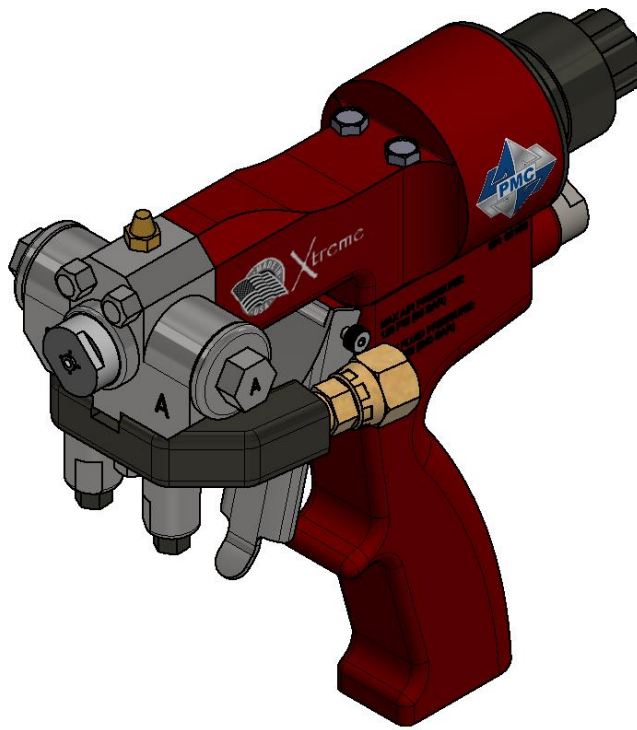




Xtreme Air Purge Spray & Pour Gun

Service Manual

Ref. # 202745
Revision 1.0
January 4, 2021



For use with non-flammable Foam and Polyurea
For professional use only
Not for use in explosive atmospheres



Polyurethane Machinery Corp.

1 Komo Drive, Lakewood, NJ 08701

732-415-4400

URL: <http://www.polymacusa.com>

TABLE OF CONTENTS

WARRANTY	1
SAFETY AND HANDLING	3
CHARACTERISTICS	5
TECHNICAL SPECIFICATIONS	5
GENERAL DESCRIPTION.....	6
INSTALLATION AND START UP	7
SHUTDOWN PROCEDURES	8
LOSS OF AIR PRESSURE/EMERGENCY SHUT-OFF.....	8
MAINTENANCE	9
GUN BLOCK AND MIXING CHAMBER REMOVAL.....	11
SCREEN SCREW AND COMPONENT MAINTENANCE	13
AIR CYLINDER MAINTENANCE	14
SPOOL VALVE MAINTENANCE	16
TRIGGERED OFF	17
TRIGGERED ON	18
TROUBLESHOOTING GUIDE	19
REFERENCE GUIDE	20
CHAMBER KITS.....	20
PCT KITS	21
DIAMOND PLATED CHAMBER/PCT KITS	24
AP-2/AP-3 SPARE PARTS KITS DESC	25
AP-2/AP-3 SPARE PARTS KITS (DIAMOND PLATED)	26
PMC RECOMMENDED O-RING GREASE.....	27
MISCELLANEOUS PARTS/KITS.....	28
SIDE SEAL KIT, RESIN	28
SCREEN SIZES	28
A & R SCREEN SCREW ASSEMBLY KITS	28
AP-3 O-RING KIT	29
AIR CYLINDER REBUILD KIT	29
1/4" UNHEATED STAINLESS STEEL HOSE ASSEMBLY	29
SPOOL VALVE REBUILD KIT	30
FULL GUN REBUILD KIT	30
RECOMMENDED SPARE PARTS	31
OPTIONAL PARTS	31

FLUSH TANKS	32
PARTS IDENTIFICATION	33
FINAL GUN ASSEMBLY	33
MANUAL VALVE ASSEMBLY	35
CHECK VALVE ASSEMBLY	36
COUPLING BLOCK ASSEMBLY	37
SCREEN SCREW ASSEMBLY	38
END CAP ASSEMBLY	39
LIST OF TOOLS	40
FLAT TIP ADAPTER KITS	41
FLAT TIP ADAPTER KIT	41
FLAT TIP RETAINER ASSEMBLY	42
APPENDIX	43
GREASE GUN ASSEMBLY	43
MIXING CHAMBER FLOW RATES	44
CHAMBER/ORIFICE COMPARISON CHART	44



Before installing the Xtreme Gun and start-up, carefully read all the technical and safety documentation included in this manual. Pay special attention to the information in order to know and understand the operation and the conditions of use of the Xtreme Gun. All of the information is aimed at improving user safety and avoiding possible breakdowns from the incorrect use of the Xtreme Gun.

WARRANTY

Polyurethane Machinery Corporation (hereinafter "PMC") provides this **LIMITED WARRANTY** (hereinafter "Warranty") to the original purchaser (hereinafter "Customer") covering this equipment and the original PMC manufactured accessories delivered with the equipment (hereinafter "Product") against defects in material or workmanship of the Product (hereinafter "Defect" or "Defective") for a period of one (1) year from the date of first purchase as shown on the original PMC invoice (hereinafter "Warranty Period").

If during the Warranty Period under normal use, the Product is suspected by Customer to be Defective in material or workmanship, it is Customer's responsibility to contact PMC and return the Product to PMC as directed by PMC, freight prepaid. If PMC determines that the Product is Defective and that such Defect is covered by this Warranty, PMC will credit Customer for the reasonable freight charges incurred by Customer in returning the Defective Product to PMC, and PMC (or its authorized agent) will, at PMC's option, repair or replace the Product, subject to the following:

Original Invoice: The original invoice must be kept as proof of the date of first sale and the Product serial number. The Warranty does not cover any Product if the Original Invoice appears to have been modified or altered, or when the serial number on the Product appears to have been altered or defaced.

Product Maintenance: It is the Customer's responsibility to maintain the Product properly. See your maintenance schedule and owner's manual for details. The Warranty does not cover an improperly maintained Product.

Non-PMC Components and Accessories: Non-PMC manufactured components and accessories that are used in the operation of the Product are not covered by this Warranty. Such components and accessories shall be subject to the warranty offered to the Customer, if any, by the original manufacturer of such component or accessory.

Other Warranty Exclusions: The Warranty does not cover any Product that PMC determines has been damaged or fails to operate properly due to misuse, negligence, abuse, carelessness, neglect, or accident. By way of example only, this includes:

- Normal wear and tear.
- Improper or unauthorized installation, repair, alteration, adjustment or modification of the Product.
- Use of heating devices, pumping equipment, dispensers, or other parts or accessories with the Product that have not been approved or manufactured by PMC.
- Failure to follow the operating instructions and recommendations provided by PMC may cause loss or damage to personnel, equipment, or work area.
- Fire, flood, "acts of God," or other contingencies beyond the control of PMC.

THE WARRANTY DESCRIBED HEREIN IS THE EXCLUSIVE REMEDY FOR THE CUSTOMER AND IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS, IMPLIED, STATUTORY OR OTHERWISE, AND THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE AND ALL OTHER WARRANTIES ARE HEREBY DISCLAIMED. TO THE FULLEST EXTENT PERMITTED BY LAW, PMC SHALL NOT BE RESPONSIBLE, WHETHER BASED IN CONTRACT, TORT (INCLUDING, WITHOUT LIMITATION, NEGLIGENCE), WARRANTY OR ANY OTHER LEGAL OR EQUITABLE GROUNDS, FOR ANY CONSEQUENTIAL, INDIRECT, INCIDENTAL, LOST PROFITS, SPECIAL, PUNITIVE OR EXEMPLARY DAMAGES, WHETHER TO PERSON OR PROPERTY, ARISING FROM OR RELATING TO THE PRODUCT, EVEN IF PMC HAS BEEN ADVISED OF THE POSSIBILITY OF SUCH LOSSES OR DAMAGES.

Non-Warranty Service by PMC: If PMC determines that the suspected Defect of the Product is not covered by this Warranty, disposition of the Product will be made pursuant to the terms and conditions of PMC's written estimate on a time and materials basis.

Continuing Warranty for Products Repaired or Replaced under Warranty: Following the repair or replacement of a Product covered by this Warranty, such Product will continue to be subject to the original Warranty for the remainder of original Warranty Period or for three (3) months from the repair or replacement date, whichever is longer.

No Rights Implied: Nothing in the sale, lease or rental of any Product by PMC shall be construed to grant any right, interest or license in or under any patent, trademark, copyright, trade secret or other proprietary right or material owned by anyone; nor does PMC encourage the infringement of same.

Exclusive Warranty: This writing is the final, complete, and exclusive expression of the Warranty covering the Product. Any statements made by PMC, its employees or agents that differ from the terms of this Warranty shall have no effect. It is expressly understood that Customer's acceptance of this Warranty, by performance or otherwise, is upon and subject solely to the terms and conditions hereof, and any additional or different terms and conditions proposed or expressed by Customer or anyone, whether in writing or otherwise, are null and void unless specifically agreed to in writing by an Officer of PMC.

SAFETY AND HANDLING

This chapter contains important information on the safety, handling and use of your Xtreme Gun.



Before installing the Xtreme Gun and start-up, carefully read all the technical and safety documentation included in this manual. Pay special attention to the information in order to know and understand the operation and the conditions of use of the Xtreme Gun. All of the information is aimed at improving user safety and avoiding possible breakdowns from the incorrect use of the Xtreme Gun.

WARNING! Presents information to alert of a situation that might cause serious injuries if the instructions are not followed.

CAUTION! Presents information that indicates how to avoid damage to the Xtreme Gun or how to avoid a situation that could cause injuries.

NOTE! Is relevant information of a procedure being carried out.

Careful study of this Manual will enable the operator to know the characteristics of the Gun and the operating procedures. By following the instructions and recommendations contained, you will reduce the potential risk of accidents in the installation, use or maintenance of the Xtreme Gun; you will provide a better opportunity for incident-free operation for a longer time, greater productivity and the possibility of detecting and resolving problems fast and simply.

Keep this Service Manual for future reference to useful information. If you lose this Manual, ask for a new copy from your PMC Service Center or go to the company website (www.polymacusa.com).

The Xtreme Gun has been designed and built for the application of polyurea chemical systems, polyurethane foam chemical systems and some two-component epoxy systems.

WARNING! The design and configuration of the Xtreme Gun does not allow its use in potentially explosive atmospheres or exceeding the pressure and temperature limits described in the Technical Specifications of this Manual to be exceeded.

Always use liquids and solvents that are compatible with the Xtreme Gun. If in doubt, consult **PMC** Technical Service.

When working with the Xtreme Gun, it is recommended that the operator wear suitable clothing and elements of personal protection, including, without limitation, gloves, protective goggles, safety footwear and face masks. Use breathing equipment when working with the Gun in enclosed spaces or in areas with insufficient ventilation. The introduction and follow-up of safety measures must not be limited to those described in this Manual. Before beginning to work with the Gun, a comprehensive analysis must be made of the risks derived from the products to be dispensed, the type of application and the working environment.



To prevent possible injury caused by incorrect handling of the materials and solvents used in the process, carefully read the Safety Data Sheet (SDS) provided by your supplier.



To avoid damage caused by the impact of pressurized fluids, do not open any connection or perform maintenance work on components subject to pressure until the pressure has been completely eliminated.



Use suitable protection when operating, maintaining or being present in the area where the equipment is functioning. This includes, but is not limited to, the use of protective goggles, gloves, shoes and safety clothing and breathing equipment.

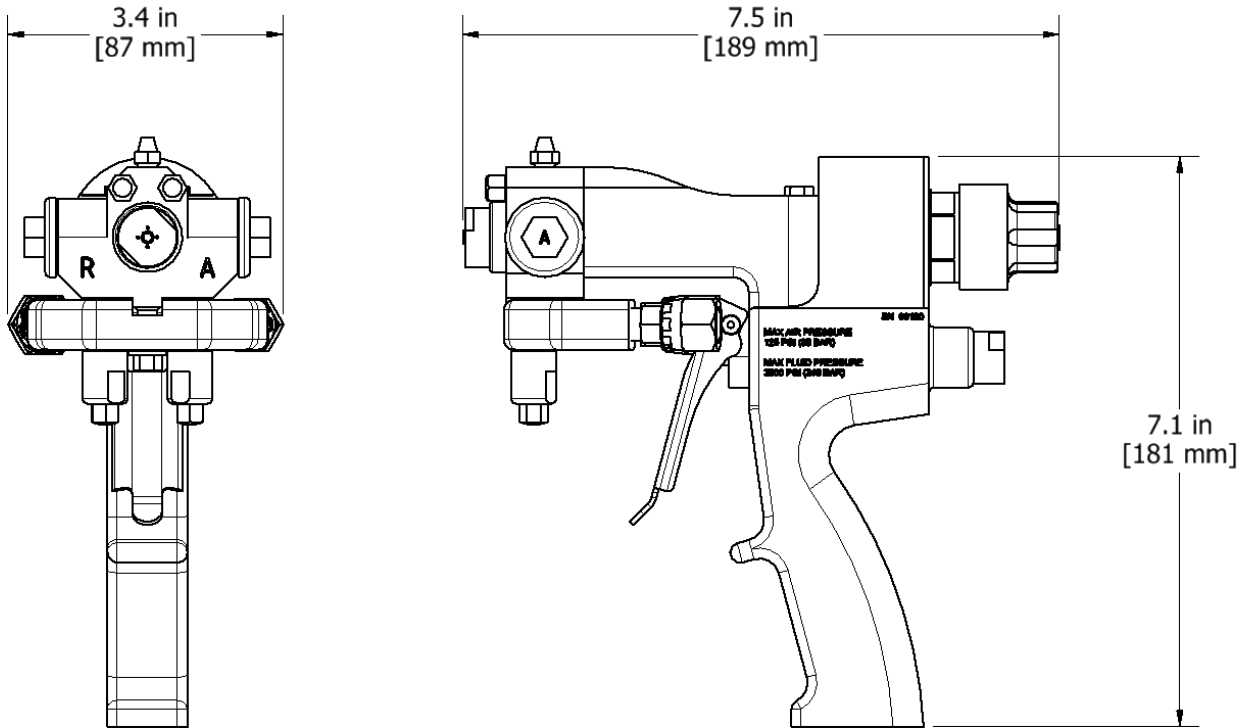


The equipment includes components that reach high temperatures and can cause burns. Hot parts of the equipment must not be handled or touched until they have cooled completely.



