

FUSION™

310649 Rev.A

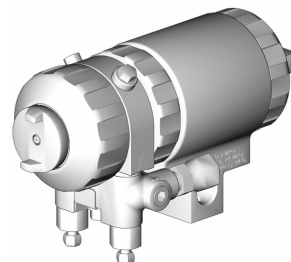
Automatic Plural Component, Impingement Mix Spray Gun

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

*3500 psi (24.2 MPa, 242 bar) Maximum Fluid Working Pressure
80-130 psi (0.55-0.9 MPa, 5.5-9.1 bar) Air Inlet Pressure Range
200°F (94°C) Maximum Fluid Temperature*

Air Purge Gun

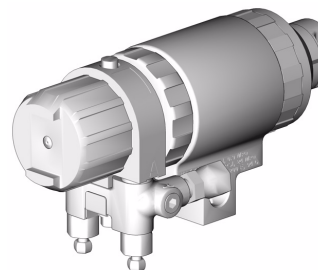
For model information and related manuals, see page 3.



TI4524a

Mechanical Purge Gun

For model information and related manuals, see page 4.



TI4525a

US Patent Number D479,305
Korean Patent 338185
Australian Patent Number 152610

PROVEN QUALITY. LEADING TECHNOLOGY.

Contents

Contents	2	Setup	10
Manual Conventions	2	Pressure Relief Procedure	13
Air Purge Guns	3	Shutdown	14
Mechanical Purge Guns	4	Parts	16
Warning	5	Air Purge Gun	16
Overall View	7	Mechanical Purge Gun	18
Installation	8	Mounting Dimensions	20
Mounting gun to rod	8	Technical Data	21
Mounting gun to stationary support or robot arm	8	Graco Standard Warranty	22
Mounting Information	8	Graco Information	22
Connecting airline and accessories	9		

Manual Conventions

Warning

WARNING

A warning alerts you to possible serious injury or death if you do not follow instructions.

Symbols, such as fluid injection (shown), alert you to a specific hazard and direct you to read the indicated hazard warnings on pages 5-6.

Caution

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

Note

A note indicates additional helpful information.

Air Purge Guns

Round Pattern Guns

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

Flat Pattern Guns

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

Related Manuals

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

Fusion Air Purge Spray Gun	
Part No.	Description
309550	Instruction-Parts Manual (English)
309745	Pistola de purga aerográfica Fusion, Instrucciones-Piezas
309746	Instructions-Pièces pour pistolet à purge d'air Fusion
309747	Betriebsanleitung für Fusion Luftspülpistole
309753	Fusion エアパーシガン取扱説明書-部品
309754	Fusion 空气清洗喷枪零部件说明书
309755	Fusion 에어 퍼지 건 지침-부품

Mechanical Purge Guns



Use only these mix module/tip combinations.

Standard Round Pattern Guns

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

Direct Impingement Round Pattern Guns

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






Direct Impingement Flat Pattern Guns





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

Related Manuals

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

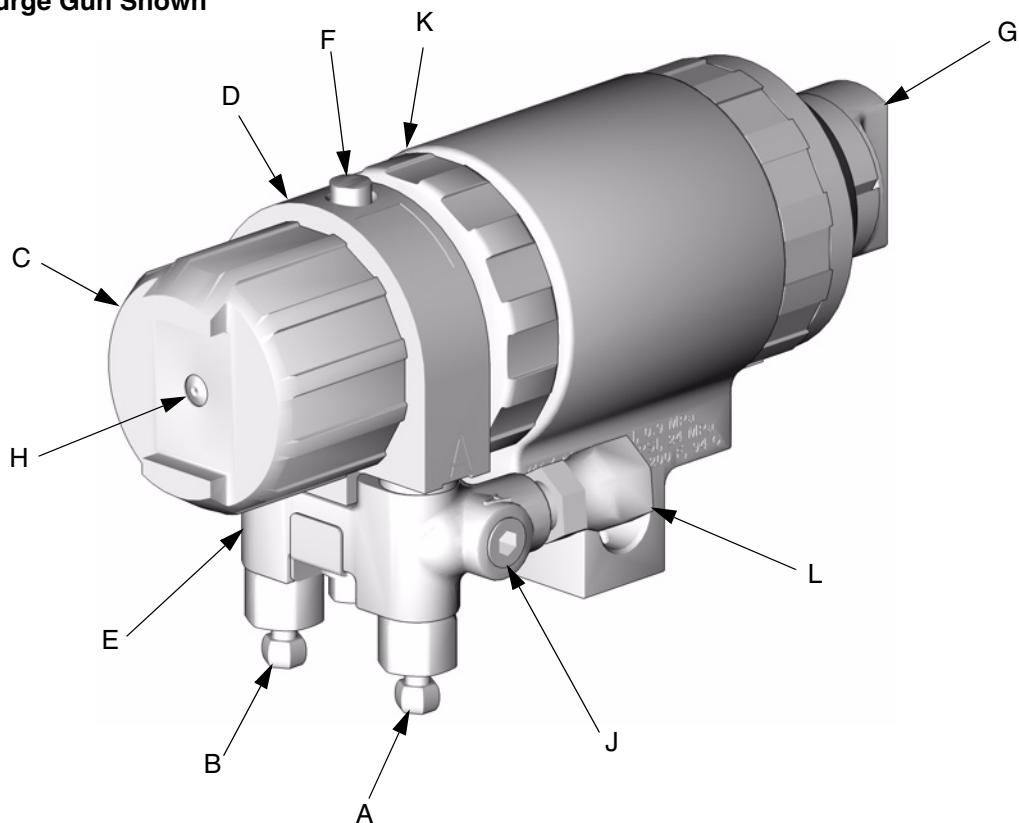
Fusion Mechanical Purge Spray Gun	
Part No.	Description
309856	Instruction-Parts Manual (English)
310627	Instructions-Pièces pour pistolet à purge d'air Fusion
310628	Betriebsanleitung für Fusion Luftspülpistole
310629	Pistola de purga aerográfica Fusion, Instrucciones-Piezas
310630	Fusion 空气清洗喷枪零部件说明书
310631	Fusion エアパーシガン取扱説明書-部品
310632	Fusion 에어 퍼지 건 지침-부품

