

FusionTM CS

312666B

Plural Component, Impingement Mix Air Purge Spray Gun with ClearShot Liquid Technology

For use with non-flammable foam and polyurea. Not for use in explosive atmospheres.

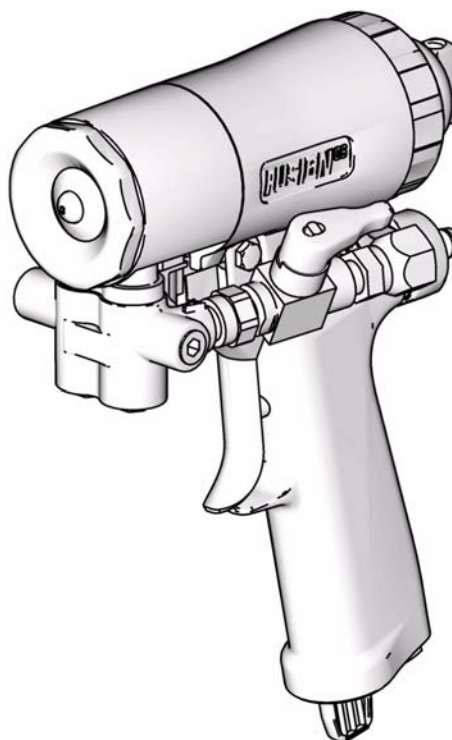
*3500 psi (24.5 MPa, 245bar) Maximum Fluid Working Pressure
80-130 psi (0.56-0.9 MPa, 5.6-9.0 bar) Air Inlet Pressure Range
200° F (94° C) Maximum Fluid Temperature*



Important Safety Instructions

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

See page 4 for model information.



TI11323a

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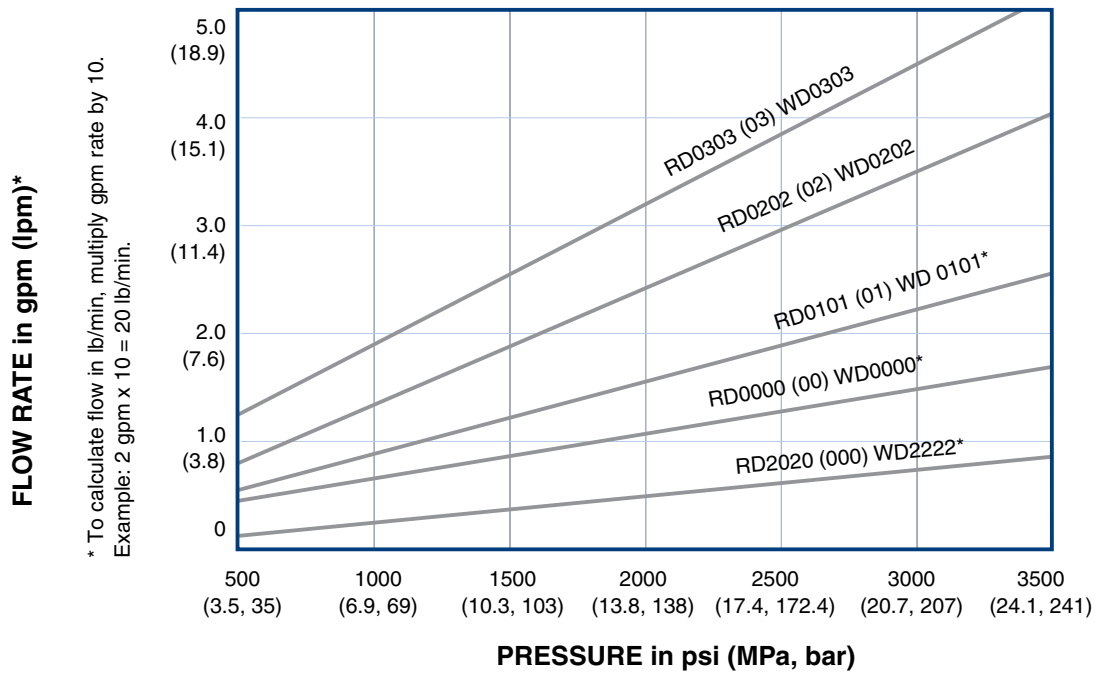
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Models/Mix Chamber Selection Guide

Round Pattern Guns

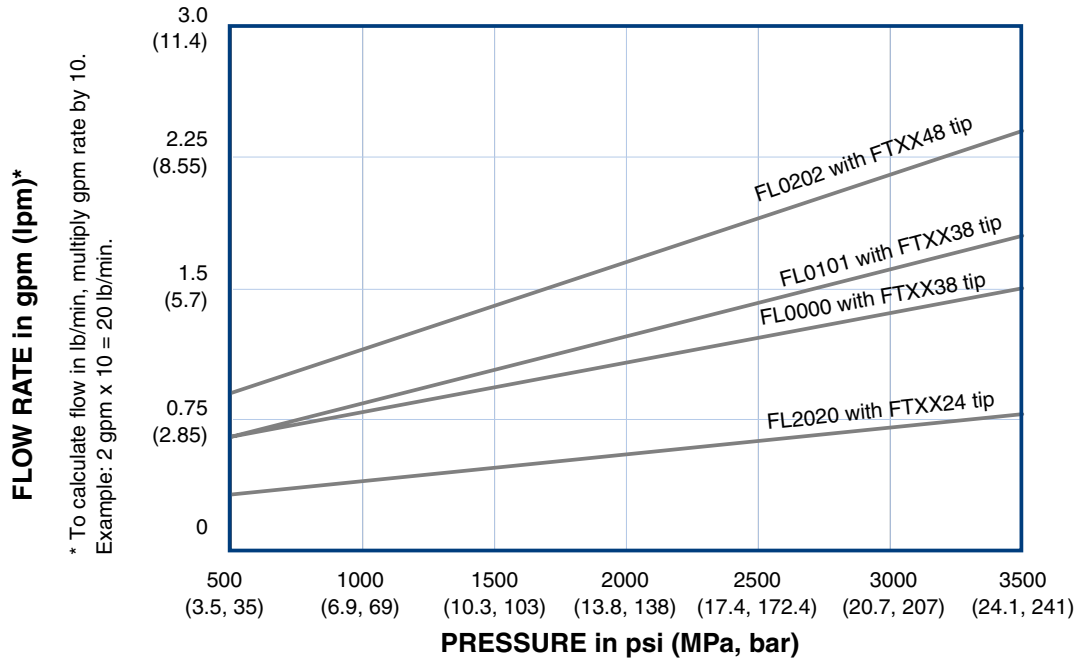
Gun Part, Series	Mix Chamber			
	Part	Impingement Port Size in. (mm)	Equivalent Size	Seal Material
CS20RD	RD2020	0.20 (0.50)	-000	SST
CS00RD	RD0000	0.029 (0.70)	-00	SST
CS01RD	RD0101	0.042 (1.00)	-01	SST
CS02RD	RD0202	0.052 (1.30)	-02	SST
CS03RD	RD0303	0.060 (1.50)	-03	SST



*Accessory WD (wide pattern) mix chambers are available. See page 47.

Flat Pattern Guns

Gun Part, Series	Mix Chamber			Flat Tip		
	Part	Impingement Port Size in. (mm)	Equivalent Size	Part No.	Pattern Size in. (mm)	Orifice Size in. (mm)
CS20F1	FL2020	0.020 (0.50)	-000	FT0424	8-10 (203-254)	0.024 (0.61)
CS20F2	FL2020	0.020 (0.50)	-000	FT0438	8-10 (203-254)	0.038 (0.97)
CS00F1	FL0000	0.029 (0.70)	-00	FT0424	8-10 (203-254)	0.024 (0.61)
CS00F2	FL0000	0.029 (0.70)	-00	FT0438	8-10 (203-254)	0.038 (0.97)
CS00F3	FL0000	0.029 (0.70)	-00	FT0624	12-14 (305-356)	0.024 (0.61)
CS00F4	FL0000	0.029 (0.70)	-00	FT0638	12-14 (305-356)	0.038 (0.97)
CS00F5	FL0000	0.029 (0.70)	-00	FT0838	16-18 (406-457)	0.038 (0.97)
CS00F6	FL0000	0.029 (0.70)	-00	FT0848	16-18 (406-457)	0.048 (1.22)
CS01F1	FL0101	0.042 (1.00)	-01	FT0424	8-10 (203-254)	0.024 (0.61)
CS01F2	FL0101	0.042 (1.00)	-01	FT0438	8-10 (203-254)	0.038 (0.97)
CS01F3	FL0101	0.042 (1.00)	-01	FT0624	12-14 (305-356)	0.024 (0.61)
CS01F4	FL0101	0.042 (1.00)	-01	FT0638	12-14 (305-356)	0.038 (0.97)
CS01F5	FL0101	0.042 (1.00)	-01	FT0838	16-18 (406-457)	0.038 (0.97)
CS01F6	FL0101	0.042 (1.00)	-01	FT0848	16-18 (406-457)	0.048 (1.22)
CS02F1	FL0202	0.052 (1.30)	-02	FT0424	8-10 (203-254)	0.024 (0.61)
CS02F2	FL0202	0.052 (1.30)	-02	FT0438	8-10 (203-254)	0.038 (0.97)
CS02F3	FL0202	0.052 (1.30)	-02	FT0624	12-14 (305-356)	0.024 (0.61)
CS02F4	FL0202	0.052 (1.30)	-02	FT0638	12-14 (305-356)	0.038 (0.97)
CS02F5	FL0202	0.052 (1.30)	-02	FT0838	16-18 (406-457)	0.038 (0.97)
CS02F6	FL0202	0.052 (1.30)	-02	FT0848	16-18 (406-457)	0.048 (1.22)








Wide Round Pattern Gun

Gun Part, Series	Mix Chamber			Pattern Diameter at 24 in. (610 mm) to Target in. (mm)	Equivalent Flow to Mix Chamber Size Reference Part No.
	Part	Impingement Port Size in. (mm)	Equivalent Size		
CS22WD	WD2222	0.022 (0.56)	N/A	8-9 (203-229)	4.5 lb/min at 1000 psi
CS00WD	WD0000	0.028 (0.71)	-00	15 (381.0)	RD0000
CS01WD	WD0101	0.039 (0.99)	-01	16 (406.4)	RD0101
CS02WD	WD0202	0.046 (1.17)	-02	18 (457.2)	RD0202
CS03WD	WD0303	0.057 (1.45)	-03	18 (457.2)	RD0303

Warnings

The following warnings are for the setup, use, grounding, maintenance, and repair of this equipment. The exclamation point symbol alerts you to a general warning and the hazard symbol refers to procedure-specific risk. Refer back to these warnings. Additional, product-specific warnings may be found throughout the body of this manual where applicable.

 WARNING	
	<p>PERSONAL PROTECTIVE EQUIPMENT</p> <p>You must wear appropriate protective equipment when operating, servicing, or when in the operating area of the equipment to help protect you from serious injury, including eye injury, inhalation of toxic fumes, burns, and hearing loss. This equipment includes but is not limited to:</p> <ul style="list-style-type: none"> • Protective eyewear • Clothing and respirator as recommended by the fluid and solvent manufacturer • Gloves • Hearing protection
	<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 MSDS's to know the specific hazards of the fluids you are using. • Store hazardous fluid in approved containers, and dispose of it according to applicable guidelines. • Always wear impervious gloves when spraying or cleaning equipment.
	<p>SKIN INJECTION HAZARD</p> <p>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.</p> <ul style="list-style-type: none"> • Do not point gun at anyone or at any part of the body. • Do not put your hand over the spray tip. • Do not stop or deflect leaks with your hand, body, glove, or rag. • Do not spray without tip guard and trigger guard installed. • Engage trigger lock when not spraying. • Follow Pressure Relief Procedure in this manual, when you stop spraying and before cleaning, checking, or servicing equipment.
	<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>

 **WARNING**
**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).
- Keep work area free of debris, including solvent, rags and gasoline.
- Do not plug or unplug power cords, or turn power or light switches on or off when flammable fumes are present.
- Ground all equipment in the work area. See **Grounding** instructions.
- Use only grounded hoses.
- Hold gun firmly to side of grounded pail when triggering into pail.
- If there is static sparking or you feel a shock, **stop operation immediately**. Do not use equipment until you identify and correct the problem.
- Keep a working fire extinguisher in the work area.

**EQUIPMENT MISUSE HAZARD**

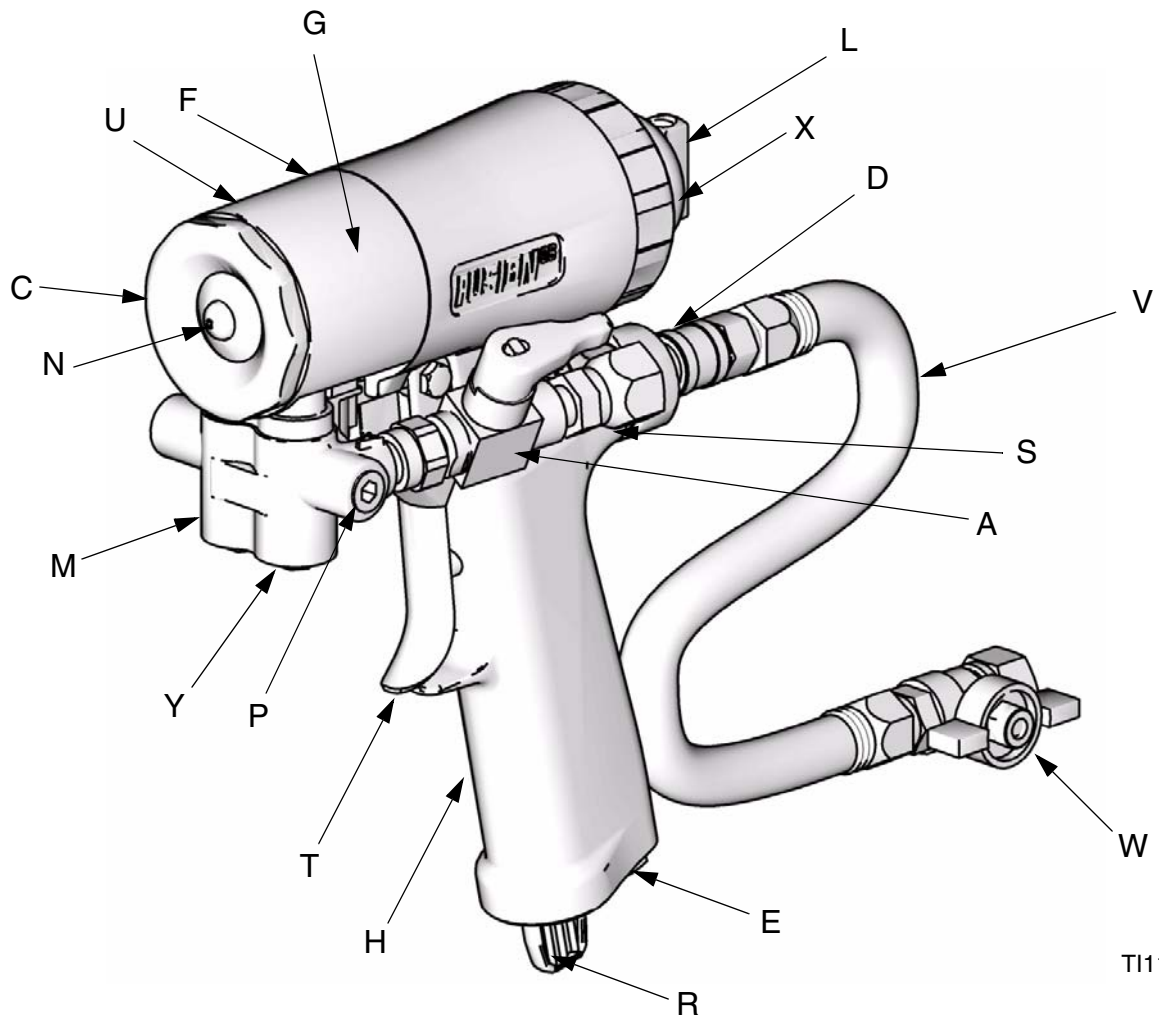
Misuse can cause death or serious injury.