The equipment sprays high pressure fluids that can lead to fluid being injected under the skin or eyes. Severe injury could be incurred. Proper personal protective equipment should be used in conjunction with training and situational awareness of all personnel on the job.

CHARACTERISTICS

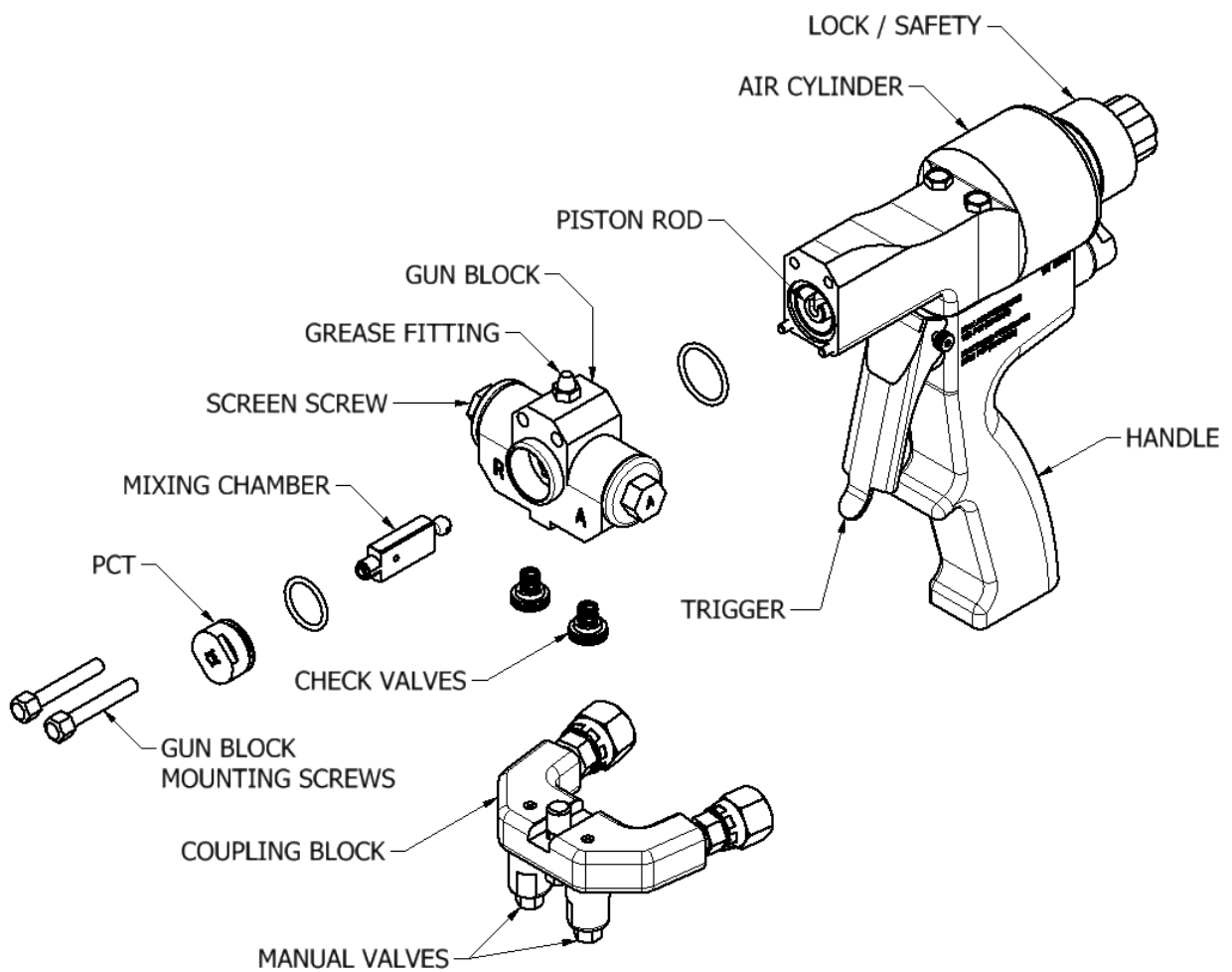


TECHNICAL SPECIFICATIONS

Maximum Working Pressure:	3,500 psi (245 Bar)
Air Pressure:	90-125 psi (6.2-8.6 Bar)
Maximum Output (1:1 ratio):	50 lb/min (22.7 L/min)
Minimum Output (1:1 ratio):	3.3 lb/min (1.55 L/min)
Opening Force @ 110 psi (8 Bar):	200 lb (91 kg)
Closing Force @ 110 psi (8 Bar):	200 lb (91 kg)
Weight (Not including Coupling Block):	2.4 lbs (1.1 kg)
Weight (Including Coupling Block):	3.1 lbs (1.4 kg)

GENERAL DESCRIPTION

For better knowledge of the Xtreme Gun, the main components and their description are shown. For a more precise identification, see the Parts Identification section.



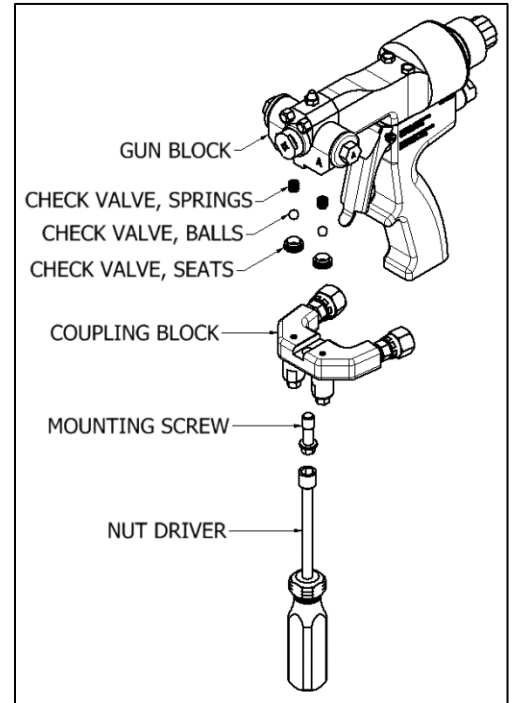
INSTALLATION AND START UP

CAUTION! When working with the Xtreme Gun or performing maintenance work, wear suitable safety protection in accordance with the recommendations and specifications provided by the product suppliers.

1. Install **Coupling Block** to the hoses.
2. Ensure the **Manual Valves** are **CLOSED** by turning them to the full clockwise position.

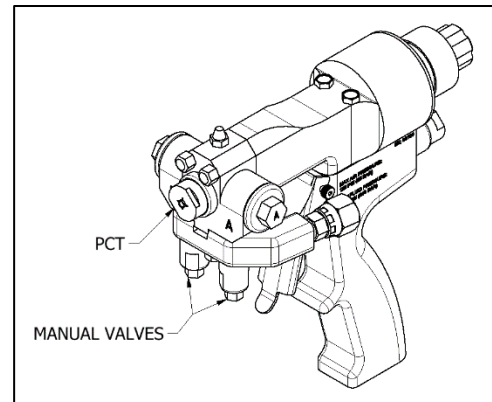
CAUTION! Excessive force closing or opening the Manual Valves may result in damage to the Manual Valves and/or Coupling Block.

3. Set the **Gun Lock** to the **LOCKED** position.
4. Ensure **Check Valve** Assemblies are properly installed in the Gun Block.
5. Connect the **Coupling Block** to the **Gun Block** using the **Nut Driver** provided (Pg. 40). Tighten **Coupling Block** until there is a hand tight seal.
6. Connect the air supply with 90 to 125 psi (6.2 to 8.6 bar) to the gun.



NOTE! The material delivery hoses are color coded Red and Blue. The Red corresponds to the Isocyanate (A) and the Blue to the Polyol (R). To avoid connection errors, the (A) and (R) hoses have connections with different sizes to avoid incorrect connections. [Set the **Gun Lock** to the **OPEN** position.]

7. Pull the **Trigger** several times to check for correct movement of the **Mixing Chamber** and **PCT**.
8. Ensure the Proportioner and supply system are in the ready position and the material pressures and temperatures are set as recommended by the chemical supplier (see Machine Service Manual).
9. **OPEN** each **Manual Valve** by turning three (3) full turns counter clockwise.
10. **Perform a test spray.**



SHUTDOWN PROCEDURES

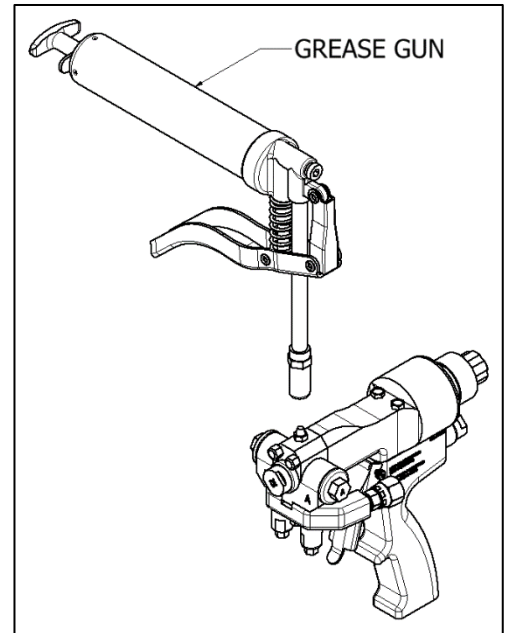
1. CLOSE the **Manual Valves** by turning them to the full clockwise position.

CAUTION! *Excessive force closing or opening Manual Valves may result in damage to the Manual Valves and/or Coupling Block.*

2. With the purge air on, use the supplied **Grease Gun** (Pg. 40) to lubricate the **Mixing Chamber** through the **Grease Fitting** until a fine mist of grease is sprayed from the gun (Pg. 43 for Grease Gun Assembly Instructions). This action will help prevent Isocyanate from crystallizing on the mixing chamber which may cause damage to the internal parts.

NOTE! *The injection of grease supplied with the Gun at the end of the day will minimize maintenance time and can eliminate the need to remove the Mixing Chamber each day to clean it. Use of grease with high moisture content will not achieve the desired results. PMC Grease is recommended. Use of incorrect grease will cause blockage in the mixing chamber.*

3. Disconnect the air supply.



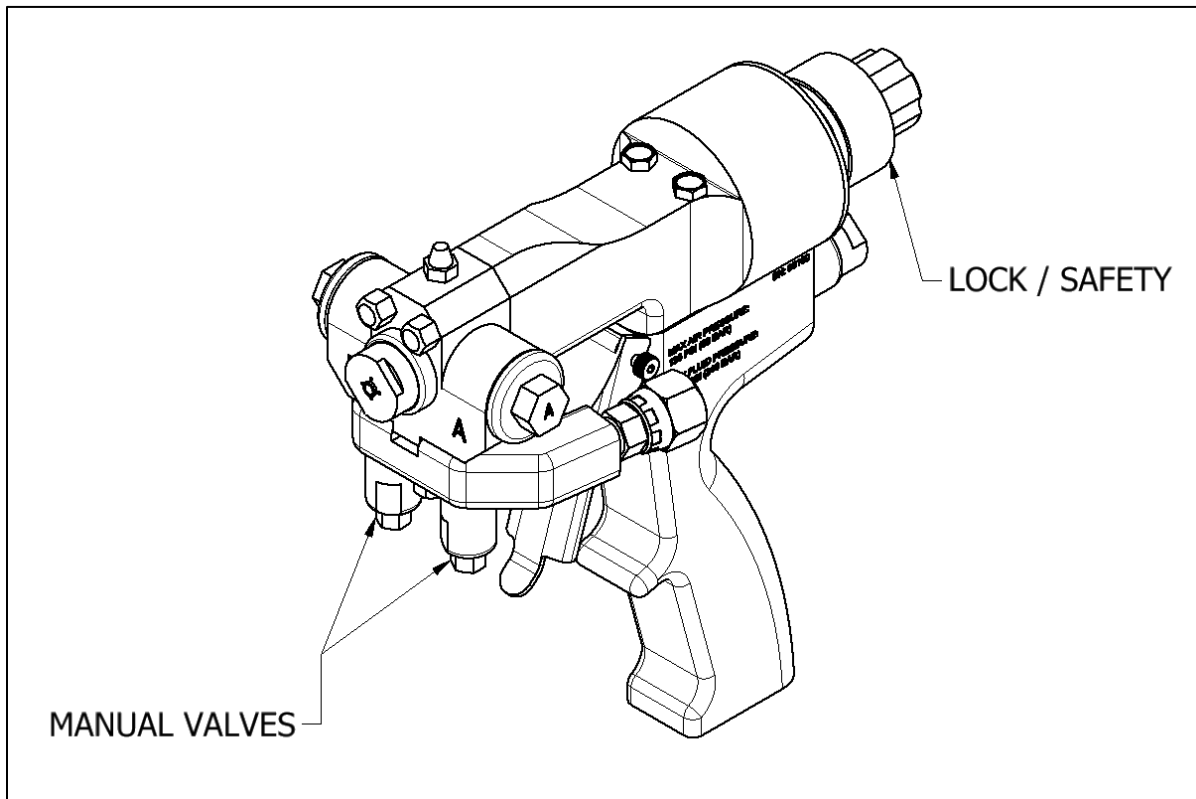
LOSS OF AIR PRESSURE/EMERGENCY SHUT-OFF

1. **SHUT OFF** air supply to gun.
2. Using the palm of your hand, push in on the **Gun Lock** and rotate clockwise to set it to the **LOCKED** position.
3. **CLOSE** each **Manual Valve**.

CAUTION! *Excessive force closing or opening Manual Valves may result in damage to the Manual Valves and/or Coupling Block.*

MAINTENANCE

To obtain maximum performance from your Xtreme Gun, it is necessary to periodically perform certain maintenance operations.



