

Fusion™ CS

312666R

EN

Plural Component, Impingement Mix Air Purge Spray Gun with ClearShot Liquid Technology. For professional use only.

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

3500 psi (24.5 MPa, 245 bar) Maximum Fluid Working Pressure

80-130 psi (0.56-0.9 MPa, 5.6-9.0 bar) Air Inlet Pressure Range

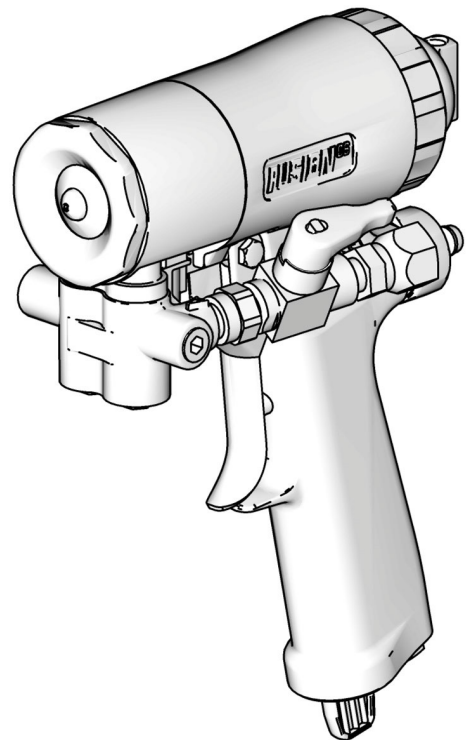
200° F (94° C) Maximum Fluid Temperature



Important Safety Instructions

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

See page 4 for model information.



T111323a

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Related Manuals

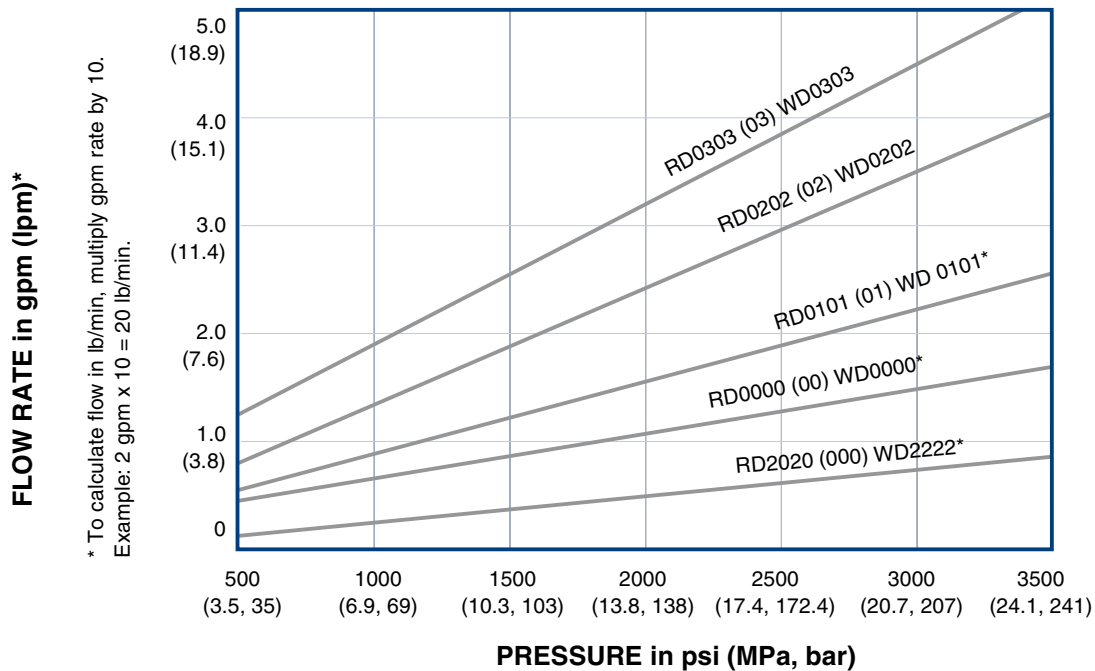
The following manuals are for accessories used with the Fusion CS spray gun. Visit www.graco.com for the most current manual revisions.

| Power-Lock™ Heated Hose | |
|---|---------------------------------------|
| Part | Description |
| 309572 | Instructions - Parts Manual (English) |
| Solvent Flush Kits | |
| Part | Description |
| 309963 | Instructions - Parts Manual (English) |
| 256566 Circulation Manifold Kit | |
| Part | Description |
| 313058 | Instructions - Parts Manual (English) |
| 256569 TP100 Kit and 256570 Stud Wall Foam Kit | |
| Part | Description |
| 313121 | Instructions - Parts Manual (English) |
| 256526 Cleanout Tool Kit | |
| Part | Description |
| 313129 | Instructions - Parts Manual (English) |

Models/Mix Chamber Selection Guide

Round Pattern Guns

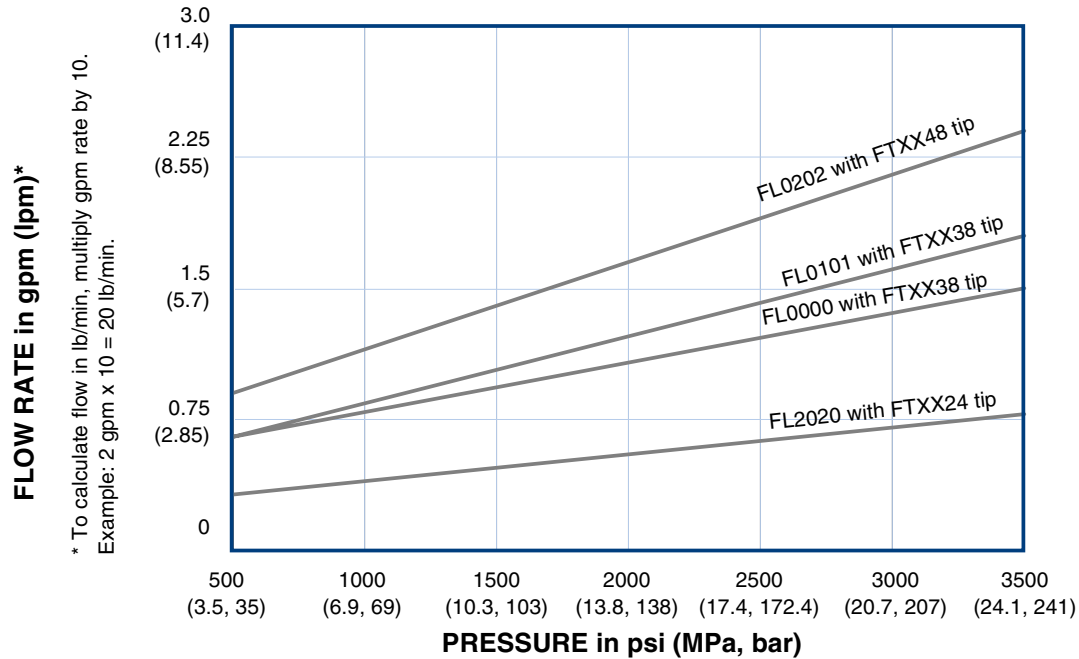
| Gun Part, Series | Mix Chamber | | | |
|------------------|-------------|--------------------------------|-----------------|---------------|
| | Part | Impingement Port Size in. (mm) | Equivalent Size | Seal Material |
| CS20RD, B | RD2020 | 0.020 (0.50) | -000 | SST |
| CS00RD, B | RD0000 | 0.029 (0.70) | -00 | SST |
| CS01RD, B | RD0101 | 0.042 (1.00) | -01 | SST |
| CS02RD, B | RD0202 | 0.052 (1.30) | -02 | SST |
| CS03RD, B | RD0303 | 0.060 (1.50) | -03 | SST |



*Accessory WD (wide pattern) mix chambers are available. See page 49.

Flat Pattern Guns

| Gun Part, Series | Mix Chamber | | | Flat Tip | | |
|---------------------|-------------|-----------------------------------|--------------------|----------|--------------------------|--------------------------|
| | Part | Impingement Port Size in. (mm) | Equivalent Size | Part | Pattern Size in. (mm) | Orifice Size in. (mm) |
| CS20F1, B | FL2020 | 0.020 (0.50) | -000 | FT0424 | 8-10 (203-254) | 0.024 (0.61) |
| CS20F2, B | FL2020 | 0.020 (0.50) | -000 | FT0438 | 8-10 (203-254) | 0.038 (0.97) |
| CS00F1, B | FL0000 | 0.029 (0.70) | -00 | FT0424 | 8-10 (203-254) | 0.024 (0.61) |
| CS00F2, B | FL0000 | 0.029 (0.70) | -00 | FT0438 | 8-10 (203-254) | 0.038 (0.97) |
| CS00F3, B | FL0000 | 0.029 (0.70) | -00 | FT0624 | 12-14 (305-356) | 0.024 (0.61) |
| CS00F4, B | FL0000 | 0.029 (0.70) | -00 | FT0638 | 12-14 (305-356) | 0.038 (0.97) |
| CS00F5, B | FL0000 | 0.029 (0.70) | -00 | FT0838 | 16-18 (406-457) | 0.038 (0.97) |
| CS00F6, B | FL0000 | 0.029 (0.70) | -00 | FT0848 | 16-18 (406-457) | 0.048 (1.22) |
| CS01F1, B | FL0101 | 0.042 (1.00) | -01 | FT0424 | 8-10 (203-254) | 0.024 (0.61) |
| CS01F2, B | FL0101 | 0.042 (1.00) | -01 | FT0438 | 8-10 (203-254) | 0.038 (0.97) |
| CS01F3, B | FL0101 | 0.042 (1.00) | -01 | FT0624 | 12-14 (305-356) | 0.024 (0.61) |
| CS01F4, B | FL0101 | 0.042 (1.00) | -01 | FT0638 | 12-14 (305-356) | 0.038 (0.97) |
| CS01F5, B | FL0101 | 0.042 (1.00) | -01 | FT0838 | 16-18 (406-457) | 0.038 (0.97) |
| CS01F6, B | FL0101 | 0.042 (1.00) | -01 | FT0848 | 16-18 (406-457) | 0.048 (1.22) |
| CS02F1, B | FL0202 | 0.052 (1.30) | -02 | FT0424 | 8-10 (203-254) | 0.024 (0.61) |
| CS02F2, B | FL0202 | 0.052 (1.30) | -02 | FT0438 | 8-10 (203-254) | 0.038 (0.97) |
| CS02F3, B | FL0202 | 0.052 (1.30) | -02 | FT0624 | 12-14 (305-356) | 0.024 (0.61) |
| CS02F4, B | FL0202 | 0.052 (1.30) | -02 | FT0638 | 12-14 (305-356) | 0.038 (0.97) |
| CS02F5, B | FL0202 | 0.052 (1.30) | -02 | FT0838 | 16-18 (406-457) | 0.038 (0.97) |
| CS02F6, B | 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, B | WD2222 | 0.022 (0.56) | N/A | 8-9 (203-229) | 4.5 lb/min at 1000 psi |
| CS00WD, B | WD0000 | 0.028 (0.71) | -00 | 15 (381.0) | RD0000 |
| CS01WD, B | WD0101 | 0.039 (0.99) | -01 | 16 (406.4) | RD0101 |
| CS02WD, B | WD0202 | 0.046 (1.17) | -02 | 18 (457.2) | RD0202 |
| CS03WD, B | 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. • 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 | |
|--|---|
|  | <p>FIRE AND EXPLOSION HAZARD</p> <p>Flammable fumes, such as solvent and paint fumes, in work area can ignite or explode. To help prevent fire and explosion:</p> <ul style="list-style-type: none"> • 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. |
|  | <p>EQUIPMENT MISUSE HAZARD</p> <p>Misuse can cause death or serious injury.</p> <ul style="list-style-type: none"> • 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. |
|  | <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> |