 WARNING	
	<p>PERSONAL PROTECTIVE EQUIPMENT</p> <p>You must wear proper 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 Material Safety Data Sheet (MSDS) 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.
	<p>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 medical attention.</p> <ul style="list-style-type: none"> • Do not point the gun at anyone or at any part of the body. • Do not put your hand or fingers over the gun fluid nozzle. • Do not stop or deflect leaks with your hand, body, glove, or rag. • Do not “blow back” fluid; this is not an air spray system. • Follow Pressure Relief Procedure, page 13, when you stop spraying and before cleaning, checking, or servicing equipment. • Use lowest possible pressure when flushing, priming, or troubleshooting. • Engage piston safety lock when not spraying. • Tighten all fluid connections before operating the equipment. • Check hoses, tubes, and couplings daily. Replace worn or damaged parts immediately. High pressure hose cannot be recoupled; replace the entire hose.
	<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). • Do not plug or unplug power cords or turn lights on or off when flammable fumes are present. • Keep the work area free of debris, including solvent, rags, and gasoline. • Ground equipment and conductive objects. See Grounding in Fusion Gun manual 309550 or 309856. • Hold gun firmly to side of grounded pail when actuating into pail. • Use only grounded hoses. • If there is static sparking or you feel a shock, stop operation immediately. Do not use equipment until you identify and correct the problem.
	<p>EQUIPMENT MISUSE HAZARD</p> <p>Misuse can cause serious injury or death.</p> <ul style="list-style-type: none"> • For professional use only. • Use equipment only for its intended purpose. Call your Graco distributor for information. • Read manuals, warnings, tags, and labels before operating equipment. Follow instructions. • Check equipment daily. Repair or replace worn or damaged parts immediately. • Do not alter or modify equipment. Use only Graco parts and accessories. • Do not exceed the maximum working pressure or temperature rating of the lowest rated system component. See Technical Data in all equipment manuals. • Use fluids and solvents that are compatible with equipment wetted parts. See Technical Data in all equipment manuals. Read fluid and solvent manufacturer's warnings. • Route hoses and cables away from traffic areas, sharp edges, moving parts, and hot surfaces. • Do not use hoses to pull equipment. • Comply with all applicable safety regulations.
	<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

Mechanical Purge Gun Shown



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Key:

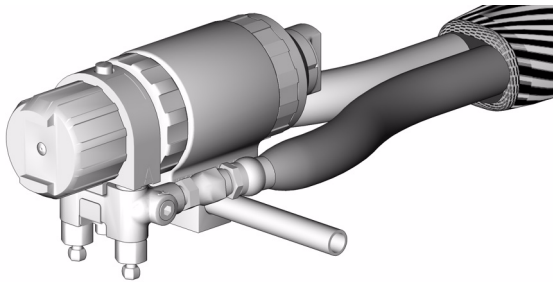
- A A Side Fluid Valve (ISO)
- B B Side Fluid Valve (RESIN)
- C Air Cap
- D Fluid Housing
- E Gun Fluid Manifold
- F Cleanoff Air Valve

- G Piston Safety Lock
- H CeramTip (behind air cap)
- J Optional Fluid Inlets (A Side Shown)
- K Lock Ring
- L Fluid Inlet Swivels (A Side Shown)

