

FUSION™

310649G

EN

Automatic Plural Component, Impingement Mix Spray Gun

For use with non-flammable foam and polyurea.

Not for use in explosive atmospheres.

3500 psi (24.2 MPa, 242 bar) Maximum Fluid Working Pressure

80-130 psi (0.55-0.9 MPa, 5.5-9.1 bar) Air Inlet Pressure Range

200° F (94° C) Maximum Fluid Temperature

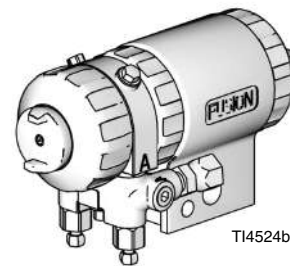


Important Safety Instructions

Read all warnings and instructions in this manual.
Save these instructions.

Air Purge Gun

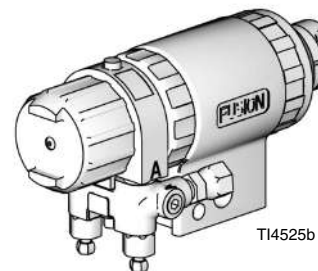
For model information and related manuals, see page 3.



TI4524b

Mechanical Purge Gun

For model information and related manuals, see page 4.





TI4525b

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Manual Conventions


Warning

						
<p>A warning alerts you to possible serious injury or death if you do not follow instructions.</p> <p>Symbols, such as fluid injection (shown), alert you to a specific hazard and direct you to read the indicated hazard warnings on pages 5-6.</p>						

Caution

CAUTION
<p>A caution alerts you to possible equipment damage or destruction if you do not follow instructions.</p>

Note

 A note indicates additional helpful information.

Air Purge Guns

Round Pattern Guns

Gun Part No., Series	Mix Chamber		
	Part No.	Impingement Port Size in (mm)	Equivalent Size
248376, A	AR2929	.029 (0.70)	-00
248377, A	AR4242	.042 (1.00)	-01
248378, A	AR5252	.052 (1.30)	-02
248379, A	AR6060	.060 (1.50)	-03

Flat Pattern Guns

Gun Part No., Series	Mix Chamber			Flat Tip		
	Part No.	Impingement Port Size in. (mm)	Equivalent Size	Part No.	Pattern Size in. (mm)	Orifice Size in. (mm)
248380, A	AF2020	.020 (0.50)	-000	FT0424	8-10 (203-254)	.024 (0.61)
248381, A	AF2929	.029 (0.70)	-00	FT0438	8-10 (203-254)	.038 (0.97)

Related Manuals

For complete safety, operation, and repair information, refer to the applicable manual listed below.

Fusion Air Purge Spray Gun	
Part No.	Description
309550	Instruction-Parts Manual (English)

Mechanical Purge Guns

Use only these mix module/tip combinations.



Standard Round Pattern Guns

Gun Part No., Series	Slip-Fit™ Polycarballoy™ Mix Module Part No., see manual 309856 for numbering code	Round CeramTip™ Part No., see manual 309856 for numbering code
248386, A	MR3535	RTM040
248387, A	MR5757	RTM070

Direct Impingement Round Pattern Guns

Gun Part No., Series	Slip-Fit™ Polycarballoy™ Mix Module Part No., see manual 309856 for numbering code	Round CeramTip™ Part No., see manual 309856 for numbering code
248382, A	XR2929	RTM040
248383, A	XR3535	RTM040

Direct Impingement Flat Pattern Guns

Gun Part No., Series	Slip-Fit™ Polycarballoy™ Mix Module Part No., see manual 309856 for numbering code	Flat CeramTip™ Part No., see manual 309856 for numbering code
248384, A	XF1313	FTM317
248385, A	XF1818	FTM424

Related Manuals

For complete safety, operation, and repair information, refer to the applicable manual listed below.

Fusion Mechanical Purge Spray Gun	
Part No.	Description
309856	Instruction-Parts Manual (English)



WARNING



SKIN INJECTION HAZARD

High-pressure fluid from gun, hose leaks, or ruptured components will pierce skin. This may look like just a cut, but it is a serious injury that can result in amputation. **Get immediate surgical treatment.**

- Do not point the gun at anyone or at any part of the body.
- Do not put your hand or fingers over the gun fluid nozzle.
- Do not stop or deflect leaks with your hand, body, glove, or rag.
- Do not “blow back” fluid; this is not an air spray system.
- Follow **Pressure Relief Procedure**, page 13, when you stop spraying and before cleaning, checking, or servicing equipment.
- Use lowest possible pressure when flushing, priming, or troubleshooting.
- Engage piston safety lock when not spraying.
- Tighten all fluid connections before operating the equipment.
- Check hoses, tubes, and couplings daily. Replace worn or damaged parts immediately. High pressure hose cannot be recoupled; replace the entire hose.



FIRE AND EXPLOSION HAZARD

Flammable fumes, such as solvent and paint fumes, in work area can ignite or explode. To help prevent fire and explosion:







- Use equipment only in well ventilated area.
- Eliminate all ignition sources, such as pilot lights, cigarettes, portable electric lamps, and plastic drop cloths (potential static arc).
- Do not plug or unplug power cords or turn lights on or off when flammable fumes are present.
- Keep the work area free of debris, including solvent, rags, and gasoline.
- Ground equipment and conductive objects. See **Grounding** in Fusion Gun manual 309550 or 309856.
- Hold gun firmly to side of grounded pail when actuating into pail.
- Use only grounded hoses.
- If there is static sparking or you feel a shock, **stop operation immediately**. Do not use equipment until you identify and correct the problem.



EQUIPMENT MISUSE HAZARD

Misuse can cause serious injury or death.

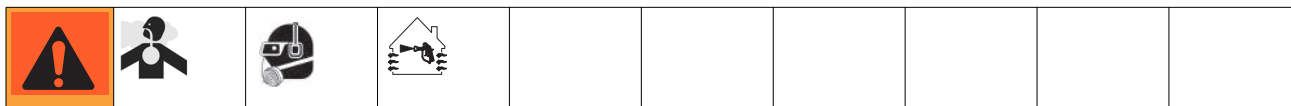
- For professional use only.
- Use equipment only for its intended purpose. Call your Graco distributor for information.
- Read manuals, warnings, tags, and labels before operating equipment. Follow instructions.
- Check equipment daily. Repair or replace worn or damaged parts immediately.
- Do not alter or modify equipment. Use only Graco parts and accessories.
- Do not exceed the maximum working pressure or temperature rating of the lowest rated system component. See **Technical Data** in all equipment manuals.
- Use fluids and solvents that are compatible with equipment wetted parts. See **Technical Data** in all equipment manuals. Read fluid and solvent manufacturer's warnings.
- Route hoses and cables away from traffic areas, sharp edges, moving parts, and hot surfaces.
- Do not use hoses to pull equipment.
- Comply with all applicable safety regulations.