- Do not operate the unit when fatigued or under the influence of drugs or alcohol.
- 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. For complete information about your material, request MSDS forms from distributor or retailer.
- Check equipment daily. Repair or replace worn or damaged parts immediately with genuine manufacturer's replacement parts only.
- Do not alter or modify equipment.
- Use equipment only for its intended purpose. Call your distributor for information.
- Route hoses and cables away from traffic areas, sharp edges, moving parts, and hot surfaces.
- Do not kink or over bend hoses or use hoses to pull equipment.
- Keep children and animals away from work area.
- Comply with all applicable safety regulations.

**PRESSURIZED ALUMINUM PARTS HAZARD**

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.

Overall View





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FIG. 1**Key:**

- | | |
|--|---|
| A A Side Fluid Valve (ISO) | R ClearShot Liquid Cartridge |
| B B Side Fluid Valve (RESIN) (not shown) | S Fluid Inlet Swivels (A Side Shown) |
| C Front Cover Retainer | T Trigger |
| D Air Line Quick Coupler | U Front Cover |
| E Breather Plug | V Gun Air Whip Hose |
| F Fluid Housing (under cover) | W Air Valve |
| G Grease Fitting (under cover) | X Variable Flow Adjustment Knob |
| H Handle | Y Manifold Check Valve/Inlet Screen Housing |
| L Piston Safety Lock/Flow Selector Knob | |
| M Gun Fluid Manifold | |
| N Mix Chamber Nozzle | |
| P Optional Fluid Inlets (A Side Shown) | |

ClearShot Liquid

					
Read material MSDS to know specific hazards and precautions related to ClearShot Liquid.					


Isocyanate Hazard

					
<p>Spraying materials containing isocyanates creates potentially harmful mists, vapors, and atomized particulates.</p> <p>Read material manufacturer's warnings and material MSDS to know specific hazards and precautions related to isocyanates.</p> <p>Prevent inhalation of isocyanate mists, vapors, and atomized particulates by providing sufficient ventilation in the work area. If sufficient ventilation is not available, a supplied-air respirator is required for everyone in the work area.</p> <p>To prevent contact with isocyanates, appropriate personal protective equipment, including chemically impermeable gloves, boots, aprons, and goggles, is also required for everyone in the work area.</p>					

Moisture Sensitivity of Isocyanates

Isocyanates (ISO) are catalysts used in two component foam and polyurea coatings. ISO will react with moisture (such as humidity) to form small, hard, abrasive crystals, which become suspended in the fluid. Eventually a film will form on the surface and the ISO will

begin to gel, increasing in viscosity. If used, this partially cured ISO will reduce performance and the life of all wetted parts.

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

To prevent exposing ISO to moisture:

- 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 lube pump reservoir filled with Graco Throat Seal Liquid (TSL), Part 206995. The lubricant creates a barrier between the ISO and the atmosphere.
- Use moisture-proof hoses specifically designed for ISO, such as those supplied with your system.
- Never use reclaimed solvents, which may contain moisture. Always keep solvent containers closed when not in use.
- Never use solvent on one side if it has been contaminated from the other side.
- Always park pumps when you shutdown.
- Always lubricate threaded parts with Part 217374 ISO pump oil or grease when reassembling.

Keep Components A and B Separate

CAUTION

To prevent cross-contamination of the equipment's wetted parts, **never** interchange component A (isocyanate) and component B (resin) parts. The gun is shipped with the A side on the left. The fluid manifold, fluid housing, side seal assembly, check valve cartridge, and mix chamber are marked on the A side.

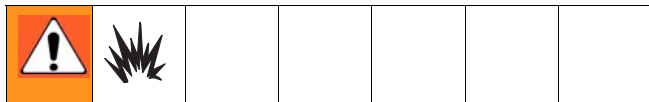
Foam Resins with 245fa Blowing Agents

New 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

- 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.
- Most materials use ISO on the A side, but some use ISO on the B side.
- Epoxies often have amines on the B (hardener) side. Polyureas often have amines on the B (resin) side.

Grounding

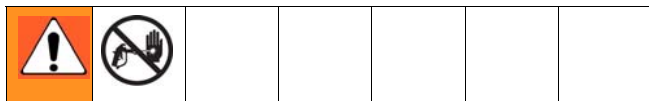


Check your local electrical code and proportioner manual for detailed grounding instructions.

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.



Engage

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

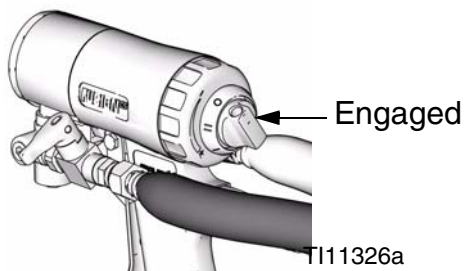


FIG. 2

Disengage

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.

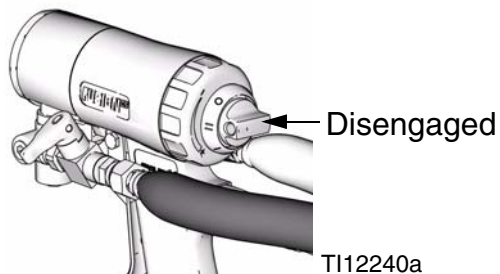
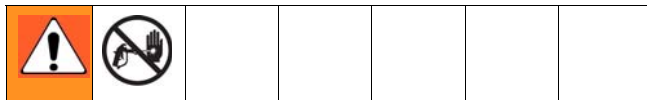
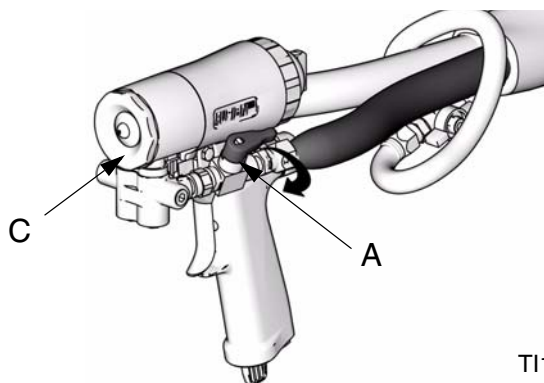


FIG. 3

Remove Front Cover



1. Follow **Pressure Relief Procedure**, page 17.
2. Ensure fluid valves A and B are closed before turning front cover retainer (C).



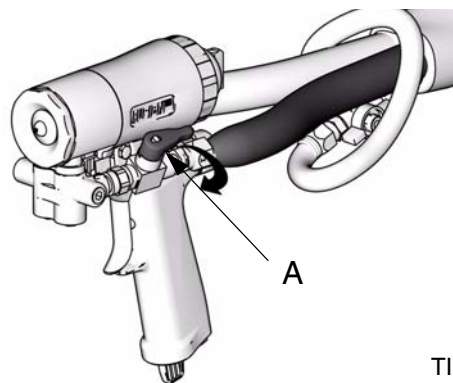
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FIG. 4

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 12.
- Close fluid valves A and B.

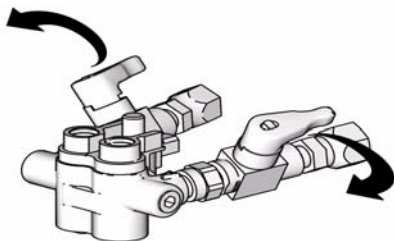


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FIG. 5

Setup

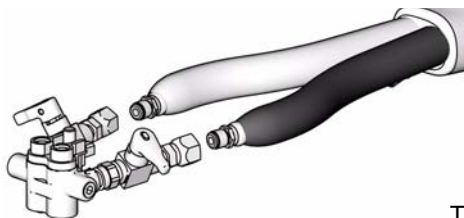
1. Close fluid valves A and B.



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FIG. 6

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

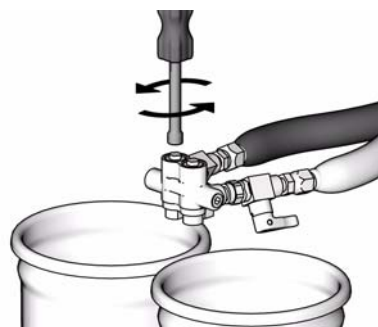


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FIG. 7

3. Purge air from fluid lines using feed pump pressure only (less than 500 psi (3.5 MPa, 35 bar)).
 - a. Ensure fluid valves are closed. Open fluid manifold check valves 2 to 2-1/2 turns.
 - b. Open fluid valves and wait for all air to bleed from fluid hoses.

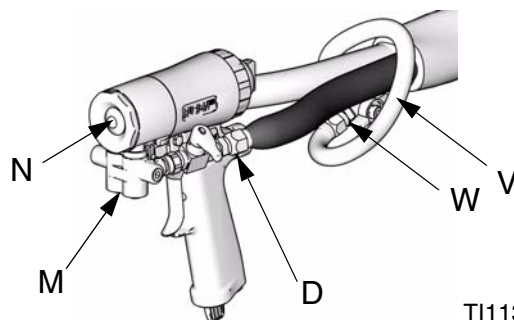
- c. Close fluid valves and retighten fluid manifold check valves.



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FIG. 8

4. Engage piston safety lock, page 12.
5. Install ClearShot Liquid cartridge. See **ClearShot Liquid Cartridge Installation/Removal**, page 22.
6. Connect gun air whip hose (V) air valve (W) to main air hose. Assemble fluid manifold (M) to gun by hand, and then tighten bolt.
7. Connect air line to quick coupler (D). Turn on air. Open air valve (W). Air should flow from nozzle (N).

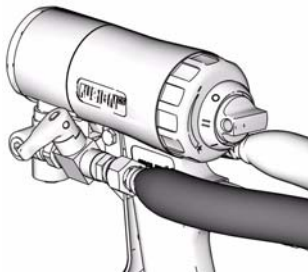


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FIG. 9

8. Apply layer of lubricant over front cover of gun and front cover retainer, or use gun cover to prevent overspray buildup and ease disassembly.

9. Disengage piston safety lock, page 12.

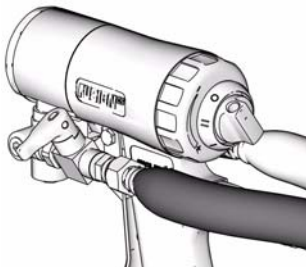


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FIG. 10

10. Trigger gun to check for full mix chamber travel and to prime ClearShot Liquid dosing pump. See **ClearShot Liquid Cartridge Installation/Removal**, page 22.

11. Engage piston safety lock, page 12.

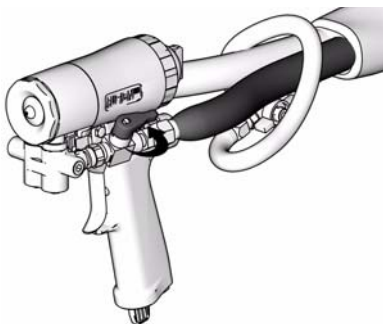


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FIG. 11

12. Turn on proportioner.

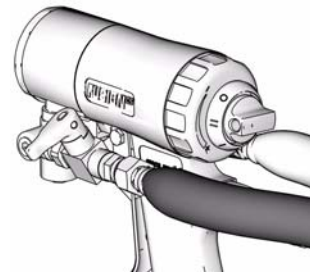
13. Open B (RESIN) fluid valve. Then open A (ISO) fluid valve.



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FIG. 12

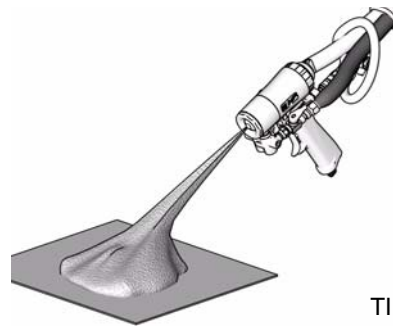
14. Disengage piston safety lock, page 12.



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FIG. 13

15. Test spray onto cardboard. Adjust pressure and temperature to get desired results.



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FIG. 14

16. The gun is now ready to spray.


CAUTION

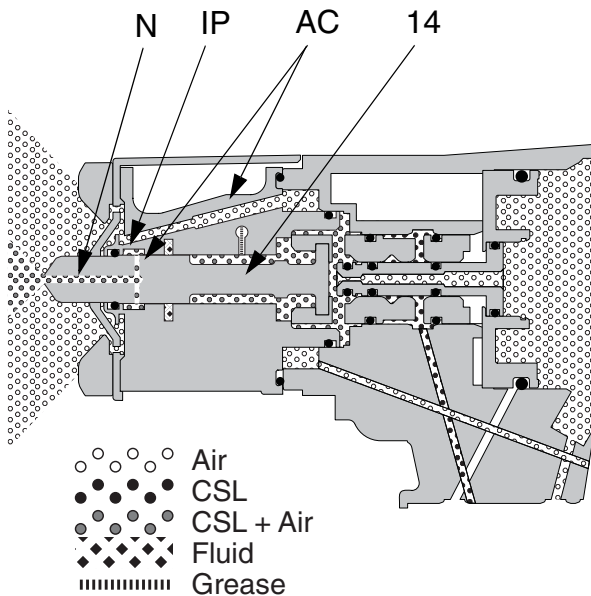
Air supply is required for gun actuation. Do not disconnect gun air supply until fluid pressure is relieved, page 17.

Shutdown

Overnight Shutdown

1. Follow **Pressure Relief Procedure**, page 17.
2. Leave air turned on and gun detriggered.

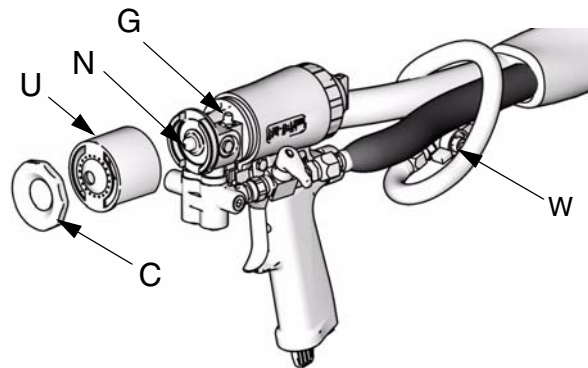
 Grease gun daily to prevent two-component curing and keep fluid passages clean. Purge air carries grease mist through air chamber (AC), impingement ports (IP), and out mix chamber nozzle (N), coating all surfaces. Use Graco 117773 grease.