WARNING! Before proceeding with any maintenance work on the Xtreme Gun, trigger the gun to remove internal material pressure, ensure the Manual Valves are **CLOSED**, ensure the Gun Lock is in the **LOCKED** position, and **SHUT OFF/DISCONNECT** the air supply. It is recommended to remove the Gun from the Coupling Block.



To prevent possible injury caused by incorrect handling of the materials and solvents used in the process, carefully read the Safety Data Sheet (SDS) provided by your supplier.



To avoid damage caused by the impact of pressurized fluids, do not open any connection or perform maintenance work on components subject to pressure until the pressure has been completely eliminated.



Use suitable protection when operating, maintaining or being present in the area where the equipment is functioning. This includes, but is not limited to, the use of protective goggles, gloves, shoes and safety clothing and breathing equipment.

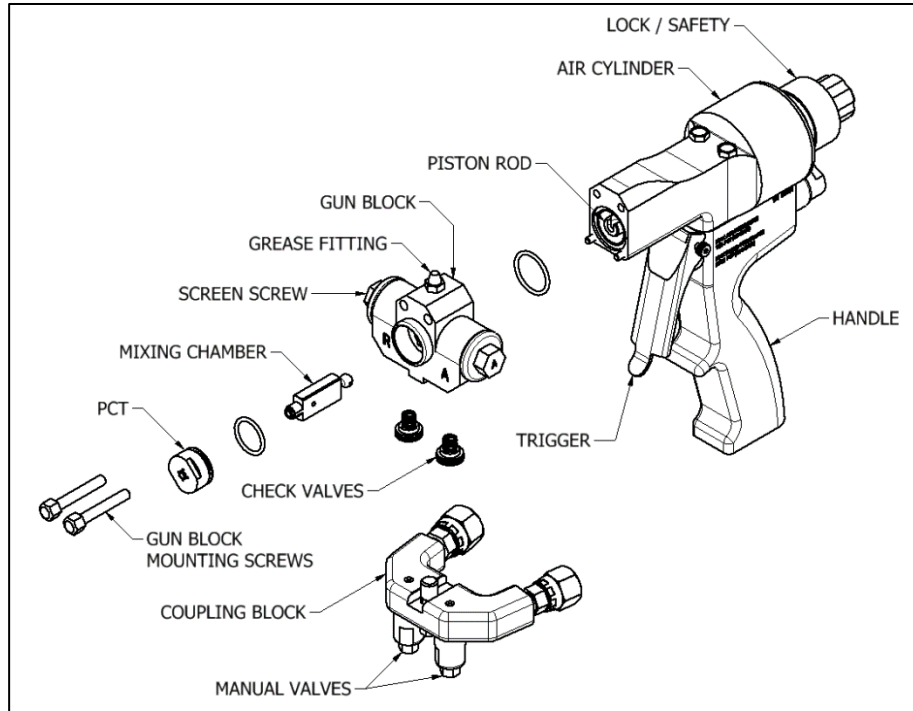


The equipment includes components that reach high temperatures and can cause burns. Hot parts of the equipment must not be handled or touched until they have cooled completely.



The equipment sprays high pressure fluids that can lead to fluid being injected under the skin or eyes. Severe injury could be incurred. Proper personal protective equipment should be used in conjunction with training and situational awareness of all personnel on the job.

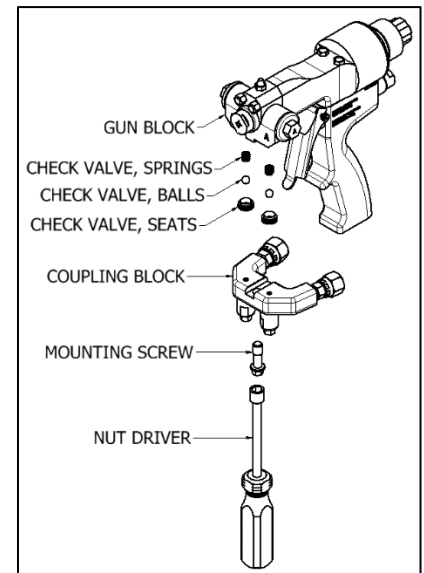
GUN BLOCK AND MIXING CHAMBER REMOVAL



1. **CLOSE** the **Manual Valves** by turning them to the full clockwise position.

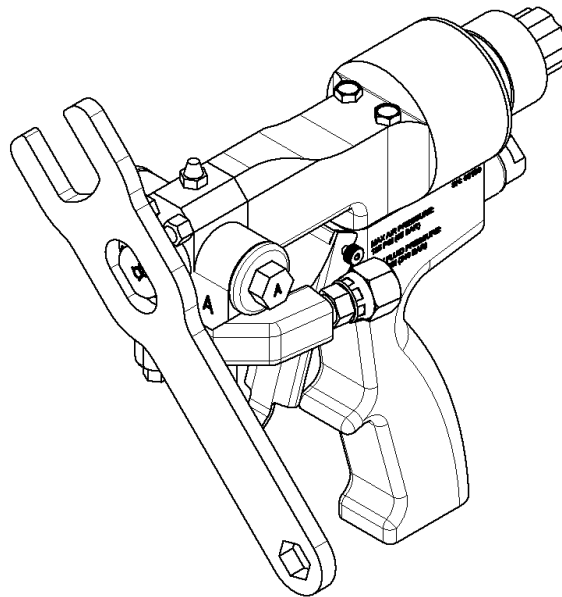
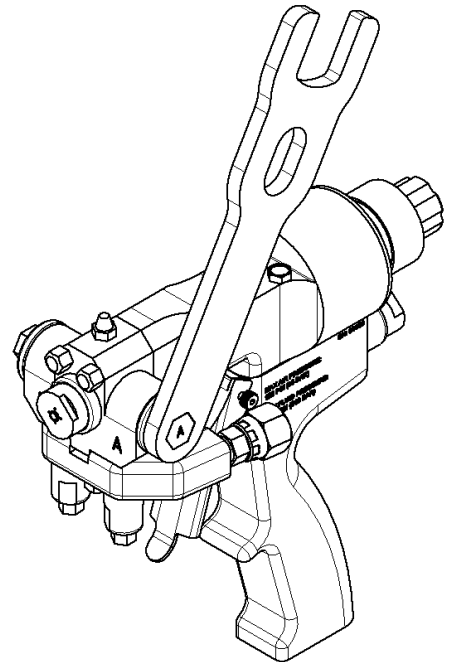
CAUTION! *Excessive force opening or closing Manual Valves may result in damage to the Manual Valves and/or Coupling Block.*

2. Point the gun over a waste container and pull the **Trigger** to relieve pressure.
3. Using the **Nut Driver** provided (Pg. 40), remove the **Mounting Screw** and disconnect the gun from the **Coupling Block**.
4. Pump grease through the **Gun Block** to remove any residue using the grease gun supplied (Pg. 32).
5. Shut off air to the gun.
6. Using the **Wrench** provided (Pg. 40) or a 1/2" wrench, loosen or remove both **Screen Screws** to facilitate easy removal of the **Mixing Chamber**, as shown below.
7. Loosen the **PCT**, but do not remove.



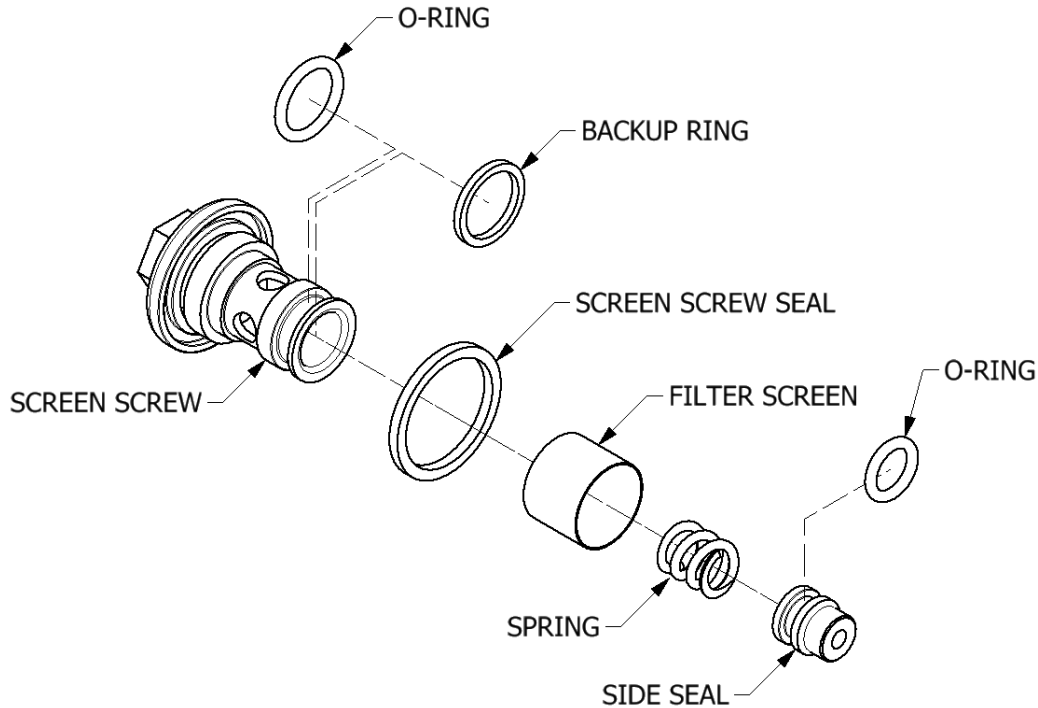
8. Using the Nut Driver (Pg. 40) provided, remove the gun block mounting screws (Pg 6).
9. Disconnect the Gun Block from the Cylinder.
10. Remove the Mixing Chamber and PCT from the Gun Block.
11. Clean or replace the **Mixing Chamber** as required.
12. When reassembling in reverse order, it is recommended to screw the **PCT** onto the **Mixing Chamber** first, then insert the **Mixing Chamber** into the front of the **Gun Block**. This helps to reduce wear on the **PCT** O-ring.

NOTE! A small amount of PMC grease applied to the Mixing Chamber and Side Seals upon assembly is recommended.



CAUTION! Use wooden or plastic tools or a brass brush for cleaning. Do not use metal or abrasive tools that can scratch or damage the contact surfaces.

SCREEN SCREW AND COMPONENT MAINTENANCE



CAUTION! To avoid possible contamination by the residual chemical inside the Gun do not interchange the Isocyanate (A) parts with the Polyol (R) parts. The Isocyanate (A) side is identified with an (A) on the Screen Screw Head and the Polyol (R) side is marked with an (R) on the Screen Screw Head. The Gun Block is also marked with (A) and (R) designation.

1. **CLOSE** the **Manual Valves** by turning them to the full clockwise position.

CAUTION! Excessive force opening or closing Manual Valves may result in damage to the Manual Valves and/or Coupling Block.

2. Point the gun over a waste container and pull the **Trigger** to relieve pressure.
3. Using the Nut Driver provided (Pg. 40), remove the Coupling Block from the Gun Block.
4. Flush the gun block to remove any residue. Use the recommended Flush Tank (Pg. 32)
5. **SHUT OFF** air supply to the gun.
6. Set the **Gun Lock** to the **LOCKED** position.

7. Use the **Wrench** provided (Pg. 40) or a ½" wrench to remove the **Screen Screw**.
8. To clean or replace the **Screens**, remove the larger **O-Ring** and **Back Up Ring**.
9. Remove the **Side Seal** and **Spring** from the **Screen Screw**. Inspect all components and O-rings. Clean or replace as required.
10. Inspect for damage and apply PMC lubrication to all O-rings and threads and reassemble in reverse order.
11. The gun is now ready for service.

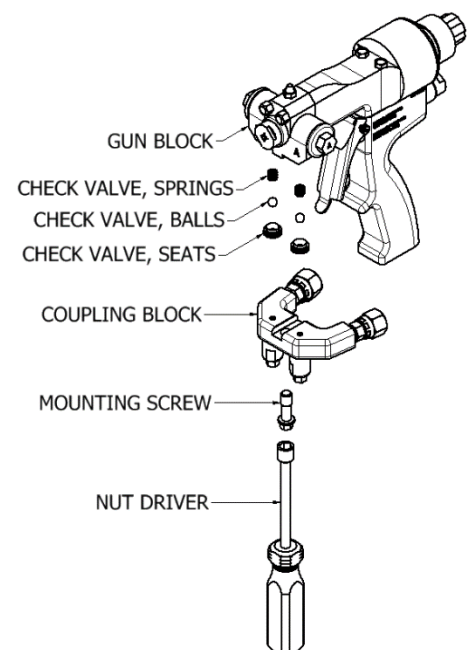
NOTE! When replacing O-rings, replace ALL O-rings included in the appropriate Kit.

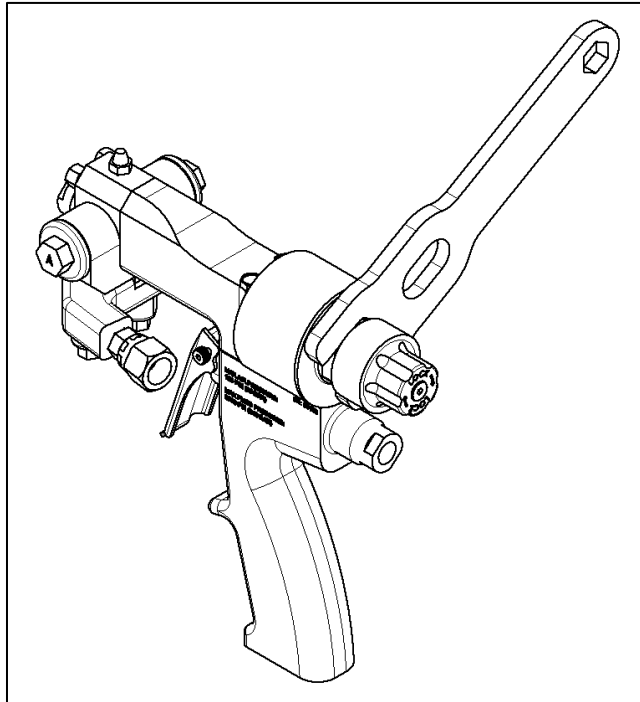
AIR CYLINDER MAINTENANCE

1. **CLOSE** the **Manual Valves** by turning them to the full clockwise position.

