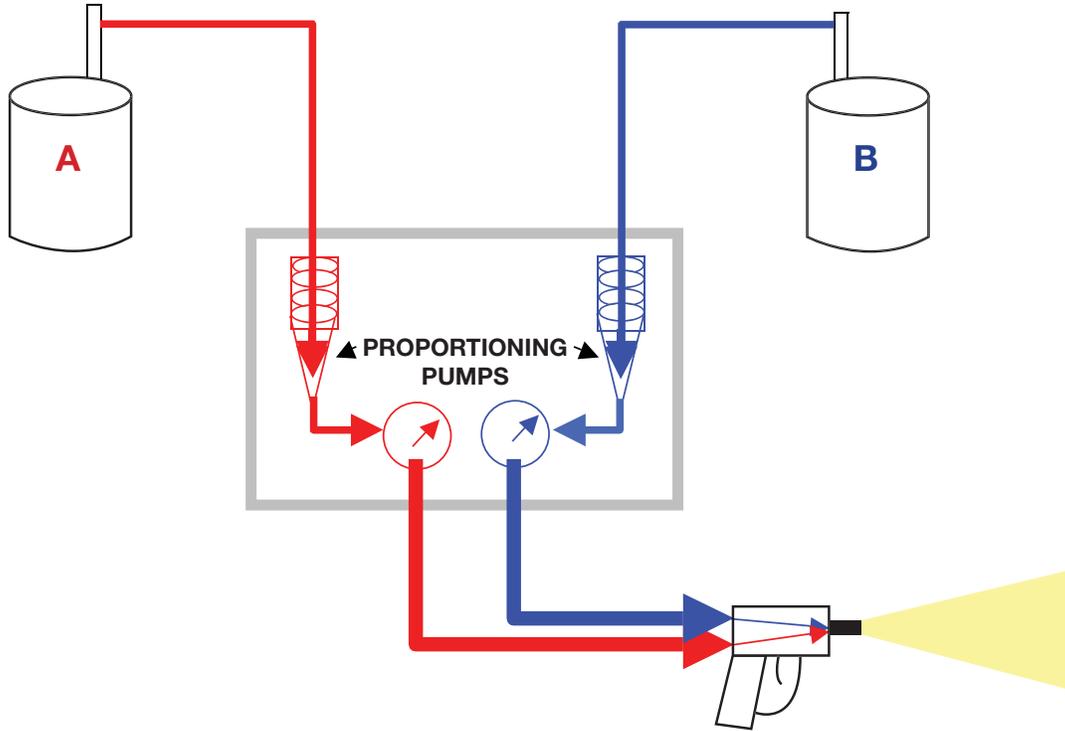




Scan code with smart phone to watch instructional video.

## DETECTING OFF-RATIO PROBLEMS



### “A” SIDE RICH

FAST 100-LV will have little rise and be dark in color. Flexible FAST will be light blue in color. Both may be brittle, crunchy or friable.

### “B” SIDE RICH

FAST 100-LV will be light in color. Flexible FAST will be dark blue in color. Both will be soft and spongy.

**The problem will be on the “B” side of the machine.**

#### POSSIBLE CAUSES:

If the “B” gauge reads high, the problem is most likely in the spray gun on the “B” side. Check for a plugged screen; check valve, mixing chamber, and passage. It is also possible that the “B” material is cold.

If the “B” gauge reads low, the pump is starving on the “B” side. Check the transfer pump, the supply valve and the supply screen. It is also possible that the pump is starving because of extremely cold material.

**The problem will be on the “A” side of the machine.**

#### POSSIBLE CAUSES:

If the “A” gauge reads high, the problem is most likely in the spray gun on the “A” side. Check for a plugged screen; check valve, mixing chamber or passage.

If the “A” gauge reads low, the pump is starving on the “A” side. Check the transfer pump, the supply valve or the supply screen.

**Always check from the barrel back toward the machine, or from the spray gun back toward the machine!**

## Morning Test Procedure for Fusion Gun

1. After the machine has reached the proper temperature, bring it up to normal pressure. Put on safety glasses, gloves and respirator. With the safety engaged so that the gun cannot be accidentally triggered, open one material valve while watching the purge air. If you don't see a mist of material, close the valve and open the other. If you don't see a mist of material, go to step three.
2. If a mist of material is visible when either valve is opened, stop immediately and find the problem. It is most likely a poor seal between the side seals and the mixing chamber caused by adhesive residue, a scratched chamber, side seal or damaged "O" rings. Once the problem is determined, repair the problem and repeat the test. If no mist is present, proceed to step three.
3. Open both valves. Turn off the safety and make a three-second test spray in a box or heavy trash bag while watching your line-pressure gauges. If the FAST 100-LV is a light-yellow or cream color or the Flexible FAST is a medium-blue color, and the gauges are within 500 PSI of each other, you can begin to spray. If there is a problem with the pressures or the foam color, refer to front of this page to determine what and where the problem is.

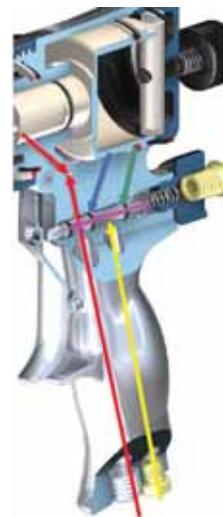


## Removing Cured Adhesive from Fusion Gun Air Passages

If gun fills with foam (crossover), you must clean all the air passages with a drill bit by hand. The passages in the handle of the gun require a 1/8" x 8" drill bit. (DO NOT USE A POWER DRILL!)

With the gun completely disassembled, clean the passages as follows:

1. The purge air passage must be cleaned from two directions, from the front of the piston cylinder down and from the bottom of the handle up.
2. The "Piston Back" passage from the cylinder down.
3. The "Piston Forward" passage from the cylinder down.
4. The trigger air from the bottom of the handle up.
5. The trigger assembly has a passage that runs between the two small holes. All three must be clean in order for the gun to function.



## Carlisle SynTec Systems contacts:

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## Equipment contacts:

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