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FIG. 15


3. Unscrew and remove front cover retainer (C). Remove front cover (U).
4. Using grease gun, dispense grease into fitting (G) until grease mist sprays from mix chamber nozzle (N). Do not over-grease; use two shots maximum. Do not spray grease mist on sprayed material.



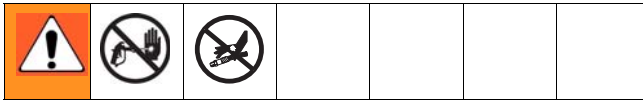
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FIG. 16

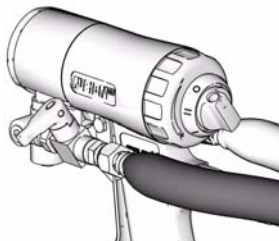
5. Replace front cover (U) and front cover retainer (C).

 Always leave a ClearShot Liquid cartridge in gun handle to prevent cartridge bore contamination.

Pressure Relief Procedure



1. Engage piston safety lock, page 12.



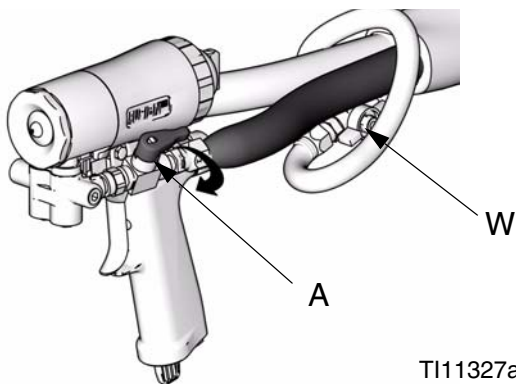
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FIG. 17

CAUTION

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

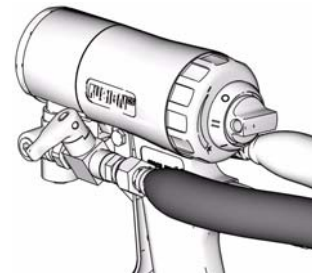
2. Close fluid valves A and B. Leave air valve (W) open.



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FIG. 18

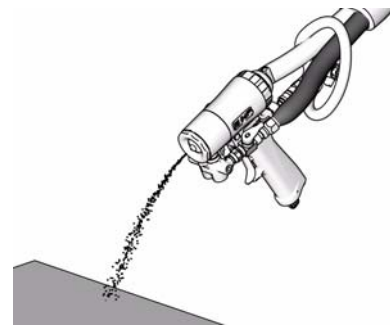
3. Disengage piston safety lock, page 12.



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FIG. 19

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



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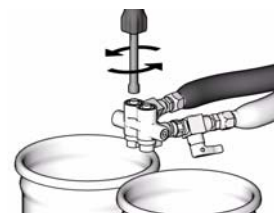
FIG. 20

5. Engage piston safety lock, page 12.



Fluid in the hose and proportioner is still under pressure. Follow the Pressure Relief Procedure in the proportioner manual.

To relieve pressure in the hose manifold after the gun is removed, place the fluid manifold over containers, facing away from you. Ensure fluid valves are closed. Very slowly open fluid manifold check valves 2 to 2-1/2 turn. Under high pressure, fluid will spray sideways from the fluid ports.



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Optional Hose Position

Fluid inlet swivel fittings point to rear. If desired, these positions can be changed so hoses point downward.

CAUTION

To prevent cross-contamination of gun's wetted parts, do not interchange A component (isocyanate) and B component (resin) parts.

1. Follow **Pressure Relief Procedure**, page 17. Also relieve system pressure, see proportioner manual.
2. Disconnect air (D) and remove fluid manifold (M).

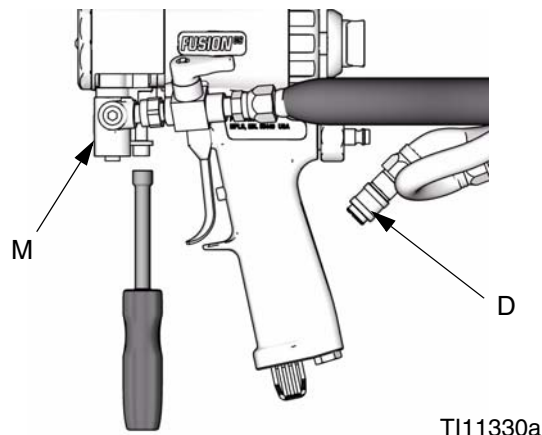


FIG. 21

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3. Disconnect fluid hoses from inlet swivels (A, B). Remove fluid valve assemblies. Remove plugs from optional inlets (P).

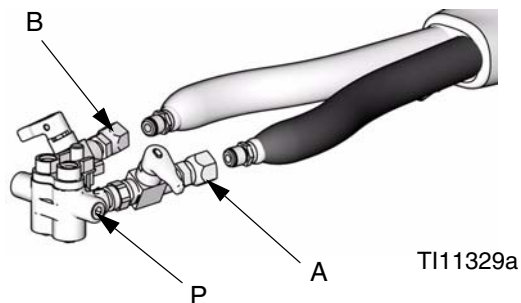


FIG. 22

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4. Apply thread sealant to plugs (1e), elbows (35), and male threads of fluid valve assemblies. Install elbows (35) in optional inlets, facing down. Install fluid valve assemblies in elbows. Be sure to install A fluid assembly in A side. Install plugs where swivels had been. Torque all parts to 235-245 in-lb (26.6-27.7 N•m).

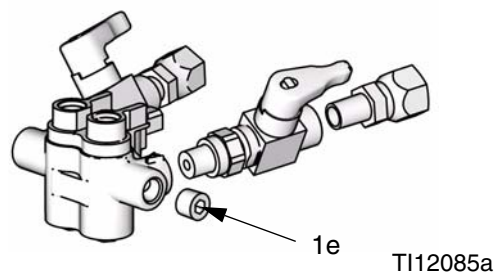


FIG. 23

5. Connect A and B hoses to A and B swivels.
6. Attach fluid manifold. Connect air. Return gun to service.

Flat Spray Tips

1. Follow **Pressure Relief Procedure**, page 17.
2. Unscrew and remove front cover retainer (C).
3. Remove front cover (U) and o-ring (2b). Inspect o-ring.
4. Remove tip retainer (46) and tip (21). Inspect o-ring (47).
5. Remove fluid housing (F). Loosen A and B side seals. Slide flat mix chamber (14) out rear of fluid housing.

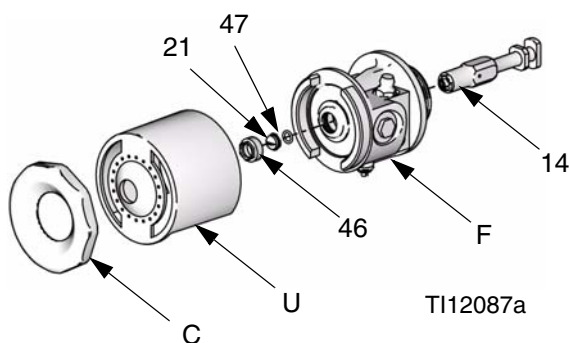



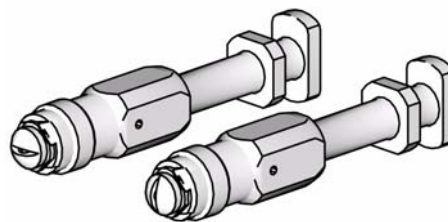
FIG. 24

 If tip is stuck, pry off with small screwdriver or pull off with pliers. Tip is hardened to resist damage.

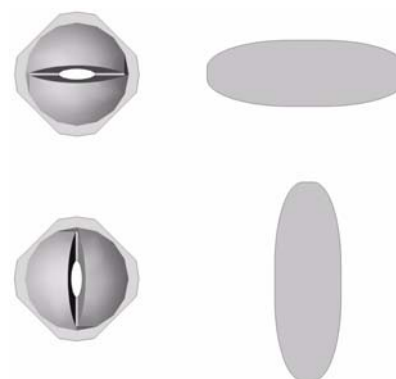
6. To clean, soak tip in compatible solvent. Clean gently with tip cleanout tool 15D234; page 54 for details of tool.
7. Reassemble in reverse order.
 - a. Insert mix chamber (14) from rear of fluid housing.
 - b. Tighten A and B side seals on fluid housing.

- c. Assemble o-ring (47), tip (21), and tip retainer (46) to front of mix chamber (14).

8. Reposition tip horizontally or vertically, or install different tip size.




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FIG. 25

 Tips marked on back with last three digits of part number. See **Flat Tip Kits**, page 48.

9. Reinstall fluid housing (F) to handle.
10. Reinstall front cover (U) and front cover retainer (C).

Variable Flow

Operation

The variable flow feature is designed to provide immediate adjustment between a full flow pattern (determined by mix chamber size) and a user defined reduced flow pattern.

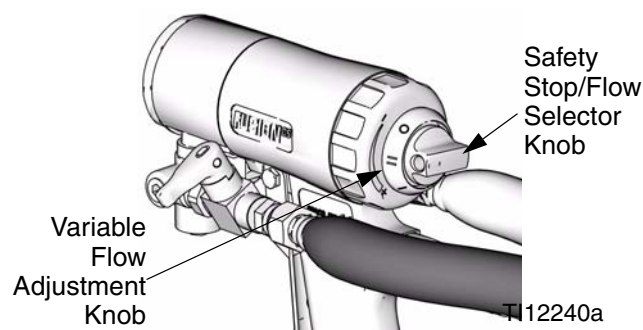


FIG. 26

Reduced Flow

To spray a reduced flow pattern, push in and turn flow selector knob to variable flow position. See FIG. 27.

Full Flow

To return to a full flow pattern, push in and turn flow selector knob to full flow position. See FIG. 27.

Adjustment

1. Follow **Pressure Relief Procedure**, page 17.
2. Turn flow selector knob to variable flow position. See FIG. 27.
3. Turn air valve (W) OFF.

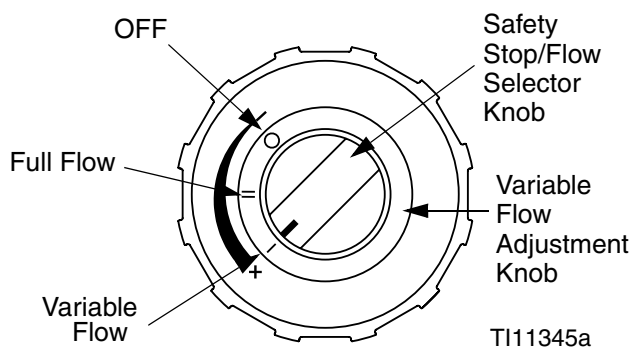


FIG. 27

4. To increase variable flow: push in and turn variable flow knob counterclockwise.

To decrease variable flow: push in and turn variable flow knob clockwise.

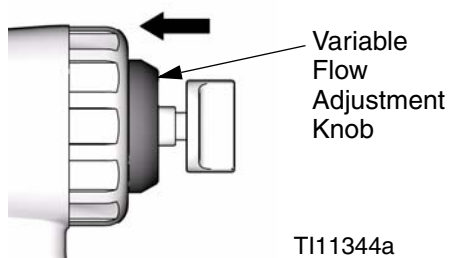



FIG. 28

 The variable flow adjustment knob cannot be adjusted when the flow selector knob is in the safety stop position. See FIG. 27.

The variable flow adjustment knob locks into detents every 15°. Ensure knob is locked into a detent before proceeding to step 5.

5. Turn air valve ON, and open fluid valves. Verify that flow selector knob is set to the variable flow position. See FIG. 27.
6. Test spray pattern on cardboard. Repeat steps 1 through 6 until desired spray pattern is reached.

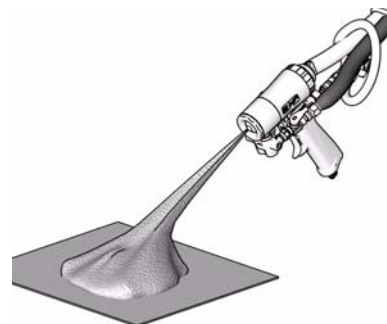




FIG. 29

ClearShot Liquid Cartridge Installation/Removal

 If ClearShot Liquid cartridge removal or installation is difficult, lubricate cartridge o-rings and/or cartridge bore with a few drops of ClearShot Liquid. Water-based lubricants can be used as well.

 Do not use Fusion grease or other petroleum- or vegetable-based lubricants. They will cause cartridge o-rings to swell and stick inside gun handle.

Installation

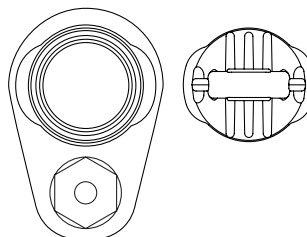
1. Follow **Pressure Relief Procedure**, page 17.
2. Remove plastic cap from new ClearShot Liquid cartridge.



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FIG. 30

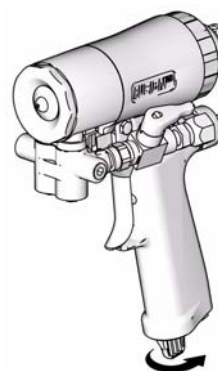
3. Insert cartridge into gun handle. Ensure cartridge tabs are aligned correctly with cartridge tab recesses in gun handle.



TI113341a

FIG. 31

4. After cartridge is fully inserted, turn cartridge 1/4 turn clockwise to lock it into gun handle.



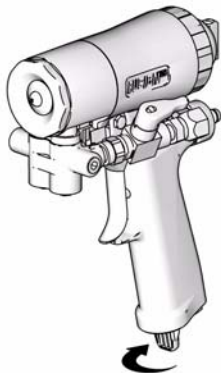
TI113342a

FIG. 32

5. Turn air valve ON and prime ClearShot Liquid dosing pump.
 - a. Trigger gun 20 times to prime dosing pump.
 - b. Trigger gun onto cardboard to see dosed ClearShot Liquid.
6. Resume spraying.

Removal

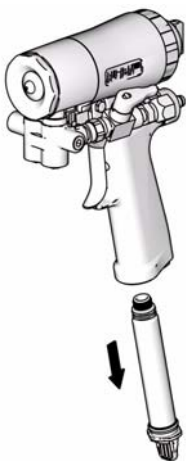
1. Follow **Pressure Relief Procedure**, page 17.
2. Turn air valve (W) OFF.
3. Push in and turn cartridge 1/4 turn counter-clockwise (viewed from bottom).



TI11338a

FIG. 33

4. Pull cartridge out of gun handle.



TI11339a

FIG. 34

Troubleshooting

For ClearShot Liquid cartridge troubleshooting, see **Troubleshooting** on page 29.