Overall View

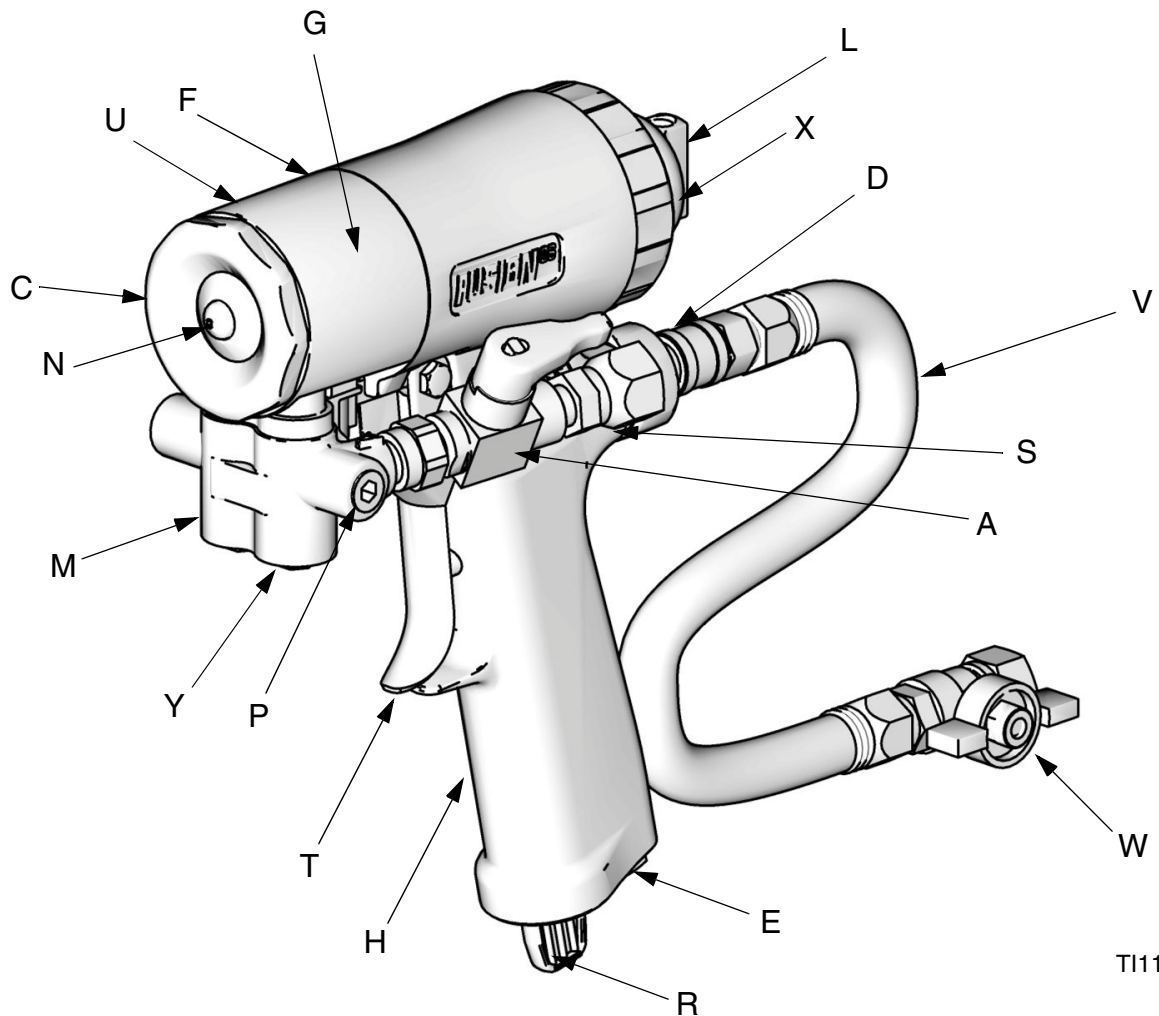




FIG. 1






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.

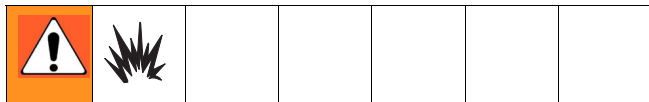
Foam Resins with 245fa Blowing Agents

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

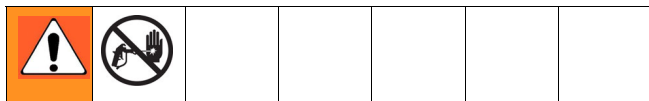


Check your local electrical code and proportioner manual for detailed grounding instructions.

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.

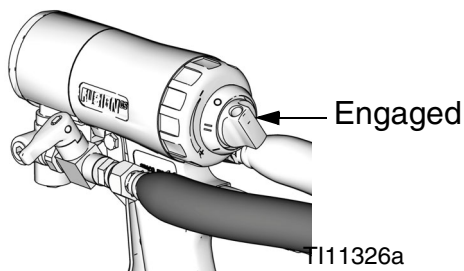


FIG. 2

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.

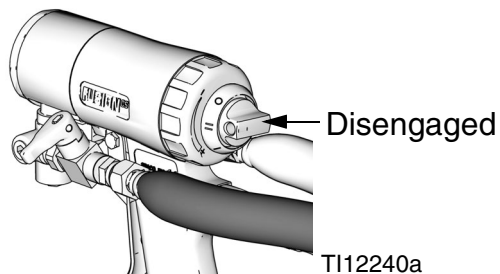
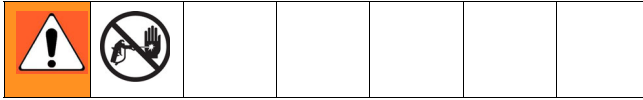
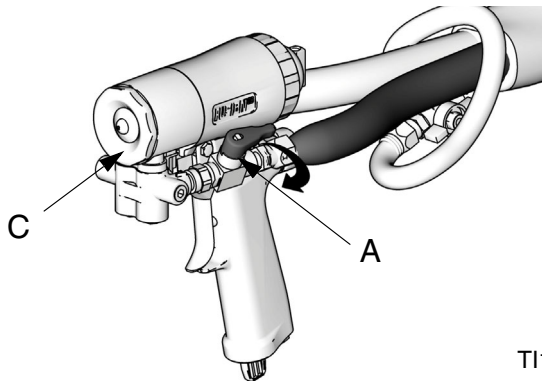


FIG. 3

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).



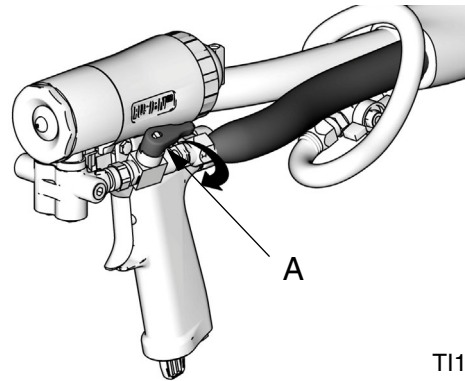
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FIG. 4

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.

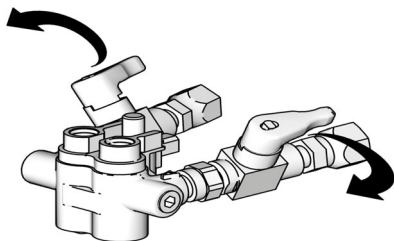


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FIG. 5

Setup

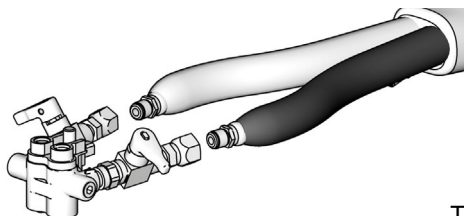
1. Close fluid valves A and B.



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FIG. 6

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



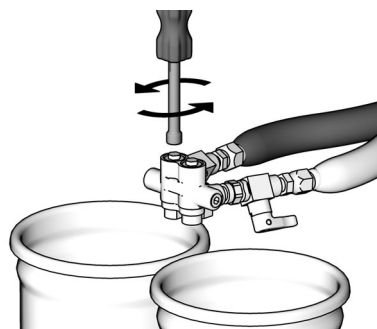
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FIG. 7

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.

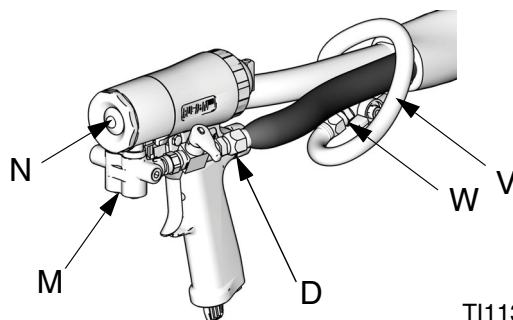
- c. Close fluid valves and retighten fluid manifold check valves.



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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 23.
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).

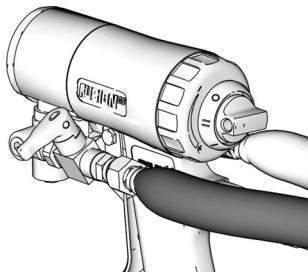


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FIG. 9

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.

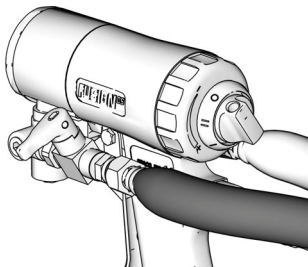


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FIG. 10

10. Trigger gun to check for full mix chamber travel and to prime ClearShot Liquid dosing pump. See **ClearShot Liquid Cartridge Installation/Removal**, page 23.

11. Engage piston safety lock, page 12.

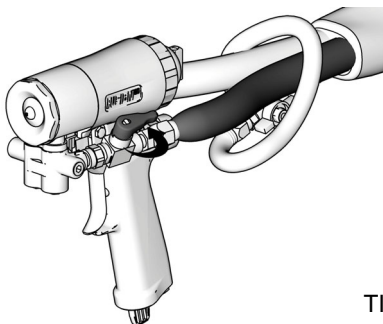


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FIG. 11

12. Turn on proportioner.

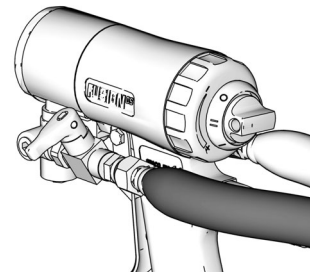
13. Open B (RESIN) fluid valve. Then open A (ISO) fluid valve.



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FIG. 12

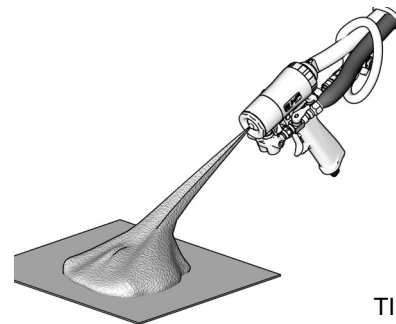
14. Disengage piston safety lock, page 12.



TI12240a

FIG. 13

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



TI11334a

FIG. 14

16. The gun is now ready to spray.


CAUTION

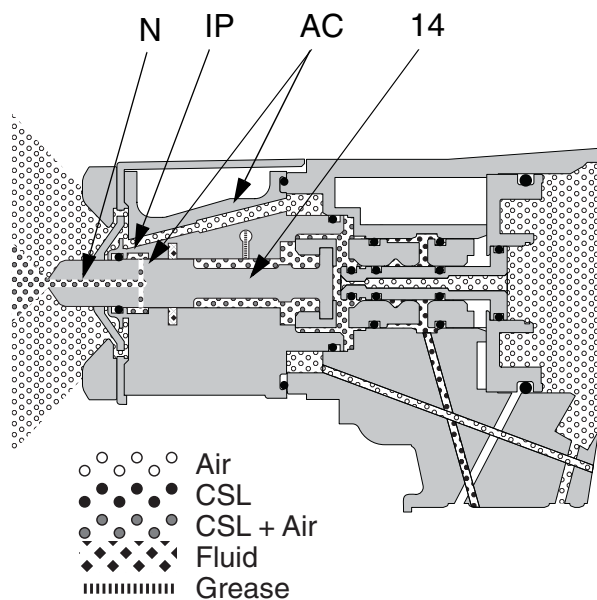
Air supply is required for gun actuation. Do not disconnect gun air supply until fluid pressure is relieved, page 17.

Shutdown

Overnight Shutdown

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

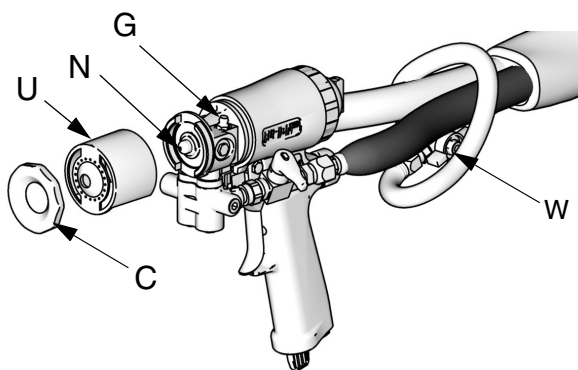
 Grease gun daily to prevent two-component curing and keep fluid passages clean. Purge air carries grease mist through air chamber (AC), impingement ports (IP), and out mix chamber nozzle (N), coating all surfaces. Use Graco 117773 grease.