CAUTION! Excessive force opening or closing **Manual Valves** may result in damage to the **Manual Valves** and/or **Coupling Block**.

2. Point the gun over a waste container and pull the **Trigger** to relieve pressure.
3. **DISCONNECT** air supply to gun.
4. Set the **Gun Lock** to the **LOCKED** position.
5. Flush the gun block to remove any residue. Use the recommended Flush Tank (Pg. 32)
6. Loosen the **Screen Screws** using the **Wrench** provided (Pg. 40) or a ½" wrench.
7. Disconnect **Coupling Block** from **Gun Block** using the **Nut Driver** provided (Pg. 40).





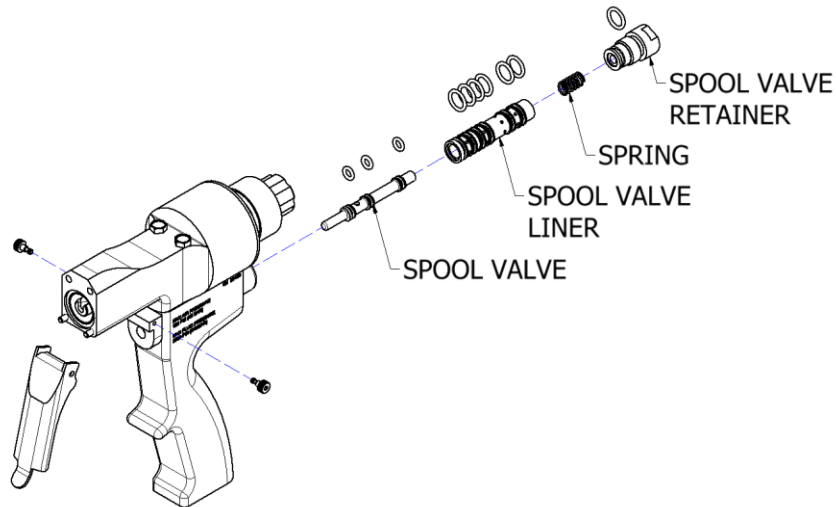
8. Using the Nut Driver provided, remove the gun block mounting screws and disconnect the Gun Block.
9. Using the **Wrench** provided (Pg. 40) or an 11/16" Wrench, remove the **End Cap**.
10. Push on the front of the **Piston** to remove the **Piston** from the rear of the **Air Cylinder**.
11. Inspect the **O-rings** on the **Piston** and **Shaft** and replace as required.
12. Inspect the **O-ring** on the **End Cap** and replace as required.

NOTE! When replacing O-rings, replace ALL O-rings included in the Rebuild Kit.

13. Coat the inside of the **Cylinder** and all **O-rings** with PMC grease to facilitate reassembly.
14. Reassemble the **Air Cylinder** in reverse order.

CAUTION! Use wooden or plastic tools or a brass brush for cleaning. Do not use metal or abrasive tools that can scratch the contact surfaces.

SPOOL VALVE MAINTENANCE



1. **CLOSE** the **Manual Valves** by turning them to the full clockwise position.

CAUTION! *Excessive force opening or closing Manual Valves may result in damage to the Manual Valves and/or Coupling Block.*

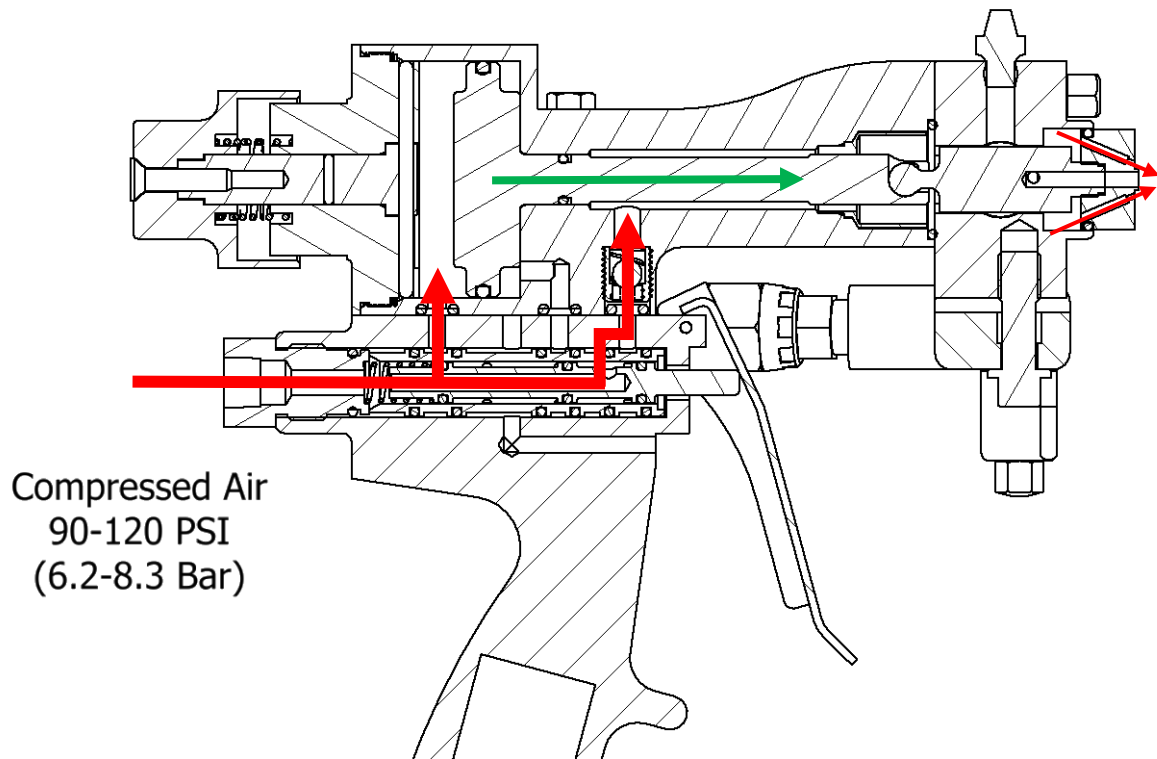
2. Set the **Gun Lock** to the **LOCKED** position.
3. **Disconnect** the air supply from the gun.
4. Use a suitable size wrench and remove the air fitting from the rear of the **Handle**.
5. Remove the **Trigger** from the assembly to access the front of the **Handle**.
6. Use the **Tool** provided (Pg. 40) and remove the **Spool Valve Retainer**.
7. Remove the **Spring**, **Spool Valve Liner**, and **Spool Valve** using the tool provided (Pg. 40), as shown below.
8. Remove and discard all **O-Rings**.
9. Replace the **O-rings** and **Spring** supplied in the Spool Valve Rebuild Kit - 202756 (page 30).

NOTE! *When replacing O-rings, replace ALL O-rings included in 202756 Rebuild Kit.*

Inspect, clean and/or replace all remaining assembly components. Apply a small amount of PMC grease to the inside of the manifold cavity and to the **O-rings** on the **Spool Valve** to facilitate reassembly.

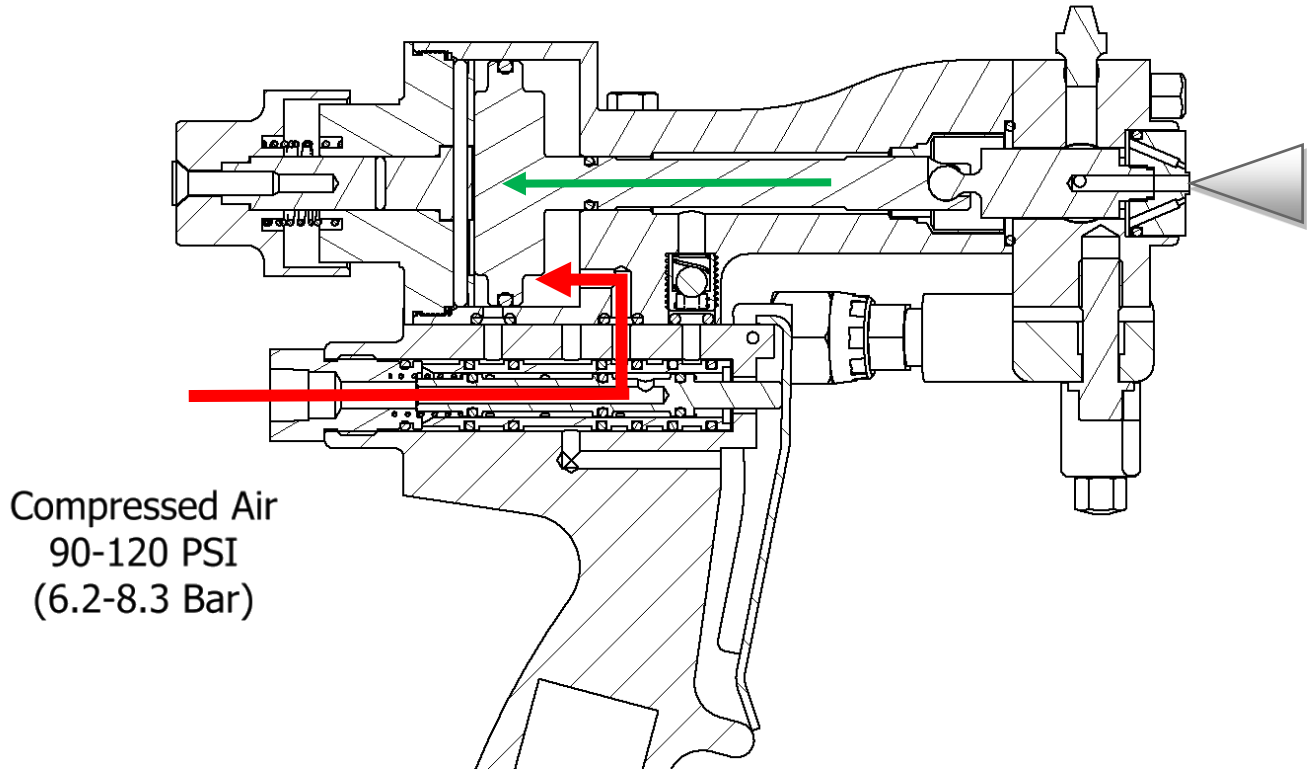
TRIGGERED OFF

1. Compressed **dry air** enters through the rear or bottom of the Gun Handle.



2. The air is directed through the spool valve and into the Rear of the Piston in the Air Cylinder, moving the Piston (and Mixing Chamber) forward to the **CLOSED** position.
3. In the **CLOSED** position, the orifices in the Mixing Chamber are **NOT** aligned with the Side Seal ports. The orifices in the Mixing Chamber are exposed to the air/grease chamber in the Gun Block.
4. Purge air passes through the Spool Valve and the Check Valve, and into the Air Cylinder and Gun Block.
5. Purge air and residual grease enter the Mixing Chamber and pass through the Mixing Chamber and PCT, expelling mixed material out of the chamber area in the process.
6. Purge air is also expelled from the PCT in a circular trajectory to keep the tip clean.

TRIGGERED ON









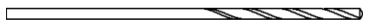







1. Compressed **dry air** is directed through the spool valve and into the front, filling the cavity and pushing the Piston and Chamber backwards.
2. The orifices in the Chamber are now aligned with the Side Seals and exposed to high pressure chemical.
3. High pressure chemical enters the chamber from the opposing orifices. The high-pressure chemicals mix by impingement, and the mixture then travels down the chamber and out the PCT.

NOTE! While the trigger is pulled, the purge air is shutoff during spraying and the PCT will be retracted to the point of being flush with the front surface of the Gun Block.

TROUBLESHOOTING GUIDE

PROBLEM	POSSIBLE CAUSE	SOLUTION
PCT not flush with Gun Block when Gun is triggered	Insufficient air pressure (minimum 90 psi, 6.2 bar)	Ensure 90 psi (6.2 Bar)
	Failed Spool Valve	Replace, see page 16
	Air passages plugged	Clean, See page 18
Material does not spray when Gun is triggered	Lock is in "Locked" position	Unlock gun
	Air supply is not on	Turn on air supply
	Manual Valve CLOSED	OPEN, see page 7
	Mixing Chamber inlet orifices plugged	Clean, see page 11
	Side Seal orifices plugged	Clean, see page 13
	Check Valve plugged	Replace
Mixing Chamber moves slowly	Failed Spool Valve	Replace, see page 17
	Insufficient air pressure (minimum 90 psi, 6.2 Bar)	Ensure 90 psi (6.2 Bar) of air pressure
	Piston assembly requires service	Rebuild, see page 14
	Air passages plugged	Clean, see page 18
Mixing Chamber moves slowly, then normally	Reacted material around Side Seals	Inspect Side Seals, Mixing Chamber and clean, see pages 11, 13
Pattern deformation	Incorrect chemical temperature	See Proportioner Manual
	Mixing Chamber nozzle and/or PCT dirty	Inspect and clean
Material spray pressure imbalance	Mixing Chamber inlet orifices plugged	Clean
	Side Seal orifices plugged	Clean, see page 13
	Dirty screens	Replace
	Material temperatures not as recommended by material supplier	Adjust, see Proportioner Operating Manual
Iso and/or Resin in Gun Air Passages	Side Seal damaged	Replace, see page 13
	Mixing Chamber damaged	Replace, see page 11
	Side Seal/ Screen Screw O-rings damaged	Replace, see page 13
Material mist from Mixing Chamber or PCT	Side Seal damaged	Replace, see page 13
	Mixing Chamber damaged	Replace, see page 11
	Side Seal/Screen Screw O-rings damaged	Replace, see page 13
Excessive overspray	Material temperatures and/or spray pressures not as recommended by material supplier	Adjust, see Proportioner Operating Manual
Buildup of material on PCT	Plugged air passages in PCT and Gun Block	Clean, see page 11
Air leakage from Handle	Air Cylinder O-rings damaged	Replace, see page 38
	Spool Valve Damaged	Replace, see page 16