 WARNING	
	<p>BURN HAZARD</p> <p>Equipment surfaces and fluid that's heated can become very hot during operation. To avoid severe burns, do not touch hot fluid or equipment. Wait until equipment/fluid has cooled completely.</p>
 	<p>TOXIC FLUID OR FUMES HAZARD</p> <p>Toxic fluids or fumes can cause serious injury or death if splashed in the eyes or on skin, inhaled or swallowed.</p> <ul style="list-style-type: none"> • Read Safety Data Sheet (SDS) for handling instructions and to know the specific hazards of the fluids you are using, including the effects of long-term exposure. • When spraying, servicing equipment, or when in the work area, always keep work area well ventilated and always wear appropriate personal protective equipment. See Personal Protective Equipment warnings in this manual. • Store hazardous fluid in approved containers, and dispose of it according to applicable guidelines.
	<p>PERSONAL PROTECTIVE EQUIPMENT</p> <p>Always wear appropriate personal protective equipment and cover all skin when spraying, servicing equipment, or when in the work area. Protective equipment helps prevent serious injury, including long-term exposure; inhalation of toxic fumes, mists or vapors; allergic reaction; burns; eye injury and hearing loss. This protective equipment includes but is not limited to:</p> <ul style="list-style-type: none"> • A properly fitting respirator, which may include a supplied-air respirator, chemically impermeable gloves, protective clothing and foot coverings as recommended by the fluid manufacturer and local regulatory authority. • Protective eyewear and hearing protection.
	<p>PRESSURIZED ALUMINUM PARTS HAZARD</p> <p>Do not use 1,1,1-trichloroethane, methylene chloride, other halogenated hydrocarbon solvents or fluids containing such solvents in pressurized aluminum equipment. Such use can cause serious chemical reaction and equipment rupture, and result in death, serious injury, and property damage.</p>

Important Isocyanate (ISO) Information



Isocyanates (ISO) are catalysts used in two component materials.

Isocyanate Conditions







Spraying or dispensing fluids that contain isocyanates creates potentially harmful mists, vapors, and atomized particulates.

- Read and understand the fluid manufacturer's warnings and Safety Data Sheet (SDS) to know specific hazards and precautions related to isocyanates.
- Use of isocyanates involves potentially hazardous procedures. Do not spray with this equipment unless you are trained, qualified, and have read and understood the information in this manual and in the fluid manufacturer's application instructions and SDS.
- Use of incorrectly maintained or mis-adjusted equipment may result in improperly cured material, which could cause off gassing and offensive odors. Equipment must be carefully maintained and adjusted according to instructions in the manual.
- To prevent inhalation of isocyanate mists, vapors and atomized particulates, everyone in the work area must wear appropriate respiratory protection. Always wear a properly fitting respirator, which may include a supplied-air respirator. Ventilate the work area according to instructions in the fluid manufacturer's SDS.
- Avoid all skin contact with isocyanates. Everyone in the work area must wear chemically impermeable gloves, protective clothing and foot coverings as recommended by the fluid manufacturer and local regulatory authority. Follow all fluid manufacturer recommendations, including those regarding handling of contaminated clothing. After spraying, wash hands and face before eating or drinking.
- Hazard from exposure to isocyanates continues after spraying. Anyone without appropriate personal protective equipment must stay out of the work area during application and after application for the time period specified by the fluid manufacturer. Generally this time period is at least 24 hours.
- Warn others who may enter work area of hazard from exposure to isocyanates. Follow the recommendations of the fluid manufacturer and local regulatory authority. Posting a placard such as the following outside the work area is recommended:

 WARNING	
	TOXIC FUMES HAZARD
DO NOT ENTER DURING SPRAY FOAM APPLICATION OR FOR ____ HOURS AFTER APPLICATION IS COMPLETE	
DO NOT ENTER UNTIL:	
DATE: _____	
TIME: _____	



For all applications except spray foam

				
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Spraying or dispensing fluids that contain isocyanates creates potentially harmful mists, vapors, and atomized particulates.




- Read and understand the fluid manufacturer's warnings and Safety Data Sheet (SDS) to know specific hazards and precautions related to isocyanates.
- Use of isocyanates involves potentially hazardous procedures. Do not spray with this equipment unless you are trained, qualified, and have read and understood the information in this manual and in the fluid manufacturer's application instructions and SDS.
- Use of incorrectly maintained or mis-adjusted equipment may result in improperly cured material. Equipment must be carefully maintained and adjusted according to instructions in the manual.
- To prevent inhalation of isocyanate mists, vapors, and atomized particulates, everyone in the work area must wear appropriate respiratory protection. Always wear a properly fitting respirator, which may include a supplied-air respirator. Ventilate the work area according to instructions in the fluid manufacturer's SDS.
- Avoid all skin contact with isocyanates. Everyone in the work area must wear chemically impermeable gloves, protective clothing and foot coverings as recommended by the fluid manufacturer and local regulatory authority. Follow all fluid manufacturer recommendations, including those regarding handling of contaminated clothing. After spraying, wash hands and face before eating or drinking.

Material Self-ignition

				
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Some materials may become self-igniting if applied too thick. Read material manufacturer's warnings and Safety Data Sheet (SDS).

Keep Components A and B Separate

				
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Cross-contamination can result in cured material in fluid lines which could cause serious injury or damage equipment. To prevent cross-contamination:

- **Never** interchange component A and component B wetted parts.
- Never use solvent on one side if it has been contaminated from the other side.

Moisture Sensitivity of Isocyanates

Exposure to moisture (such as humidity) will cause ISO to partially cure, forming small, hard, abrasive crystal that become suspended in the fluid. Eventually a film will form on the surface and the ISO will begin to gel, increasing in viscosity.

NOTICE				
Partially cured ISO will reduce performance and the life of all wetted parts.				
<ul style="list-style-type: none"> • Always use a sealed container with a desiccant dryer in the vent, or a nitrogen atmosphere. Never store ISO in an open container. • Keep the ISO pump wet cup or reservoir (if installed) filled with appropriate lubricant. The lubricant creates a barrier between the ISO and the atmosphere. • Use only moisture-proof hoses compatible with ISO. • Never use reclaimed solvents, which may contain moisture. Always keep solvent containers closed when not in use. • Always lubricate threaded parts with an appropriate lubricant when reassembling. 				

