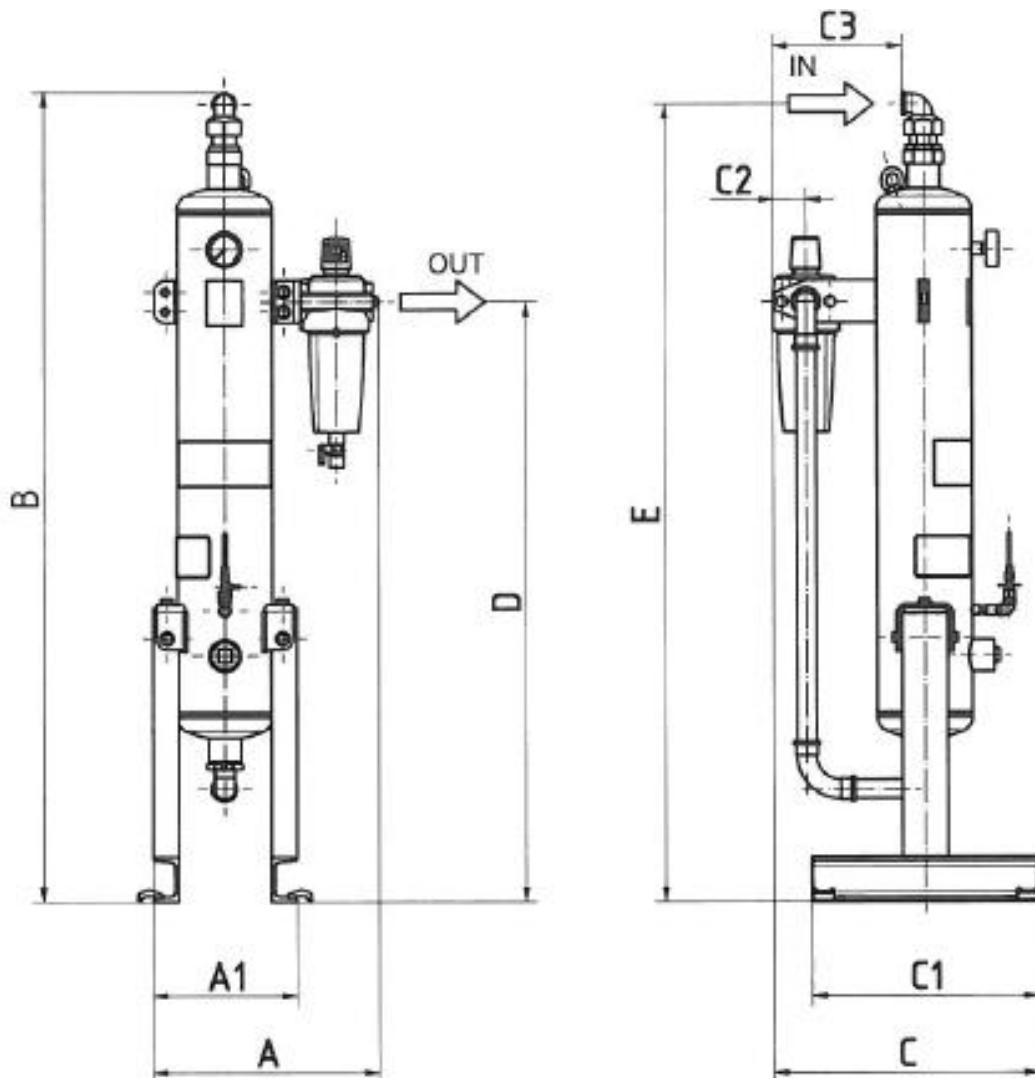


Pos.	Designation
2	Dust sieve
3	Oil indicator

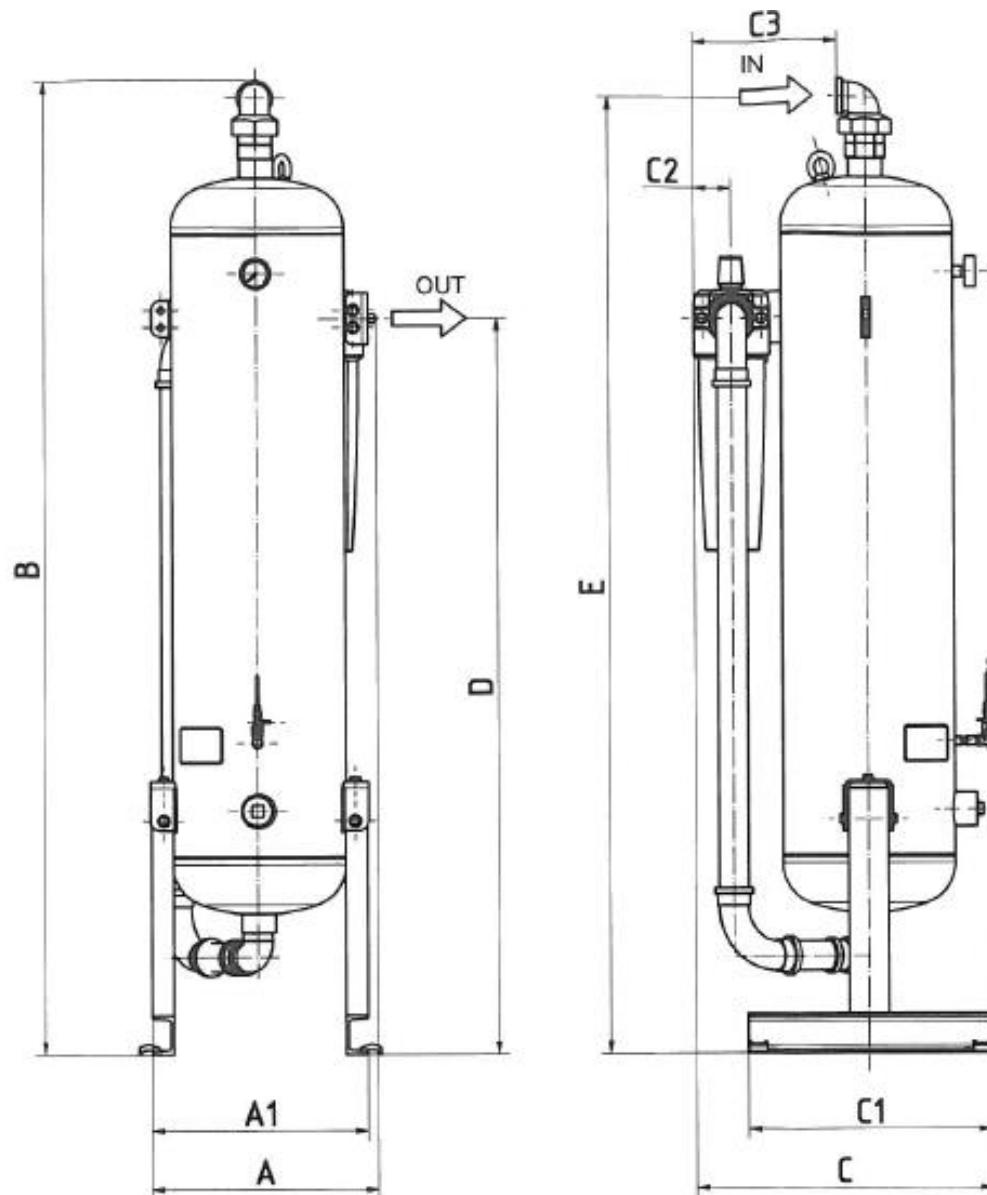
Pos.	Designation
*	Optional devices:
1	Upstream filter
4	Downstream filter

Dimensional drawing

AKM 10 – AKM 15



AKM 20 – AKM 95



Type	Connection	Dimension [mm]									weight [kg]
		A	A1	B	C	C1	C2	C3	D	E	
AKM 10	G 1	420	270	1450	480	400	60	240	1070	1425	59
AKM 15	G 1	420	270	1780	480	400	60	240	1320	1755	70
AKM 20	G 1	340	320	1550	480	400	60	240	1160	1530	70
AKM 25	G 1½	360	320	1785	515	400	60	270	1320	1755	82
AKM 35	G 1½	370	350	1805	515	400	60	270	1320	1770	92
AKM 45	G 1½	400	380	1830	535	400	80	280	1320	1975	109
AKM 60	G 2	460	420	1930	615	500	80	310	1320	1890	140
AKM 75	G 2	480	460	2010	615	500	80	310	1515	1970	172
AKM 95	G 2½	520	500	2060	645	500	80	330	1515	2030	215