Maintenance

Supplied Tool Kit

- Hex Nut Driver; 5/16
- Screwdriver; 1/8 blade
- Nozzle Drill Bit; various sizes depending on nozzle size. See Table 1.
- Impingement Port Drill Bit; various sizes depending on port size. See Table 3.
- 117661 Pin Vise; dual reversible chucks



FIG. 35

- 551189 Grease Gun; with 3 oz grease
- 15B817 Flush Manifold

Keep Gun Clean

Keep gun clean with accessory gun cover, page 53.

Applying a light coat of lubricant will make cleaning easier.

As Needed

1. **Clean Outside of Gun**, page 25.
2. **Clean Mix Chamber Nozzle**, page 26, a minimum of once a day.
3. **Clean Breather Plug**, page 25.
4. **Clean Fluid Manifold**, page 25.
5. **Clean Passages**, page 27.
6. **Clean Impingement Ports**, page 27.

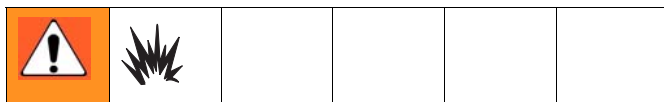
Daily

Follow **Shutdown**, page 16.


Weekly to Monthly

1. Clean **Mix Chamber and Side Seal Assemblies**, page 36. Check o-rings.
2. Clean **Check Valves**, page 38. Check o-rings and filters.

Flush Gun



1. Follow **Pressure Relief Procedure**, page 17.
2. Flush with compatible solvent into a grounded metal pail, holding a metal part of fluid manifold firmly to side of pail. Use lowest possible fluid pressure when flushing.
3. Follow **Pressure Relief Procedure**, page 17.

 For a more thorough flush, Solvent Flush Kit 218669 is available as an accessory. The kit connects to Flush Manifold 15B817.

Clean Outside of Gun

Wipe off outside of gun with compatible solvent. Use N-Methylpyrrolidone (NMP), Dynasolve CU-6, Dzolv, or an equivalent to soften cured material.

CAUTION

These solvents are not recommended for flushing; use only for cleaning.

Clean or Replace Front Cover and Retainer

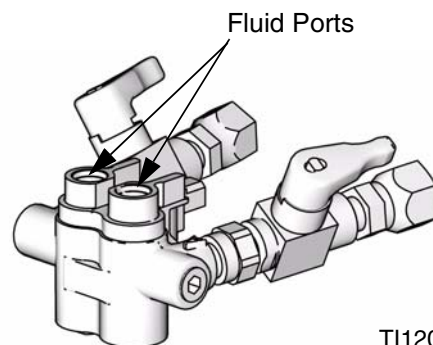
Soak front cover retainer (C) and front cover (U) in compatible solvent. Brush or wipe clean. Replace as needed.

Clean Breather Plug

Remove and clean breather plug with compatible solvent.

Clean Fluid Manifold

Clean fluid manifold fluid ports with compatible solvent and brush whenever removed from gun. Do not damage the internal sealing surfaces. Fill fluid ports with grease if left exposed, to seal out moisture.

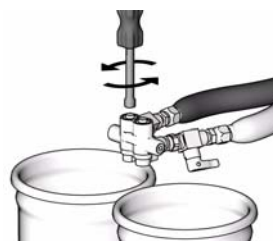


TI12089a

FIG. 36:

Clean or Replace Fluid Screens

1. Follow **Pressure Relief Procedure**, page 17.
2. Relieve pressure in hose manifold after gun is removed.
 - a. Place the fluid manifold over containers, facing away from you.
 - b. Ensure fluid valves are closed.
 - c. Very slowly open fluid manifold check valves 2 to 2-1/2 turn. Under high pressure, fluid will spray sideways from the fluid ports.



TI11337a

FIG. 37

- 3. Remove fluid screens by unthreading them from fluid manifold.

CAUTION

To prevent cross-contamination of the check valves, do not interchange A component and B component parts. The A component check valve is marked with an A.

- 4. Clean or replace fluid screens. See **Accessories**, page 53.
- 5. Carefully inspect o-rings and fluid screen surfaces. Replace if worn or damaged.
- 6. Liberally lubricate o-rings and reassemble. Use a hex nut driver to tighten.

Clean Mix Chamber Nozzle

- 1. Engage piston safety lock, page 12.

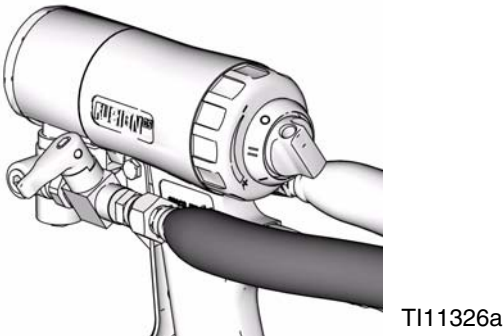


FIG. 38

- 2. Refer to Table 1. Also see identification chart under **Drill Bit Kits**, page 51. Use appropriate size drill bit to clean mix chamber nozzle (N).

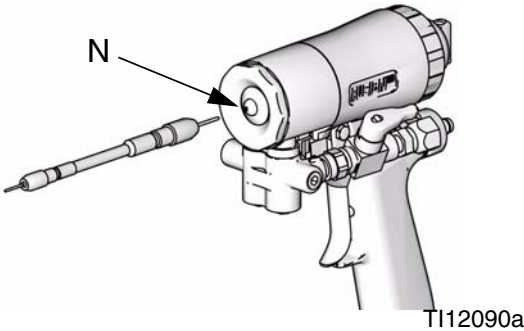


FIG. 39

Table 1: Nozzle Drill Bit Sizes

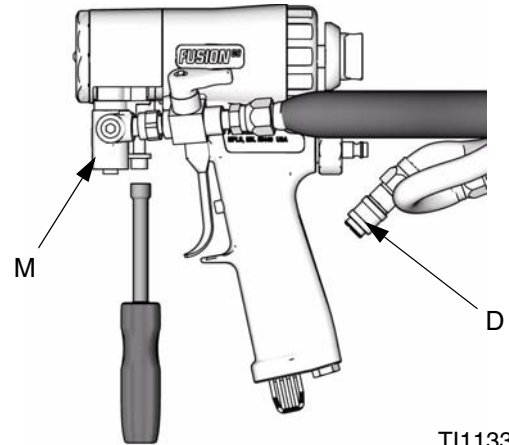
Round Spray		Flat Spray	
Mix Chamber	Drill Size in. (mm)	Mix Chamber	Drill Size in. (mm)
RD2020	#58, .042 (1.00)	FL2020	3/32, .094 (2.35)
RD0000	#55, .052 (1.30)	FL0000	3/32, .094 (2.35)
RD0101	#53, .060 (1.50)	FL0101	3/32, .094 (2.35)
RD0202	#50, .070 (1.75)	FL0202	3/32, .094 (2.35)
RD0303	#44, .086 (2.15)		

Clean Passages

If necessary, clean out passages in fluid housing and handle with drill bits. All drill bits are available in an accessory kit. Order kit 256526 for ClearShot Handle Drill Kit; see **Accessories**, page 53.

Clean Impingement Ports

1. Follow **Pressure Relief Procedure**, page 17.
2. Disconnect air (D) and remove fluid manifold (M).




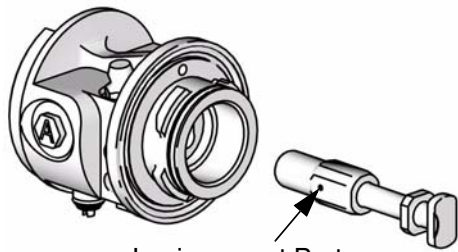
TI11330a

FIG. 40

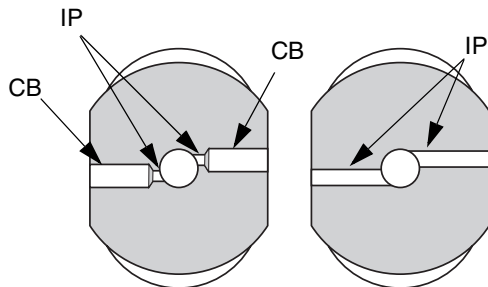
3. **Flush Gun**, page 25. If gun will not flush, see **Mix Chamber and Side Seal Assemblies**, page 36.
4. **Remove Front End**, page 34.

5. Loosen A and B side seals two turns.
6. Pull out mix chamber from back of fluid. See Table 2 for appropriate size drill to clean ports. Also see identification chart under **Drill Bit Kits**, page 51.

 Some mix chambers have counter bored holes and require two drill sizes to clean impingement ports completely.



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Mix Chambers RD and
FL, 2020 and 2929

Mix Chambers RD and FL,
4242 or larger

FIG. 41**Table 2: Impingement Port Drill Bit Sizes**

Mix Chamber	Impingement Port (IP) Drill Bit Size in. (mm)	Counter-bore (CB) Drill Bit Size in. (mm)
RD2020	#76, .020 (0.50)	#53, .060 (1.50)
RD0000	#69, .029 (0.70)	#53, .060 (1.50)
RD0101	#58, .042 (1.00)	N/A
RD0202	#55, .052 (1.30)	N/A
RD0303	#53, .060 (1.50)	N/A
FL2020	#76, .020 (0.50)	#53, .060 (1.50)
FL0000	#69, .029 (0.70)	#53, .060 (1.50)
FL0101	#58, .042 (1.00)	N/A
FL0202	#55, .052 (1.30)	N/A

7. Push mix chamber back into position.
8. Tighten A and B side seals.
9. **Attach Front End**, page 35.
10. Attach fluid manifold (M). Connect air (D). Return gun to service.

Troubleshooting

1. Follow **Pressure Relief Procedure**, page 17, before checking or repairing gun.
2. Check all possible problems and causes before disassembling gun.

CAUTION

To prevent cross-contamination of gun's wetted parts, do not interchange A component (isocyanate) and B component (resin) parts.

PROBLEM	CAUSE	SOLUTION
Gun does not fully actuate when triggered.	Safety lock engaged.	Disengage piston safety lock. See Piston Safety Lock , page 12.
	Plugged breather plug (9).	Clean Breather Plug , page 25.
	Damaged air valve o-rings (15).	Replace. See Air Valve , page 40.
Fluid does not spray when gun is fully actuated.	Closed fluid valves (1b).	Open.
	Plugged impingement ports.	Clean Impingement Ports , page 27.
	Plugged check valves (44,45).	Clean. See Check Valves , page 38.
Gun actuates slowly.	Plugged breather plug (9).	Clean Breather Plug , page 25.
	Damaged piston o-rings (4a, 4c).	Replace. See Piston , page 39.
	Dirty air valve, or damaged o-rings (15).	Clean air valve or replace o-rings. See Air Valve , page 40.
Gun delays, then actuates abruptly.	Cured material around side seals (42, 43).	Inspect side seals (42c) and mix chamber (14) for scratches. Replace; see Mix Chamber and Side Seal Assemblies , page 36.
Loss of round pattern.	Dirty mix chamber (14) nozzle.	Clean Mix Chamber Nozzle , page 26.
	Empty ClearShot Liquid cartridge.	Replace. See ClearShot Liquid Cartridge Installation/Removal , page 22.
	Dosing pump is not primed.	Prime dosing pump. See ClearShot Liquid Cartridge Installation/Removal , page 22.
Loss of flat pattern.	Plugged spray tip.	Clean in compatible solvent.
	Worn tip.	Replace. See Flat Spray Tips , page 19.
	Empty ClearShot Liquid cartridge.	Replace. See ClearShot Liquid Cartridge Installation/Removal , page 22.
	Dirty mix chamber (14) nozzle.	Clean Mix Chamber Nozzle , page 26.

PROBLEM	CAUSE	SOLUTION
Leakage between flat tip and mix chamber.	Tip not seated properly.	Reassemble. See Flat Spray Tips , page 19.
	Damaged/missing o-ring (47).	Replace. See Flat Spray Tips , page 19.
Pressure imbalance.	Plugged impingement ports.	Clean Impingement Ports , page 27.
	Plugged check valves (44, 45).	Clean. See Check Valves , page 38.
	Viscosities not equal.	Adjust temperature to compensate.
	Plugged fluid screens.	Clean. See Clean or Replace Fluid Screens , page 25.
A and/or B fluid in gun air section.	Damaged side seals (42, 43).	Replace. See Mix Chamber and Side Seal Assemblies , page 36.
	Damaged mix chamber (14).	Replace. See Mix Chamber and Side Seal Assemblies , page 36.
	Damaged side seal o-rings (42d, 42e).	Replace. See Mix Chamber and Side Seal Assemblies , page 36.
	Tightened flat tip retainer with fluid valves (1b) open.	Close valves first.
Fluid mist from mix chamber.	Damaged side seals (42, 43).	Replace. See Mix Chamber and Side Seal Assemblies , page 36.
	Damaged side seal o-rings (42d, 42e).	Replace. See Mix Chamber and Side Seal Assemblies , page 36.
	Damaged mix chamber (14).	Replace. See Mix Chamber and Side Seal Assemblies , page 36.
	Dosed ClearShot Liquid normal.	No action required.
Rapid buildup of material on air cap.	Plugged front cover holes.	Clean or Replace Front Cover and Retainer , page 25.
	Damaged/missing fluid housing o-ring (2b or 2c).	Replace. See Parts , page 41.
	Damaged front o-ring (2b).	Replace. See Parts , page 41.
Reduced cleanoff air.	Damaged fluid housing o-ring (2d).	Replace. See Parts , page 41.
Excessive purge air when fluid valves are closed and gun is de-triggered.	Damaged/missing fluid housing o-ring (2c).	Replace. See Parts , page 41.
Fluid does not shut off when fluid valves are closed.	Damaged fluid valves (1b).	Replace. See Parts , page 41.
Burst of air from muffler when gun is triggered.	Normal.	No action required.


PROBLEM	CAUSE	SOLUTION
Steady air leakage from muffler.	Damaged air valve o-rings (4d).	Replace. See Air Valve , page 40.
	Damaged piston o-rings (4a, 4c).	Replace. See Piston , page 39.
Air leakage from front air valve.	Damaged air valve o-rings (4d).	Replace. See Air Valve , page 40.
Air leak between handle and fluid housing	Damaged o-ring (2c or 2d).	Replace. See Parts , page 41.
Cannot tighten front cover retainer (20) until it bottoms out.	Installing round mix chamber front cover on a flat tip gun.	Inspect front cover for flat tips 296416 and for round tips 296414.
Gun does not dose ClearShot Liquid.	Empty ClearShot Liquid cartridge.	Replace. See ClearShot Liquid Cartridge Installation/Removal , page 22.
	Dosing pump is not primed.	Prime dosing pump. See ClearShot Liquid Cartridge Installation/Removal , page 22.
	Damaged cartridge o-rings.	Replace. See ClearShot Liquid Cartridge Installation/Removal , page 22.
	Damaged or cracked cartridge.	Replace. See ClearShot Liquid Cartridge Installation/Removal , page 22.
	Damaged dosing piston.	Repair. See Piston , page 39.
ClearShot Liquid cartridge installation or removal is difficult.	Friction between cartridge o-rings and cartridge bore.	Lubricate cartridge o-rings and/or cartridge bore with a few drops of ClearShot Liquid. See ClearShot Liquid Cartridge Installation/Removal , page 22.
ClearShot Liquid cartridge is pressure locked in cartridge bore.	Cartridge is empty. Temporary cartridge pressure lock.	Engage piston safety lock and trigger gun 20 times to bleed pressure in cartridge. See ClearShot Liquid Cartridge Installation/Removal , page 22.