Installation

Mounting gun to rod

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



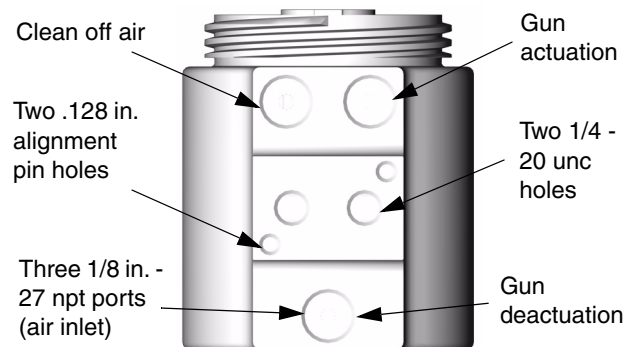
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2. Secure the gun to the bar by tightening 1/4 in. - 20 mounting screws.

Mounting gun to stationary support or robot arm

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

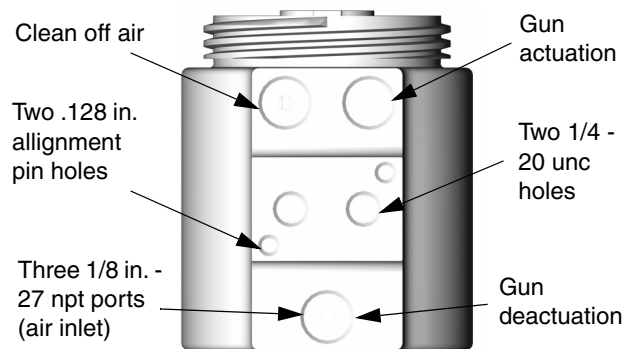
Mounting Information



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Connecting airline and accessories

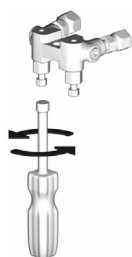
- 1.** On each gun air supply line, install an air pressure regulator.
 - It is recommended that the tip clean off air, gun actuation, and gun deactuation air be supplied and regulated separately.
 - A minimum of 80 psi (.55 mpa, 5.5 bar) air pressure must be supplied to the gun for proper operation.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



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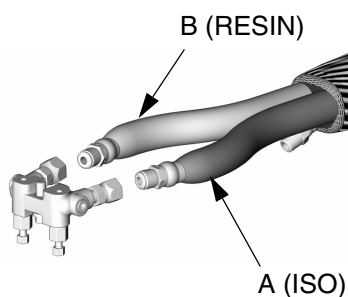
Setup

1. Close fluid valves A and B.



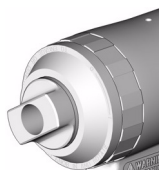
TI2411A

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



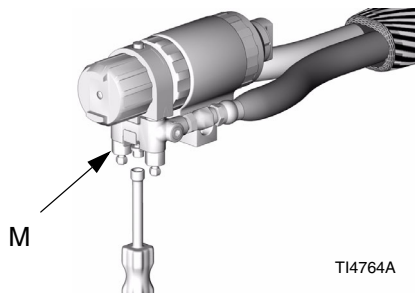
TI2417A

3. Engage piston safety lock.




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

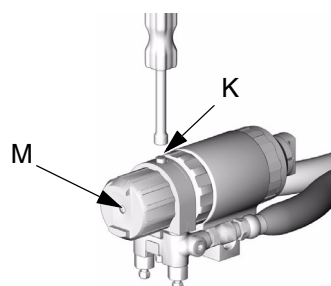


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 To change position of fluid manifold or use optional fluid inlets, see Fusion Gun manual 309856 or 309550.

5. For Mechanical Purge Guns Only:

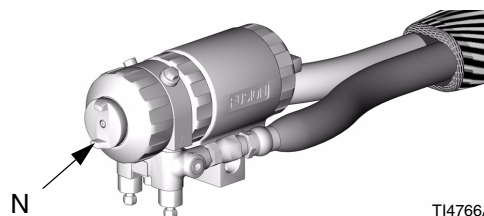
- a. Open clean off air line valve. Air should flow from air cap around Ceram Tip (M).
- b. Open clean off air valve (K) about 1/4 to 1/2 turn, then adjust air flow as required.
- c. Adjust purge rod, see manual 309856.
- d. Go to step 10.