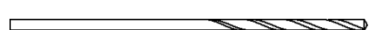


REFERENCE GUIDE

CHAMBER KITS					
KIT NUMBER	PART NUMBER	QTY	DESCRIPTION (INCH)	FOR USE WITH	ILLUSTRATION
GU-814-DP-000	200476	1	#63 DRILL (.0370)	MIXING NOZZLE	
	GU-03031	1	#70 DRILL (.0280)	MIXING CHAMBER PORT	
	RM-814-DP-000	1	CHAMBER #000	-	DIAMOND PLATED
GU-814-DP-00	200477	1	1.25mm DRILL (.0492)	MIXING NOZZLE	
	GU-03027	1	#69 DRILL (.0292)	MIXING CHAMBER PORT	
	RM-814-DP-00	1	CHAMBER #00	-	DIAMOND PLATED
GU-814-DP-00X	200478	1	1.35mm DRILL (.0531)	MIXING NOZZLE	
	GU-03032	1	#61 DRILL (.0390)	MIXING CHAMBER PORT	
	RM-814-DP-00X	1	CHAMBER #00X	-	DIAMOND PLATED
GU-814-DP-01	200479	1	1.45mm DRILL (.0571)	MIXING NOZZLE	
	GU-03021	1	#59 DRILL (.0410)	MIXING CHAMBER PORT	
	RM-814-DP-01	1	CHAMBER #01	-	DIAMOND PLATED
GU-814-DP-01X	GU-03053	1	#52 DRILL (.0635)	MIXING NOZZLE	
	GU-03052	1	#57 DRILL (.0430)	MIXING CHAMBER PORT	
	RM-814-DP-01X	1	CHAMBER #01X	-	DIAMOND PLATED
GU-814-DP-02	GU-03024	1	#51 DRILL (.0676)	MIXING NOZZLE	
	GU-03023	1	#56 DRILL (.0465)	MIXING CHAMBER PORT	
	RM-814-DP-02	1	CHAMBER #02	-	DIAMOND PLATED
GU-814-DP-02X	200480	1	2mm DRILL (.0787)	MIXING NOZZLE	
	GU-03050	1	#55 DRILL (.0520)	MIXING CHAMBER PORT	
	RM-814-DP-02X	1	CHAMBER #02X	-	DIAMOND PLATED












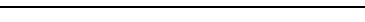


CHAMBER KITS (CONTINUED)

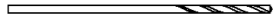
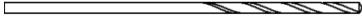






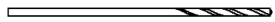
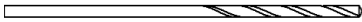






GU-814-DP-03	GU-03028	1	#44 DRILL (.0860)	MIXING NOZZLE	
	GU-03035	1	#54 DRILL (.055)	MIXING CHAMBER PORT	
	RM-814-DP-03	1	CHAMBER #03	-	DIAMOND PLATED
GU-814-DP-04	200481	1	2.4mm DRILL (.0945)	MIXING NOZZLE	
	GU-03054	1	#50 DRILL (.0700)	MIXING CHAMBER PORT	
	RM-814-DP-04	1	CHAMBER #04	-	DIAMOND PLATED
GU-814-DP-05	GU-03028	1	#44 Drill (.0860)	MIXING NOZZLE	
	201120	1	#33 DRILL (0.1130)	MIXING CHAMBER PORT	
	RM-814-DP-05	1	CHAMBER #05	-	DIAMOND PLATED

PCT KITS

KIT NUMBER	PART NUMBER	QTY	DESCRIPTION	FOR USE WITH	ILLUSTRATION
GU-815-000	GU-03033	1	#65 DRILL (.0350)	PCT PURGE PORT	
	GU-03035	1	#54 DRILL (.055)	PCT PURGE PORT	
	2000476	1	#63 DRILL (.0370)	PCT NOZZLE PORT	
	OR-00042A	2	O-RING, VITON, - 016	-	
	RM-815-000	1	PATTERN CONTROL TIP 000	-	
GU-815-00	GU-03033	1	#65 DRILL (.0350)	PCT PURGE PORT	
	GU-03035	1	#54 DRILL (.055)	PCT PURGE PORT	
	200477	1	1.25mm DRILL (.0492)	PCT NOZZLE PORT	
	OR-00042A	2	O-RING, VITON, - 016	-	
	RM-815-00	1	PATTERN CONTROL TIP 00	-	

PCT KITS (CONTINUED)

GU-815-00X	GU-03033	1	#65 DRILL (.0350)	PCT PURGE PORT	
	200478	1	1.35mm DRILL (.0531)	PCT PURGE AND NOZZLE PORT	
	OR-00042A	2	O-RING, VITON, - 016	-	
	RM-815-00X	1	PATTERN CONTROL TIP 00.X	-	
GU-815-01	GU-03033	1	#65 DRILL (.0350)	PCT PURGE PORT	
	200479	1	1.45mm DRILL (.0571)	PCT PURGE & NOZZLE PORT	
	OR-00042A	2	O-RING, VITON, - 016	-	
	RM-815-01	1	PATTERN CONTROL TIP 01	-	
GU-815-01X	GU-03033	1	#65 DRILL (.0350)	PCT PURGE PORT	
	GU-03035	1	#54 DRILL (.055)	PCT PURGE PORT	
	GU-03053	1	#52 DRILL (.0635)	PCT NOZZLE PORT	
	OR-00042A	2	O-RING, VITON, - 016	-	
	RM-815-01X	1	PATTERN CONTROL TIP 01X	-	
GU-815-02	GU-03033	1	#65 DRILL (.0350)	PCT PURGE PORT	
	GU-03035	1	#54 DRILL (.055)	PCT PURGE PORT	
	GU-03024	1	#51 DRILL (.0676)	PCT NOZZLE PORT	
	OR-00042A	2	O-RING, VITON, - 016	-	
	RM-815-02	1	PATTERN CONTROL TIP 02	-	

PCT KITS (CONTINUED)					
GU-815-02X	GU-03033	1	#65 DRILL (.0350)	PCT PURGE PORT	
	GU-03035	1	#54 DRILL (.055)	PCT PURGE PORT	
	200480	1	2mm DRILL (.0787)	PCT NOZZLE PORT	
	OR-00042A	2	O-RING, VITON, -016	-	
	RM-815-02X	1	PATTERN CONTROL TIP 02X	-	
GU-815-03	GU-03033	1	#65 DRILL (.0350)	PCT PURGE PORT	
	GU-03035	1	#54 DRILL (.055)	PCT PURGE PORT	
	GU-03028	1	#44 DRILL (.0860)	PCT NOZZLE PORT	
	OR-00042A	2	O-RING, VITON, -016	-	
	RM-815-03	1	PATTERN CONTROL TIP 03	-	
GU-815-04	GU-03033	1	#65 DRILL (.0350)	PCT PURGE PORT	
	GU-03035	1	#54 DRILL (.055)	PCT PURGE PORT	
	200481	1	2.4mm DRILL (.0945)	PCT NOZZLE PORT	
	OR-00042A	2	O-RING, VITON, -016	-	
	RM-815-04	1	PATTERN CONTROL TIP 04	-	
200919	GU-03033	1	#65 DRILL (.0350)	PCT PURGE PORT	
	GU-03035	1	#54 DRILL (.055)	PCT PURGE PORT	
	201093	1	2.9mm DRILL (.114)	PCT NOZZLE PORT	
	OR-00042A	2	O-RING, VITON, -016	-	
	200918	1	PATTERN CONTROL TIP 05	-	

DIAMOND PLATED CHAMBER/PCT KITS			
KIT NUMBER	PART NUMBER	QTY	DESCRIPTION
KT-814-DP-000	GU-814- DP -000	1	CHAMBER 000 W/ DRILLS
	GU-815-000	1	PCT 000 RND W/ DRILLS
	OR-00042A	1	O-RING, VITON, -016
KT-814-DP-00	GU-814- DP -00	1	CHAMBER 00 W/ DRILLS
	GU-815-00	1	PCT 00 RND W/ DRILLS
	OR-00042A	1	O-RING, VITON, -016
KT-814-DP-00X	GU-814- DP -00X	1	CHAMBER 00X W/ DRILLS
	GU-815-00X	1	PCT 00X W/ DRILLS
	OR-00042A	1	O-RING, VITON, -016
KT-814-DP-01	GU-814- DP -01	1	CHAMBER 01 W/ DRILLS
	GU-815-01	1	PCT 01 RND W/ DRILLS
	OR-00042A	1	O-RING, VITON, -016
KT-814-DP-01X	GU-814- DP -01X	1	CHAMBER 01X W/ DRILLS
	GU-815-01X	1	PCT 01X RND W/ DRILLS
	OR-00042A	1	O-RING, VITON, -016
KT-814-DP-02	GU-814- DP -02	1	CHAMBER 02 W/ DRILLS
	GU-815-02	1	PCT 02 RND W/ DRILLS
	OR-00042A	1	O-RING, VITON, -016
KT-814-DP-02X	GU-814- DP -02X	1	CHAMBER 02X W/ DRILLS
	GU-815-02X	1	PCT 02X RND W/ DRILLS
	OR-00042A	1	O-RING, VITON, -016
KT-814-DP-03	GU-814- DP -03	1	CHAMBER 03 W/ DRILLS
	GU-815-03	1	PCT 03 RND W/ DRILLS
	OR-00042A	1	O-RING, VITON, -016
KT-814-DP-04	GU-814- DP -04	1	CHAMBER 04 W/ DRILLS
	GU-815-04	1	PCT 04 RND W/ DRILLS
	OR-00042A	1	O-RING, VITON, -016
KT-814-DP-05	200920	1	CHAMBER 05 W/ DRILLS
	200918	1	PCT 05 RND W/ DRILLS
	OR-00042A	1	O-RING, VITON, -016

AP-2/AP-3 SPARE PARTS KITS DESC		
PART NUMBER	DESCRIPTION	REFERENCE PAGE
200445	AP-2/AP-3-000 SPARE PARTS KIT	28
200446	AP-2/AP-3-00 SPARE PARTS KIT	28
200447	AP-2/AP-3-00X SPARE PARTS KIT	28
200448	AP-2/AP-3-01 SPARE PARTS KIT	28
200449	AP-2/AP-3-01X SPARE PARTS KIT	28
200450	AP-2/AP-3-02 SPARE PARTS KIT	28
200451	AP-2/AP-3-02X SPARE PARTS KIT	28
200452	AP-2/AP-3-03 SPARE PARTS KIT	28
200453	AP-2/AP-3-04 SPARE PARTS KIT	28
201173	AP-2/AP-3-05 SPARE PARTS KIT	28
202536	AP-2/AP-3-000 SPARE PARTS KIT, DP	29
202537	AP-2/AP-3-00 SPARE PARTS KIT, DP	29
202538	AP-2/AP-3-00X SPARE PARTS KIT, DP	29
202539	AP-2/AP-3-01 SPARE PARTS KIT, DP	29
202540	AP-2/AP-3-01X SPARE PARTS KIT, DP	29
202541	AP-2/AP-3-02 SPARE PARTS KIT, DP	29
202542	AP-2/AP-3-02X SPARE PARTS KIT, DP	29
202543	AP-2/AP-3-03 SPARE PARTS KIT, DP	29
202544	AP-2/AP-3-04 SPARE PARTS KIT, DP	29
202545	AP-2/AP-3-05 SPARE PARTS KIT, DP	29

AP-2/AP-3 SPARE PARTS KITS (DIAMOND PLATED)

KIT PART NUMBER		202536	202537	202538	202539	202540	202541	202542	202543	202544	202545
PART NUMBER	DESCRIPTION	000	00	00X	01	01X	02	02X	03	04	05
200459	O-RING, VITON, -018	2	2	2	2	2	2	2	2	2	2
200592	000 PKG DRILL BITS	1	-	-	-	-	-	-	-	-	-
200593	00 PKG DRILL BITS	-	1	-	-	-	-	-	-	-	-
200598	00X PKG DRILL BITS	-	-	1	-	-	-	-	-	-	-
KT-830	01 PKG DRILL BITS	-	-	-	1	-	-	-	-	-	-
200596	01X PKG DRILL BITS	-	-	-	-	1	-	-	-	-	-
KT-829	02 PKG DRILL BITS	-	-	-	-	-	1	-	-	-	-
200597	02X PKG DRILL BITS	-	-	-	-	-	-	1	-	-	-
200594	03 PKG DRILL BITS	-	-	-	-	-	-	-	1	-	-
200595	04 PKG DRILL BITS	-	-	-	-	-	-	-	-	1	-
201174	05 PKG DRILL BITS	-	-	-	-	-	-	-	-	-	1
202454	SIDE SEAL, .125 RESIN	2	2	2	2	2	2	2	2	2	2
GP-00101	PIN VICE	1	1	1	1	1	1	1	1	1	1
GP-LUBEGREASE	GREASE; TUBE	1	1	1	1	1	1	1	1	1	1
GU-020	MANUAL VALVE ASSY.	1	1	1	1	1	1	1	1	1	1
GU-04007	SCREEN SCREW SEAL	2	2	2	2	2	2	2	2	2	2
GU-818-80	FILTER SCREEN; 80 MESH	4	4	4	4	4	4	4	4	4	4
KT-020	MANUAL VALVE SOFTWARE KIT	1	1	1	1	1	1	1	1	1	1
KT-814-DP-SIZE	CHAMBER/PCT ROUND SIZE W/DRILLS, DP	1	1	1	1	1	1	1	1	1	1
KT-850	CHECK VALVE KIT	1	1	1	1	1	1	1	1	1	1
OR-00026A	O-RING, VITON, -129	2	2	2	2	2	2	2	2	2	2
OR-00042A	O-RING, VITON, -016	2	4	4	4	4	4	4	4	4	4
OR-00043B	O-RING, AFLAS, -010	10	10	10	10	10	10	10	10	10	10
OR-800	#013 BACK UP RING	2	2	2	2	2	2	2	2	2	2
OR-801A	O-RING, AFLAS, -013	2	2	2	2	2	2	2	2	2	2
OR-804	O-RING, BUNA, 2MMX4MM	3	3	3	3	3	3	3	3	3	3
OR-805	O-RING, VITON, -108	8	8	8	8	8	8	8	8	8	8
SP-04005	SPRING; SIDE SEAL	2	2	2	2	2	2	2	2	2	2