Theory of Operation

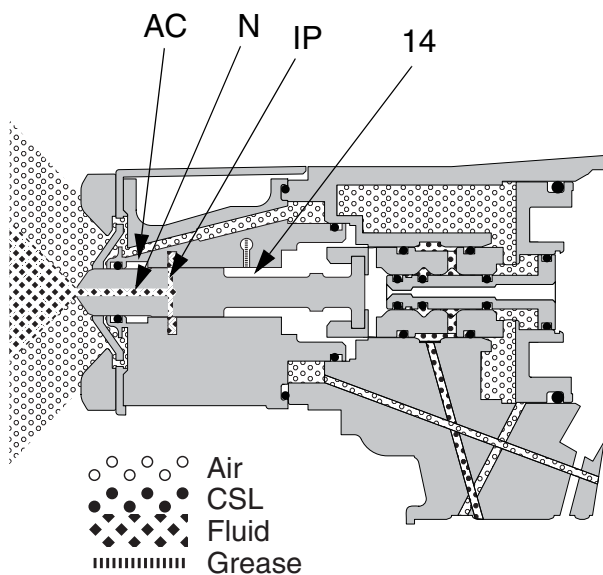
Gun Triggered (Fluid Spraying)

Mix chamber (14) moves back, shutting off purge air flow. Impingement ports (IP) align with fluid ports of side seals (42, 43), allowing fluid to flow through mix chamber nozzle (N).

See **Setup** (page 14) to adjust cleanoff air valve (K).

 Flow paths are not shown to scale, for clarity.

CSL is dosed into purge air.




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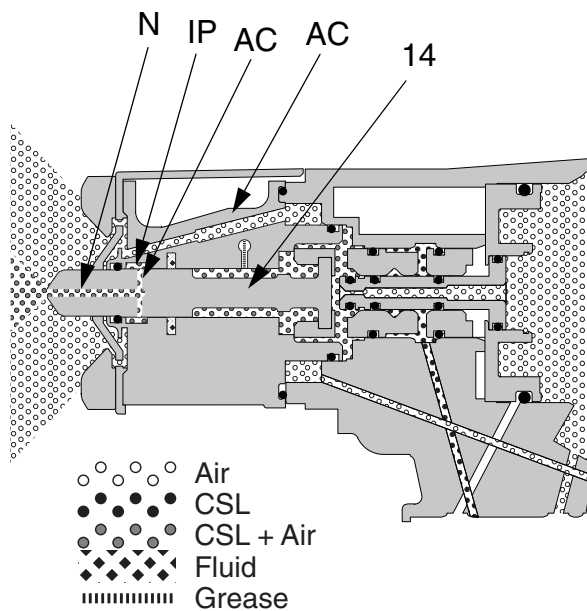
Gun Detriggered (Air Purging)

Mix chamber (14) moves forward, shutting off fluid flow. Impingement ports (IP) open to air chamber (AC), allowing purge air to flow through mix chamber nozzle (N).

See **Shutdown** (page 16) for use of grease fitting (G).

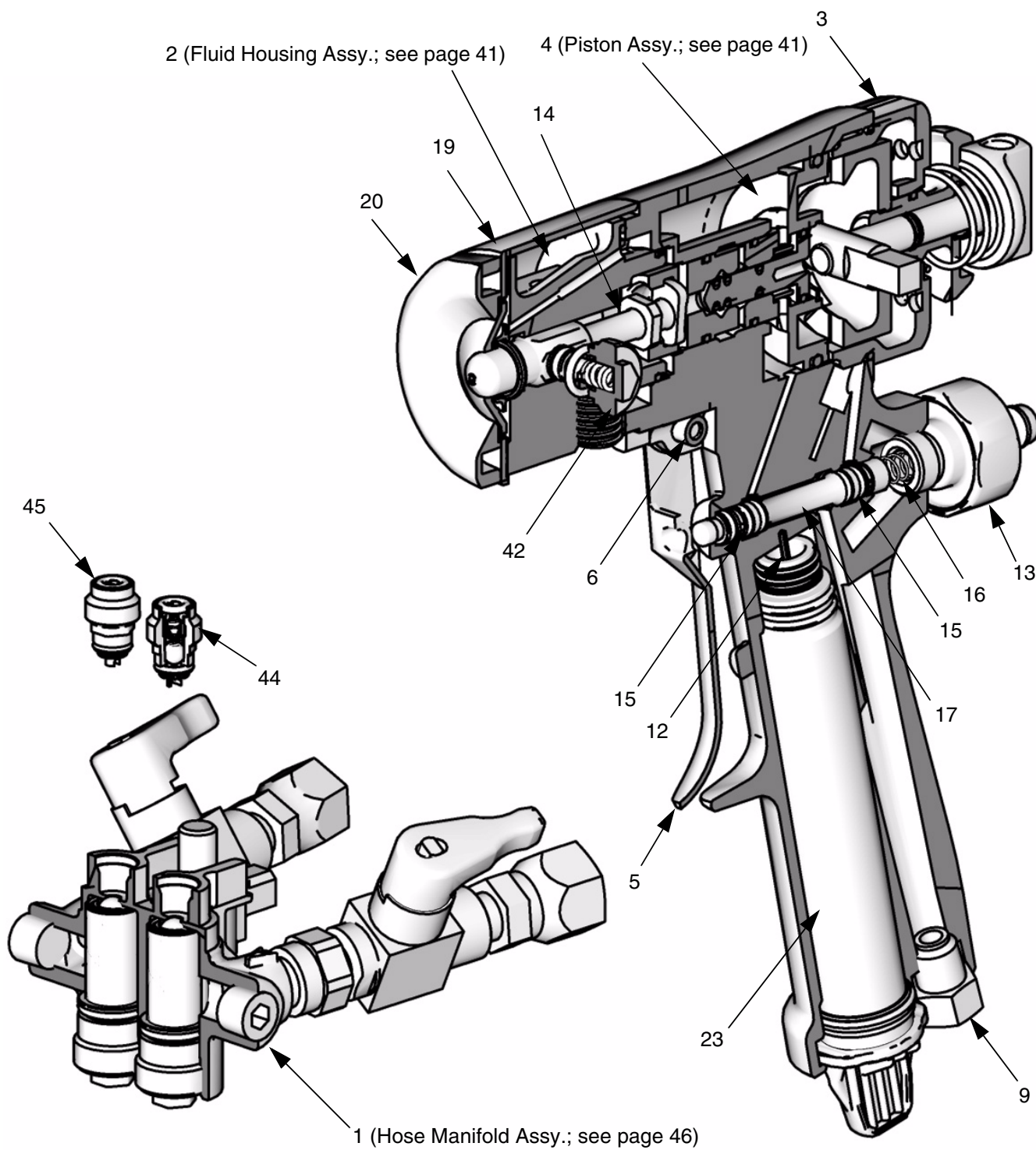
 Flow paths are not shown to scale, for clarity.

CSL is dosed into purge air.



TI12124a

Cutaway View



T112091a

Repair


Tools Required

Tools required to complete gun repair procedures:

- adjustable wrench
- flat head screwdriver (included)
- 5/16 hex nut driver (included)

Lubrication

See page 53 to order lubricant. Liberally lubricate all o-rings, seals, and threads.

 Do not lubricate o-ring, seals, and threads on ClearShot Liquid cartridge.

Remove Front End



Proper attachment of front end is critical. Do not operate gun if front end is loose or not snug against handle.

1. Follow **Pressure Relief Procedure**, page page 17.
2. **Flush Gun**, page 25.

CAUTION

If front cover retainer (C) and front cover (U) are stuck due to material buildup, do not force it by turning entire front end. Soak front of gun in solvent to soften cured material and free front cover and front cover retainer.

3. Use hex nut driver to remove fluid manifold (M).

4. Unscrew and remove front cover retainer (C).
5. Remove front cover (U).

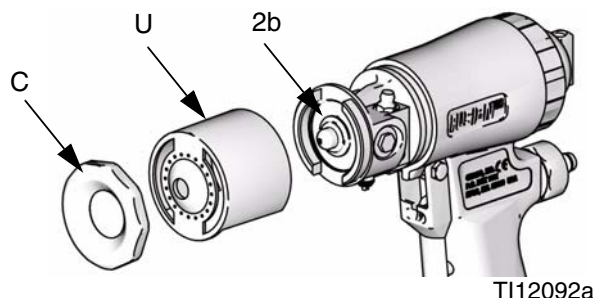


FIG. 42

6. Turn fluid housing (F) 1/4 turn counter-clockwise to disengage slots. Remove fluid housing.

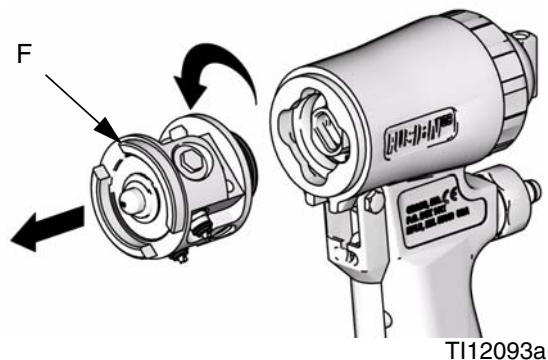
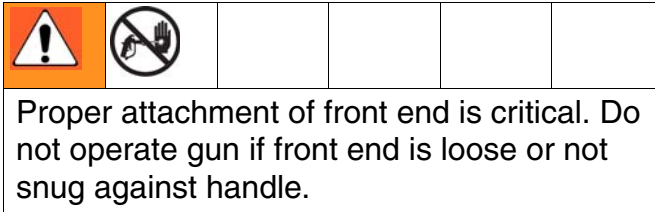


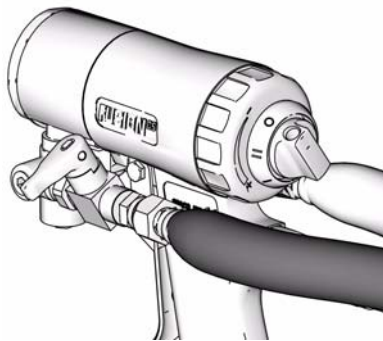
FIG. 43

7. Inspect fluid housing o-rings for wear or damage. Replace if necessary.

Attach Front End



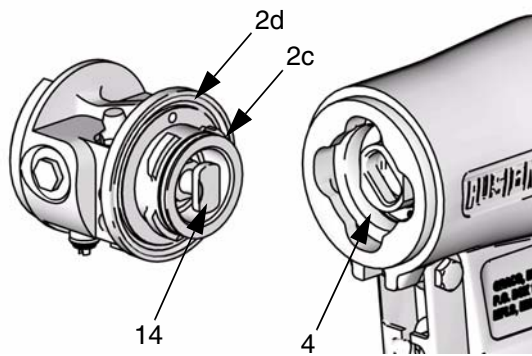
1. Engage piston safety lock, page 12.



TI11326a

FIG. 44

2. Liberally lubricate o-rings (2c, 2d) and reassemble on fluid housing. Insert keyed end of mix chamber (14) in socket of piston assembly (4).



TI12129a

FIG. 45

3. Push fluid housing (F) flush to handle.

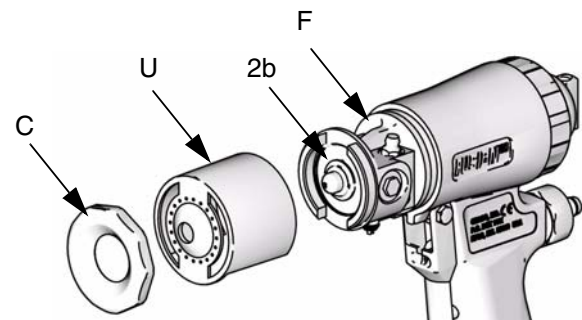
4. Turn fluid housing 1/4 turn clockwise to engage slots.



TI12094a

FIG. 46

5. Replace front cover (U).
6. Screw on front cover retainer (C).



TI12092a

FIG. 47

Mix Chamber and Side Seal Assemblies

See **Models/Mix Chamber Selection Guide**, page 4, for available mix chamber sizes.

1. Follow **Pressure Relief Procedure**, page 17.
2. Remove fluid manifold (M). Leave air connected.

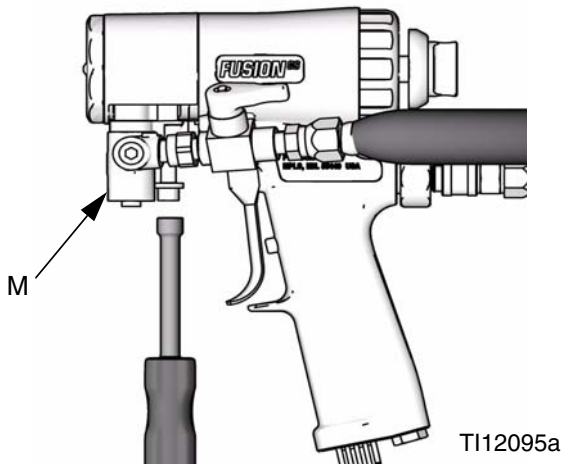


FIG. 48

3. Flush gun to remove residual A and B components. See **Flush Gun**, page 25. Follow **Pressure Relief Procedure**, page 17.
4. Disconnect air (D).

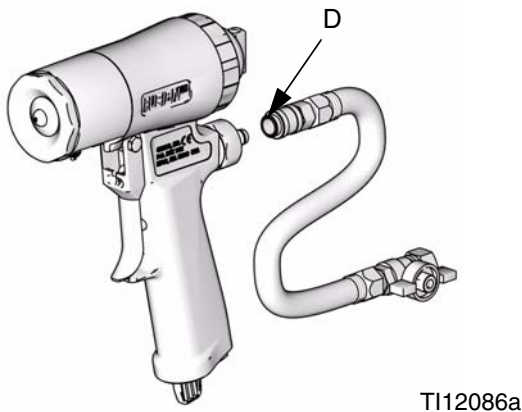


FIG. 49

5. Remove Front End, page 34.

CAUTION

To prevent cross-contamination of side seal assemblies, do not interchange A component and B component parts. The A component assembly is marked with an A.

6. Use hex nut driver to remove side seal assemblies (42, 43).

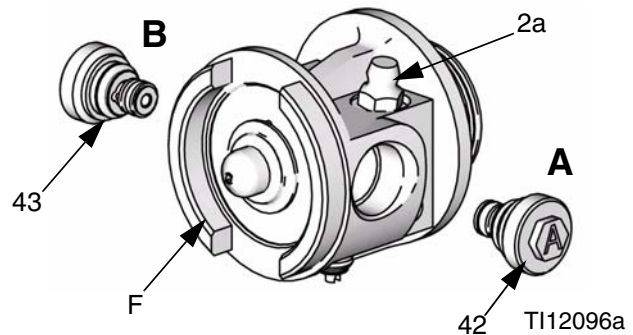


FIG. 50

7. Push on front of mix chamber (14) to loosen. Pull mix chamber out rear of fluid housing (F). Inspect for damage and **Clean Impingement Ports**, page 27.