NOTE: The amount of film formation and rate of crystallization varies depending on the blend of ISO, the humidity, and the temperature.

Foam Resins with 245 fa Blowing Agents

Some foam blowing agents will froth at temperatures above 90°F (33°C) when not under pressure, especially if agitated. To reduce frothing, minimize preheating in a circulation system.

Changing Materials

NOTICE

Changing the material types used in your equipment requires special attention to avoid equipment damage and downtime.

- When changing materials, flush the equipment multiple times to ensure it is thoroughly clean.
- Always clean the fluid inlet strainers after flushing.
- Check with your material manufacturer for chemical compatibility.
- When changing between epoxies and urethanes or polyureas, disassemble and clean all fluid components and change hoses. Epoxies often have amines on the B (hardener) side. Polyureas often have amines on the B (resin) side.

Grounding

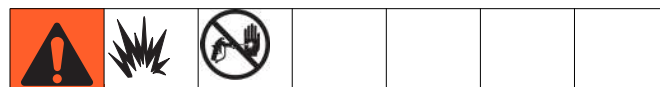


Check your local electrical code and proportioner manual for detailed grounding instructions.

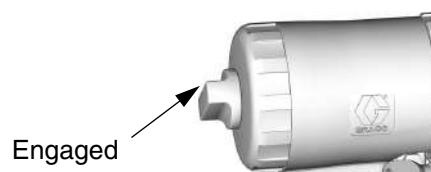
Ground the spray gun through connection to a Graco-approved grounded fluid supply hose.

Piston Safety Lock

Engage piston safety lock whenever you stop spraying, to avoid accidental triggering.

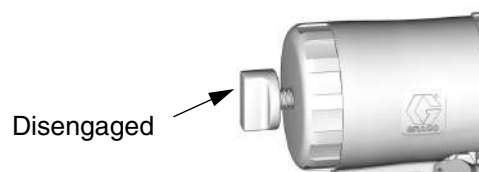


To engage piston safety lock: push knob in and turn clockwise. If engaged, gun will not actuate.



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To disengage piston safety lock: push knob in and turn counterclockwise until it pops out. There will be a gap between knob and gun body.

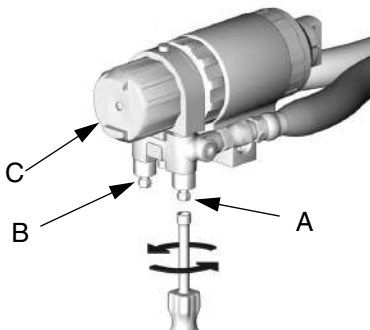


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Turning Air Cap



1. Follow **Pressure Relief Procedure**, page 16.
2. Close fluid valves A and B before turning air cap (C).

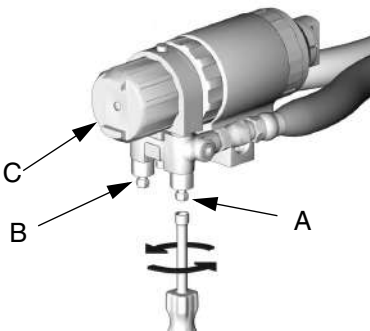


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Loss of Air Pressure

In event of loss of air pressure, gun will continue to spray. To shut off gun, do one of the following:

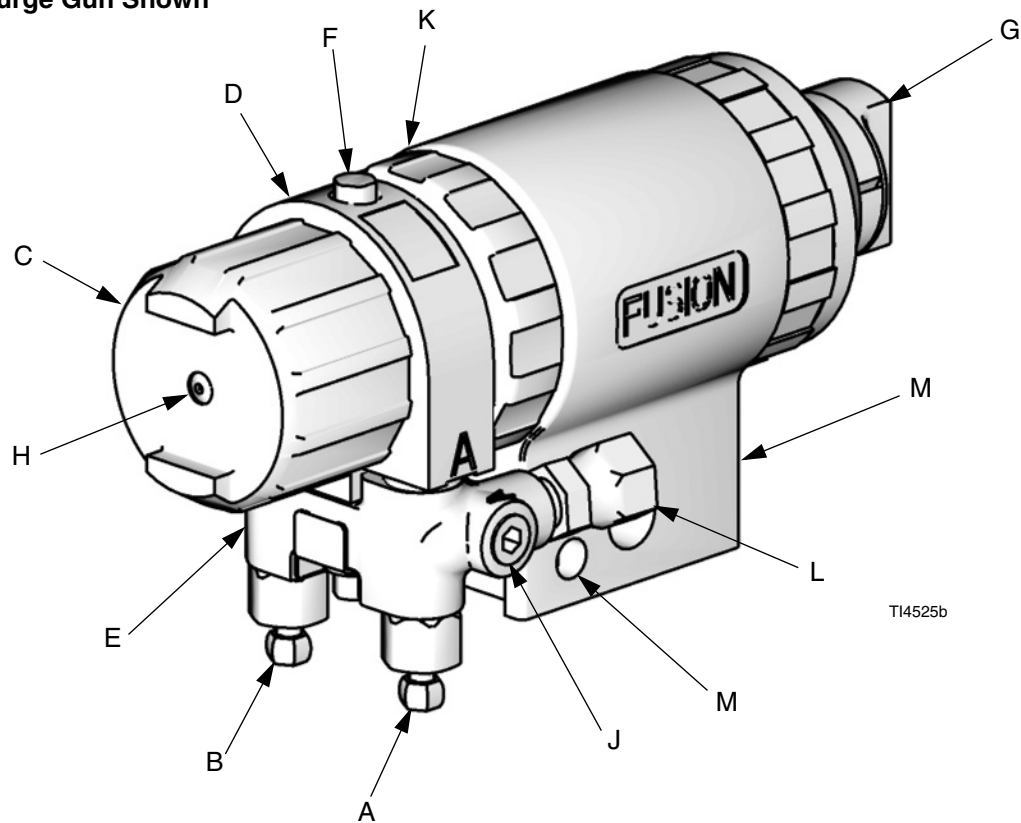
- Push in piston safety lock, see page 9.
- Close fluid valves A and B.