AP-2/AP-3 PACKAGE DRILL BITS											
KIT PART NUMBER		200592	200593	200598	KT-830	200596	KT-829	200597	200594	200595	201174
PART NUMBER	DESCRIPTION	000	00	00X	01	01X	02	02X	03	04	05
200476	DRILL 0.94mm (.0370")	2	-	-	-	-	-	-	-	-	-
200477	DRILL 1.25mm (.0492")	-	2	-	-	-	-	-	-	-	-
200478	DRILL 1.35mm (.0531")	-	-	2	-	-	-	-	-	-	-
200480	DRILL 2.00mm (.0787")	-	-	-	-	-	-	2	-	-	-
200481	DRILL 2.40mm (.0945")	-	-	-	-	-	-	-	-	2	-
201093	DRILL 2.90mm (.1142")	-	-	-	-	-	-	-	-	-	1
201120	DRILL 2.87mm (.1130")	-	-	-	-	-	-	-	-	-	1
GU-03021	DRILL 1.04mm (.0410")	-	-	-	1	-	-	-	-	-	-
GU-03023	DRILL 1.18mm (.0465")	-	-	-	-	-	1	-	-	-	-
GU-03024	DRILL 1.70mm (.0670")	-	-	-	-	-	1	-	-	-	-
GU-03027	DRILL 0.74mm (.0292")	-	1	-	-	-	-	-	-	-	-
GU-03028	DRILL 2.18mm (.0860")	-	-	-	-	-	-	-	1	-	1
GU-03031	DRILL 0.71mm (.0280")	1	-	-	-	-	-	-	-	-	-
GU-03032	DRILL 0.99mm (.0390")	-	-	1	-	-	-	-	-	-	-
GU-03033	DRILL 0.89mm (.0350")	1	1	1	1	1	1	1	1	1	1
GU-03035	DRILL 1.40mm (.0550")	1	1	1	2	1	1	1	1	1	1
GU-03050	DRILL 1.32mm (.0520")	-	-	-	-	-	-	1	-	-	-
GU-03052	DRILL 1.09mm (.0430")	-	-	-	-	1	-	-	-	-	-
GU-03053	DRILL 1.61mm (.0635")	-	-	-	-	1	-	-	-	-	-
GU-03054	DRILL 1.78mm (.0700")	-	-	-	-	-	-	-	-	1	-

PMC RECOMMENDED O-RING GREASE		
PART NUMBER	QTY	DESCRIPTION
GP-LUBEGREASE	1	LUBRIPLATE GREASE
TL-04003	1	GREASE TUBE FOR USE W/ GREASE GUN

MISCELLANEOUS PARTS/KITS

SIDE SEAL KIT, RESIN (202546)		
PART NUMBER	QTY	DESCRIPTION
202454	2	SIDE SEAL, .125, RESIN
OR-00043B	2	O-RING, AFLAS, -010, 80D

SCREEN SIZES		
PART NUMBER	QTY	DESCRIPTION
GU-818-40	1	FILTER SCREEN, 40 MESH
GU-818-60	1	FILTER SCREEN, 60 MESH
GU-818-80	1	FILTER SCREEN, 80 MESH (STANDARD)
KT-818-40	1	FILTER SCREEN, 40 MESH (PKG 10)
KT-818-60	1	FILTER SCREEN, 60 MESH (PKG 10)
KT-818-80	1	FILTER SCREEN, 80 MESH (PKG 10)

A & R SCREEN SCREW ASSEMBLY KITS			
KIT NUMBER	PART NUMBER	QTY	DESCRIPTION
KT-819-A	GU-04007	1	SCREEN SCREW SEAL
	GU-819-A	1	A SCREEN SCREW
	OR-800	1	#013 BACK UP RING
	OR-801A	1	O-RING, AFLAS, -013
KT-819-R	GU-04007	1	SCREEN SCREW SEAL
	GU-819-R	1	R SCREEN SCREW
	OR-800	1	#013 BACK UP RING
	OR-801A	1	O-RING, AFLAS, -013

AP-3 O-RING KIT (201118)

PART NUMBER	QTY	DESCRIPTION
200459	1	O-RING, VITON, -018
OR-00026A	2	O-RING, VITON, -129
OR-00042A	1	O-RING, VITON, -016
OR-00043B	4	O-RING, AFLAS, -010
OR-800	2	#013 BACK UP RING
OR-801A	2	O-RING, AFLAS, -013
OR-804	3	O-RING, BUNA, 2mm X 4mm

AIR CYLINDER REBUILD KIT (202744)

PART NUMBER	QTY	DESCRIPTION
200459	1	O-RING, VITON, -018
201562	1	AIR CYLINDER BUSHING
202705	1	SEAT, CHECK VALVE
202714	1	BALL, CHECK VALVE
202712	1	SPRING, CHECK VALVE
OR-00026A	2	O-RING, VITON, -129
OR-00042A	1	O-RING, VITON, -016
OR-00043B	2	O-RING, AFLAS, -010
OR-804	3	O-RING, BUNA, 2mm X 4mm
202715	1	WASHER, FLAT, NO 3, SS

1/4" UNHEATED STAINLESS STEEL HOSE ASSEMBLY

PART NUMBER	DESCRIPTION
MA-41	HOSE PACKAGE KIT, UNHEATED
MA-41A	REPLACEMENT HOSE, "A" SIDE
MA-41R	REPLACEMENT HOSE, "R" SIDE

SPOOL VALVE REBUILD KIT (202756)

PART NUMBER	QTY	DESCRIPTION
200513	7	O-RING, VITON, 9.25mm X 1.78mm
202568	1	SPOOL VALVE LINER, XTREME
GU-824	1	SPOOL VALVE SPRING, XTREME
OR-00002A	3	O-RING, VITON, -008
OR-804	3	O-RING, BUNA, 2mm X 4mm

FULL GUN REBUILD KIT, XTREME (202757)

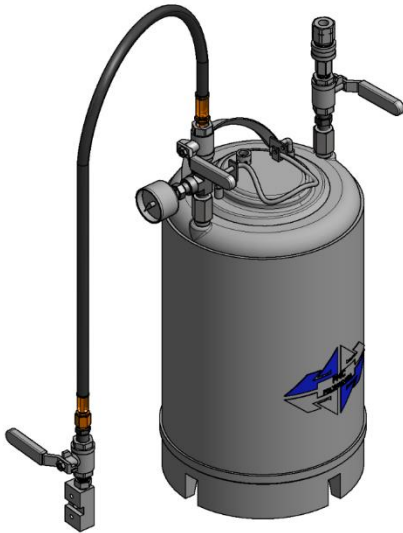
PART NUMBER	QTY	DESCRIPTION
200459	1	O-RING, VITON, -018
200513	7	O-RING, VITON, 9.25mm X 1.78mm
201562	1	BUSHING, AIR CYLINDER, AP-3
202454	2	SIDE SEAL, .125, RESIN
202568	1	SPOOL VALVE LINER, XTREME
202705	1	SEAT, CHECK VALVE, XTREME
202712	1	SPRING, CHECK VALVE, XTREME
202714	1	BALL, 7/32" STEEL
202715	1	WASHER, FLAT, NO 3, SS
GU-04007	2	SCREEN SCREW SEAL
GU-818-80	2	FILTER SCREEN, 80 MESH
GU-824	1	SPOOL VALVE SPRING, AP-2
KT-850	1	CHECK VALVE ASSY KIT
OR-00002A	3	O-RING, VITON, -008
OR-00026A	1	O-RING, VITON, -129
OR-00042A	1	O-RING, AFLAS, -016, BLK
OR-00043B	2	O-RING, AFLAS, -010, 80D
OR-800	2	BACKUP RING, -013
OR-801A	2	O-RING, AFLAS, -013, 80D
OR-804	3	O-RING, BUNA, 2mm X 4mm
SP-04005	2	SPRING, SIDE SEAL
TL-04003	1	GREASE TUBE

RECOMMENDED SPARE PARTS			
PART NUMBER	QTY	DESCRIPTION	PAGE
201118	1	AP-3 O-RING KIT	29
202744	1	AIR CYLINDER REBUILD KIT	29
202546	1	SIDE SEAL KIT, RESIN	28
GU-020	1	MANUAL VALVE ASSEMBLY	35
GU-04007	2	SCREEN SCREW SEAL	38
GU-818-40	4	FILTER SCREEN 40 MESH	28
GU-818-60	4	FILTER SCREEN 60 MESH	28
GU-818-80	4	FILTER SCREEN 80 MESH (STANDARD)	28
KT-850	1	CHECK VALVE ASSEMBLY	36
OR-00042A	2	O-RING, VITON, -016	29
OR-00043B	8	O-RING, AFLAS, -010	29
OR-800	8	#013 BACK UP RING	29
OR-801A	8	O-RING, AFLAS, -013	29
SP-04005	2	SPRING; SIDE SEAL	38
TL-04003	1	GREASE TUBE	40

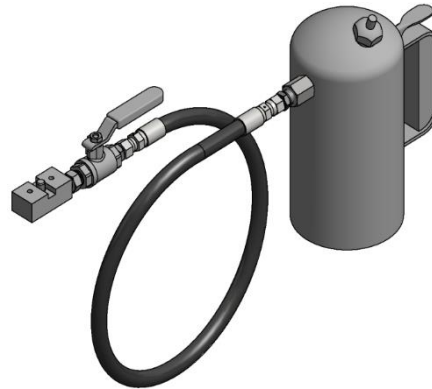
OPTIONAL PARTS		
PART NUMBER	QTY	DESCRIPTION
GU-815-50-509	1	BLASTER TIP .059
GU-815-50	1	BLASTER TIP 3.5
GU-815-51	1	POUR TIP
GU-815-53	1	POUR NOZZLE
GU-815-52	1	PCT FLAT TIP RETAINER ASSEMBLY
GU-815-52-1	1	PCT FLAT TIP BODY
GU-815-52-2	1	PCT FLAT TIP GASKET
GU-815-52-3	1	PCT FLAT TIP RETAINER
OR-00042A	1	O-RING, VITON, -016
202454	1	SIDE SEAL, .125, RESIN

FLUSH TANKS

Optional 2.5 Gallon Flush Tank (200426, 200427) and 1QT Mini Flush Tank (200216, 200217) shown.



2.5 Gallon Flush Tank

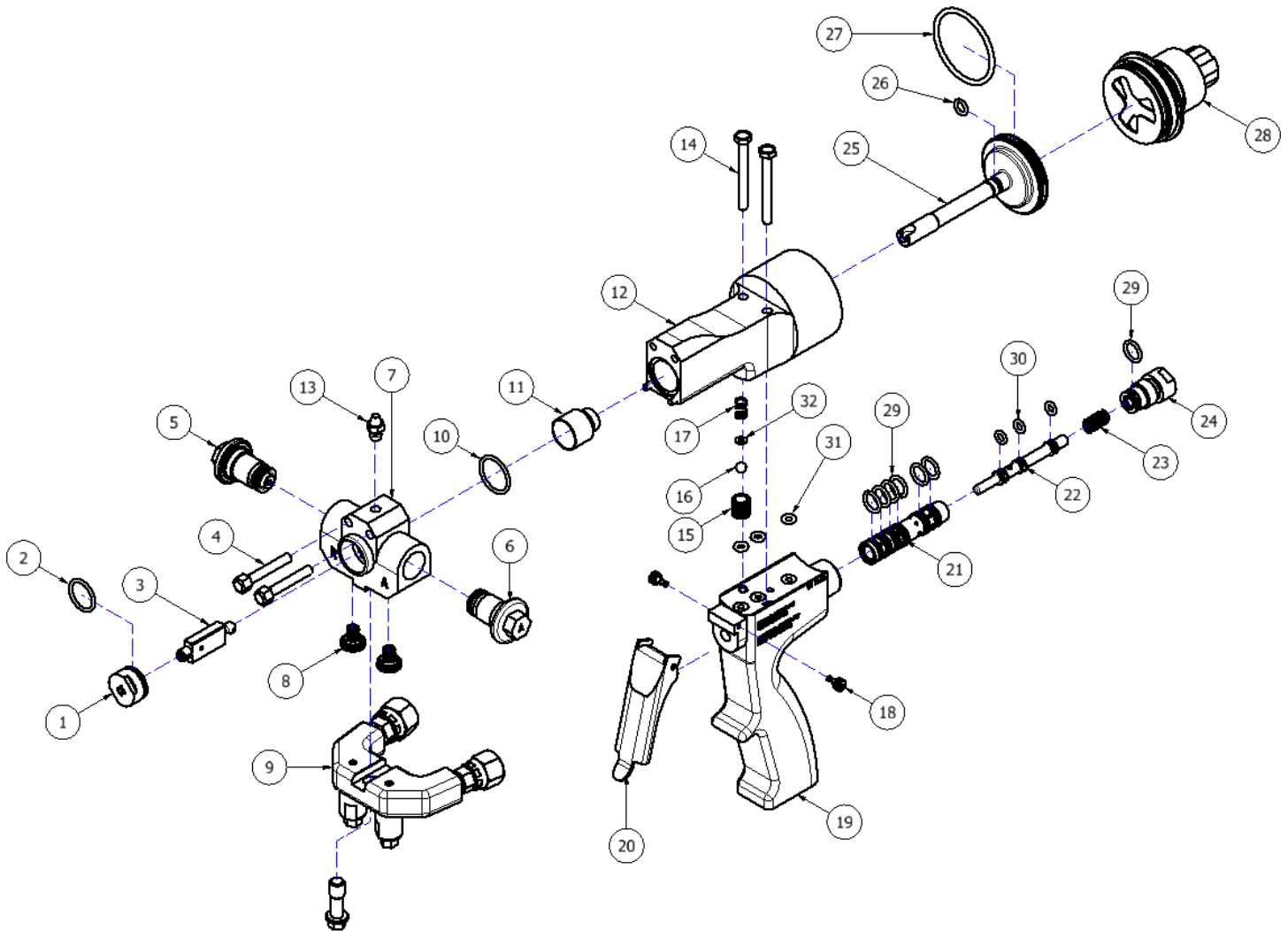


1 QT Mini Flush Tank

FLUSH TANKS	
2.5 Gallon Flush Tank	1 QT Mini Flush Tank
200426 – Solvent Flush Kit, 2.5 Gal, AP	200216 – Solvent Flush Kit, Quart, AP
200427 – Solvent Flush Kit, 2.5 Gal, F-AP	200217 – Solvent Flush Kit, Quart, F-AP