TI12124a

FIG. 15


3. Unscrew and remove front cover retainer (C). Remove front cover (U).
4. Using grease gun, dispense a half shot of grease into fitting (G). Do not over-grease; use a half shot maximum.



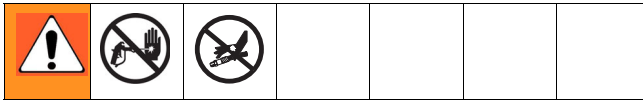
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FIG. 16

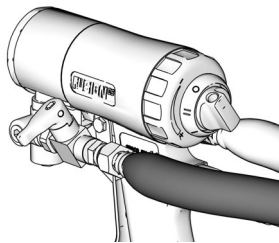
5. Replace front cover (U) and front cover retainer (C).

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

Pressure Relief Procedure



1. Engage piston safety lock, page 12.



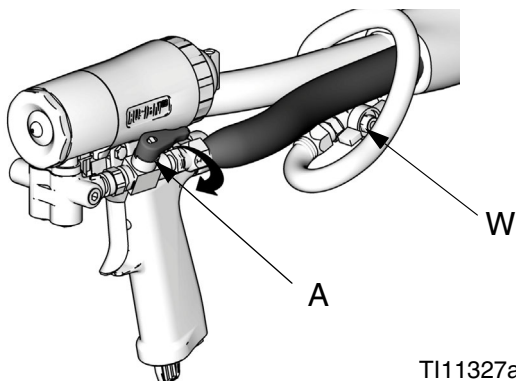
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FIG. 17

CAUTION

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

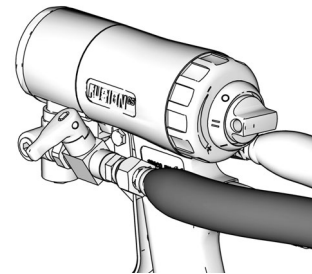
2. Close fluid valves A and B. Leave air valve (W) open.



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FIG. 18

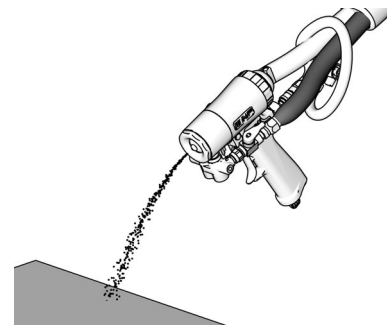
3. Disengage piston safety lock, page 12.



TI12240a

FIG. 19

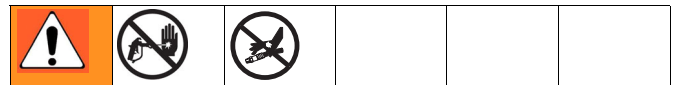
4. Trigger gun onto cardboard or into waste container to relieve pressure.



TI11336a

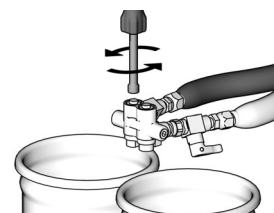
FIG. 20

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.



TI11337a

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).

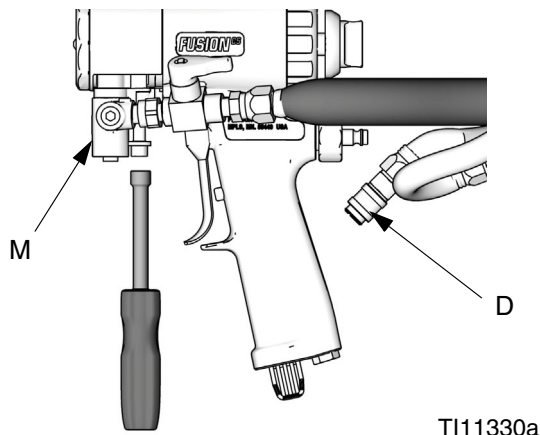


FIG. 21

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

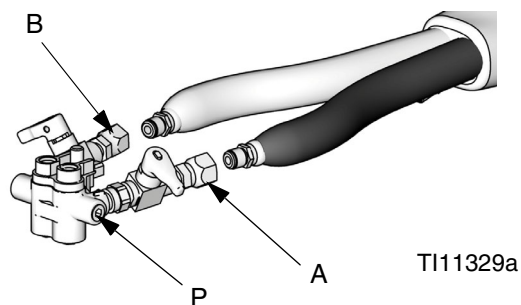


FIG. 22

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).

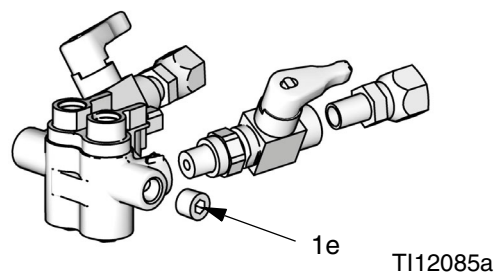


FIG. 23

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.

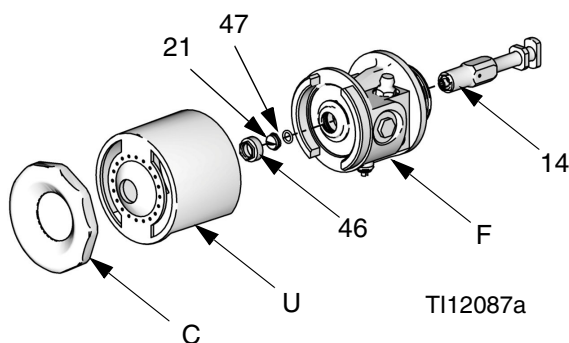



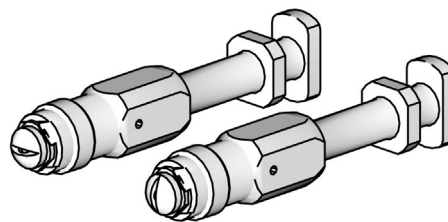
FIG. 24

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

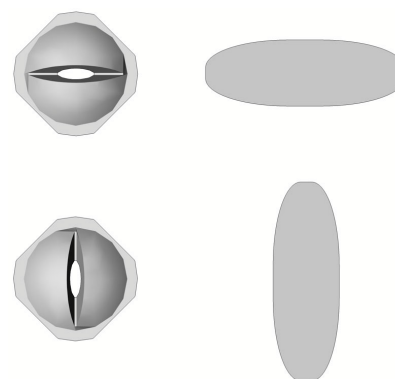
6. To clean, soak tip in compatible solvent. Clean gently with tip cleanout tool 15D234; page 56 for details of tool.
7. Reassemble in reverse order.
 - a. Insert mix chamber (14) from rear of fluid housing.
 - b. Tighten A and B side seals on fluid housing.

- 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.




TI12088a



TI2648a

FIG. 25

 Tips marked on back with last three digits of part number. See **Flat Tip Kits**, page 50.

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.

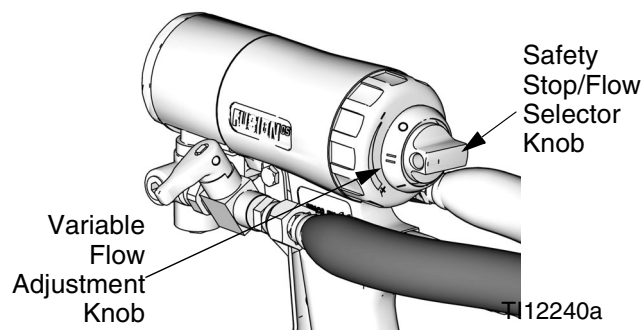


FIG. 26

Change Variable Flow Adjustment Knob

1. Turn air valve (W) OFF.
2. Turn flow selector knob to variable flow position. See FIG. 27.

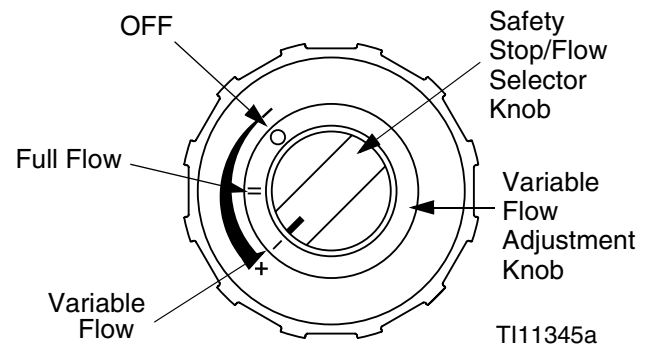


FIG. 27

Reduced Flow

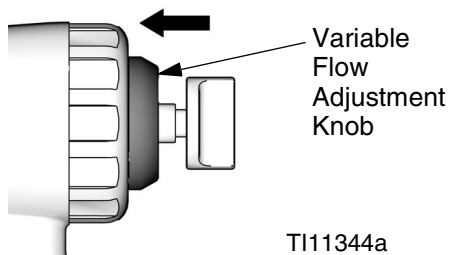
To spray a reduced flow pattern, push in and turn flow selector knob to variable flow position. See FIG. 27.


Full Flow

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

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

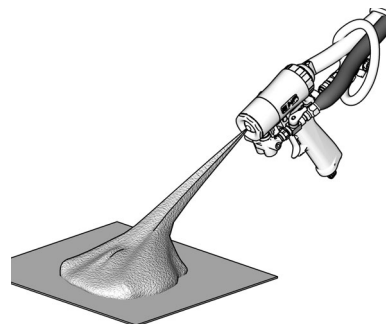
To decrease variable flow: push in and turn variable flow knob clockwise.

**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.

4. Turn air valve ON, and open fluid valves. Verify that flow selector knob is set to the variable flow position. See FIG. 27.
5. 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

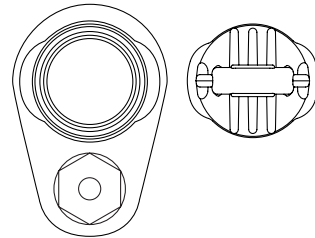
1. Follow **Pressure Relief Procedure**, page 17.
2. Remove plastic cap from new ClearShot Liquid cartridge.



TI113340a

FIG. 30

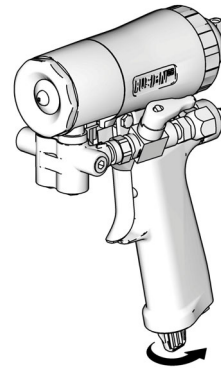
3. Insert cartridge into gun handle. Ensure cartridge tabs are aligned correctly with cartridge tab recesses in gun handle.



TI113341a

FIG. 31

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



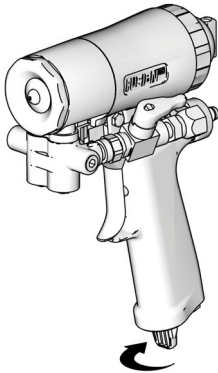
TI113342a

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

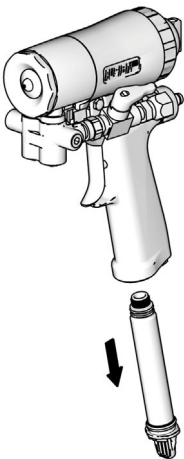
1. Follow **Pressure Relief Procedure**, page 17.
2. Turn air valve (W) OFF.
3. Push in and turn cartridge 1/4 turn counter-clockwise (viewed from bottom).



TI11338a

FIG. 33

4. Pull cartridge out of gun handle.



TI11339a

FIG. 34

Troubleshooting

For ClearShot Liquid cartridge troubleshooting, see **Troubleshooting** on page 31.

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

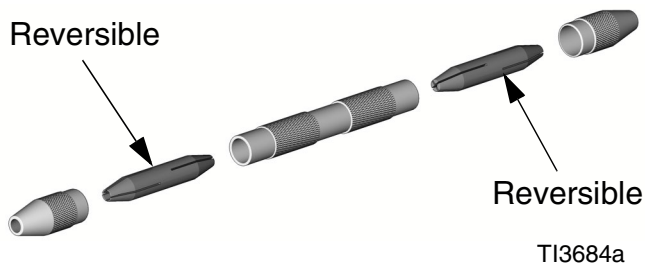


FIG. 35

- 117792 Grease Gun; with 3 oz grease
- 15B817 Flush Manifold

Keep Gun Clean

Keep gun clean with accessory gun cover, page 55.

Applying a light coat of lubricant will make cleaning easier.