CAUTION

To prevent cross-contamination of the gun's wetted parts, mix chamber is marked with an A and a notch on back edge. Be sure the A side of mix chamber is on the A side of gun.

8. Apply thin coat of lubricant to mix chamber (14). Install mix chamber. Etched **A** and notch must be on same side as **A** on fluid housing. Mix chamber is keyed to fit in fluid housing.

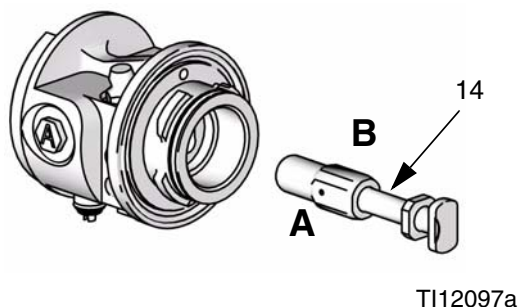


FIG. 51

CAUTION

To prevent cross-contamination of side seal assemblies, do not interchange A component and B component parts. The A component assembly is marked with an A.

9. Push down on seal housing (42a) and turn so side seal detents unlock and remove.
10. Carefully inspect side seal assembly o-rings and surfaces. Replace worn or damaged parts. Liberally lubricate o-rings (42d, 42e) and reassemble.
11. Line up tabs on seal (42c) and seal housing (42a). Push down on seal and turn to lock in place. Check proper spring (42b) operation.

Seal (42c) should rotate slightly in seal housing (42a).

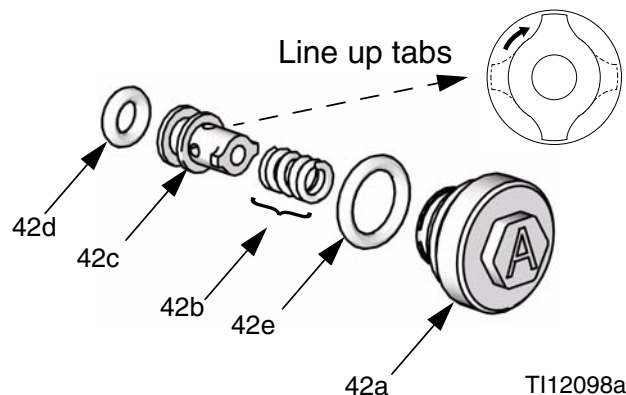


FIG. 52

12. Liberally lubricate and reinstall side seal assemblies (42, 43). Use hex nut driver to tighten.

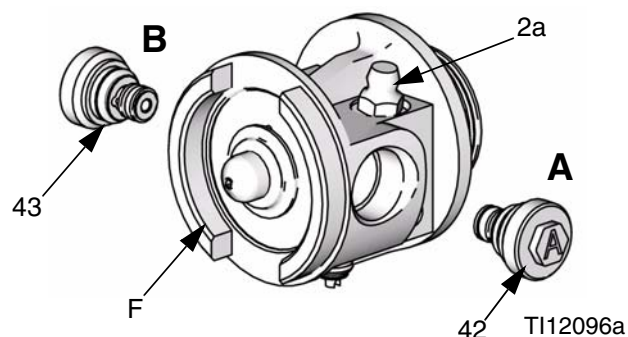


FIG. 53

13. **Attach Front End**, page 35.

14. Connect air, and trigger the gun a few times to check for leaks. If purge air leaks from mix chamber nozzle when gun is triggered, inspect mix chamber and side seals. Correct the problem before attaching fluid manifold.

15. Attach fluid manifold (F). Connect air. Return gun to service.

Check Valves

1. Follow **Pressure Relief Procedure**, page 17.
2. Remove fluid manifold (M). Leave air connected. **Clean Fluid Manifold**, page 25.

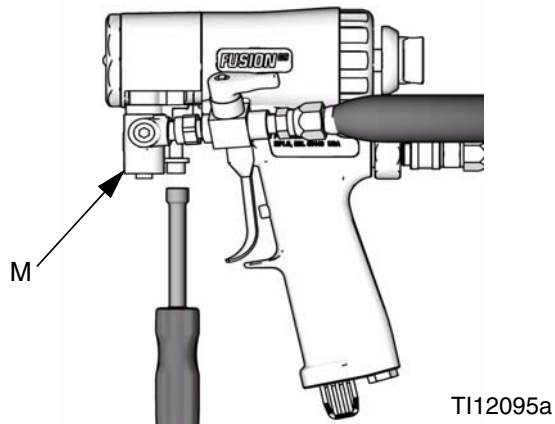


FIG. 54

3. Flush gun to remove residual A and B components. See **Flush Gun**, page 25. Follow **Pressure Relief Procedure**, page 17.
4. Disconnect air (D).

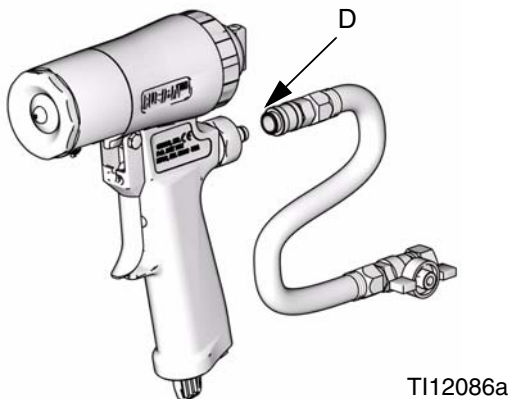


FIG. 55

CAUTION

To prevent cross-contamination of the check valves, do not interchange A component and B component parts. The A component check valve is marked with an A.

5. Use hex nut driver to remove check valves (44, 45).

CAUTION

Damaged check valve o-rings (44e, 44f) may result in external leakage. Replace o-rings if they are damaged.

6. Clean and inspect all parts. Thoroughly inspect o-rings (44e, 44f). Press on ball (44b) to test check valve for proper movement and spring action. Replace check valves if necessary. Check valves are non-serviceable.

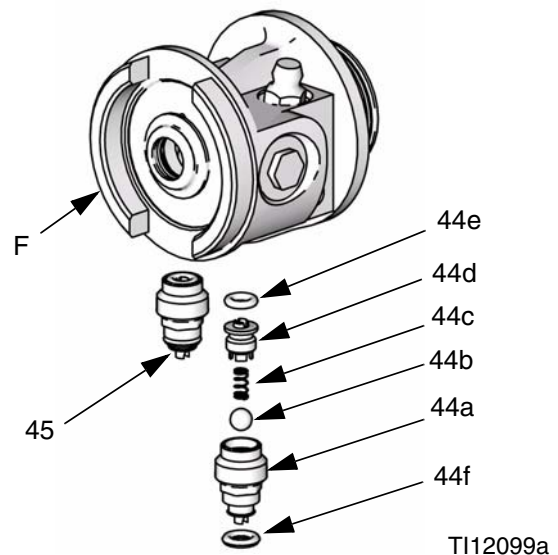


FIG. 56

7. Liberally lubricate o-rings (44e, 44f) and carefully reinstall in fluid housing (F). Use hex nut driver to tighten.
8. Attach fluid manifold (M). Connect air (D). Return gun to service.

Piston

1. Follow **Pressure Relief Procedure**, page 17
2. Disconnect air (D) and remove fluid manifold (M).

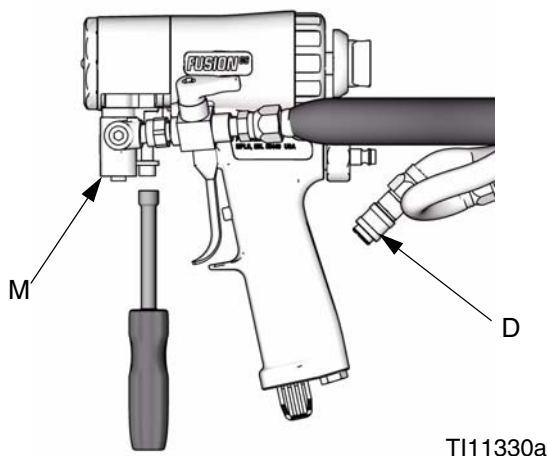


FIG. 57

3. **Remove Front End**, page 34.
4. Unscrew variable flow adjustment knob (X) and inspect o-ring (3a).

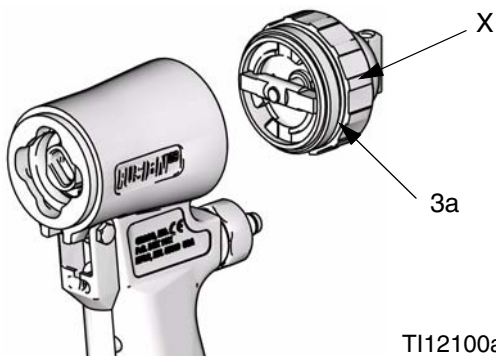


FIG. 58

5. Push piston shaft to remove piston (4b). Inspect piston o-ring (4c) and shaft o-rings (4a).

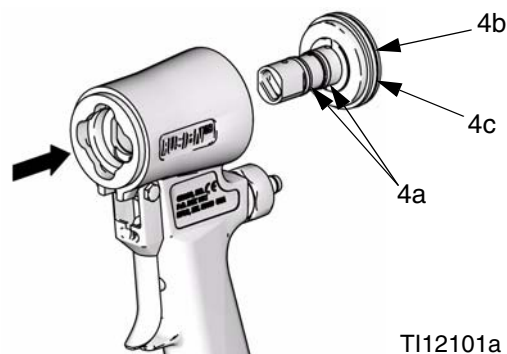
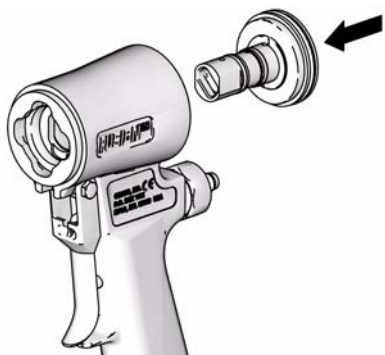


FIG. 59

6. Remove dosing piston.
 - a. Use supplied screw driver to remove spiral retaining ring (4g).
 - b. Use screw driver to push dosing piston (4e) out back of piston (4b) through access hole on front side.
7. Clean and inspect o-rings on dosing piston (4e). Clean dosing bore in piston (4b) with a nylon brush and compatible solvent.
8. Lubricate dosing piston (4e) o-rings with ClearShot Liquid prior to reassembly.
9. Liberally lubricate piston o-ring (4c) and lightly lubricate shaft o-rings (4a).
10. Reinstall retaining ring (4g). Press it into groove of dosing piston (4e).

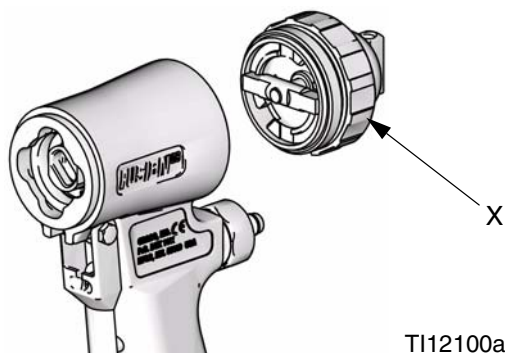
11. Reinstall piston. Shaft is keyed for proper assembly. Push firmly to seat piston.



TI12102a

FIG. 60

12. Install variable flow adjustment knob (X).



TI12100a

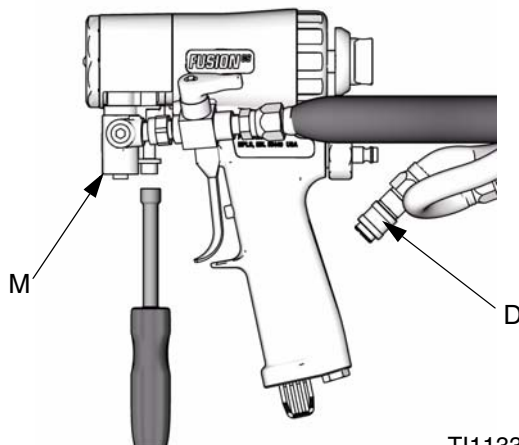
FIG. 61

13. Attach Front End, page 35.
14. Attach fluid manifold (M).
15. Install ClearShot Liquid cartridge. See **ClearShot Liquid Cartridge Installation/Removal**, page 22.
16. Connect air. Return gun to service.

Air Valve

1. Follow **Pressure Relief Procedure**, page 17

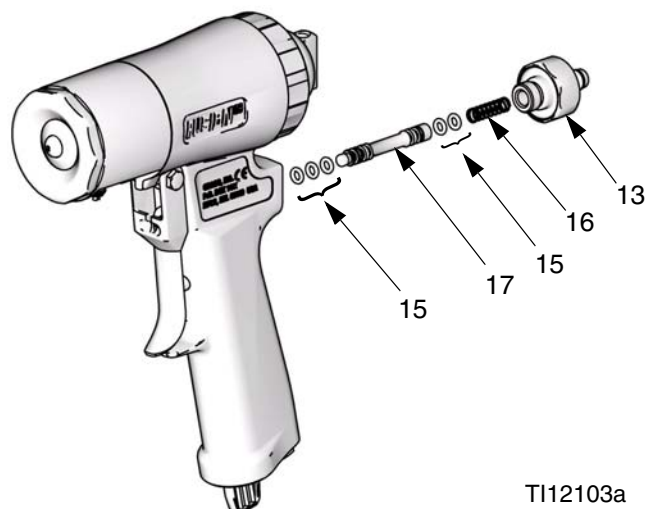
2. Disconnect air (D) and remove fluid manifold (M).



TI11330a

FIG. 62

3. Unscrew air valve plug (13) and remove spring (16). Using a small diameter tool, push spool (17) out from front. Inspect all five o-rings (15).