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Overall View

Mechanical Purge Gun Shown



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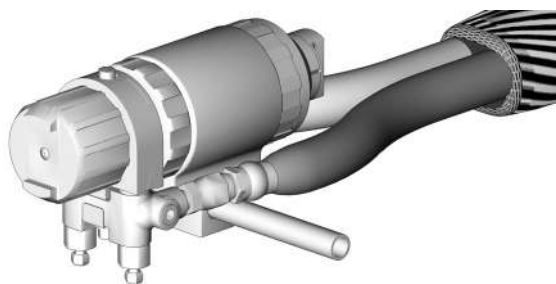
Key:

- A A Side Fluid Valve (ISO)
- B B Side Fluid Valve (RESIN)
- C Air Cap
- D Fluid Housing
- E Gun Fluid Manifold
- F Cleanoff Air Valve
- G Piston Safety Lock
- H CeramTip (behind air cap)
- J Optional Fluid Inlets (A Side Shown)
- K Lock Ring
- L Fluid Inlet Swivels (A Side Shown)
- M Optional Air Inlets (A Side Shown)

Installation

Mounting gun to rod

1. To mount the gun on a 1/2 in. diameter rod, insert the bar (A) through the hole in the gun body as shown.

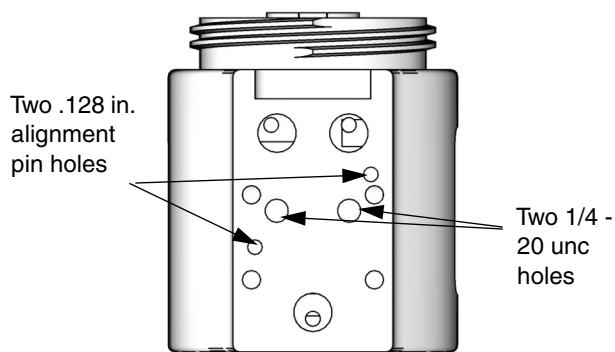


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2. Secure the gun to the bar by tightening 1/4 in. - 20 mounting screws.

Mounting gun to stationary support or robot arm

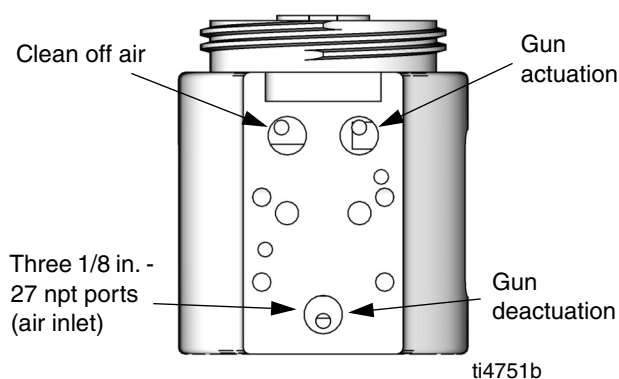
To mount gun to stationary support or robot arm, see mounting hole dimensions page 20.



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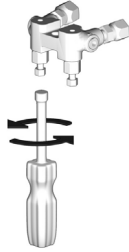
Connecting airline and accessories

- 1.** On each gun air supply line, install an air pressure regulator.
 - It is recommended that the tip clean off air, gun actuation, and gun deactuation air be supplied and regulated separately.
 - A minimum of 80 psi (.55 mpa, 5.5 bar) air pressure must be supplied to the gun for proper operation.
 - A three-way air valve, which exhausts cylinder air, is required.
- 2.** On each gun air supply line, install a bleed-type air shut off valve down stream of the gun air regulator.
- 3.** On the main air line, install a bleed-type air shut off valve.



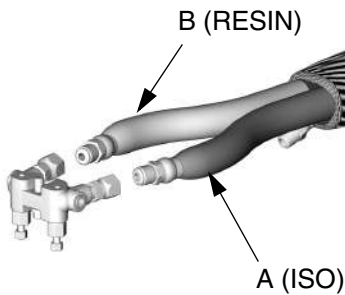
Setup

1. Close fluid valves A and B.



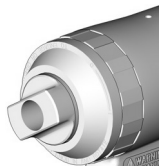
TI2411A

2. Connect A (ISO) and B (RESIN) fluid hoses to fluid manifold.



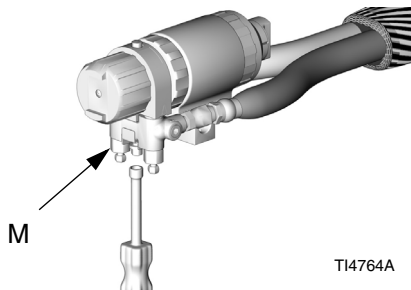
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3. Engage piston safety lock.




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4. Connect the airlines, see **Installation** page 8.
Attach fluid manifold (D) to gun.

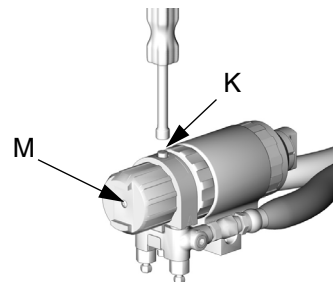


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 To change position of fluid manifold or use optional fluid inlets, see Fusion Gun manual 309856 or 309550.

5. For Mechanical Purge Guns Only:

- a. Open clean off air line valve. Air should flow from air cap around Ceram Tip (M).
- b. Open clean off air valve (K) about 1/4 to 1/2 turn, then adjust air flow as required.
- c. Adjust purge rod, see manual 309856.
- d. Go to step 10.



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For Air Purge Guns Only:

- a. Open clean off air line valve. Air should flow from nozzle (N). Continue through steps below.

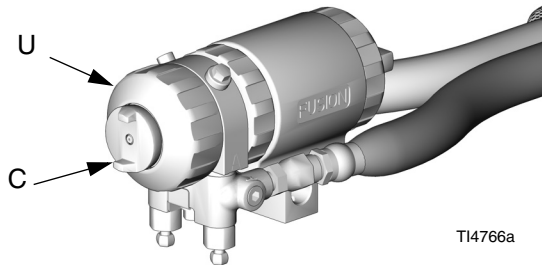


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6. Disengage piston safety lock.

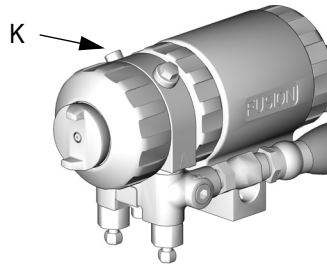


- 7.** Actuate gun to check for full mix chamber travel. Front of air cap (C) should be approximately flush with front retaining ring (U).