As Needed

1. **Clean Outside of Gun**, page 26.
2. **Clean Mix Chamber Nozzle**, page 28, a minimum of once a day.
3. **Clean Breather Plug**, page 26.
4. **Clean Fluid Manifold**, page 27.
5. **Clean Passages**, page 29.
6. **Clean Impingement Ports**, page 29.
7. **Adjust Fluid Valve Packings**, page 27.

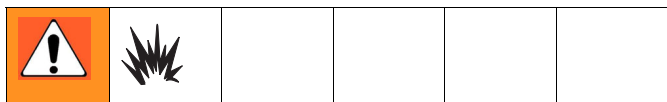
Daily

Follow **Shutdown**, page 16.


Weekly to Monthly

1. Clean **Mix Chamber and Side Seal Assemblies**, page 38. Check o-rings.
2. Clean **Check Valves**, page 41. 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, a solvent flush kit (256510 248229) is available as an accessory.

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.

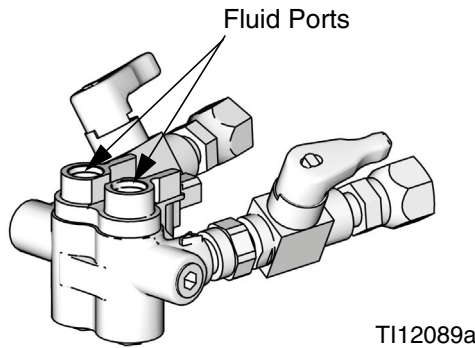


FIG. 36:

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.

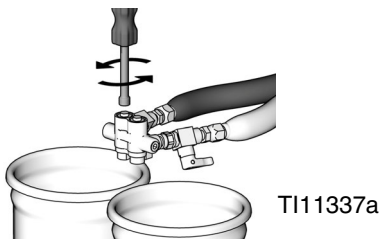


FIG. 37

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 55.
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.

Adjust Fluid Valve Packings

Periodic adjustment may be necessary to stop fluid leakage. If fluid valve is leaking, adjust the packings:

1. Follow **Pressure Relief Procedure**, page 17.
2. Loosen set screw and remove valve handle.
3. Turn valve packing nut clockwise in 1/8-turn increments until leak is corrected.
4. Re-pressurize system then check for leaks. Repeat procedure as necessary.

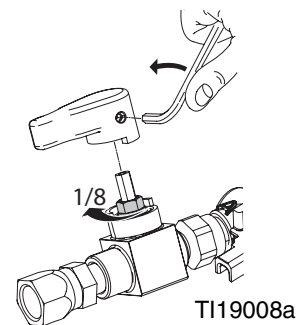


FIG. 38

Clean Mix Chamber Nozzle

1. Engage piston safety lock, page 12.

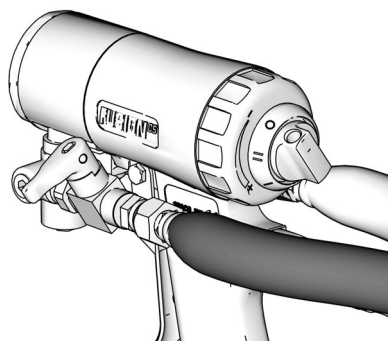


FIG. 39

2. Refer to Table 1. Also see identification chart under **Drill Bit Kits**, page 53. Use appropriate size drill bit to clean mix chamber nozzle (N).

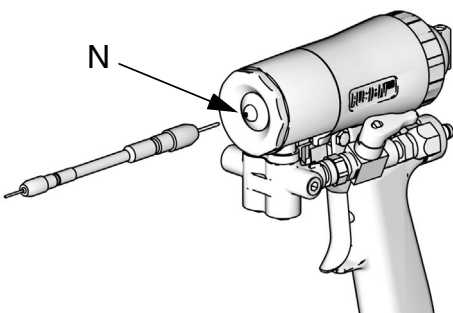


FIG. 40

Table 1: Nozzle Drill Bit Sizes

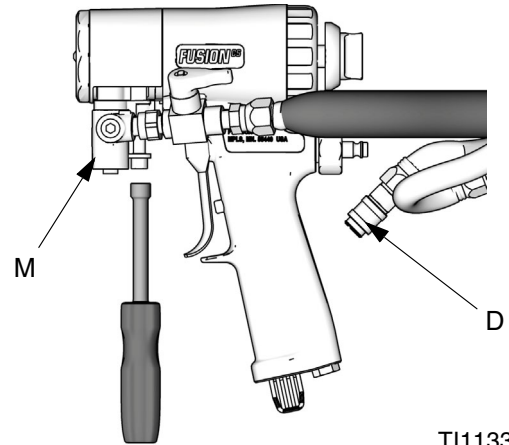
| Round Spray | | Flat Spray | |
|-------------|---------------------|-------------|---------------------|
| Mix Chamber | Drill Size in. (mm) | Mix Chamber | Drill Size in. (mm) |
| RD2020 | #58, .042 (1.00) | FL2020 | 3/32, .094 (2.35) |
| RD0000 | #55, .052 (1.30) | FL0000 | 3/32, .094 (2.35) |
| 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 55.

Clean Impingement Ports

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




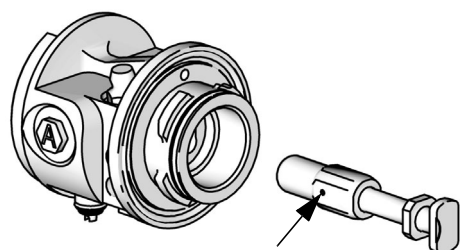
TI11330a

FIG. 41

3. **Flush Gun**, page 26. If gun will not flush, see **Mix Chamber and Side Seal Assemblies**, page 38.
4. **Remove Front End**, page 36.

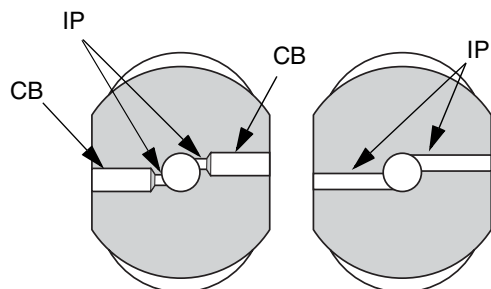
5. Loosen A and B side seals two turns.
6. Pull out mix chamber from back of fluid housing. See Table 2 for appropriate size drill to clean ports. Also see identification chart under **Drill Bit Kits**, page 53.

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



Impingement Port

TI12097a



TI3533a

Mix Chambers RD and
FL, 2020 and 2929Mix Chambers RD and FL,
4242 or larger**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 37.
10. Attach fluid manifold (M). Connect air (D). Return gun to service.

FIG. 42

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 26. |
| | Damaged air valve o-rings (15). | Replace. See Air Valve , page 43. |
| Fluid does not spray when gun is fully actuated. | Closed fluid valves (1b). | Open. |
| | Plugged impingement ports. | Clean Impingement Ports , page 29. |
| | Plugged check valves (44,45). | Clean. See Check Valves , page 41. |
| Gun actuates slowly. | Plugged breather plug (9). | Clean Breather Plug , page 26. |
| | Damaged piston o-rings (4a, 4c). | Replace. See Piston , page 42. |
| | Dirty air valve, or damaged o-rings (15). | Clean air valve or replace o-rings. See Air Valve , page 43. |
| 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 38. |
| Loss of round pattern. | Dirty mix chamber (14) nozzle. | Clean Mix Chamber Nozzle , page 28. |
| | Empty ClearShot Liquid cartridge. | Replace. See ClearShot Liquid Cartridge Installation/Removal , page 23. |
| | ClearShot Liquid dosing pump is not primed. | Prime dosing pump. See ClearShot Liquid Cartridge Installation/Removal , page 23. |
| 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 23. |
| | Dirty mix chamber (14) nozzle. | Clean Mix Chamber Nozzle , page 28. |


| 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 29. |
| | Plugged check valves (44, 45). | Clean. See Check Valves , page 41. |
| | Viscosities not equal. | Adjust temperature to compensate. |
| | Plugged fluid screens. | Clean. See Clean or Replace Fluid Screens , page 27. |
| A and/or B fluid in gun air section. | Damaged side seals (42, 43). | Replace. See Mix Chamber and Side Seal Assemblies , page 38. |
| | Damaged mix chamber (14). | Replace. See Mix Chamber and Side Seal Assemblies , page 38. |
| | Damaged side seal o-rings (42d, 42e). | Replace. See Mix Chamber and Side Seal Assemblies , page 38. |
| | 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 38. |
| | Damaged side seal o-rings (42d, 42e). | Replace. See Mix Chamber and Side Seal Assemblies , page 38. |
| | Damaged mix chamber (14). | Replace. See Mix Chamber and Side Seal Assemblies , page 38. |
| | 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 26. |
| | Damaged/missing fluid housing o-ring (2b or 2c). | Replace. See Parts , page 44. |
| | Damaged front o-ring (2b). | Replace. See Parts , page 44. |
| Reduced cleanoff air. | Damaged fluid housing o-ring (2d). | Replace. See Parts , page 44. |
| Excessive purge air when fluid valves are closed and gun is de-triggered. | Damaged/missing fluid housing o-ring (2c). | Replace. See Parts , page 44. |
| Fluid does not shut off when fluid valves are closed. | Damaged fluid valves (1b). | Replace. See Parts , page 44. |
| 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 43. |
| | Damaged piston o-rings (4a, 4c). | Replace. See Piston , page 42. |
| Air leakage from front air valve. | Damaged air valve o-rings (4d). | Replace. See Air Valve , page 43. |
| Air leak between handle and fluid housing | Damaged o-ring (2c or 2d). | Replace. See Parts , page 44. |
| 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 256416 and for round tips 256414. |
| Gun does not dose ClearShot Liquid. | Empty ClearShot Liquid cartridge. | Replace. See ClearShot Liquid Cartridge Installation/Removal , page 23. |
| | ClearShot Liquid dosing pump is not primed. | Prime dosing pump. See ClearShot Liquid Cartridge Installation/Removal , page 23. |
| | Damaged cartridge o-rings. | Replace. See ClearShot Liquid Cartridge Installation/Removal , page 23. |
| | Damaged or cracked cartridge. | Replace. See ClearShot Liquid Cartridge Installation/Removal , page 23. |
| | Damaged dosing piston. | Repair. See Piston , page 42. |
| Excessive ClearShot Liquid dosing; producing less than 1000 doses per cartridge. | Non-regulated air supply to gun. | Regulate air supply to gun. |
| | Excessive air pressure at gun. | Regulate air supply to 80 psi (0.56 MPa, 5.6 bar). |
| | Damaged or dirty o-rings on air piston and/or dosing piston. | Repair or clean o-rings. See Piston , page 42. |
| 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 , 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 23. |

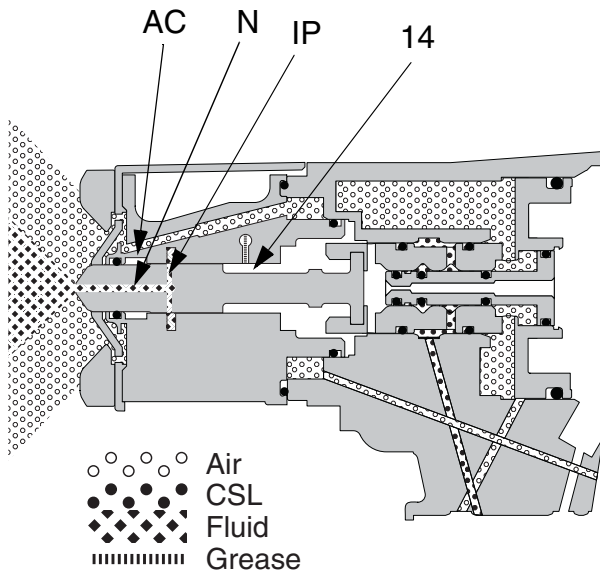
Theory of Operation

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).

 Flow paths are not shown to scale, for clarity.

CSL is dosed into purge air.