TI4765A

For Air Purge Guns Only:

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

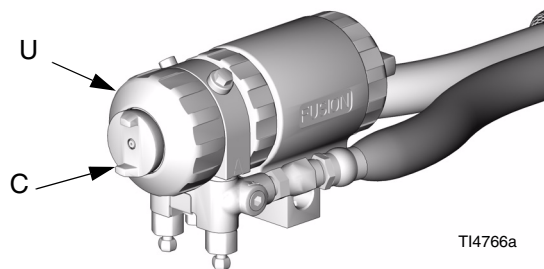


TI4766A

6. Disengage piston safety lock.



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

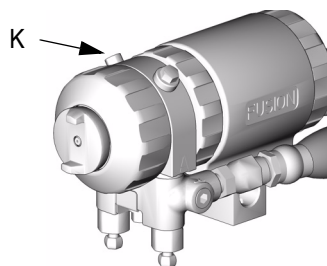


- 9.** Engage piston safety lock.



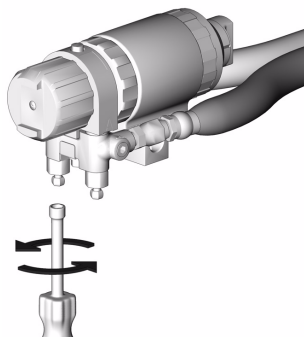
TI2409A

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



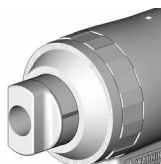
10. Turn on proportioner.

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



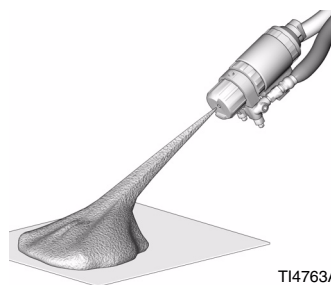
TI4752A

12. Disengage piston safety lock.



TI3849

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



TI4763A

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

15. Gun is ready to spray.

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

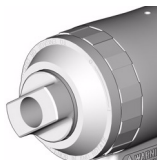
Pressure Relief Procedure

⚠ WARNING



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

1. Engage piston safety lock.

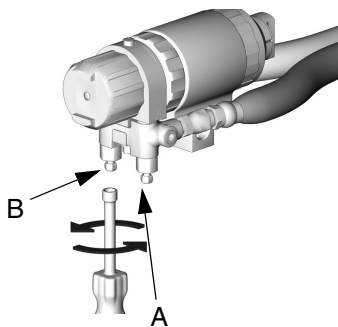


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CAUTION

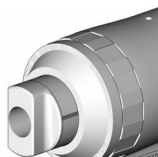
Air supply is required for gun actuation. Do not disconnect gun air supply until fluid pressure is relieved.

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



TI4752A

3. Disengage piston safety lock.



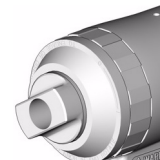
TI3849A

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



TI4753a

5. Engage piston safety lock.



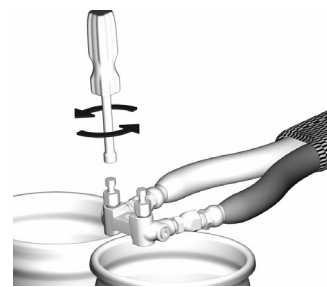
TI3850A

⚠ WARNING



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 after the gun is removed, place the fluid manifold over containers, facing away from you. Very carefully open the fluid valves. Under high pressure, fluid will spray sideways from the fluid ports.



