

# 249421 Stud Wall Foam Kit

For Fusion™ Air Purge Spray Guns



**Important Safety Instructions**

Read all warnings and instructions in manual 309550. Save these instructions.

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*To spray wall insulation foam into stud walls with a single pass.*

Ref No	Part No	Description	Qty
1	15F240	ADAPTER, stud wall	1
2	15F854	PACKING, tip; stud wall	1
3	15F241	CAP, air; stud wall	1
4	FTM979	TIP, flat; stud wall	1

⚠ Use with flat pattern mix chambers only. Order separately.

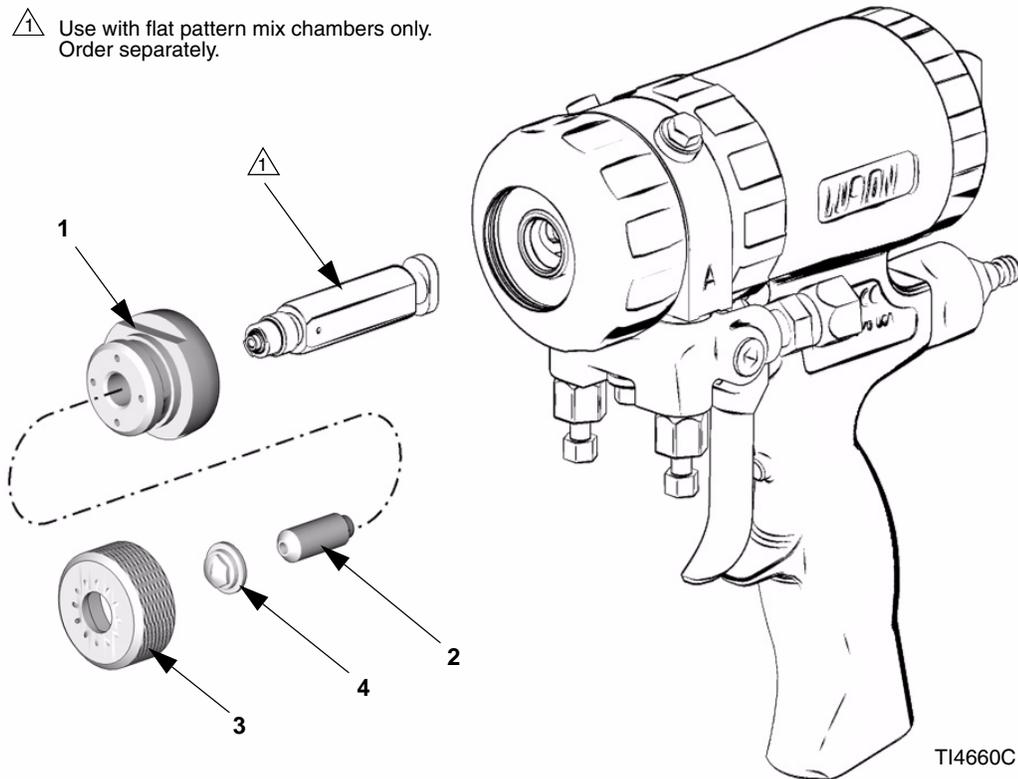


FIG. 1

# Installation

- This kit will not work with round mix chambers (i.e. ARXXXX). If there is a round mix chamber in the gun, replace it with a flat mix chamber. Smaller flat mix chambers can be ordered for lower fluid flow applications. See Flat Mix Chamber Kit chart.

Flat Mix Chamber Kit*	Type	Flow Rate (approx.) at 1000 psi (7.0 MPa, 70 bar)
AF5252	Standard	15 lb/min (6.81 kg/min)
AF0052†	Special	15 lb/min (6.81 kg/min)
AF4242	Standard	11 lb/min (4.99 kg/min)
AF0042†	Special	11 lb/min (4.99 kg/min)
AF2929	Standard	7 lb/min (3.18 kg/min)

\* Includes mix chamber and cleanout tool.  
 † Extended wear life for abrasive materials.

- A FTM979 Stud Wall Tip is included in this kit. **NOTE:** FTM762 Stud Wall Tip is available for lower fluid flow applications as an accessory.

	FTM979 Stud Wall Tip	FTM762 Stud Wall Tip
Pattern size	22 in. (559 mm)	14 in. (355.6 mm)
Spray distance	2 ft. (0.61 m)	2 ft. (0.61 m)
Fluid flow‡	15 lb/min (6.81 kg/min)	13 lb/min (5.90 kg/min)

‡ When used with mix chamber AR5252 at 1000 psi (7.0 MPa, 70 bar).

- The small plastic o-ring on the end of the flat mix chamber must be removed.

1. Remove the existing air cap (round or flat) from the Fusion Gun and replace it with the adapter (1). Thread the adapter onto the mix chamber until it bottoms out.
2. Insert the packing (2) through the center of the adapter (1) with the stepped end facing the mix chamber.

3. Place the stud wall tip (4) onto the packing (2) and tighten the air cap (3) with light hand force.

- Overtightening may distort the packing inside the mix chamber. Reopen the hole with the 0.94 in. (3/32 in, 2.39 mm) drill bit provided if necessary.
4. Adjust the tip orientation with a standard 5/16 in. nut driver (provided with gun). See FIG. 2.