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- 8.** Open cleanoff air valve (K) 1/4-1/2 turn and actuate air line to check that cleanoff air is flowing. Adjust as desired.



- 9.** Engage piston safety lock.



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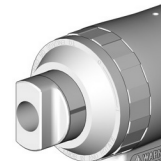
- 10.** Turn on proportioner.

- 11.** Open B (RESIN) fluid valve (about three half turns). Then open A (ISO) fluid valve.



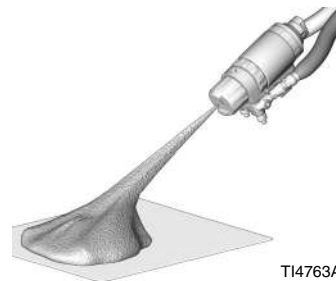
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- 12.** Disengage piston safety lock.



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- 13.** Test spray onto card board. Adjust pressure and temperature to get desired results.



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- 14.** Apply layer of lubricant over front of gun and lock ring, or use gun cover to prevent overspray buildup and ease disassembly. See Fusion Gun Manual 309856 or 309550 to order lubricant and gun cover

- 15.** Gun is ready to spray.

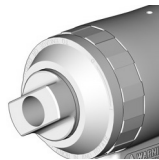
CAUTION

Air supply is required for gun actuation. Do not disconnect gun air supply until fluid pressure is relieved, see page 13.

Pressure Relief Procedure

						
Read warnings, page 5. Relieve pressure before cleaning or repairing gun.						

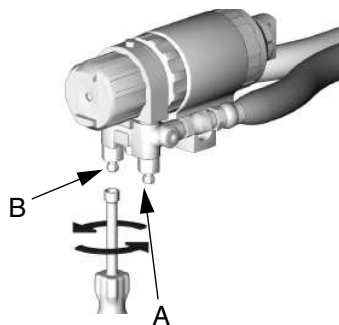
1. Engage piston safety lock.



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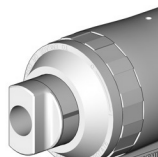
CAUTION
Air supply is required for gun actuation. Do not disconnect gun air supply until fluid pressure is relieved.

2. Close fluid valves A and B. Leave air inlet (W) open.



TI4752A

3. Disengage piston safety lock.



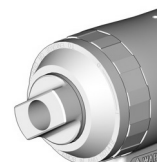
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4. Actuate gun onto cardboard or into waste container to relieve pressure.



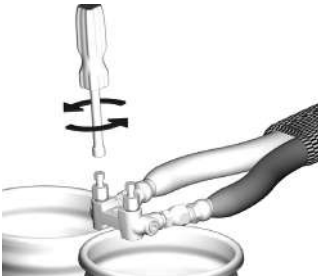


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5. Engage piston safety lock.



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<p>Fluid in the hose and proportioner is still under pressure. Follow the Pressure Relief Procedure in the proportioner manual.</p> <p>To relieve pressure in the hose after the gun is removed, place the fluid manifold over containers, facing away from you. Very carefully open the fluid valves. Under high pressure, fluid will spray sideways from the fluid ports.</p>						
						

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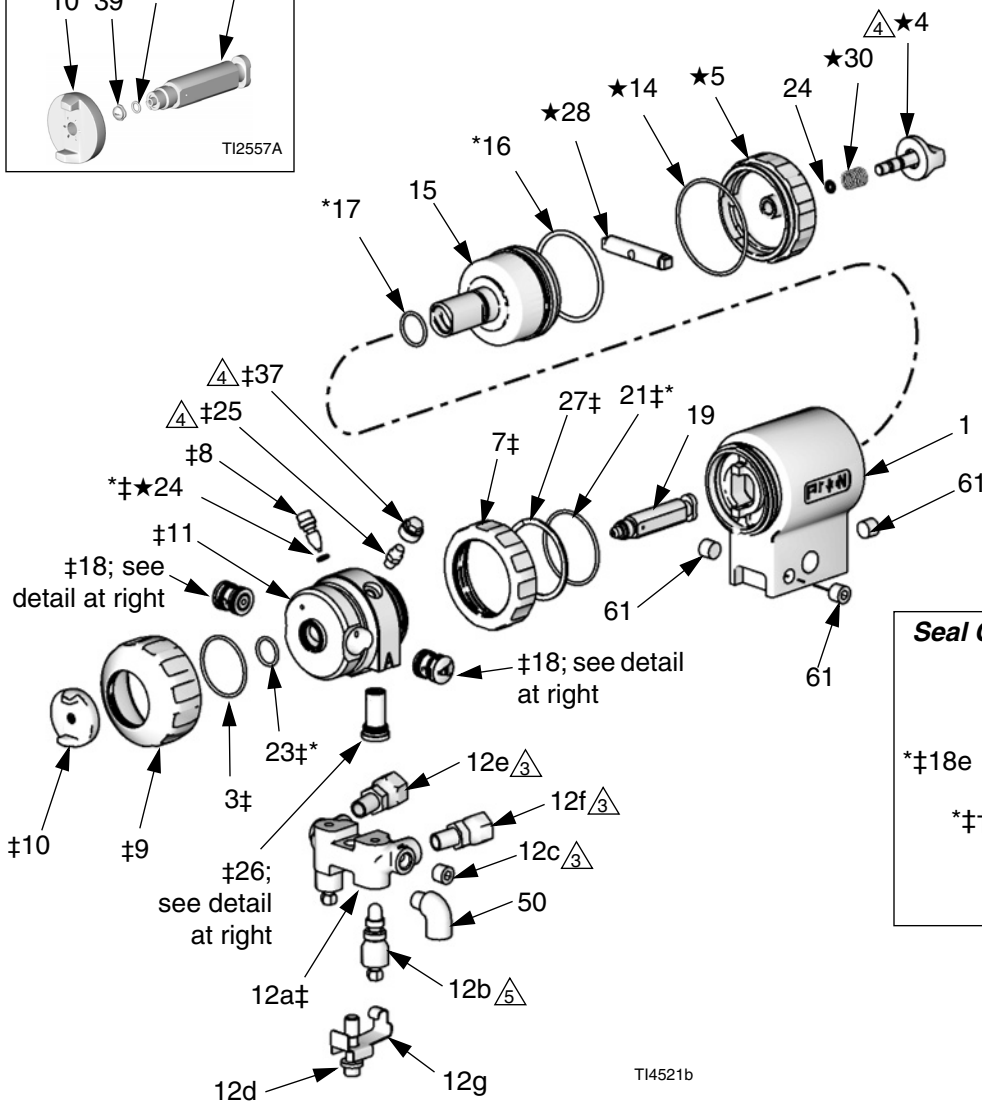
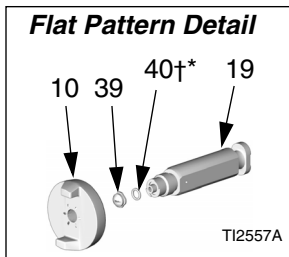
Shutdown

For complete shutdown procedure, refer to Fusion Gun manual 309550 or 309856.