TI2484A

Shutdown

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

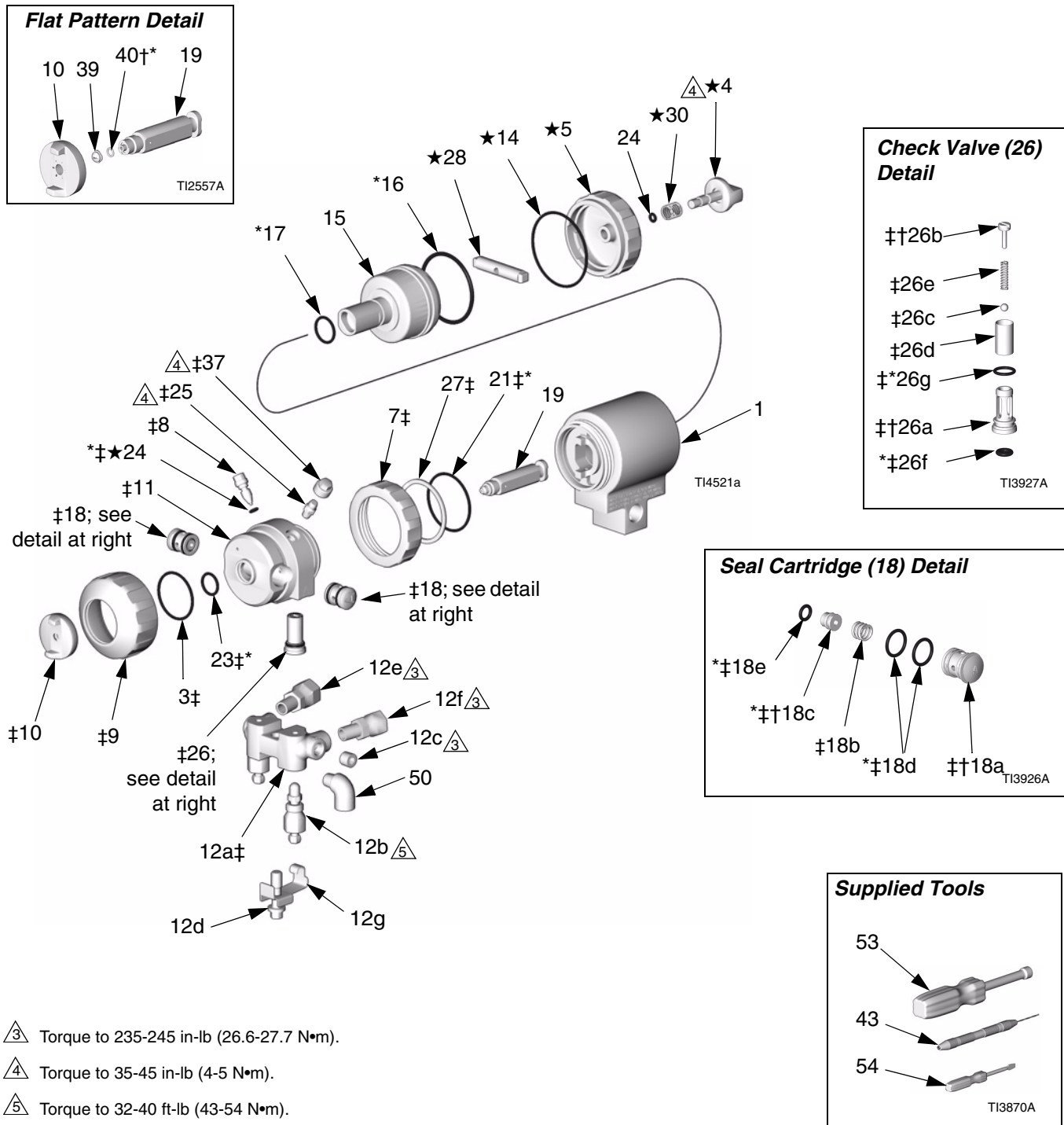


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Parts

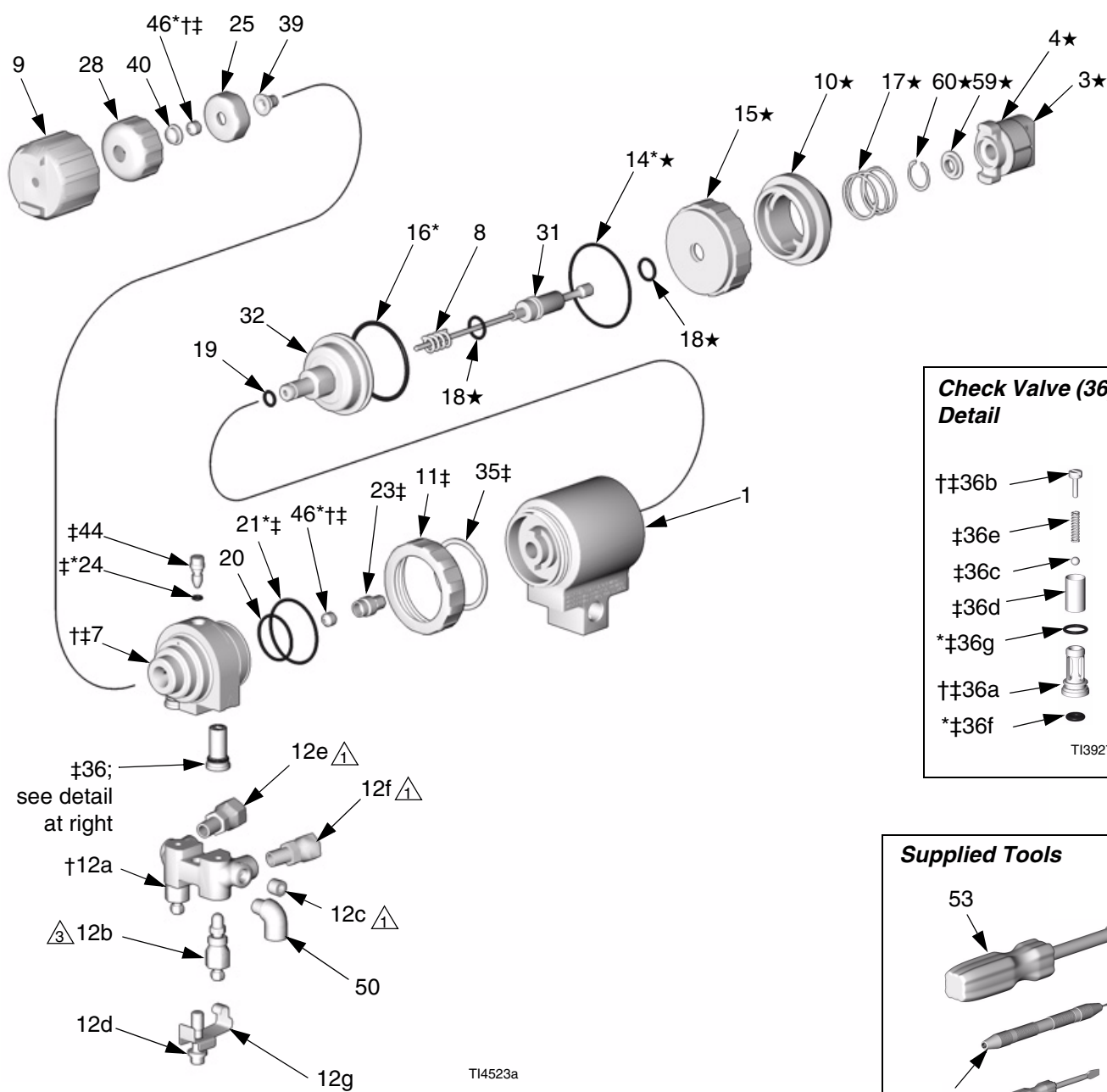
Air Purge Gun

Round Pattern Gun Shown

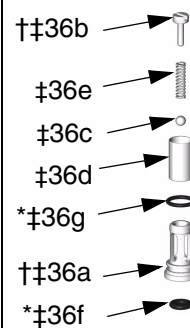


Ref. No.	Part No.	Description	Qty	Ref. No.	Part No.	Description	Qty
1	15D918	BODY, air purge	1	27†	116550	RING, retaining	1
3†	248137	O-RING; PTFE; package of 6	1	28★	15B205	STOP, piston	1
4★	15B206	LOCK, safety	1	30★	114070	SPRING	1
5★	15B204	CAP, cylinder	1	36▲	222385	CARD, warning; not shown	1
7†	15B215	RING, lock	1	37†	15B689	COVER, grease fitting	1
8†	15B223	VALVE, cleanoff air	1	39	FTxxxx	TIP, flat; see page 3	1
9†	15B211	RING, retaining	1	40*	246360	O-RING; PTFE; flat tip models only; package of 3;	1
10†	15B210	AIR CAP; for round pattern guns	1	43	117661	WISE, pin; dual reversible chucks	1
	15B801	AIR CAP; for flat pattern guns; not included in Front End Replacement Kit 246361	1	46	117792	GREASE GUN; not shown	1
11†	246491	HOUSING, fluid	1	50	112307	ELBOW, street; 1/8 npt (m x f)	2
12	246012	MANIFOLD, fluid; includes 12a-12g	1	53	117642	NUT DRIVER, hex; 5/16	1
12a†		. MANIFOLD	1	54	118575	SCREWDRIVER; 1/8 blade	1
12b	246356	. VALVE, fluid	2	55▲	172479	TAG, warning; not shown	1
12c	100139	. PLUG, pipe; 1/8-27 npt	2	57	117773	GREASE CARTRIDGE; 3 oz; not shown; MSDS sheet available at www.graco.com	1
12d	15B221	. BOLT; 5/16-24	1	58	197979	COVER, gun; not shown	1
12e	117634	. SWIVEL, B side; 1/8 npt(m) x no. 6 JIC(f)	1	59■	118665	LUBRICANT, Fusion Gun; 4 oz (113 gram)	1
12f	117635	. SWIVEL, A side; 1/8 npt(m) x no. 5 JIC(f)	1	* These parts are only available in repair kits. To select a kit, refer manual 309550.			