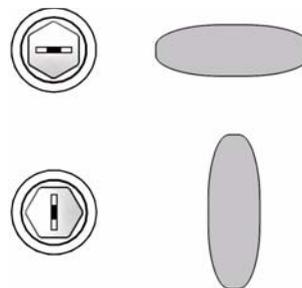


FIG. 2

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## Cleaning Tips

1. If the pattern begins to shrink or becomes distorted, relieve pressure (see your gun manual) and clean the internal dome of the tip (4) with the tip cleanout tool (15D234). See FIG. 3.
2. Clean out the inside diameter of the packing (2) and the flat mix chamber with a 0.94 in. (3/32 in, 2.39 mm) dia. drill bit (Graco cleanout tool kit 246624).
3. Add a thin layer of lubricant on the outside faces of the air cap (3) to ease cleaning.



FIG. 3

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All written and visual data contained in this document reflects the latest product information available at the time of publication. Graco reserves the right to make changes at any time without notice.

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# Foam Accessories

## Special Mix Chamber Kits

Kit includes mix chamber and cleanout drills. For extended wear life with abrasive materials.

Kit Part No.	Description
AR0042	Special mix chamber with equivalent flow AR4242
AR0052	Special mix chamber with equivalent flow AR5252

## Wide Pattern Mix Chamber Kits

Kits include mix chamber and cleanout drills. To spray larger diameter patterns than the standard mix chambers.

Kit Part No.	Pattern Diameter at 24 in. (609.6 mm) to target in (mm)	Equivalent flow to mix chamber size	Nozzle Drill Bit Size in (mm)	Impingement Drill Bit Size in. (mm)
AW2828	15 (381.0)	Ref. AR2929	1/16, .062 (1.59)	#70, .028 (0.71)
AW3333	15 (381.0)	Ref. AR3737	#53, .060 (1.52)	#66, .033 (0.84)
AW3939	16 (406.4)	Ref. AR4242	#50, .070 (1.78)	#61, .039 (0.99)
AW4646	18 (457.2)	Ref. AR5252	.085 (2.15)	#56, .046 (1.17)
AW5757	18 (457.2)	Ref. AR6060	#42, .089 (2.26)	1.45 mm, .057 (1.45)
AW6464	22 (563.9)	Ref. AR7070	7/64, .109 (2.77)	#52, .064 (1.63)
AW8282	24 (609.6)	Ref. AR8686	1/8, .125 (3.18)	#45, .082 (2.08)

## Stud Wall Foam Kit

249421 Sprays wall foam insulation into stud walls with a single pass. Kit includes adapter parts & clean out drill. For use with flat mix chambers: AF2929, AF4242, AF0042, AF5252 ad AF0052.

Flat pattern mix chambers sold separately. Optional FTM762 tip available for lower flow and smaller pattern applications.

## Extension Tip Kits

Kits include extension, flat tip seal and round tip seal, cleanout drill bit, and instructions.

Requires 248020 Extension Tip Air Cap Kit (order separately).

Kit Part No.	Hole Diameter x Length, in. (mm)	Recommended Mix Chambers	Spray Distance, ft (m) *	Pattern Diameter, in. (mm) *
248010	.042 x 0.50 (1.06 x 12.7)	AR2020/AF2929	15 (4.57)	10 (254)
248011	.052 x 0.50 (1.32 x 12.7)	AR2929/AF2929	12 (3.66)	10 (254)
248012	.060 x 0.50 (1.52 x 12.7)	AR4242/AF4242	12 (3.66)	12 (305)
248013	.070 x 0.50 (1.78 x 12.7)	AR5252/AF5252	8 (2.44)	20 (508)
248014	.042 x 1.0 (1.06 x 25.4)	AR2020/AF2929	15 (4.57)	10 (254)
248015	.052 x 1.0 (1.32 x 25.4)	AR2929/AF2929	12 (3.66)	8 (203)
248016	.060 x 1.0 (1.52 x 25.4)	AR4242/AF4242	12 (3.66)	8 (203)
248017	.070 x 1.0 (1.78 x 25.4)	AR5252/AF5252	8 (2.44)	8 (203)

\* Measured with less than 8 in. (203 mm) drop in stream center at 1200 psi (8.4 MPa, 84 bar) static pressure.

## Extension Tip Seal Kits

Kits include 5 seals.

Kit Part No.	Description
248018	Flat Extension Tip Seal Kit
248019	Round Extension Tip Seal Kit

## Extension Tip Air Cap Kit

### 248020

Includes air cap for use with extension tip kits 248010-248017.

## Hose Adapter Kits

### 246944

To connect non-Graco gun to Graco heated hose.

### 248029

To connect Graco Fusion Kit gun to non-Graco D-gun hose set.

### 246945

To connect Graco Fusion gun to non-Graco heated hose.

## Spatter Conversion Kit

### 248414

To convert Fusion air purge gun to spray, round pattern only, large droplet, low overspray applications. Includes air cap, tip, retainer, seal, and cleanout drill bits.