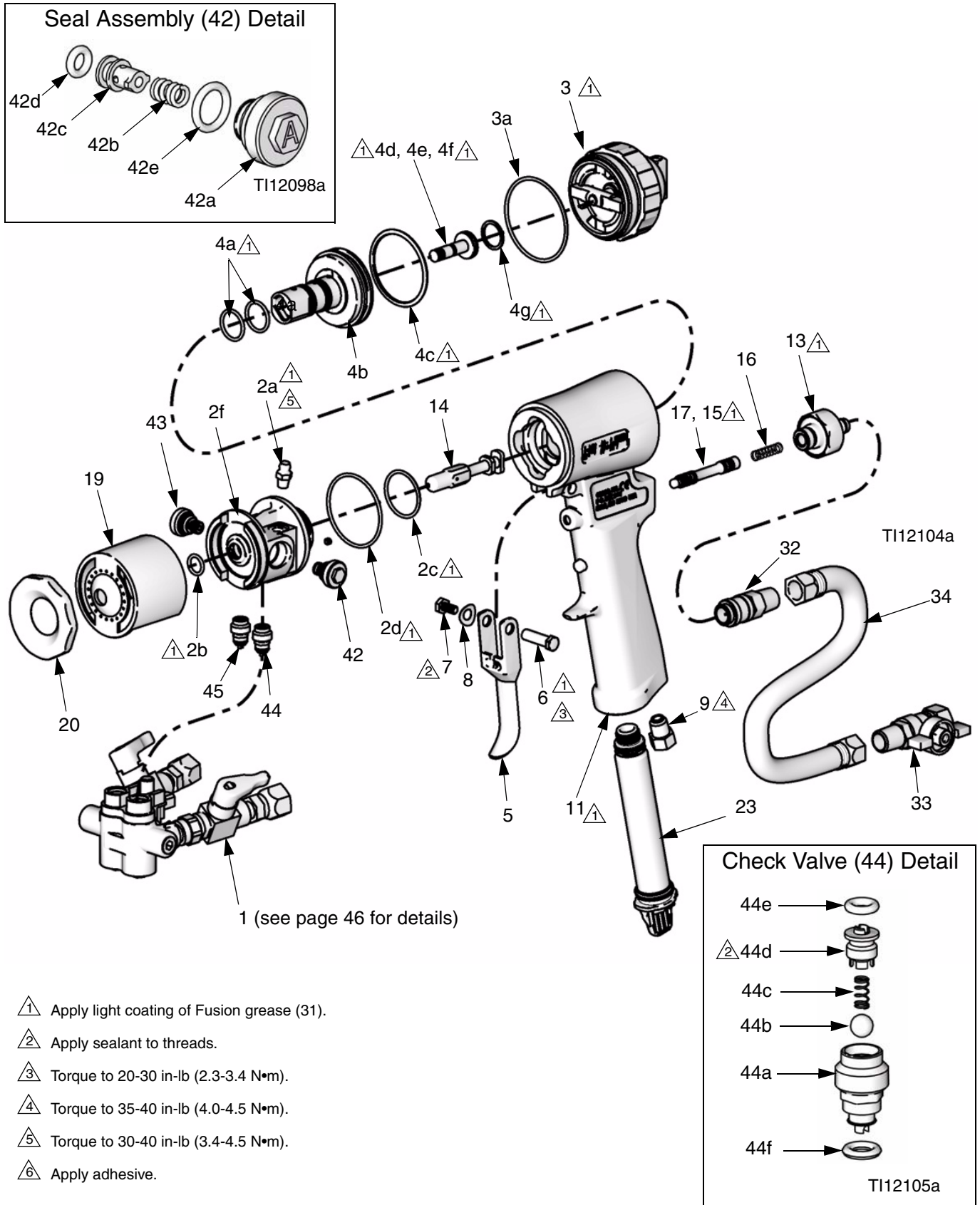


TI12103a

FIG. 63

4. Liberally lubricate o-rings and reassemble. Torque plug (13) to 25-135 in-lb (14-15 N•m).
5. Attach fluid manifold (M). Connect air (D). Return gun to service.

Parts



Wide and Round Pattern Models

Ref.	Part	Description	Qty.	Ref.	Part	Description	Qty.
1	256466	MANIFOLD, hose, assy.	1	5	15B209	TRIGGER	1
1a		MANIFOLD	1	6	192272	PIN, pivot	1
1b	256462	VALVE, check; includes o-ring 248129	1	7	203953	SCREW; 10-24 x 3/8 in. (10 mm)	1
1c	256462	VALVE, check; includes o-ring 248129	1	8	15C480	WASHER, wave	1
1d	15B221	BOLT; 5/16-24	3	9	121540	PLUG, breather	1
1e	100139	PLUG, pipe	1	11	2 56458	HANDLE, kit; includes ref. 12	1
1f	117634	SWIVEL, union; #6 JIC	1	12†		PIN, roll; 1/16 x 1/4 (shown in Cutaway View , page 33)	1
1g	117635	SWIVEL, union	1	13	15T897	PLUG, air valve	1
1h	256460	VALVE, ball, resin	1	14❖		CHAMBER, mix	1
1j	256459	VALVE, ball, iso	1	15		O-RING	5
1k	15U395	ADAPTER, male x female; 1/8 npt	1	16	117485	SPRING, compression	1
2	256457	HOUSING, fluid, assy; includes 2a-2f and 42-45	1	17	256455	VALVE, spool	1
2a	100846	FITTING, lubrication	1	19	256414	RETAINER, cover; 5 pack	1
2b✓	248648	O-RING	1	20✕	256415	COVER, front; 5 pack	1
2c✓	256646	O-RING	1	23★	256385	KIT, clearshot cartridge, 25-pack	1
2d✓	248132	O-RING	1	25❖		TOOL, cleanout	1
2f		HOUSING	1	26❖		TOOL, cleanout	1
3	256456	ADJUSTER, variable-flow	1	27❖		TOOL, cleanout, #69	1
3a	256647	O-RING	1	28	117661	PIN, vise	1
4	256454	PISTON, assy.	1	29†	117773	LUBRICANT	1
4a✓	256645	O-RING	2	30†	117792	GUN, grease	1
4b		PISTON	1	31†	118665	GREASE, Fusion; 4 oz	1
4c✓	256648	O-RING	1	32	117510	COUPLER, line, air; 1/4 npt	1
4d✓		O-RING	3	33	15B565	VALVE, ball	1
4e		PISTON, dosing	1	34	15B772	HOSE, air; 18 in.	1
4f✓		O-RING	1	35	112307	ELBOW, street	2
4g		RING, retaining, internal spiral	1	36	117642	NUT DRIVER	1
				37	118575	SCREW DRIVER, 1/8 blade	1
				38▲	172479	TAG, instruction	1
				39▲	222385	TAG, warning	1

Ref.	Part	Description	Qty.
40	15R909	MANIFOLD, flush	1
41	256566	CAP, inlet	1
42	256463	SEAL, a side, assy.	1
42a		HOUSING, seal, side	1
42b		SPRING, compression	1
42c*	256464	SEAL, side; includes 42d	1
42d✓	256467	O-RING	1
42e✓	256468	O-RING	1
43	256463	SEAL, b side, assy.	1
43a		HOUSING, seal, side	1
43b		SPRING, compression	1
43c*	256464	SEAL, side; includes 43d	1
43d✓	256467	O-RING	1
43e✓	256468	O-RING	1
44	256461	VALVE, check, a side	1
44a		HOUSING, check valve	1
44b		BALL; carbide	1
44c		SPRING, compression	1
44d		RETAINER, ball	1
44e✓		O-RING	1
44f✓	256644	O-RING	1
45	256461	VALVE, check, b side	1
45a		HOUSING, check valve	1
45b		BALL; carbide	1
45c		SPRING, compression	1
45d		RETAINER, ball	1
45e✓		O-RING	1
45f✓	256644	O-RING	1
48	15R909	MANIFOLD, flush	1
49	100721	PLUG, pipe	1
50	117509	FITTING, air line; 1/4 npt	1

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

† Not shown.

❖ See table for kit number.

✓ Also included in o-ring repair kit(s); see page 49.

★ ClearShot Liquid cartridges also available in packages of 50 and 100. See **Accessories**, page 53.

* Side seals also available in packages of 2 and 20. See **Accessories**, page 53.

✱ Part 277779 is not available for individual sale. Order part 256415.

Wide and Round Pattern Models Varying Parts

	Reference Number			
Model	14	25	26	27
CS00WD	Order Kit WD0000			
CS01WD	Order Kit WD0101			
CS02WD	Order Kit WD0202			
CS03WD	Order Kit WD0303			
CS22WD	Order Kit WD2222			
CS01RD	Order Kit RD0101			
CS02RD	Order Kit RD0202			
CS03RD	Order Kit RD0303			
CS20RD	Order Kit RD2020			
CS00RD	Order Kit RD0000			

Flat Pattern Models

Ref.	Part	Description	Qty.	Ref.	Part	Description	Qty.
				5	15B209	TRIGGER	1
				6	192272	PIN, pivot	1
1	256466	MANIFOLD, hose, assy	1	7	203953	SCREW, cap hex hd	1
1a		MANIFOLD	1	8	15C480	WASHER, wave	1
1b	256462	VALVE, check; includes o-ring	1	9	121540	PLUG, breather	1
		248129		11	256458	HANDLE, kit; includes ref. 12	1
1c	255958	VALVE, check; includes o-ring	1	12†		PIN, roll; 1/16 x 1/4 (shown in	1
		248129				Cutaway View , page 33)	
1d	15B221	BOLT; 5/16-24	3	13	15T897	PLUG, air valve	1
1e	100139	PLUG, pipe	1	14❖		CHAMBER, mix	1
1f	117634	SWIVEL, union; #6 JIC	1	15✓		O-RING	5
1g	117635	SWIVEL, union	1	16	117485	SPRING, compression	1
1h	256460	VALVE, ball, resin	1	17	256455	VALVE, spool	1
1j	256459	VALVE, ball, iso	1	19	256414	RETAINER, cover; 5 pack	1
1k	15U395	ADAPTER, male x female;	1	20✕	256416	COVER, front, tip; 5 pack	1
		1/8 npt		21❖		TIP, spray	1
2	256457	HOUSING, fluid, assy	1	23★	256385	KIT, clearshot cartridge,	1
2a	100846	FITTING, lubrication	1			25-pack	
2b✓	248648	O-RING	1	25❖		TOOL, clean out, 3/32	1
2c✓	256646	O-RING	1	26❖		TOOL, clean out, #53	1
2d✓	248132	O-RING	1	27❖		TOOL, clean out, #69	1
2f		HOUSING	1	28†	117661	PIN, vise	1
3	256456	ADJUSTER, variable-flow	1	29†	117773	LUBRICANT	1
3a	256647	O-RING	1	30†	117792	GUN, grease	1
4	256454	PISTON, assy	1	31†	118665	GREASE, Fusion; 4 oz	1
4a✓	256645	O-RING	2	32	117510	COUPLER, line, air; 1/4 npt	1
4b		PISTON	1	33	15B565	VALVE, ball	1
4c✓	256648	O-RING	1	34	15B772	HOSE, air; 18 in.	1
4d✓		O-RING	3	35	112307	ELBOW, street	2
4e		PISTON, dosing	1	36	117642	NUT DRIVER	1
4f✓		O-RING	1	37	118575	SCREW DRIVER, 1/8 blade	1
4g		RING, retaining, internal spi- ral	1				

Ref.	Part	Description	Qty.
38▲	172479	TAG, instruction	1
39▲	222385	TAG, warning	1
40	15R909	MANIFOLD, flush	1
41	256566	CAP, inlet	1
42	256463	SEAL, a side, assy.	1
42a		HOUSING, seal, side	1
42b		SPRING, compression	1
42c*	256464	SEAL, side; includes 42d	1
42d✓	256467	O-RING	1
42e✓	256468	O-RING	1
43	256463	SEAL, b side, assy.	1
43a		HOUSING, seal, side	1
43b		SPRING, compression	1
43c*	256464	SEAL, side; includes 43d	1
43d✓	256467	O-RING	1
43e✓	256468	O-RING	1
44	256461	VALVE, check, a side	1
44a		HOUSING, check valve	1
44b		BALL; carbide	1
44c		SPRING, compression	1
44d		RETAINER, ball	1
44e✓		O-RING	1
44f✓	256644	O-RING	1
45	256461	VALVE, check, b side	1
45a		HOUSING, check valve	1
45b		BALL; carbide	1
45c		SPRING, compression	1
45d		RETAINER, ball	1
45e✓		O-RING	1
45f✓	256644	O-RING	1
46	256567	RETAINER, tip	1
47*	246360	O-RING; PTFE; package of 3	1
48	15R909	MANIFOLD, flush	1
49	100721	PLUG, pipe	1
50	117509	FITTING, air line; 1/4 npt	1

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

❖ See table for kit number.

† Not shown.

✓ Also included in o-ring repair kit(s); see page 49.

★ ClearShot Liquid cartridges also available in packages of 50 and 100. See **Accessories**, page 53.

* Side seals also available in packages of 2 and 20. See **Accessories**, page 53.

✱ Also included in Kits FL0000, FL0101, FL0202, and FL2020.

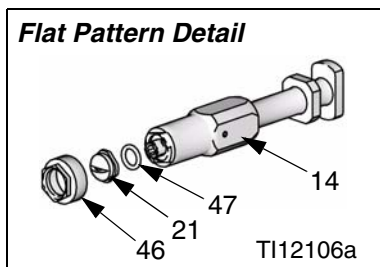
✱ Part 277781 is not available for individual sale. Order part 256415.

Flat Pattern Models Varying Parts

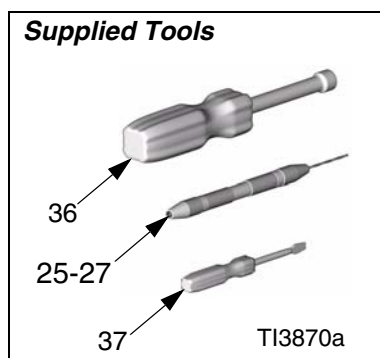
	Reference Number				
Model	14	21	25	26	27
CS00F1	Order Kit FL0000				
CS00F2	Order Kit FL0000				
CS00F3	Order Kit FL0000				
CS00F4	Order Kit FL0000				
CS00F5	Order Kit FL0000				
CS00F6	Order Kit FL0000				
CS01F1	Order Kit FL0101				
CS01F2	Order Kit FL0101				
CS01F3	Order Kit FL0101				
CS01F4	Order Kit FL0101				
CS01F5	Order Kit FL0101				
CS01F6	Order Kit FL0101				
CS02F1	Order Kit FL0202				
CS02F2	Order Kit FL0202				
CS02F3	Order Kit FL0202				
CS02F4	Order Kit FL0202				
CS02F5	Order Kit FL0202				
CS02F6	Order Kit FL0202				
CS20F1	Order Kit FL2020				
CS20F2	Order Kit FL2020				

Detail Views

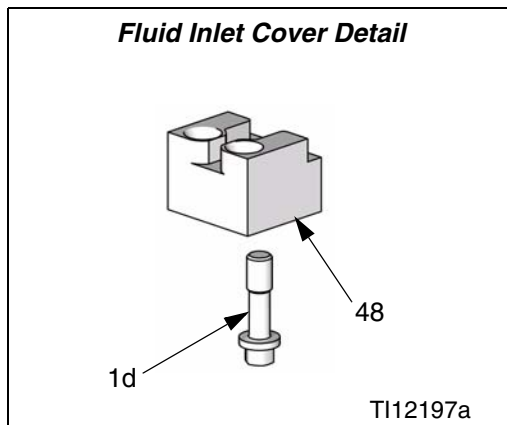
Flat Pattern Detail



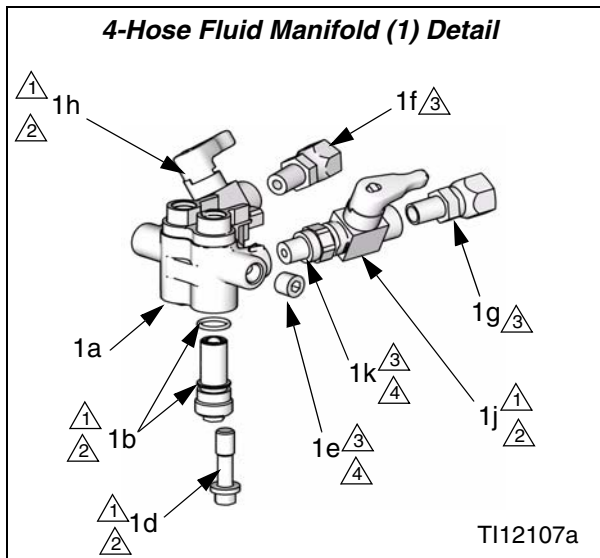
Supplied Tools



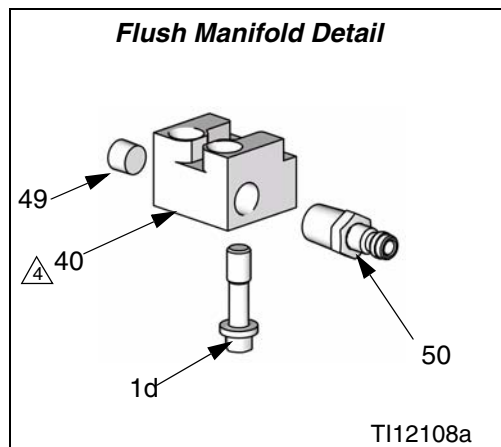
Fluid Inlet Cover Detail



4-Hose Fluid Manifold (1) Detail



Flush Manifold Detail



- △1 Apply lubricant to seals.
- △2 Torque to 20-25 in-lb (2.3-2.8 N•m).
- △3 Apply sealant to threads.
- △4 Torque to 125-135 in-lb (14-15 N•m).