12g	15B993	. SPRING, ring, lock	1	† These parts are not available singly.			
14*★	248136	O-RING, cylinder cap; package of 6	1	‡ These parts are included in Front End Replacement Kit 246361.			
15	15B203	PISTON	1	★ These parts are included in Safety Stop Assembly 248064 (includes 1 of item 24).			
16*	248135	O-RING, piston; package of 6	1	▲ Replacement Danger and Warning labels, tags, and cards are available at no cost.			
17*	248134	O-RING, piston shaft; package of 6	1	■ Available in 248279 Kit, package of 10.			
18†	246349	CARTRIDGE, seal, A side; includes 18a-18e	1	Check Valve Filter Screen Kits (10 per kit)			
	246350	CARTRIDGE, seal, B side; includes 18a-18e	1	80 mesh filter screen is standard with gun.			
18a†		. CARTRIDGE BODY	1	246357 40 mesh (.015 in., 375 micron)			
18b	117491	. SPRING	1	246358 60 mesh (.010 in., 238 micron)			
18c*†	246348	. SEAL KIT	1	246359 80 mesh (.007 in., 175 micron)			
18d*	248130	. O-RING, cartridge body; package of 6	1				
18e*	248128	. O-RING, side seal; package of 6	1				
19		CHAMBER, mix, see page 3	1				
21†*	248132	O-RING; package of 6	1				
23†*	248131	O-RING; package of 6	1				
24†*★	246354	O-RING; package of 6	1				
25†	100846	FITTING, grease	1				
26†	246731	VALVE, check, A side; includes 26a-26g	1				
	246352	VALVE, check, B side; includes 26a-26g	1				
26a††		. HOUSING	1				
26b††	15B214	. SCREW; 5/16-18 x 1/2 in. (13 mm)	1				
26c†	104396	. BALL; carbide	1				
26d†		. SCREEN; see below	1				
26e†	117490	. SPRING	1				
26f†*	248133	. O-RING, check valve face; package of 6	1				
26g†*	248129	. O-RING, check valve housing; package of 6	1				

