

246362 Circulation Manifold Kit

309818 Rev.B

For Fusion™ Spray Gun. Allows rapid preheating of hose by circulating fluid through gun manifold.

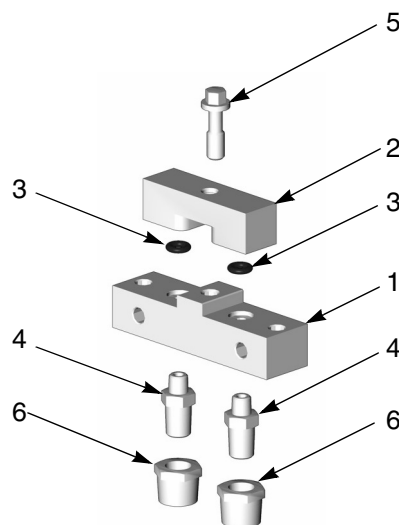
**WARNING**

To reduce the risk of explosion, do not circulate fluid containing a blowing agent without consulting with your material supplier regarding fluid temperature limits.

Parts

Ref. No.	Part No.	Description	Qty
1	15B853	MANIFOLD, circulation	1
2	15C850	BLOCK	1
3	117520	O-RING	2
4	151519	NIPPLE; 1/4 x 1/8 npt	2
5	15B221	BOLT; 5/16-24	1
6	100206	BUSHING, pipe; 1/2 npt(m) x 1/4 npt(f)	2

See pages 2 and 3 for initial setup and installation instructions.



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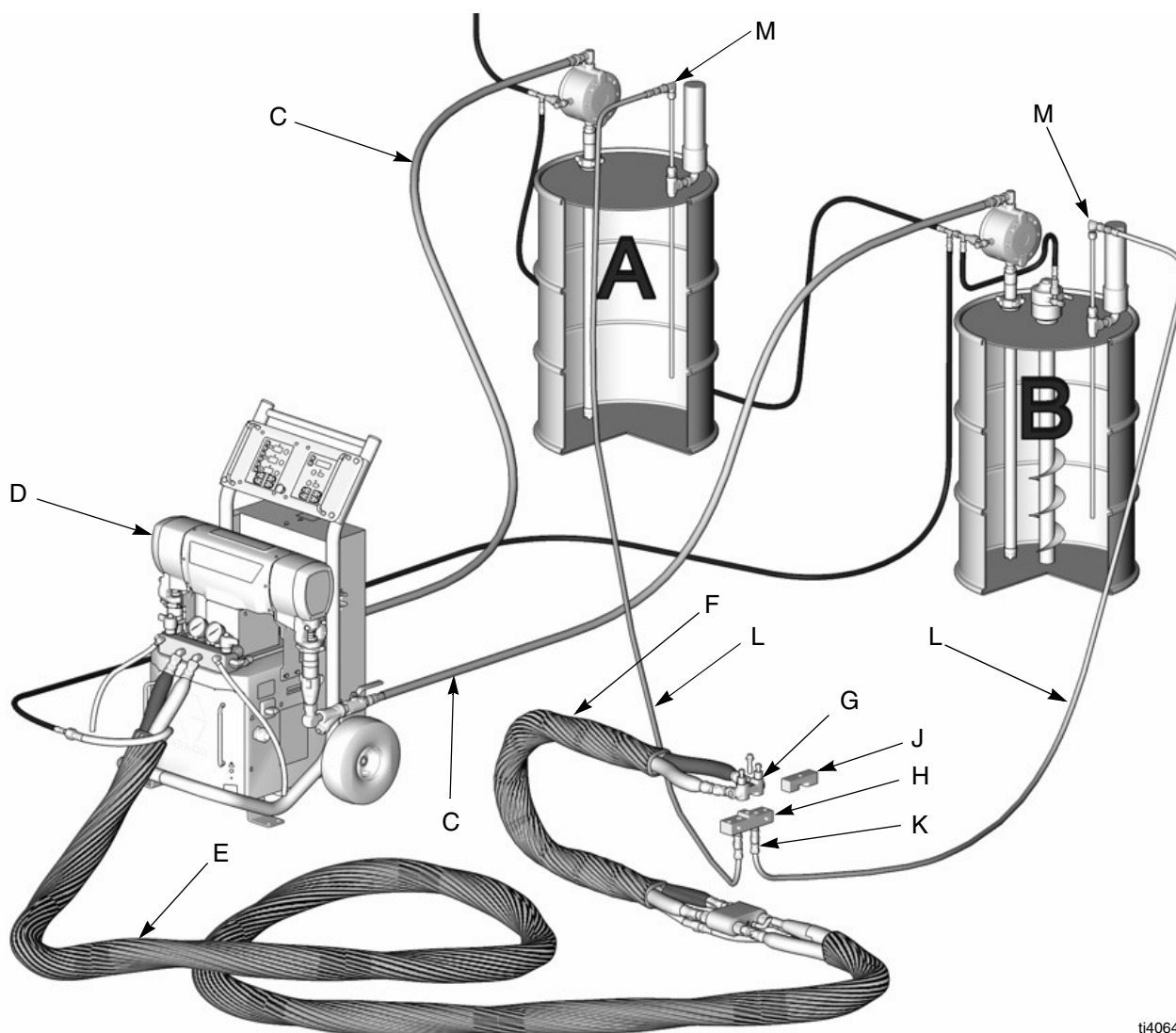
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Initial Setup

See FIG. 1. Connect high pressure moisture-resistant circulation lines (L) to circulation manifold (H). Route circulation lines back to return tube kit (M) at respective component A or B supply drum. Use hoses rated at maximum working pressure of the equipment.

Key for FIG. 1

- C Fluid Supply Lines
- D Reactor Proportioner
- E Heated Hose
- F Heated Whip Hose
- G Gun Fluid Manifold
- H 246362 Circulation Manifold
- J Manifold Block (included in 246362)
- K 246978 Circulation Kit (includes return lines and 246477 Return Tube Kit); see manual 309852
- L Circulation Return Lines (included in 246978)
- M 246477 Return Tube Kit (included in 246978); see manual 309852



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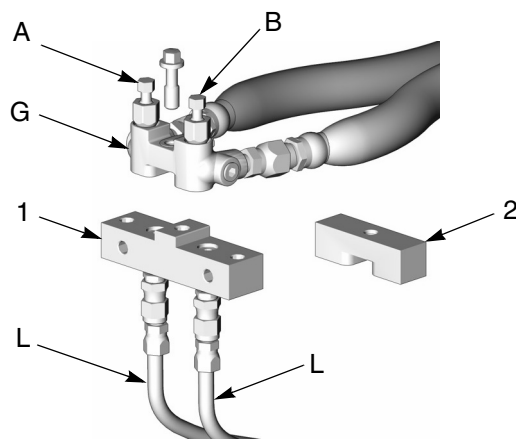
FIG. 1. Circulation System Setup

Installation

⚠ WARNING

To reduce the risk of explosion, do not cross-contaminate fluids when circulating. Be sure to circulate component A (isocyanate) to the component A drum and component B (resin) to the component B drum.

1. Remove block (2, see FIG. 2). Install circulation manifold (1) on gun fluid manifold (G). Open all valves in the fluid circuit.
2. Load fluid per instructions in proportioner manual.
3. Start proportioner. Set temperature targets. Circulate fluid at low pressure until temperature reaches targets.
4. Close fluid valves A and B. Remove circulation manifold (1) from gun fluid manifold (G). Attach block (2) to circulation manifold to prevent air from reacting with isocyanate.



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FIG. 2. Install Kit

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