Mix Chamber Kits

Round Pattern Mix Chamber Kits

Mix Chamber Kit (includes drill bits)	Nozzle Orifice Size	Nozzle Drill Bit Size, in. (mm)	Impingement Port Size	Impingement Port Drill Bit Size, in. (mm)	Counter-bore Size	Counter-bore Drill Bit Size, in. (mm)
RD2020	0.042	#58 (1.00)	0.020	#76 (0.50)	0.060	#53 (1.50)
RD0000	0.052	#55 (1.30)	0.029	#69 (0.70)	0.060	#53 (1.50)
RD0101	0.060	#53 (1.50)	0.042	#58 (1.00)	N/A	N/A
RD0202	0.070	#50 (1.75)	0.052	#55 (1.30)	N/A	N/A
RD0303	0.086	#44 (2.15)	0.060	#53 (1.50)	N/A	N/A

Wide Pattern Mix Chamber Kits

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

Kit Part	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) *
WD2222	8 (203.2)	N/A	0.047 (1.20)	#74, 0.022 (0.56)
WD0000	15 (381.0)	Ref. RD0000	1/16, 0.062 (1.59)	#70, 0.028 (0.71)
WD0101	16 (406.4)	Ref. RD0101	#50, 0.070 (1.78)	#61, 0.039 (0.99)
WD0202	18 (457.2)	Ref. RD0202	0.085 (2.15)	#56, 0.046 (1.17)
WD0303	18 (457.2)	Ref. RD0303	#42, 0.089 (2.26)	1.45 mm, 0.057 (1.45)

Flat Pattern Guns

Mix Chamber Kit (includes drill bits and o-ring)	Ref. 47†, O-ring	Nozzle Orifice Size	Nozzle Drill Bit Size, in. (mm)	Impinge-ment Port Size	Impinge-ment Port Drill Bit Size, in. (mm)	Counter-bore Size	Counter-bore Drill Bit Size, in. (mm)
FL2020	246360	0.094	3/32 (2.35)	0.020	#76 (0.50)	0.060	#53 (1.50)
FL0000	246360	0.094	3/32 (2.35)	0.029	#69 (0.70)	0.060	#53 (1.50)
FL0101	246360	0.094	3/32 (2.35)	0.042	#58 (1.00)	N/A	N/A
FL0202	246360	0.094	3/32 (2.35)	0.052	#55 (1.30)	N/A	N/A

† Available only in flat mix chamber kits or in 246360 multi-pack kit.

Mix Chamber Part Reference Guide

Sample part RD0101:

RD	01	01
RD= round pattern	A orifice size (0.042 in.)	B orifice size (0.042 in.)
FL= flat pattern		
WD = wide pattern		

Flat Tip Kits

Ref. 21, Flat Spray Tip	Pattern Size, in. (mm)
FT0424	low flow, 8-10 (203-254)
FT0438	medium flow, 8-10 (203-254)
FT0624	low flow, 12-14 (305-356)
FT0638	medium flow, 12-14 (305-356)
FT0838	medium flow, 16-18 (406-457)
FT0848	high flow, 16-18 (406-457)

Flat Tip Part Reference Guide

Sample part FT0848:

FT	08	48
FT=Flat tip	x2=pattern length (8x2=16 in.)	Equivalent orifice diameter size (.048 in.)

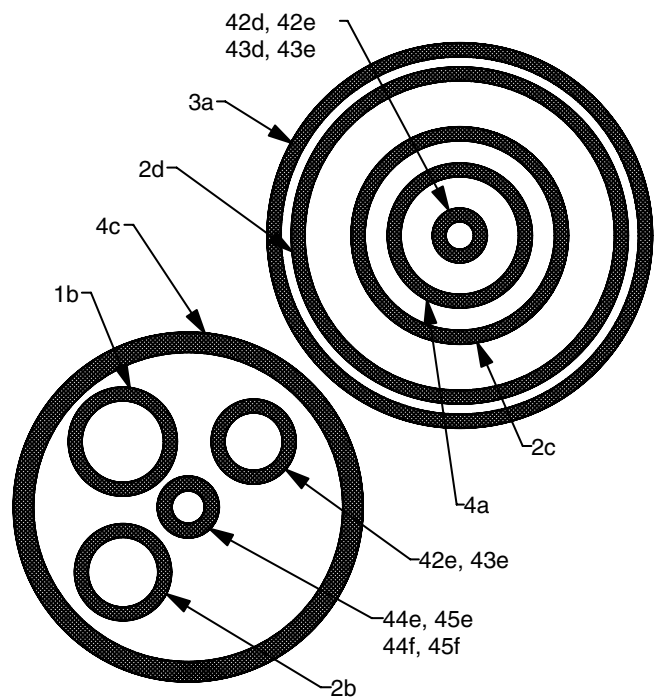
O-ring Repair Kits

The following table indicates the specific o-ring(s) reference number and quantity included in each o-ring kit.

Kit	Reference Number										
	1b	2b	2c	2d	3a	4a	4c	42d, 43d	42e, 43e	44e, 45e	44f, 45f
256490 Complete Kit	2	1	1	1	1	2	1	2	2	2	2
256467 Side Seal								6			
256468 Side Seal Housing									6		
256640 Fluid Head Check Valves										6	6
256471 Fluid Head		1	1	1							
256470 Air Piston						2	1				
256472 Back Cap					1						
256469 Hose Manifold Check Valves	6										

Complete O-ring Kit Placement Guide

Each o-ring in kit 256490 is labeled by the reference number. See the table entry for 256490 in **O-ring Repair Kits** on page 49 for the quantity of each.




Check Valve Filter Screen Kits

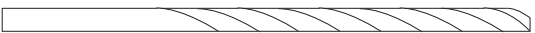

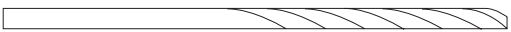
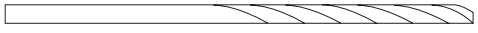
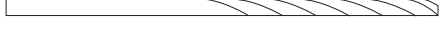
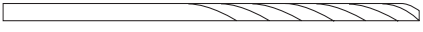
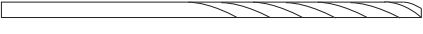
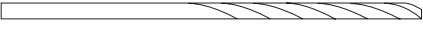

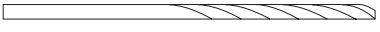

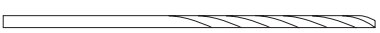
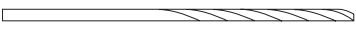



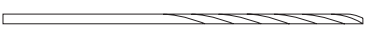


Kits include 10 filter screens.
The 80 mesh filter screen is standard with gun.














Part	Description
246357	40 mesh (0.015 in., 375 micron)
246358	60 mesh (0.010 in., 238 micron)
246359	80 mesh (0.007 in., 175 micron)

Drill Bit Kits

For cleaning gun ports and orifices. Illustrations are actual size for comparison.

 Not all sizes are used with every gun model.

Kit Part	Qty in Kit	Drill Bit Size			Illustration
		nominal	in.	mm	
249115	6	1/8	0.125	3.18	
246623	3	#32	0.116	2.90	
246810	3	7/64	0.109	2.77	
246813	3	#39	0.099	2.51	
246624	3	3/32	0.094	2.39	
246812	3	#43	0.089	2.26	
246625	3	#44	0.086	2.18	
248639	6	2.15 mm	0.085	2.15	
249114	6	#45	0.082	2.08	
246811	3	2 mm	0.079	2.00	
246626	6	#50	0.070	1.78	
249113	6	#52	0.64	1.63	
248893	6	1/16	0.062	1.59	
246627	6	#53	0.060	1.52	
249112	6	1.45 mm	0.057	1.45	
246809	6	#54	0.055	1.40	
246628	6	#55	0.052	1.32	
249764	6	1.20 mm	0.047	1.20	
246814	6	#56	0.046	1.18	

Kit Part	Qty in Kit	Drill Bit Size			Illustration
		nominal	in.	mm	
246629	6	#58	0.042	1.07	
246808	6	#60	0.040	1.02	
248640	6	#61	0.039	0.99	
248618	6	#63	0.037	0.94	
248891	6	#66	0.033	0.84	
246807	6	#67	0.032	0.81	
246630	6	#69	0.029	0.74	
248892	6	#70	0.028	0.71	
246815	6	#73	0.024	0.61	
276984	6	#74	0.023	0.57	
246631	6	#76	0.020	0.51	
246816	6	#77	0.018	0.46	
246817	6	#81	0.013	0.33	

ClearShot Handle Cleanout Drill Kit

256526

Kit includes all 7 drill bits of extra length needed to clean out all air passages in the Fusion CS gun handle and fluid housing. See **Clean Passages**, page 27.

Accessories

Stainless Steel Side Seal Kit

Kit 256464 includes 2 stainless steel side seals and 2 o-rings.

Polycarballoy Side Seal Kits

Kits include a packing o-ring for each polycarballoy side seal. The optional high wear, non-metallic polycarballoy seals are for alternate fluids.

Kit	Description	Number of Seals Per Kit
256465	SEAL KIT, Polycarballoy	2
256489	SEAL KIT, Polycarballoy	20

Flat Pattern Stud Wall Kits

Use to spray wall insulation foam into stud walls with a single pass.

Kit	Description
256569	Includes TP100
256570	Includes FTM979

Gun Cover

244914 Covers

Keeps gun clean while spraying. Pack of 10.

Lubricant for Gun Rebuild

248279, 4 oz (113 gram) [10]

High adhesion, water resistant, lithium-based lubricant. MSDS sheet available at www.graco.com.

Grease Cartridge for Gun Shutdown

248280 Cartridge, 3 oz [10]

Specially formulated low viscosity grease flows easily through gun passages, to prevent two-component curing and keep fluid passages clean.

Flushing Manifold

256641 Manifold Block

See page 46.

Fluid Inlet Cover

Kit 256642; includes 15R910 and 15B221. See page 46.

Gun Cleaning Kit

15D546

Kit includes 11 tools and brushes to clean the gun.

ClearShot Liquid Cartridges

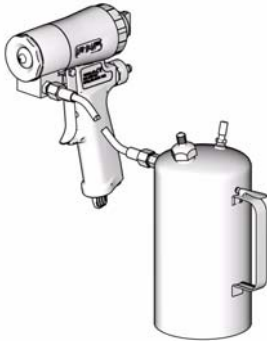
See MSD060.

Kit	Description
256385	Package of 25 cartridges
256386	Package of 50 cartridges
256387	Package of 100 cartridges

Solvent Flush Canister Kit

256510, 1 qt (0.95 liter) Solvent Cup

Includes flushing manifold to flush gun with solvent. Portable for remote flushing. See manual 309963.

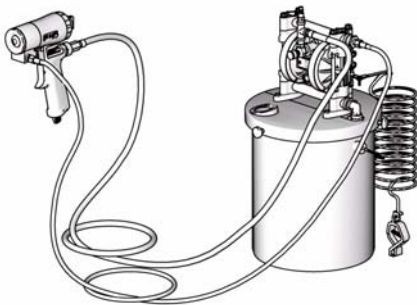


TI12110a

Solvent Flush Pail Kit

248299 5.0 gal. (19 liter) Pail

Includes flush manifold with individual A and B shutoff valves, and air regulator. See manual 309963.

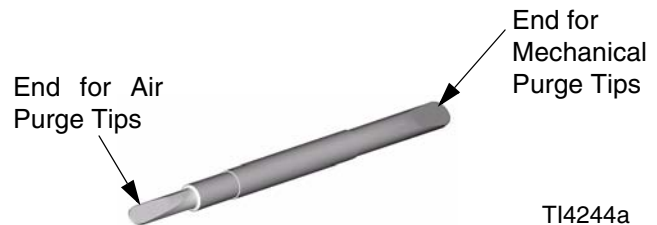


TI12111a

Tip Cleanout Tool

15D234

Designed to fit CeramTip internal dome and flat tip slits.

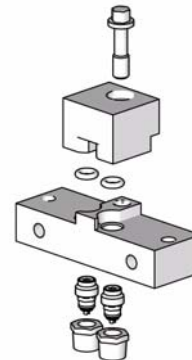


TI4244a

Circulation Manifold

256566

Attach to gun fluid manifold to enable preheating of hose. See manual 313058.



TI12109

Technical Data

Category	Data
Maximum Fluid Working Pressure	3500 psi (24.5 MPa, 245 bar)
Minimum Air Inlet Pressure	80 psi (0.56 MPa, 5.6 bar)
Maximum Air Inlet Pressure	130 psi (0.9 MPa, 9 bar)
Air Flow Range	See chart below
Maximum Fluid Temperature	200° F (94° C)
Air Inlet Size	1/4 npt Quick Disconnect Nipple
A Component (ISO) Inlet Size	-5 JIC; 1/2-20 UNF
B Component (Resin) Inlet Size	-6 JIC; 9/16-18 UNF
Sound Pressure	81.1 dB(A), using RD0202 at 100 psi (0.7 MPa, 7 bar)
Sound Power, measured per ISO 9416-2	91.0 dB(A), using RD0202 at 100 psi (0.7 MPa, 7 bar)
Dimensions	7.5 x 8.1 x 3.3 in. (191 x 206 x 84 mm)
Weight	2.6 lbs (1.18 kg)
Wetted Parts	Aluminum, stainless steel, carbon steel, carbide, chemically resistant o-rings

All other brand names or marks are used for identification purposes and are trademarks of their respective owners.

Air Flow Data

Air Pressure (detriggered) psi (MPa, bar)	Air Flow in scfm (m ³ /min) for all mix chambers
80 (0.56, 5.6)	2.1 (0.059)
100 (0.7, 7)	3.1 (0.088)
130 (0.9, 9)	5.2 (0.147)

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