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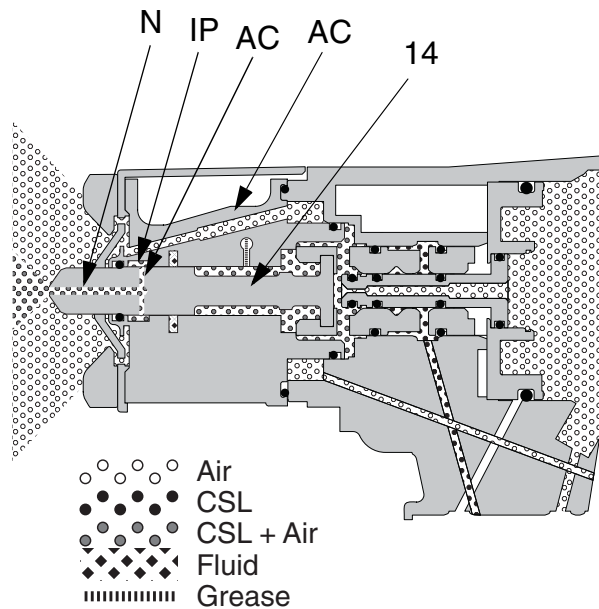
Gun Detriggered (Air Purging)

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).

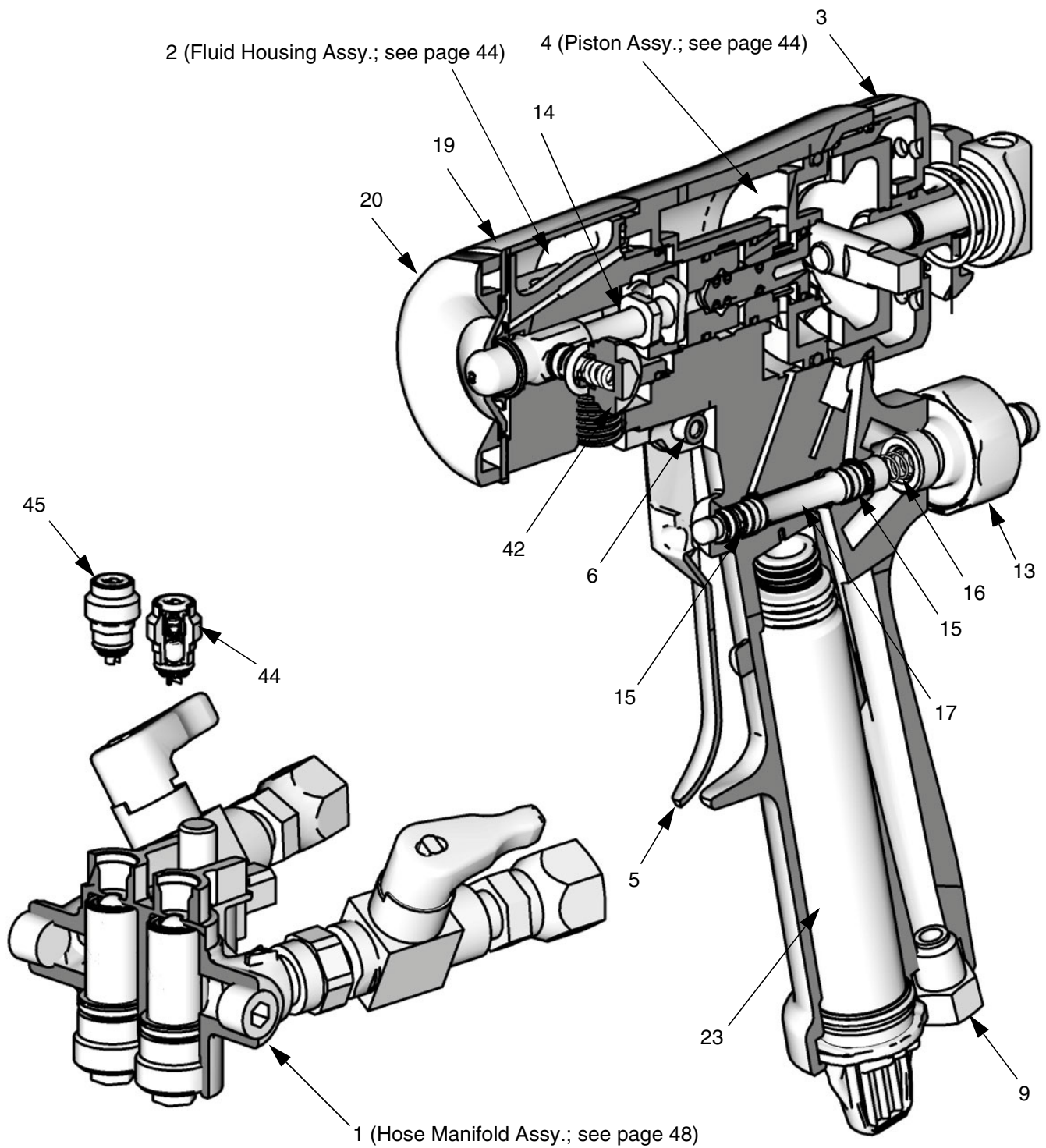
 Flow paths are not shown to scale, for clarity.

CSL is dosed into purge air.



TI12124a

Cutaway View



TI12091a

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 55 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

| | | | | | |
|---|---|--|--|--|--|
|  |  | | | | |
| <p>Proper attachment of front end is critical. Do not operate gun if front end is loose or not snug against handle.</p> | | | | | |

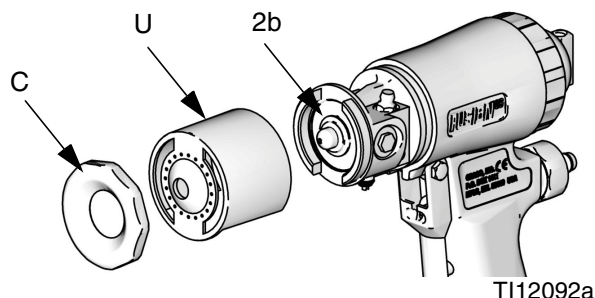
1. Follow **Pressure Relief Procedure**, page page 17.
2. **Flush Gun**, page 26.

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).

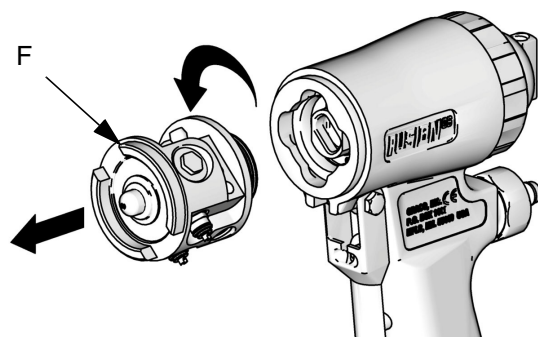
4. Unscrew and remove front cover retainer (C).
5. Remove front cover (U).



TI12092a

FIG. 43

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

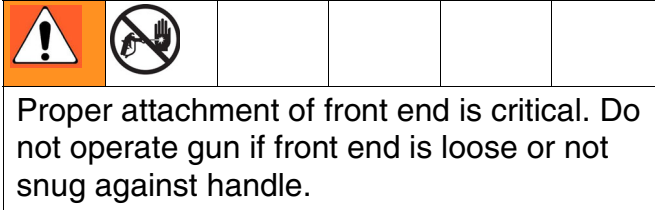


TI12093a

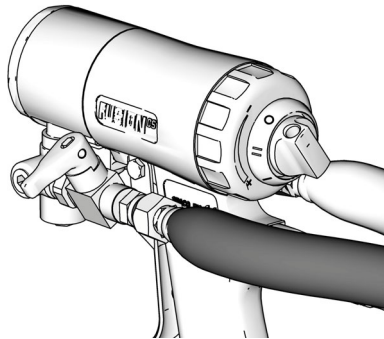
FIG. 44

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

Attach Front End



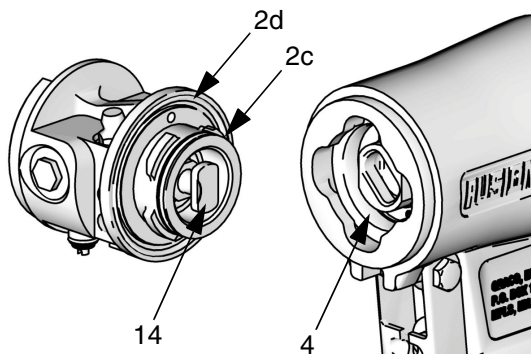
1. Engage piston safety lock, page 12.



TI11326a

FIG. 45

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. 46

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

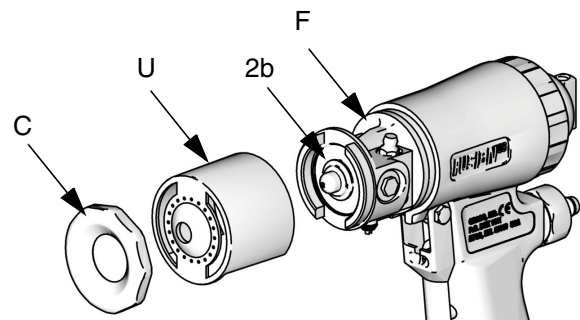
4. Turn fluid housing 1/4 turn clockwise to engage slots.



TI12094a

FIG. 47

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



TI12092a

FIG. 48

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.

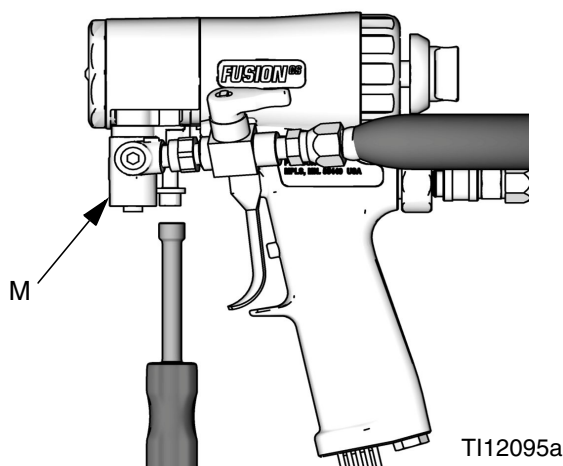


FIG. 49

3. Flush gun to remove residual A and B components. See **Flush Gun**, page 26. Follow **Pressure Relief Procedure**, page 17.
4. Disconnect air (D).

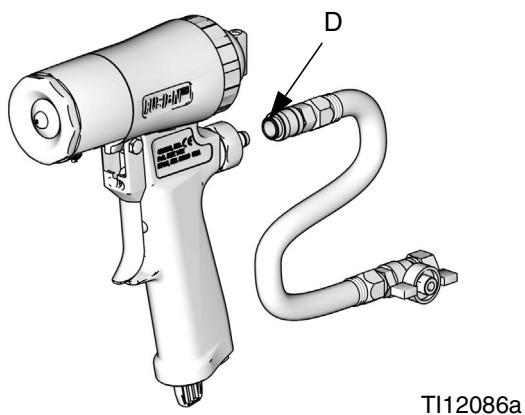


FIG. 50

5. Remove Front End, page 36.

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).

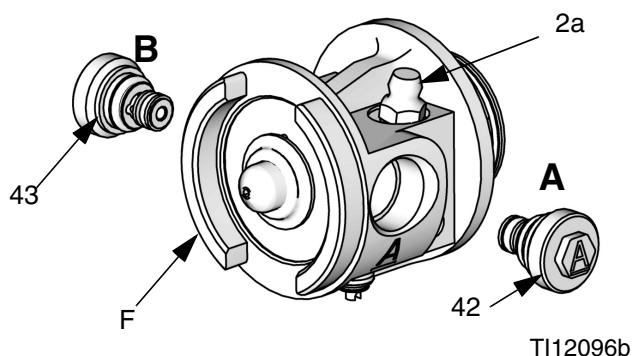


FIG. 51

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 29.

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.

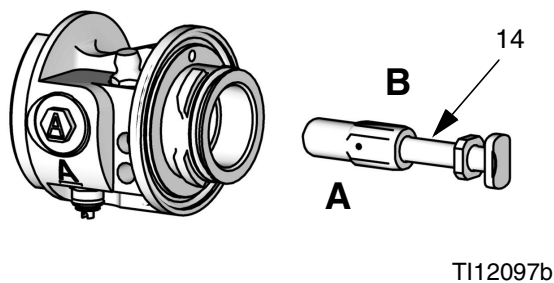


FIG. 52

11. Line up tabs on seal (42c) and seal housing (42a); insert seal into housing. Push down on seal and turn to lock in place.