PARTS IDENTIFICATION

FINAL GUN ASSEMBLY

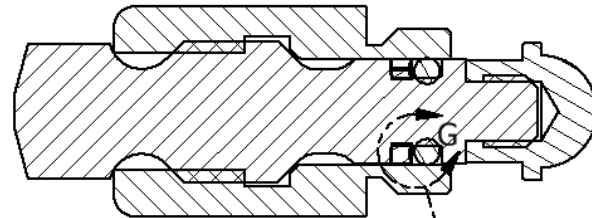
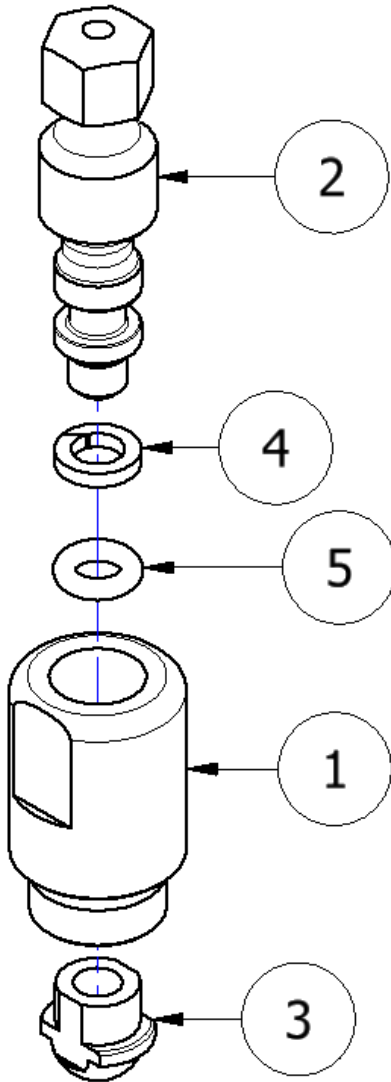


NOTE: WHEN ASSEMBLING BE SURE TO APPLY GREASE TO **ALL** O-RINGS. THIS ENSURES GOOD PERFORMANCE AND REDUCES RISK OF GUN MALFUNCTION.

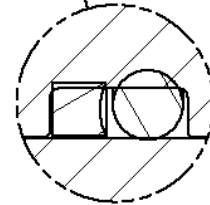
FINAL GUN ASSEMBLY			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	RM-815-SIZE	PCT
2	1	OR-00042A	O-RING, VITON, -016
3	1	RM-814-DP-SIZE	MIXING CHAMBER
4	2	201108	SCREW, HEX CAP, 10-32 CUSTOM
5	1	202410	SCREEN SCREW ASSEMBLY, R-SIDE
6	1	202409	SCREEN SCREW ASSEMBLY, A-SIDE
7	1	202735	ALUMINIUM GUN BLOCK, XTREME
		202736	STEEL GUN BLOCK, XTREME
8	1	KT-850	CHECK VALVE ASSEMBLY
9	1	GU-04001	GUN BLOCK ASSEMBLY
10	1	200459	O-RING, VITON, -018
11	1	201562	AIR CYLINDER BUSHING
12	1	202716	CYLINDER, PINNED, XTREME
13	1	TN-04186	GREASE FITTING, 1/4-28
14	2	201109	HHCS, 10-24 X 1.750, ZP
15	1	202705	SEAT, CHECK VALVE
16	1	202714	BALL, CHECK VALVE
17	1	202712	SPRING, CHECK VALVE
18	2	201110	SHOULDER BOLT, 1/8D, 1/8L, SS
19	1	202566	HANDLE, XTREME
20	1	200673	TRIGGER, AP-3
21	1	202568	SPOOL VALVE, LINER
22	1	202569	SPOOL VALVE
23	1	GU-824	SPOOL VALVE, SPRING
24	1	GU-833	HOSE ADAPTER
25	1	202245	PISTON, AP-3
26	1	OR-00043B	O-RING, AFLAS, -010
27	1	OR-00026A	O-RING, VITON, -129
28	1	GU-844	END CAP ASSEMBLY, AP-2/3
29	7	200513	O-RING, VITON, 9.25mm X 1.78mm
30	3	OR-00002A	O-RING, VITON, -008
31	3	OR-804	O-RING, BUNA, 2mm X 4mm
32	1	202715	WASHER, FLAT, NO 3, SS

MANUAL VALVE ASSEMBLY

(GU-020)



Item 4 is flat on top
and concave on the bottom
meeting with Item 5.



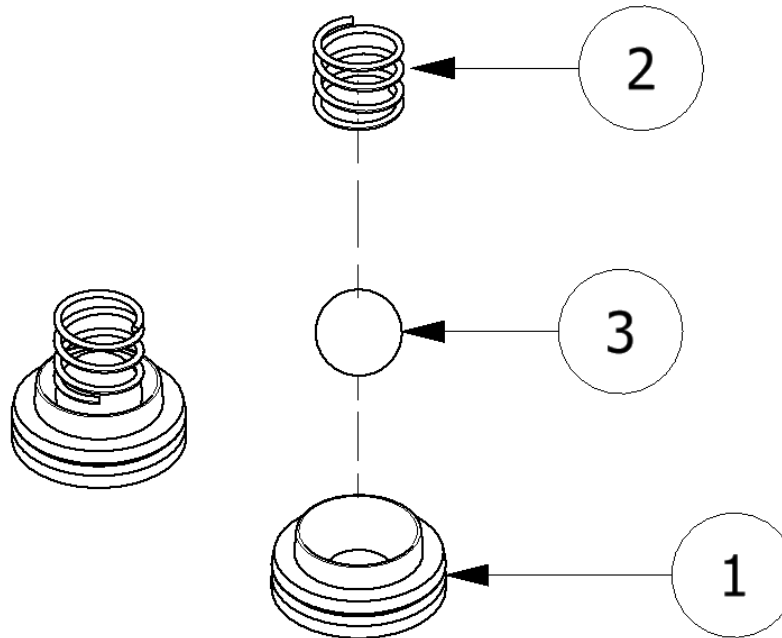
NOTE: The orientation of the back-up ring is important.
The concave face must point towards the O-Ring.

MANUAL VALVE ASSEMBLY			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	GU-022	MANUAL VALVE HOUSING
2	1	GU-021	MANUAL VALVE STEM
3	1	GU-023	MANUAL VALVE SEAT
4	1	OR-016	007 VITON CURVED BACKUP RING
5	1	OR-015	#007 AFLAS O-RING

MANUAL VALVE SOFTWARE KIT (KT-020)		
PART NUMBER	QTY	DESCRIPTION
GU-LOCTITE	1	LOCTITE #242
OR-015	4	O-RING, AFLAS, -007
OR-016	4	#007 VITON CURVED BACKUP RING

CHECK VALVE ASSEMBLY

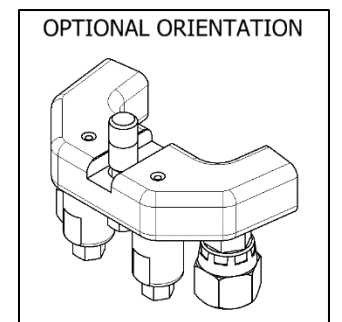
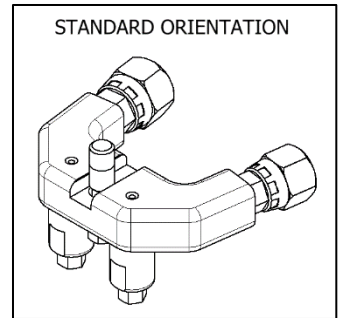
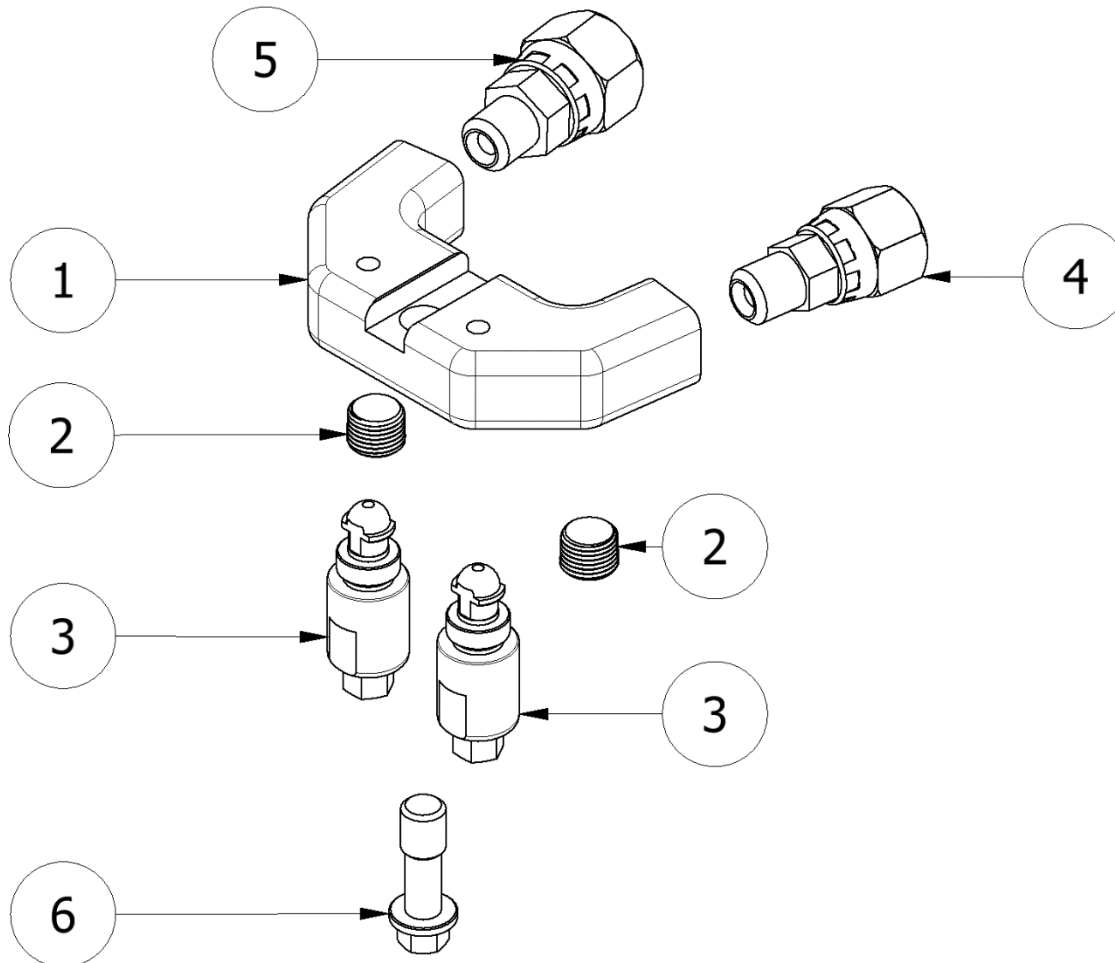
(KT-850)



CHECK VALVE ASSEMBLY			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	GU-851	CHECK VALVE SEAT
2	2	GU-852	CHECK VALVE SPRING
3	2	GU-853	1/4" CHECK VALVE BALL

COUPLING BLOCK ASSEMBLY

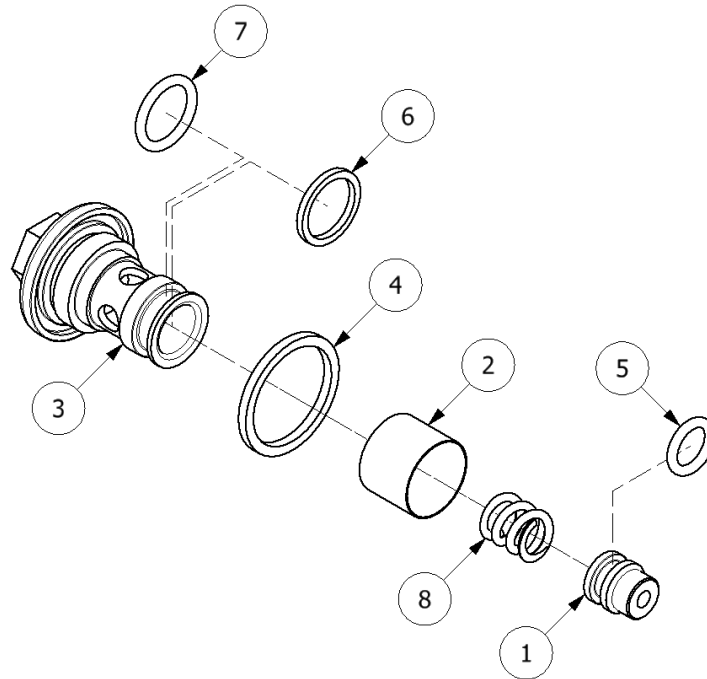
(GU-04001)



COUPLING BLOCK ASSEMBLY			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	GU-04001-01	COUPLING BLOCK BODY
2	2	TN-04192	1/8 NPT PIPE PLUG
3	2	GU-020	MANUAL VALVE ASSY
4	1	RA-00005A	1/8 NPT X #5 JIC SWIVEL
5	1	RA-00006A	1/8 NPT X #6 JIC SWIVEL
6	1	TN-04193	COUPLING BLOCK MOUNTING SCREW