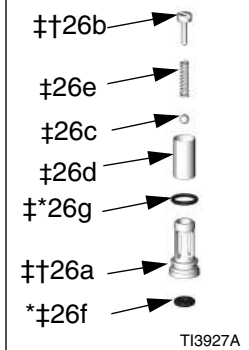
Parts

Air Purge Gun

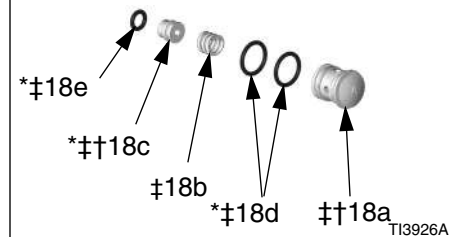
Round Pattern Gun Shown



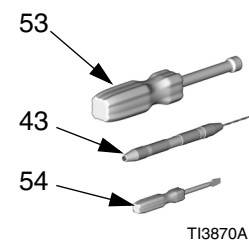
Check Valve (26) Detail



Seal Cartridge (18) Detail



Supplied Tools



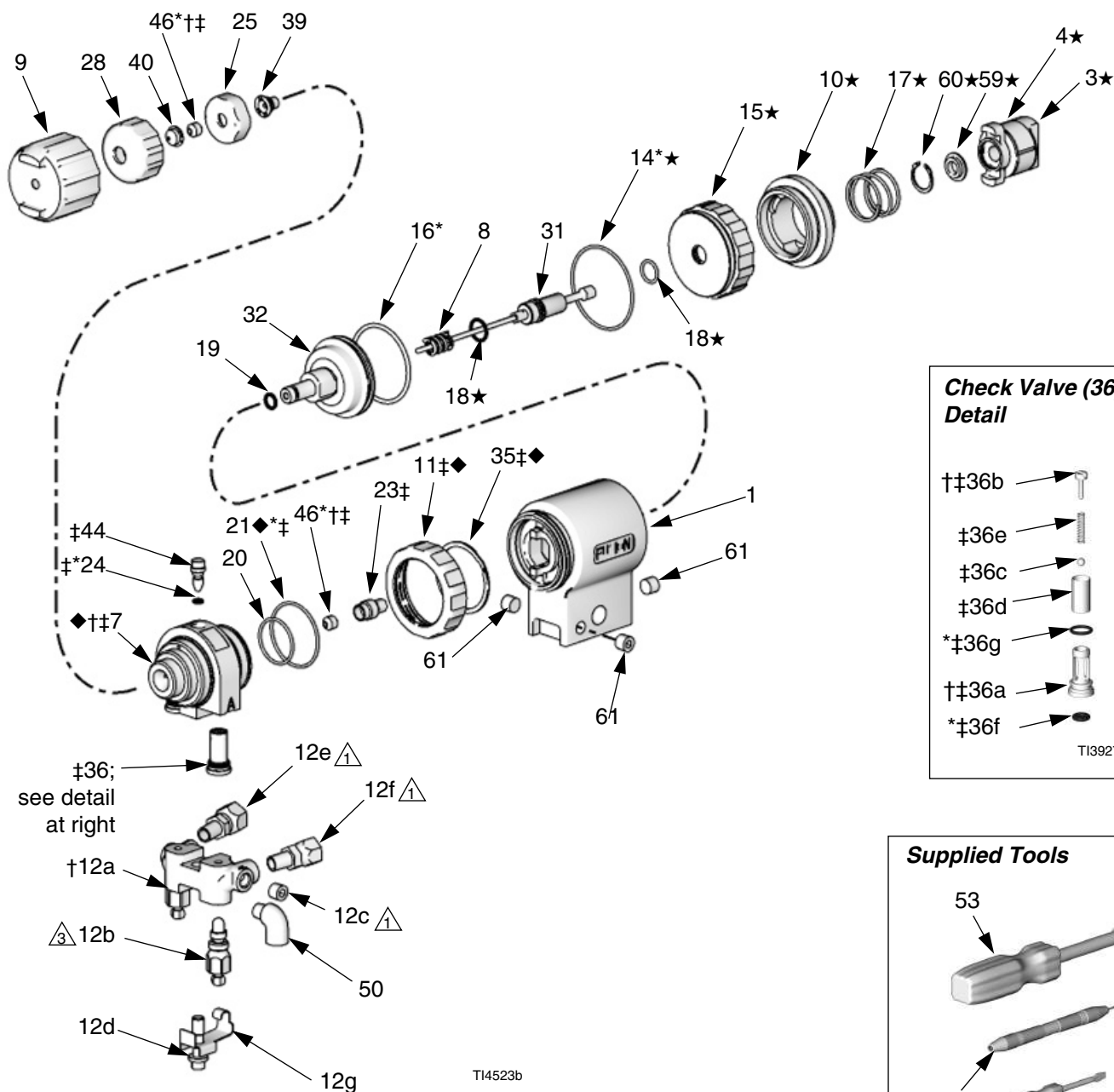
△₃ Torque to 235-245 in-lb (26.6-27.7 N•m).

△₄ Torque to 35-45 in-lb (4-5 N•m).

△₅ Torque to 32-40 ft-lb (43-54 N•m).