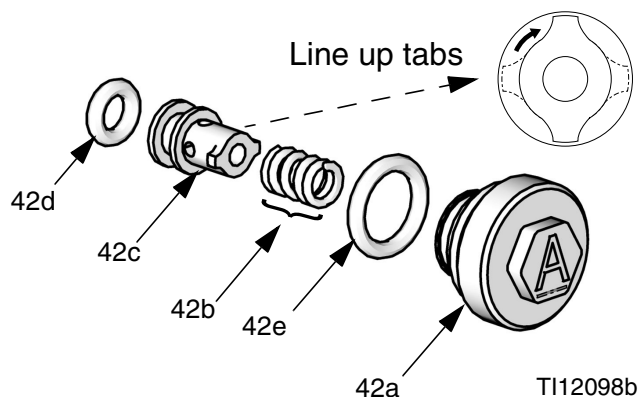


FIG. 53

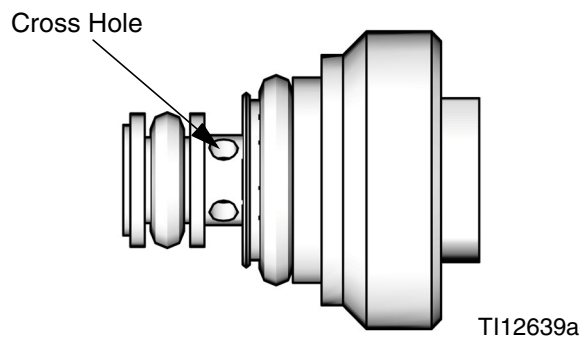
| CAUTION |
|---|
| To prevent cross-contamination of side seal assemblies, do not interchange A component and B component parts. The A component assembly is marked with an A. |

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.

12. Check for proper spring (42b) operation, and that the seal (42c) rotates slightly in the seal housing (42a) detents.

When the seal is installed correctly the spring will be flexible and all four cross holes of the seal will be completely visible. See FIG. 54 for an example of the correct and incorrect seal installation.

Correct Seal Installation



Incorrect Seal Installation

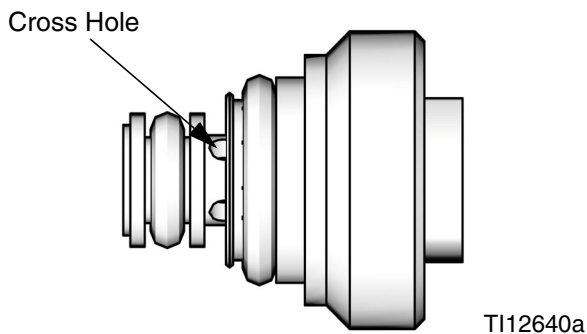


FIG. 54

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

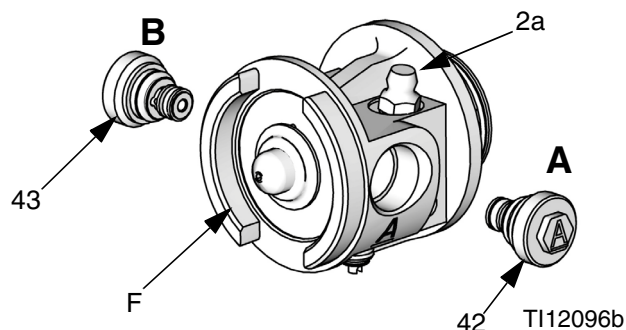


FIG. 55

14. **Attach Front End**, page 37.
15. 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.
16. 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 27.

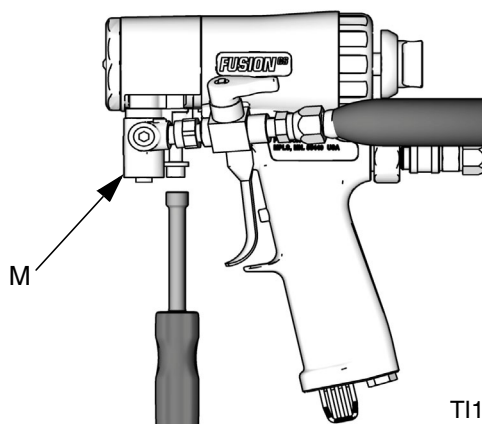


FIG. 56

TI12095a

3. Flush gun to remove residual A and B components. See **Flush Gun**, page 26. Follow **Pressure Relief Procedure**, page 17.
4. Disconnect air (D).

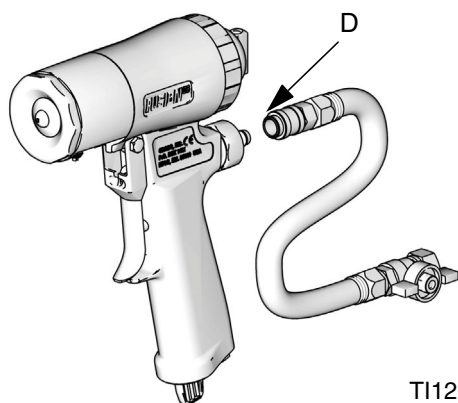


FIG. 57

TI12086a

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).
6. Disassemble check valves using a flat head screwdriver.

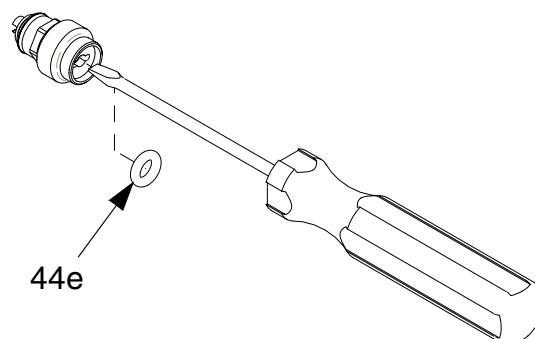
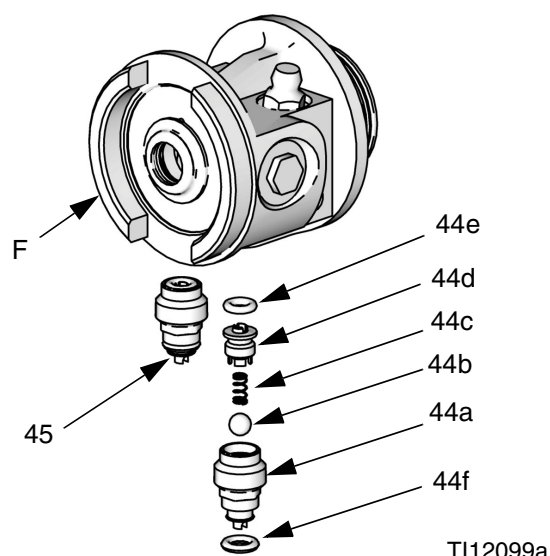


FIG. 58

CAUTION

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

7. 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 individual check valve parts as needed.



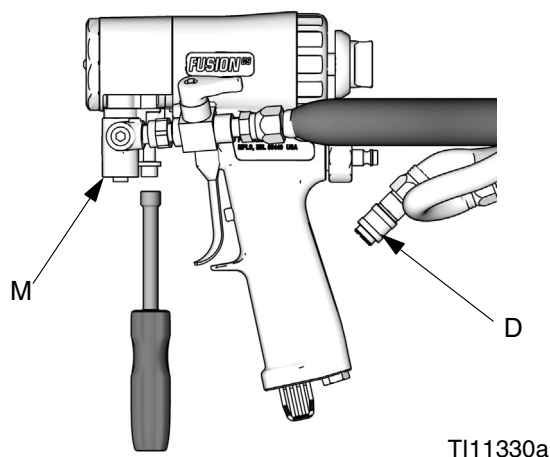
TI12099a

FIG. 59

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

Piston

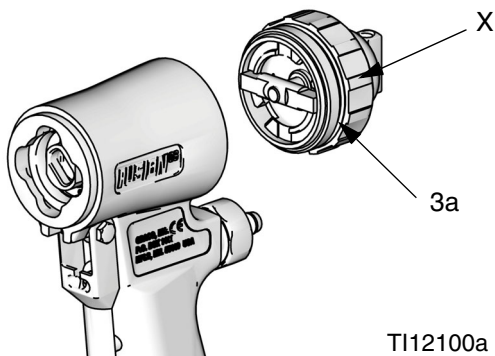
1. Follow **Pressure Relief Procedure**, page 17
2. Disconnect air (D) and remove fluid manifold (M).



TI11330a

FIG. 60

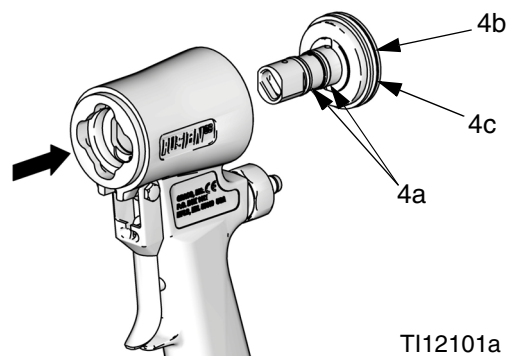
3. **Remove Front End**, page 36.
4. Unscrew variable flow adjustment knob (X) and inspect o-ring (3a).



TI12100a

FIG. 61

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

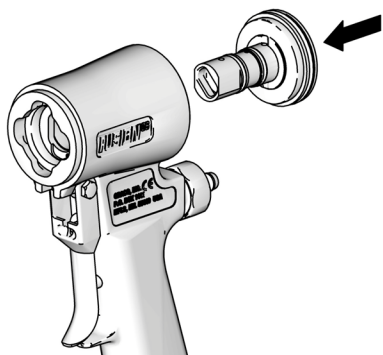


TI12101a

FIG. 62

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).

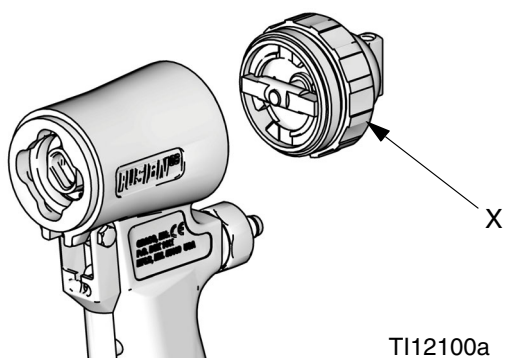
11. Reinstall piston. Shaft is keyed for proper assembly. Push firmly to seat piston.



TI12102a

FIG. 63

12. Install variable flow adjustment knob (X).



TI12100a

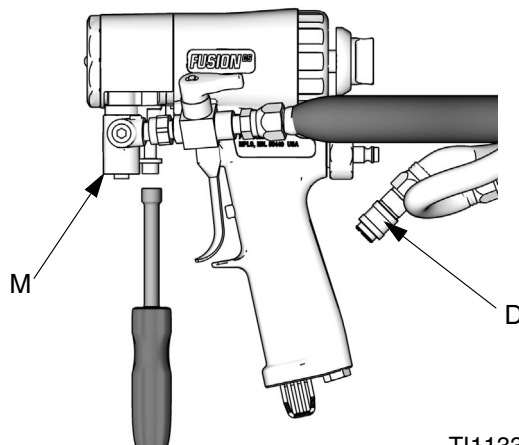
FIG. 64

13. **Attach Front End**, page 37.
14. Attach fluid manifold (M).
15. Install ClearShot Liquid cartridge. See **ClearShot Liquid Cartridge Installation/Removal**, page 23.
16. Connect air. Return gun to service.

Air Valve

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

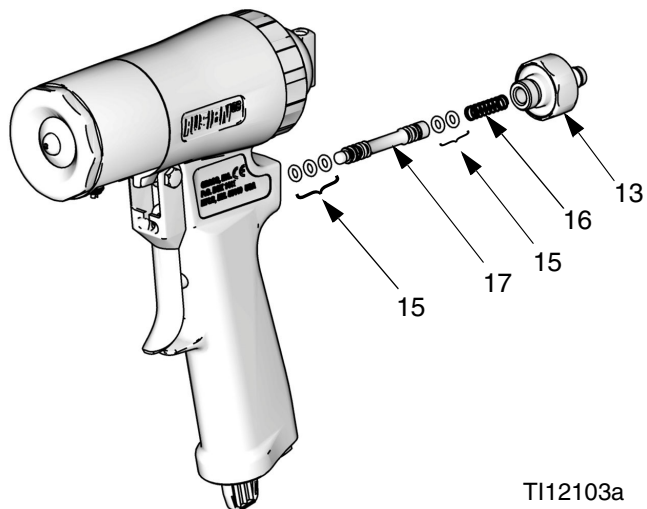
2. Disconnect air (D) and remove fluid manifold (M).



TI11330a

FIG. 65

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).