Mechanical Purge Gun

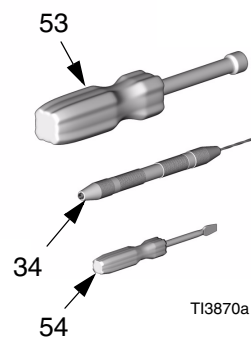


Check Valve (36) Detail



TI3927A

Supplied Tools



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

△ 3 Torque to 32-40 ft-lb (43-54 N•m).

Ref. No.	Part No.	Description	Qty
1	15D919	BODY, mechanical purge	1
3★	15C374	ACTUATOR; safety	1
4★	15C390	BUSHING, safety	1
7††		HOUSING, fluid	1
8	118145	SPRING, purge rod	1
9	15C375	AIR CAP	1
10★	15C373	CAP, rear	1
11†	15B215	RING, lock	1
12	246012	MANIFOLD, fluid; includes 12a-12g	1
12a†		. MANIFOLD	1
12b	246356	. VALVE, fluid	2
12c	100139	. PLUG, pipe; 1/8-27 npt	2
12d	15B221	. BOLT; 5/16-24	1
12e	117634	. SWIVEL, B side; 1/8 npt(m) x no. 6 JIC(f)	1
12f	117635	. SWIVEL, A side; 1/8 npt(m) x no. 5 JIC(f)	1
12g	15B993	. SPRING, ring, lock	1
14★	248136	O-RING, rod stop; package of 6	1
15★	15C372	STOP, purge rod	1
16★	248135	O-RING, piston; package of 6	1
17★	118144	SPRING, piston safety lock	1
18★	248095	O-RING, purge rod; package of 6	1
19	248096	O-RING, piston shaft; package of 6	1
20	248138	O-RING, housing, small; package of 6	1
21†*	248132	O-RING, housing, large; package of 6	1
23†	15C378	NUT, rod seal, rear	1
24†*	246354	O-RING; package of 6	1
25	15C377	NUT, mix module	1
28	15C376	RETAINER, CeramTip	1
31	248001	ROD, purge; includes 1 of item 18	1
32	15C371	PISTON	1
34	117661	WISE, pin; dual reversible chucks	1
35†	116550	RING, retaining	1
36†	246731	VALVE, check, A side; includes 36a-36g	1
	246352	VALVE, check, B side; includes 36a-36g	1
36a††		. HOUSING	1
36b††	15B214	. SCREW; 5/16-18 x 1/2 in. (13 mm)	1
36c†	104396	. BALL; carbide	1
36d†		. SCREEN; see below	1
36e†	117490	. SPRING	1
36f†*	248133	. O-RING, check valve face; package of 6	1
36g†*	248129	. O-RING, check valve housing; package of 6	1
37▲	222385	TAG, warning; not shown	1

Ref. No.	Part No.	Description	Qty
39		MODULE, mix, see page 4	1
40		CeramTip; see page 4	1
44†	15C382	VALVE, cleanoff air	1
46††*	248003	SEAL KIT, purge rod; includes 4 seals	1
50	112307	ELBOW, street; 1/8 npt (m x f)	2
53	117642	NUT DRIVER, hex; 5/16	1
54	118575	SCREWDRIVER; 1/8 blade	1
55	197979	COVER, gun; not shown	1
57■	118665	LUBRICANT, Fusion Gun; 4 oz (113 gram)	1
59★	15D329	STOP, rod	1
60★	115452	RING, retaining	1

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

† These parts are not available singly.