Ref. No.	Part No.	Description	Qty	Ref. No.	Part No.	Description	Qty
1	16H881	BODY, air purge	1	27‡	116550	RING, retaining	1
3‡	248137	O-RING; PTFE; package of 6	1	28★	15B205	STOP, piston	1
4★	15B206	LOCK, safety	1	30★	114070	SPRING	1
5★	15B204	CAP, cylinder	1	36▲	222385	CARD, warning; not shown	1
7‡	15B215	RING, lock	1	37‡	15B689	COVER, grease fitting	1
8‡	15B223	VALVE, cleanoff air	1	39	FTxxxx	TIP, flat; see page 3	1
9‡	15B211	RING, retaining	1	40*	246360	O-RING; PTFE; flat tip models only; package of 3;	1
10‡	15B210	AIR CAP; for round pattern guns	1	43	117661	WISE, pin; dual reversible chucks	1
	15B801	AIR CAP; for flat pattern guns; not included in Front End Replacement Kit 246361	1	46	117792	GREASE GUN; not shown	1
11‡	246491	HOUSING, fluid	1	50	112307	ELBOW, street; 1/8 npt (m x f)	2
12	246012	MANIFOLD, fluid; includes 12a-12g	1	53	117642	NUT DRIVER, hex; 5/16	1
12a†		. MANIFOLD	1	54	118575	SCREWDRIVER; 1/8 blade	1
12b	246356	. VALVE, fluid	2	55▲	172479	TAG, warning; not shown	1
12c	100139	. PLUG, pipe; 1/8-27 npt	2	57	117773	GREASE CARTRIDGE; 3 oz; not shown; MSDS sheet available at www.graco.com	1
12d	15B221	. BOLT; 5/16-24	1	58	197979	COVER, gun; not shown	1
12e	117634	. SWIVEL, B side; 1/8 npt(m) x no. 6 JIC(f)	1	59■	118665	LUBRICANT, Fusion Gun; 4 oz (113 gram)	1
12f	117635	. SWIVEL, A side; 1/8 npt(m) x no. 5 JIC(f)	1	61	100139	PLUG, 1/8 NPT	3
12g	15B993	. SPRING, ring, lock	1	* These parts are only available in repair kits. To select a kit, refer manual 309550.			
14*★	248136	O-RING, cylinder cap; package of 6	1	† These parts are not available singly.			
15	15B203	PISTON	1	‡ These parts are included in Front End Replacement Kit 246361.			
16*	248135	O-RING, piston; package of 6	1	★ These parts are included in Safety Stop Assembly 248064 (includes 1 of item 24).			
17*	248134	O-RING, piston shaft; package of 6	1	▲ Replacement Danger and Warning labels, tags, and cards are available at no cost.			
18‡	246349	CARTRIDGE, seal, A side; includes 18a-18e	1	■ Available in 248279 Kit, package of 10.			
	246350	CARTRIDGE, seal, B side; includes 18a-18e	1	Check Valve Filter Screen Kits (10 per kit)			
18a†		. CARTRIDGE BODY	1	80 mesh filter screen is standard with gun.			
18b	117491	. SPRING	1	246357 40 mesh (.015 in., 375 micron)			
18c*†	246348	. SEAL KIT	1	246358 60 mesh (.010 in., 238 micron)			
18d*	248130	. O-RING, cartridge body; package of 6	1	246359 80 mesh (.007 in., 175 micron)			
18e*	248128	. O-RING, side seal; package of 6	1				
19		CHAMBER, mix, see page 3	1				
21‡	248132	O-RING; package of 6	1				
23‡	248131	O-RING; package of 6	1				
24‡★	246354	O-RING; package of 6	1				
25‡	100846	FITTING, grease	1				
26‡	246731	VALVE, check, A side; includes 26a-26g	1				
	246352	VALVE, check, B side; includes 26a-26g	1				
26a††		. HOUSING	1				
26b††	15B214	. SCREW; 5/16-18 x 1/2 in. (13 mm)	1				
26c‡	104396	. BALL; carbide	1				
26d‡		. SCREEN; see below	1				
26e‡	117490	. SPRING	1				
26f‡*	248133	. O-RING, check valve face; package of 6	1				
26g‡*	248129	. O-RING, check valve housing; package of 6	1				

Mechanical Purge Gun



△1 Torque to 125-135 in-lb (14-15 N•m).

△3 Torque to 32-40 ft-lb (43-54 N•m).

Ref. No.	Part No.	Description	Qty	Ref. No.	Part No.	Description	Qty
1	16H942	BODY, mechanical purge	1	39		MODULE, mix, see page 4	1
3★	15C374	ACTUATOR; safety	1	40		CeramTip; see page 4	1
4★	15C390	BUSHING, safety	1	44†	15C382	VALVE, cleanoff air	1
7†◆		HOUSING, fluid	1	46†*	248003	SEAL KIT, purge rod; includes 4 seals	1
8	118145	SPRING, purge rod	1	50	112307	ELBOW, street; 1/8 npt (m x f)	2
9	15C375	AIR CAP	1	53	117642	NUT DRIVER, hex; 5/16	1
10★	15C373	CAP, rear	1	54	118575	SCREWDRIVER; 1/8 blade	1
11†◆	15B215	RING, lock	1	55	197979	COVER, gun; not shown	1
12	246012	MANIFOLD, fluid; includes 12a-12g	1	57■	118665	LUBRICANT, Fusion Gun; 4 oz (113 gram)	1
12a†		. MANIFOLD	1	59★	15D329	STOP, rod	1
12b	246356	. VALVE, fluid	2	60★	115452	RING, retaining	1
12c	100139	. PLUG, pipe; 1/8-27 npt	2	61	100139	PLUG, 1/8 NPT	3
12d	15B221	. BOLT; 5/16-24	1				
12e	117634	. SWIVEL, B side; 1/8 npt(m) x no. 6 JIC(f)	1				
12f	117635	. SWIVEL, A side; 1/8 npt(m) x no. 5 JIC(f)	1				
12g	15B993	. SPRING, ring, lock	1				
14*★	248136	O-RING, rod stop; package of 6	1				
15★	15C372	STOP, purge rod	1				
16*	248135	O-RING, piston; package of 6	1				
17★	118144	SPRING, piston safety lock	1				
18★	248095	O-RING, purge rod; package of 6	1				
19	248096	O-RING, piston shaft; package of 6	1				
20	248138	O-RING, housing, small; package of 6	1				
21†◆	248132	O-RING, housing, large; package of 6	1				
23†	15C378	NUT, rod seal, rear	1				
24†*	246354	O-RING; package of 6	1				
25	15C377	NUT, mix module	1				
28	15C376	RETAINER, CeramTip	1				
31	248001	ROD, purge; includes 1 of item 18	1				
32	15C371	PISTON	1				
34	117661	WISE, pin; dual reversible chucks	1				
35†◆	116550	RING, retaining	1				
36†	246731	VALVE, check, A side; includes 36a-36g	1				
	246352	VALVE, check, B side; includes 36a-36g	1				
36a††		. HOUSING	1				
36b††	15B214	. SCREW; 5/16-18 x 1/2 in. (13 mm)	1				
36c†	104396	. BALL; carbide	1				
36d†		. SCREEN; see below	1				
36e†	117490	. SPRING	1				
36f†*	248133	. O-RING, check valve face; package of 6	1				
36g†*	248129	. O-RING, check valve housing; package of 6	1				
37▲	222385	TAG, warning; not shown	1				

* These parts are only available in repair kits. To select a kit, refer to Gun Repair Kits in manual 309856.