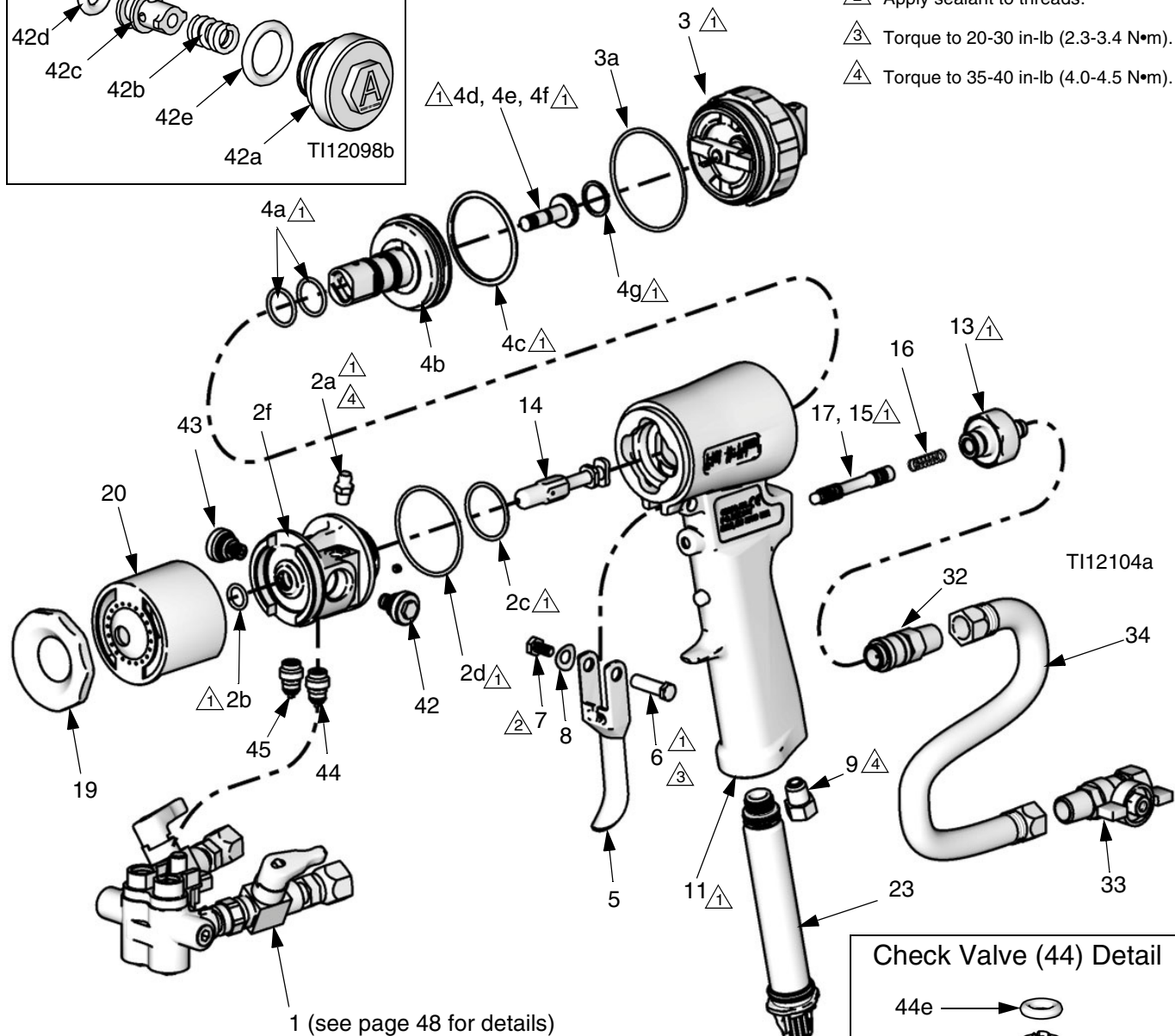
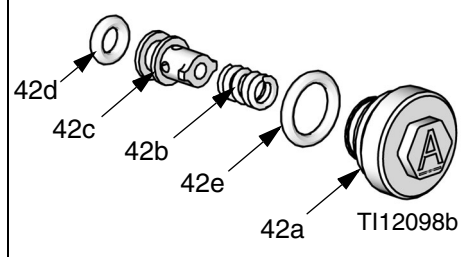
TI12103a

FIG. 66

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.

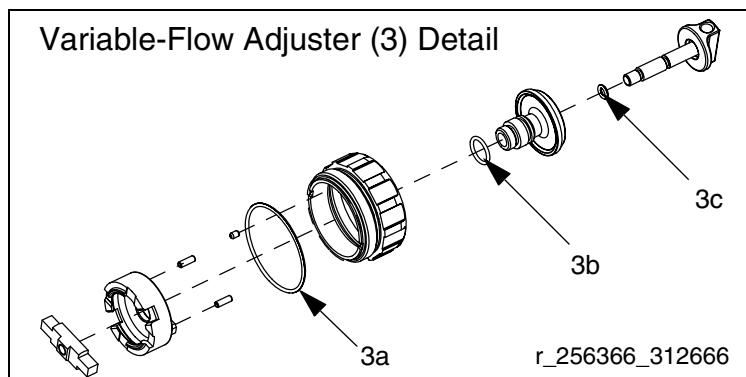
Parts

Seal Assembly (42) Detail

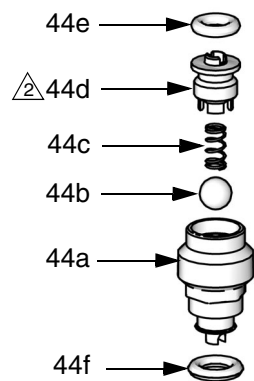


1 (see page 48 for details)

Variable-Flow Adjuster (3) Detail



Check Valve (44) Detail



T112105a

Parts

| 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 | KIT, valve, check, a side; includes 1c and 256469 (o-ring) | 1 | 7 | 203953 | SCREW; 10-24 x 3/8 in. (10 mm) | 1 |
| 1c† | 256462 | KIT, valve, check, b side; includes 1b and 256469 (o-ring) | 1 | 8 | 15C480 | WASHER, wave | 1 |
| 1d | 15B221 | BOLT; 5/16-24 | 3 | 9 | 121540 | PLUG, breather | 1 |
| 1e | 100139 | PLUG, pipe | 1 | 11 | 256458 | HANDLE, kit; includes ref. 12 | 1 |
| 1f | 117634 | SWIVEL, union; #6 JIC | 1 | 13 | 15T897 | PLUG, air valve | 1 |
| 1g | 117635 | SWIVEL, union | 1 | 14❖ | | CHAMBER, mix | 1 |
| 1h‡ | 256460 | VALVE, ball, resin | 1 | 15 | | O-RING | 5 |
| 1j‡ | 256459 | VALVE, ball, iso | 1 | 16 | 117485 | SPRING, compression | 1 |
| 1k | 15U395 | ADAPTER, male x female; 1/8 npt | 2 | 17 | 256455 | VALVE, spool; includes 15 | 1 |
| 2 | 256457 | HOUSING, fluid, assy; includes 2a-2f and 42-45 | 1 | 19 | 256414 | RETAINER, cover (pack of 5) | 1 |
| 2a | 100846 | FITTING, lubrication | 1 | 20 | ❖256415 | COVER, front, round, tip (pack of 5) | 1 |
| 2b✓ | 248648 | O-RING (pack of 6) | 1 | | ❖256416 | COVER, front, flat, tip (pack of 5) | 1 |
| 2c✓ | 256773 | O-RING (pack of 6) | 1 | 21❖* | | TIP, spray | 1 |
| 2d✓ | 248132 | O-RING (pack of 6) | 1 | 23★ | 256385 | KIT, clearshot cartridge (pack of 25) | 1 |
| 2f | | HOUSING | 1 | 25❖ | | TOOL, cleanout | 1 |
| 3 | 256456 | ADJUSTER, variable-flow | 1 | 26❖ | | TOOL, cleanout | 1 |
| 3a✓ | 256774 | O-RING (pack of 6) | 1 | 27❖ | | TOOL, cleanout, #69 | 1 |
| 3b | 257426 | O-RING (pack of 6) | 1 | 28 | 117661 | PIN, vise | 1 |
| 3c | 257425 | O-RING (pack of 6) | 1 | 29† | 117773 | LUBRICANT | 1 |
| 4 | 256454 | PISTON, assy. | 1 | 30† | 117792 | GUN, grease | 1 |
| 4a✓ | 256772 | O-RING (pack of 6) | 2 | 31† | 118665 | GREASE, Fusion; 4 oz | 1 |
| 4b | | PISTON | 1 | 32 | 117510 | COUPLER, line, air; 1/4 npt | 1 |
| 4c✓ | 256775 | O-RING (pack of 6) | 1 | 33 | 15B565 | VALVE, ball | 1 |
| 4d | | O-RING | 3 | 34 | 15B772 | HOSE, air; 18 in. | 1 |
| 4e | 257424 | PISTON, dosing, assy; includes 4d and 4f | 1 | 35 | 112307 | ELBOW, street | 2 |
| 4f | 257426 | O-RING (pack of 6) | 1 | 36 | 117642 | NUT DRIVER | 1 |
| 4g | 121642 | RING, retaining, internal spiral | 1 | 37 | 118575 | SCREW DRIVER, 1/8 blade | 1 |
| | | | | 38▲ | 172479 | TAG, instruction | 1 |
| | | | | 39▲ | 222385 | TAG, warning | 1 |

| Ref. | Part | Description | Qty. |
|------|--------|--|------|
| 40 | 256641 | MANIFOLD, flush; includes 1d, 49, and 50. | 1 |
| 41 | 256642 | KIT, inlet cap; includes 1d | 1 |
| 42 | 256463 | KIT, seal, a side, assy; includes 42a-42e and 43 | 1 |
| 42a | | HOUSING, seal, side | 1 |
| 42b | 256923 | SPRING, compression (pack of 10) | 1 |
| 42c* | 256464 | SEAL, side; includes 42d | 1 |
| 42d✓ | 256467 | O-RING (pack of 6) | 1 |
| 42e✓ | 256468 | O-RING (pack of 6) | 1 |
| 43† | 256463 | KIT, seal, b side, assy; includes 42 and 43a-43e | 1 |
| 43a | | HOUSING, seal, side | 1 |
| 43b | 256923 | SPRING, compression | 1 |
| 43c* | 256464 | SEAL, side; includes 43d | 1 |
| 43d✓ | 256467 | O-RING (pack of 6) | 1 |
| 43e✓ | 256468 | O-RING (pack of 6) | 1 |
| 44◆ | 257422 | KIT, valve, check, a side; includes 44a-44f | 1 |
| 44a | 257427 | HOUSING, check valve, a side (pack of 10) | 1 |
| 44b | 257420 | BALL; carbide (pack of 10) | 1 |
| 44c | 257419 | SPRING, compression (pack of 10) | 1 |
| 44d | 257421 | RETAINER, ball (pack of 10) | 1 |
| 44e✓ | 246354 | O-RING (pack of 6) | 1 |
| 44f✓ | 256771 | O-RING (pack of 6) | 1 |
| 45◆† | 257423 | KIT, valve, check, b side; includes 45a-45f | 1 |
| 45a | 257428 | HOUSING, check valve, b side (pack of 10) | 1 |
| 45b | 257420 | BALL; carbide (pack of 10) | 1 |
| 45c | 257419 | SPRING, compression (pack of 10) | 1 |
| 45d | 257421 | RETAINER, ball (pack of 10) | 1 |
| 45e✓ | 246354 | O-RING (pack of 6) | 1 |
| 45f✓ | 256771 | O-RING (pack of 6) | 1 |
| 46✕ | 256567 | RETAINER, tip | 1 |
| 47✕✱ | 246360 | O-RING; PTFE (pack of 3) | 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.

✕ Wide and round pattern models only.

✕ Flat pattern models only.

❖ See tables on page 47 for kit number.

✓ Also included in o-ring repair kit(s); see page 51.

★ ClearShot Liquid cartridges also available in packages of 50 and 100. See **Accessories**, page 55.

* Side seals also available in packages of 2 and 20. See **Accessories**, page 55.

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

◆ Parts included in kit 256461.

* See **Flat Tip Kits**, page 50, for part number.

‡ Replacement handles are available in Kit 24W375.