‡ These parts are included in Fluid Housing Assembly Kit 248004 (includes 1 of items 24 and 46).

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

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

■ Available in 248279 Kit, package of 10.

Check Valve Filter Screen Kits (10 per kit)

80 mesh filter screen is standard with gun.

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

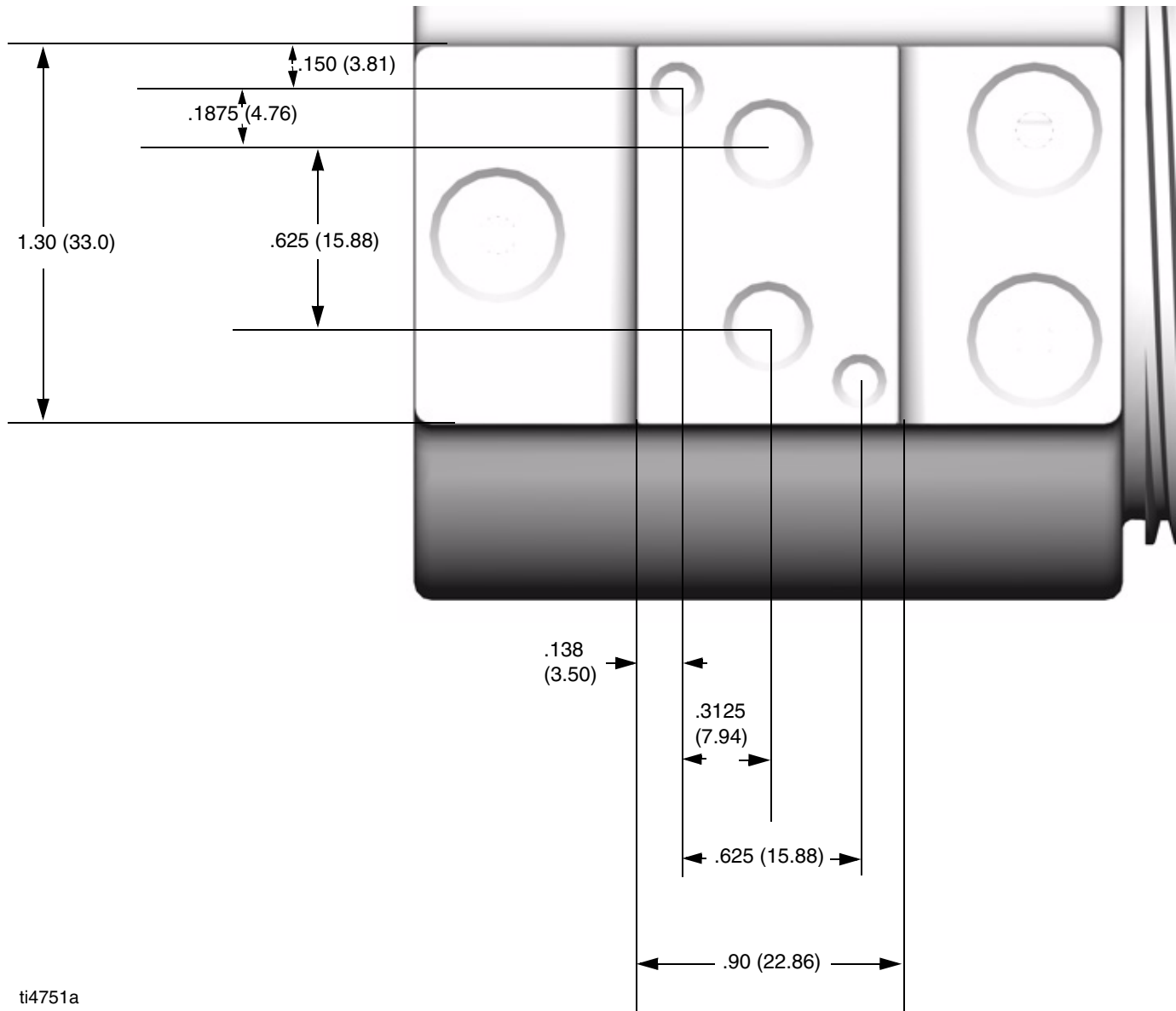
246358 60 mesh (.010 in., 238 micron)

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

Mounting Dimensions

Gun mounting plate dimensions

in. (mm)



ti4751a

FIG. 1

Technical Data

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

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GRACO INC. P.O. BOX 1441 MINNEAPOLIS, MN 55440-1441

www.graco.com

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