† These parts are not available singly.

‡ These parts are included in Fluid Housing Assembly Kit 246875 (includes 1 of items 24 and 46).

★ These parts are included in Safety Stop Assembly 248028 (includes 1 of item 18).

▲ Replacement Danger and Warning labels, tags, and cards are available at no cost.

■ Available in 248279 Kit, package of 10.

◆ Available in Fluid Housing Assembly Kit 248004.

Check Valve Filter Screen Kits (10 per kit)

80 mesh filter screen is standard with gun.

246357 40 mesh (.015 in., 375 micron)

246358 60 mesh (.010 in., 238 micron)

246359 80 mesh (.007 in., 175 micron)

Mounting Dimensions

Gun mounting plate dimensions

in. (mm)

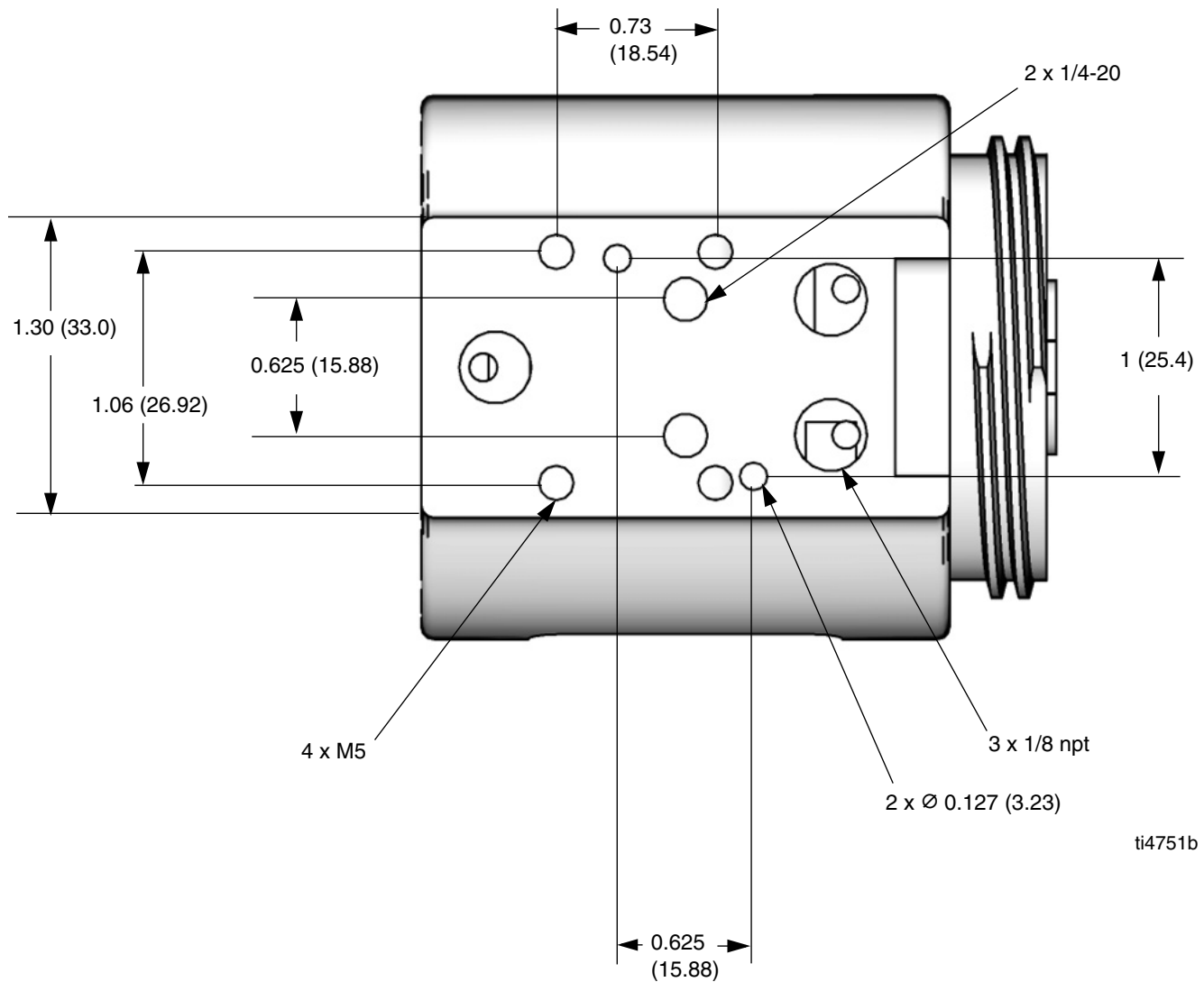


FIG. 1

Technical Data

Category	Data
Maximum Fluid Working Pressure	3500 psi (24.2 MPa, 242 bar)
Minimum Air Inlet Pressure	80 psi (0.55 MPa, 5.5 bar)
Maximum Air Inlet Pressure	130 psi (0.9 MPa, 9 bar)
Air Flow Range at 100 psi (0.7 MPa, 7 bar)	0.9-8.8 scfm (.03-0.25 m ³ /min)
Maximum Fluid Temperature	200° F (94° C)
Air Inlet Size	1/8 - 27 NPT
A Component (ISO) Inlet Size	-5 JIC; 1/2-20 UNF
B Component (Resin) Inlet Size	-6 JIC; 9/16-18 UNF
Sound Pressure	70 dB(A), at 100 psi (0.7 MPa, 7 bar)
Sound Power, measured per ISO 9416-2	79.9 dB(A), at 100 psi (0.7 MPa, 7 bar)
Length	7.6 in. (193 mm)
Height	3.75 in. (95 mm)
Width	3.1 in. (79 mm)
Weight	Air Purge Guns: 2.35 lb (1.06 kg) Mechanical Purge Guns: 2.75 lb (1.24 kg)
Wetted Parts	Aluminum, stainless steel, carbon steel, chemically resistant o-rings, ultra-high molecular weight polyethylene (UHMWPE), brass, Polycarbally™

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Accessories

Part No.	Description
115807	SOLENOID, 24 VDC, 4-way

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For patent information, see www.graco.com/patents.

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