Wide and Round Pattern Models Varying Parts Table

| | 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 Varying Parts Table

| | Reference Number | | | |
|--------|------------------|----|----|----|
| Model | 14 | 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 | | | |

Convert Round Pattern to Flat Pattern

To convert a round pattern gun to a flat pattern gun, order the following parts.

| Ref. | Part | Description | Qty. |
|------|--------|--|------|
| 14 | FLxxxx | CHAMBER, mix; see Flat Pattern Mix Chamber Kits , page 50 | 1 |
| 20 | 256416 | COVER, front, flat, tip (pack of 5) | 1 |
| 21 | FTxxxx | TIP, spray; see Flat Tip Part Reference Guide , page 50 | 1 |
| 46 | 256567 | RETAINER, tip | 1 |

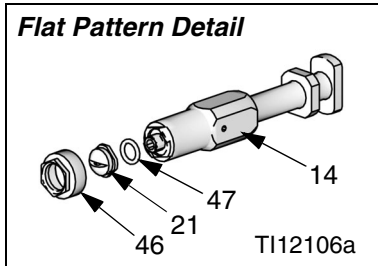
Convert Flat Pattern to Round Pattern

To convert a flat pattern gun to a round pattern gun, order the following parts.

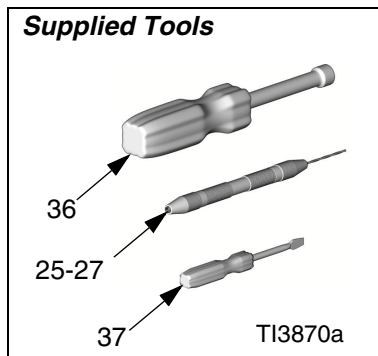
| Ref. | Part | Description | Qty. |
|------|--------|---|------|
| 14 | RDxxxx | CHAMBER, mix; see Round Pattern Mix Chamber Kits , page 49 | 1 |
| | WDxxxx | CHAMBER, mix; see Wide Pattern Mix Chamber Kits , page 49 | |
| 20 | 256415 | COVER, front, round, tip (pack of 5) | 1 |

Detail Views

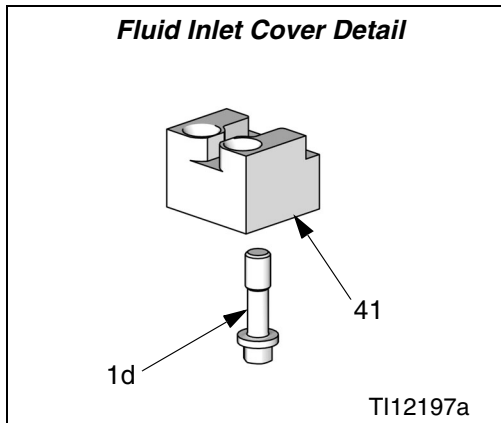
Flat Pattern Detail



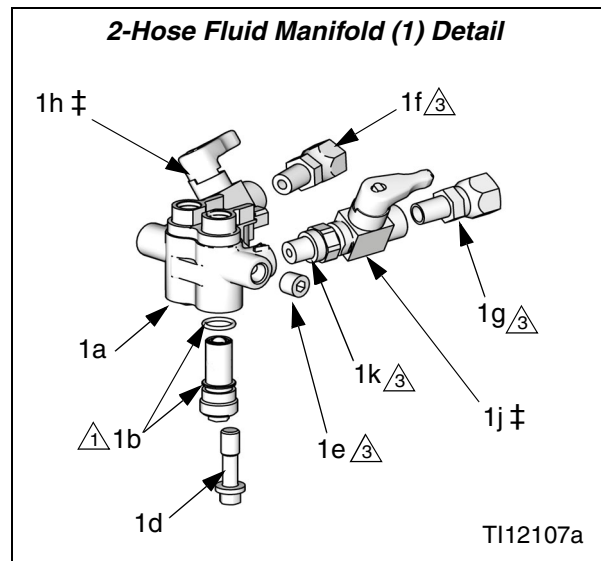
Supplied Tools



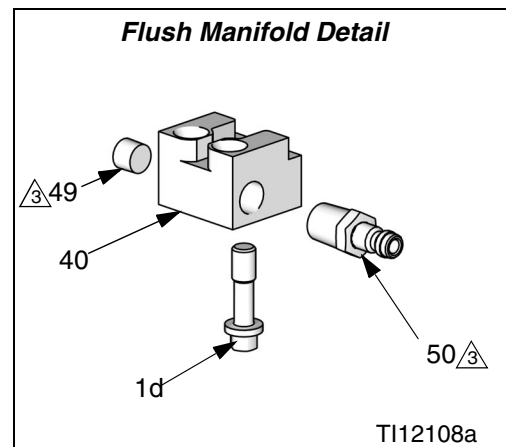
Fluid Inlet Cover Detail



2-Hose Fluid Manifold (1) Detail



Flush Manifold Detail



1 Apply lubricant to seals.

3 Apply sealant to threads.

Mix Chamber Kits

Round Pattern Mix Chamber Kits

| Mix Chamber Kit (includes drill bits) | Pattern Diameter at 24 in. (609.6 mm) to target in (mm) | 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 | 5 (127) | 0.042 | #58 (1.00) | 0.020 | #76 (0.50) | 0.060 | #53 (1.50) |
| RD0000 | 8 (203) | 0.052 | #55 (1.30) | 0.029 | #69 (0.70) | 0.060 | #53 (1.50) |
| RD0101 | 11 (279) | 0.060 | #53 (1.50) | 0.042 | #58 (1.00) | N/A | N/A |
| RD0202 | 12 (305) | 0.070 | #50 (1.75) | 0.052 | #55 (1.30) | N/A | N/A |
| RD0303 | 14 (356) | 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 Mix Chamber Kits

| 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

| Flat Pattern Model | Ref. 21, Spray Tip | Pattern Size, in. (mm) |
|--------------------|--------------------|------------------------------|
| CSxxF1 | FT0424 | low flow, 8-10 (203-254) |
| CSxxF2 | FT0438 | medium flow, 8-10 (203-254) |
| CSxxF3 | FT0624 | low flow, 12-14 (305-356) |
| CSxxF4 | FT0638 | medium flow, 12-14 (305-356) |
| CSxxF5 | FT0838 | medium flow, 16-18 (406-457) |
| CSxxF6 | 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 | | | | | | | | | | |

Bulk O-ring Kits

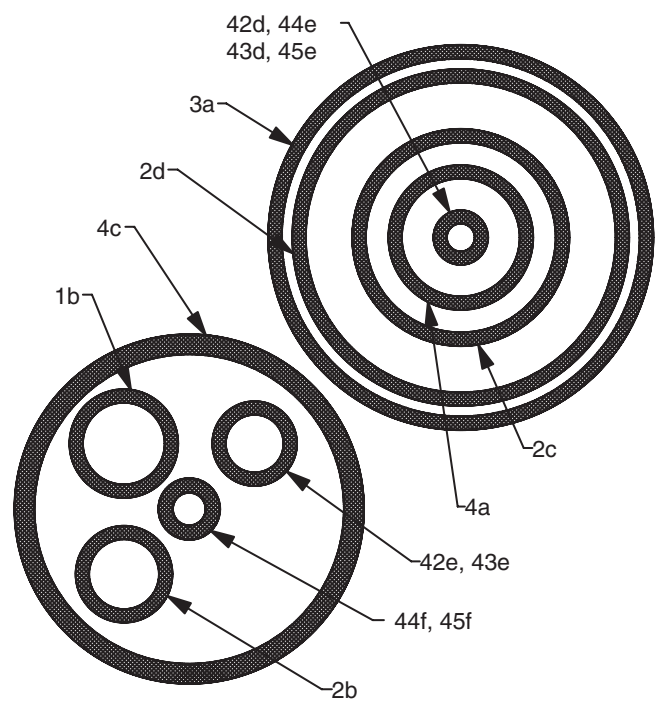
The following table indicates the specific o-ring(s) reference number and corresponding kit number. Each kit includes a quantity of six o-rings.

| | Reference Number | | | | | | | | | | |
|------------|------------------|--------|--------|--------|--------|--------|--------|-------------|-------------|-------------|-------------|
| | 1b | 2b | 2c | 2d | 3a | 4a | 4c | 42d, 43d | 42e, 43e | 44e, 45e | 44f, 45f |
| Kit | 256469 | 248648 | 256773 | 248132 | 256774 | 256772 | 256775 | *256467 | 256468 | 246354 | 256771 |

* Includes installation tools and side seal springs.

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 51 for the quantity of each.




Check Valve Filter Screen Kits

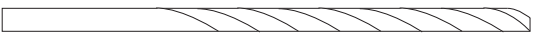

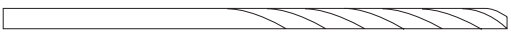
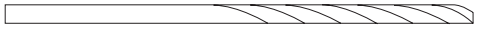
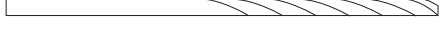
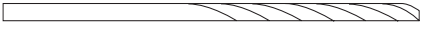
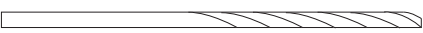
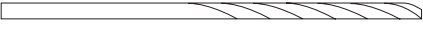

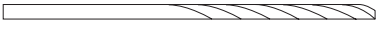

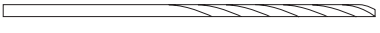


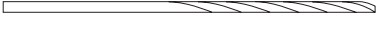
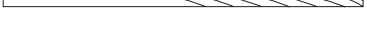

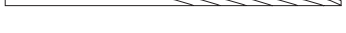

Kits include 10 filter screens.
The 80 mesh filter screen is standard with gun.












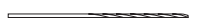

| Part | Description |
|--------|---------------------------------|
| 246357 | 40 mesh (0.015 in., 375 micron) |
| 246358 | 60 mesh (0.010 in., 238 micron) |
| 246359 | 80 mesh (0.007 in., 175 micron) |

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 29.

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 48.

Fluid Inlet Cover

Kit 256642; includes 15R910 and 15B221. See page 48.

Gun Cleaning Kit

15D546

Kit includes 11 tools and brushes to clean the gun.

ClearShot Liquid Cartridges

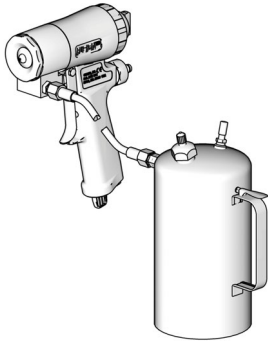
See MSD060.

| 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.

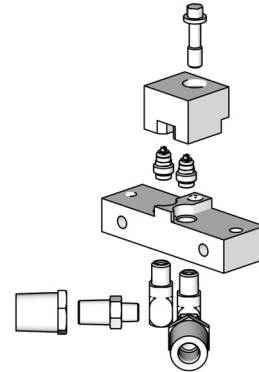


TI12110a

Circulation Manifold

256566

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

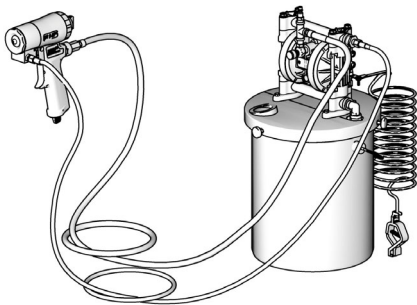


TI12109a

Solvent Flush Pail Kit

248229 5.0 gal. (19 liter) Pail

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

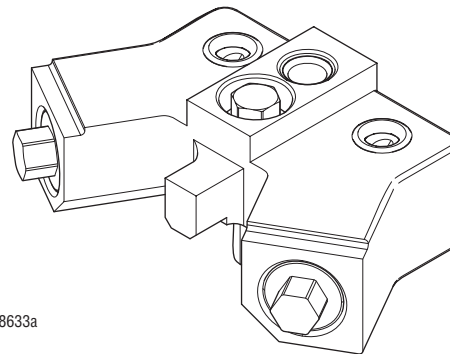


TI12111a

Fusion AP Manifold Adapter

258996

Allows Fusion CS gun to fit onto existing Fusion manifold.

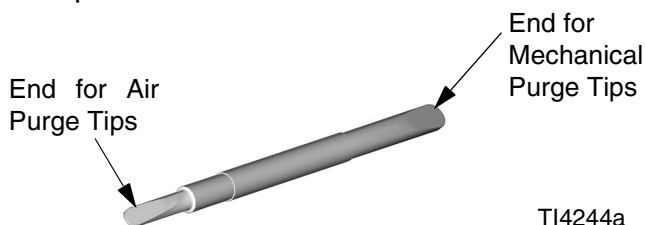


ti18633a

Tip Cleanout Tool

15D234

Designed to fit CeramTip internal dome and flat tip slits.



TI4244a

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 | 75.27 dB(A), using RD0202 at 100 psi (0.7 MPa, 7 bar) |
| Sound Power, measured per ISO 9416-2 | 73.45 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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Original instructions. This manual contains English. MM 312666

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