SCREEN SCREW ASSEMBLY

(A-SIDE: 202409 / R-SIDE: 202410)



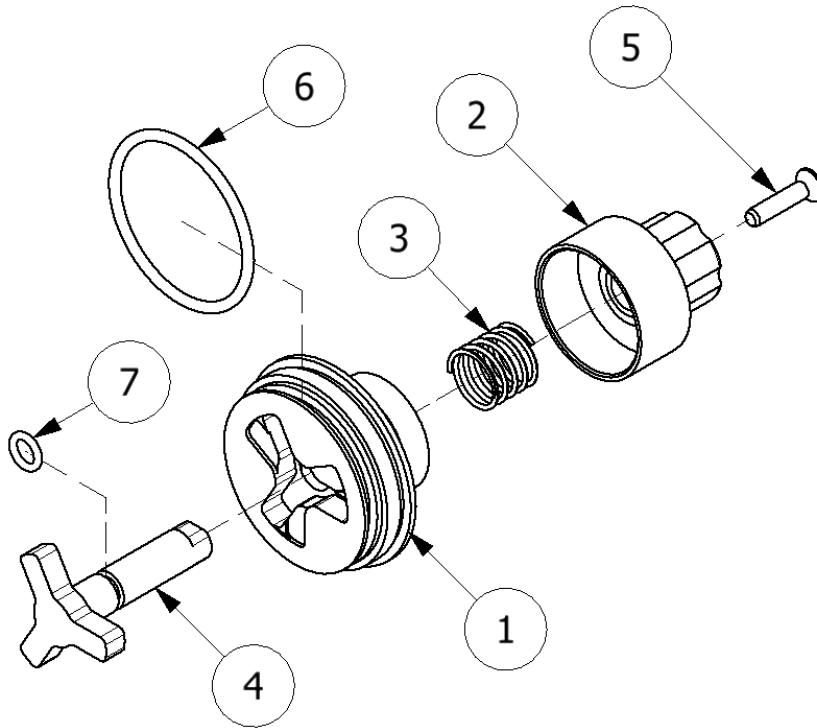
NOTE: WHEN ASSEMBLING BE SURE TO APPLY GREASE TO **ALL** O-RINGS. THIS ENSURES GOOD PERFORMANCE AND REDUCES RISK OF GUN MALFUNCTION.

SCREEN SCREW ASSEMBLY			
ITEM	QTY	PART NUMBER	DESCRIPTION
1*	1	202454	SIDE SEAL, .125, RESIN
2	1	GU-818-40	FILTER SCREEN; 40 MESH
	1	GU-818-60	FILTER SCREEN; 60 MESH
	1	GU-818-80	FILTER SCREEN; 80 MESH (STANDARD)
3*	1	GU-819-R	"R" SCREEN SCREW
	1	GU-819-A	"A" SCREEN SCREW
4*	1	GU-04007	SCREEN SCREW SEAL
5	1	OR-00043B	O-RING, AFLAS, -010
6*	1	OR-800	#013 BACK UP RING
7*	1	OR-801A	O-RING, AFLAS, -013
8	1	SP-04005	SPRING; SIDE SEAL

*Included in KT-819-R and KT-819-A (Pg. 28)

END CAP ASSEMBLY

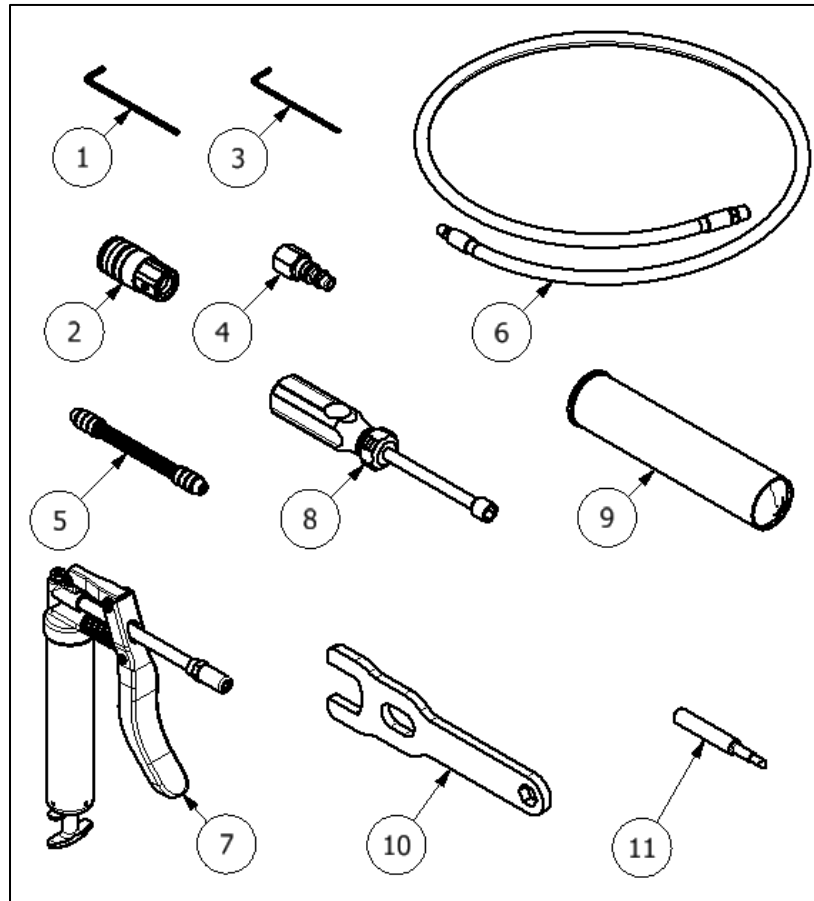
(GU-844)



NOTE: WHEN ASSEMBLING BE SURE TO APPLY GREASE TO **ALL** O-RINGS. THIS ENSURES GOOD PERFORMANCE AND REDUCES RISK OF GUN MALFUNCTION.

SCREEN SCREW COMPONENTS			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	GU-803	CYLINDER END CAP
2	1	GU-804	LOCK KNOB
3	1	GU-806	SPRING
4	1	GU-807	TWO POSITION STOP
5	1	GU-831	RETAINING SCREW
6	1	OR-00026A	O-RING, VITON, -129
7	1	OR-00043B	O-RING, AFLAS, -010

LIST OF TOOLS



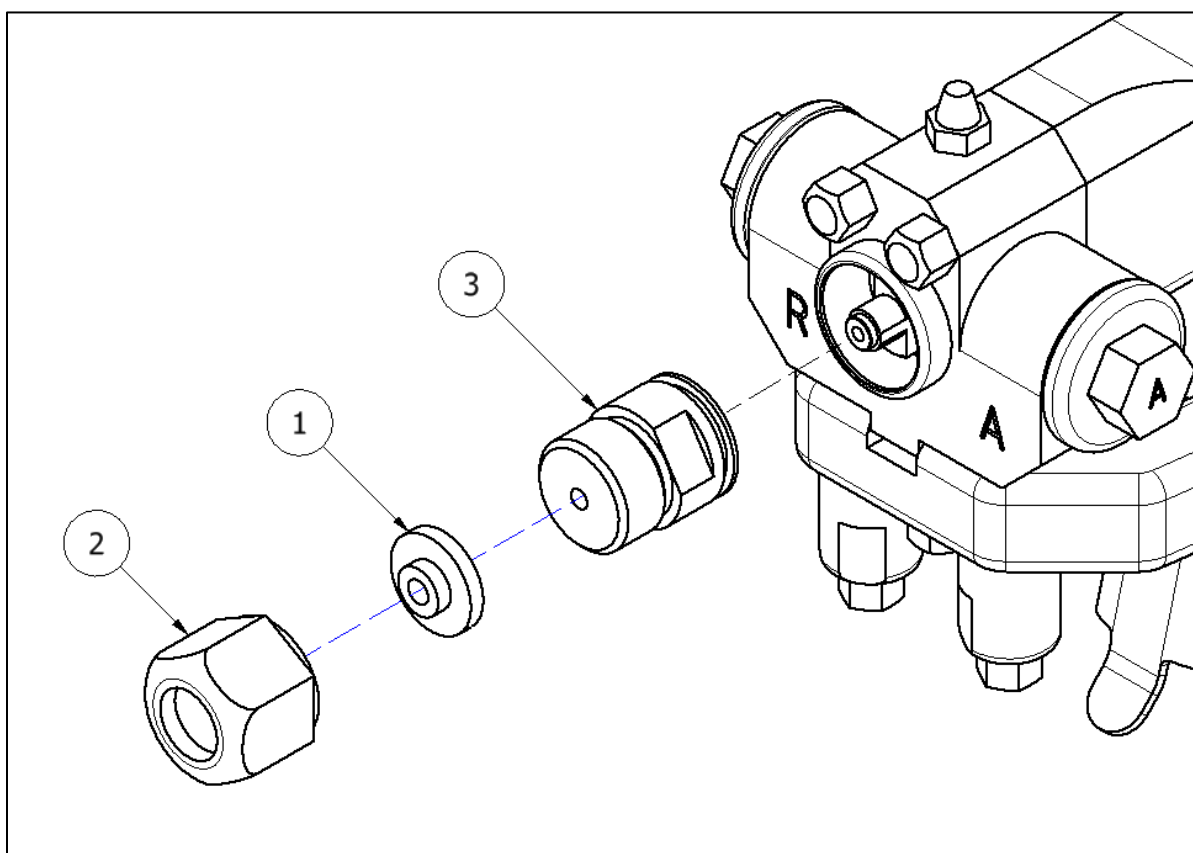
LIST OF TOOLS			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	200581	3/32" ALLEN WRENCH
2	1	200585	QUICK CONNECT, FEMALE
3	1	200609	5/64" ALLEN WRENCH
4	1	202340	QD,PLUG,1/4 IND X 1/4 FNPT,STL
5	1	GP-00101	DOUBLE ENDED PIN VISE
6	1	GU-04019	AIR HOSE
7	1	TL-00002	GREASE GUN
8	1	TL-04001	5/16 SPINTITE, NUT DRIVER
9	1	TL-04003	GREASE TUBE
10	1	TL-09	OPEN END WRENCH
11	1	TL-10	CHECK VALVE REMOVAL TOOL

FLAT TIP ADAPTER KITS

FLAT TIP ADAPTER KIT

(201152)

NOTE: This kit is intended for use with 201099 (PCD, TP-100, PX-7) for foam applications.

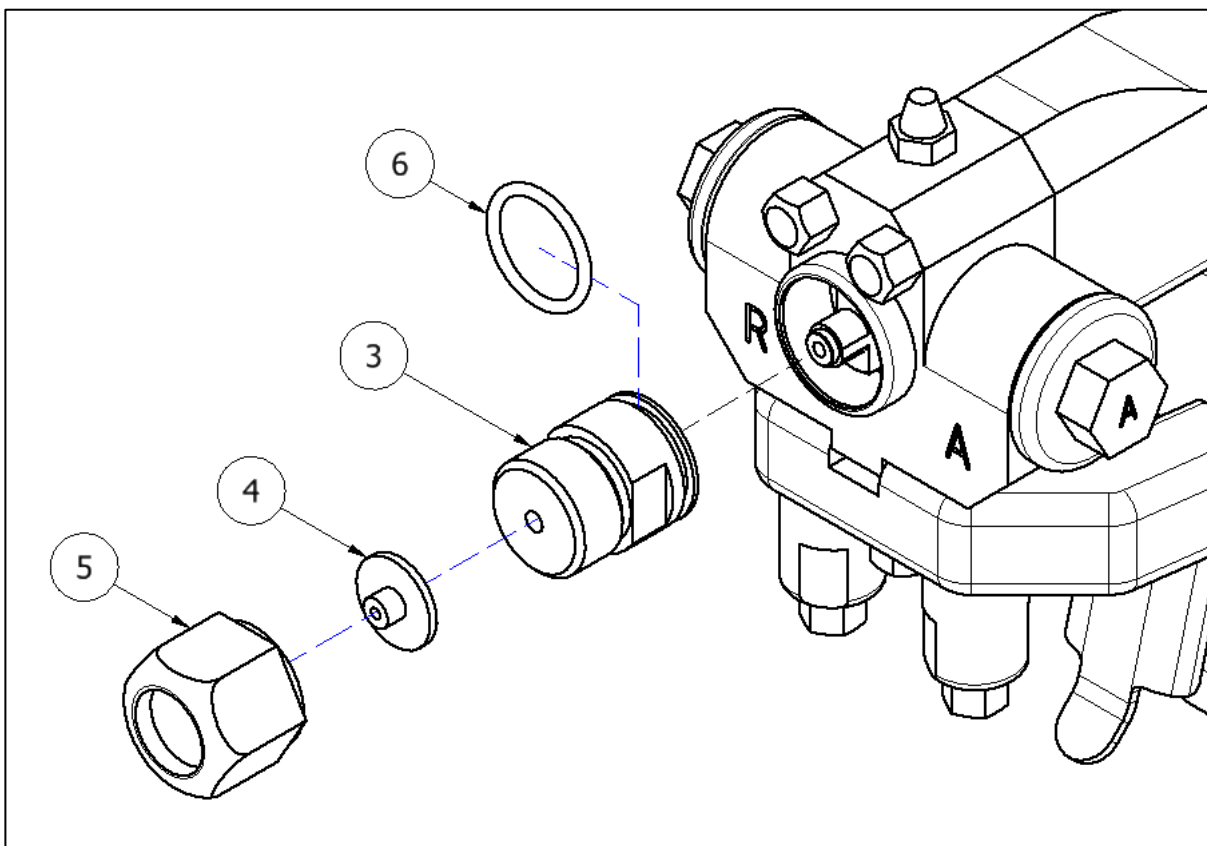


PCT FLAT TIP RETAINER ASSEMBLY (201152)

ITEM	PART NUMBER	DESCRIPTION	QTY
1	201150	FLAT TIP ADAPTER GASKET	1
2	201151	FLAT TIP RETAINER	1
3	GU-815-52-1	FLAT TIP ADAPTER BODY	1

FLAT TIP RETAINER ASSEMBLY

(GU-815-52)



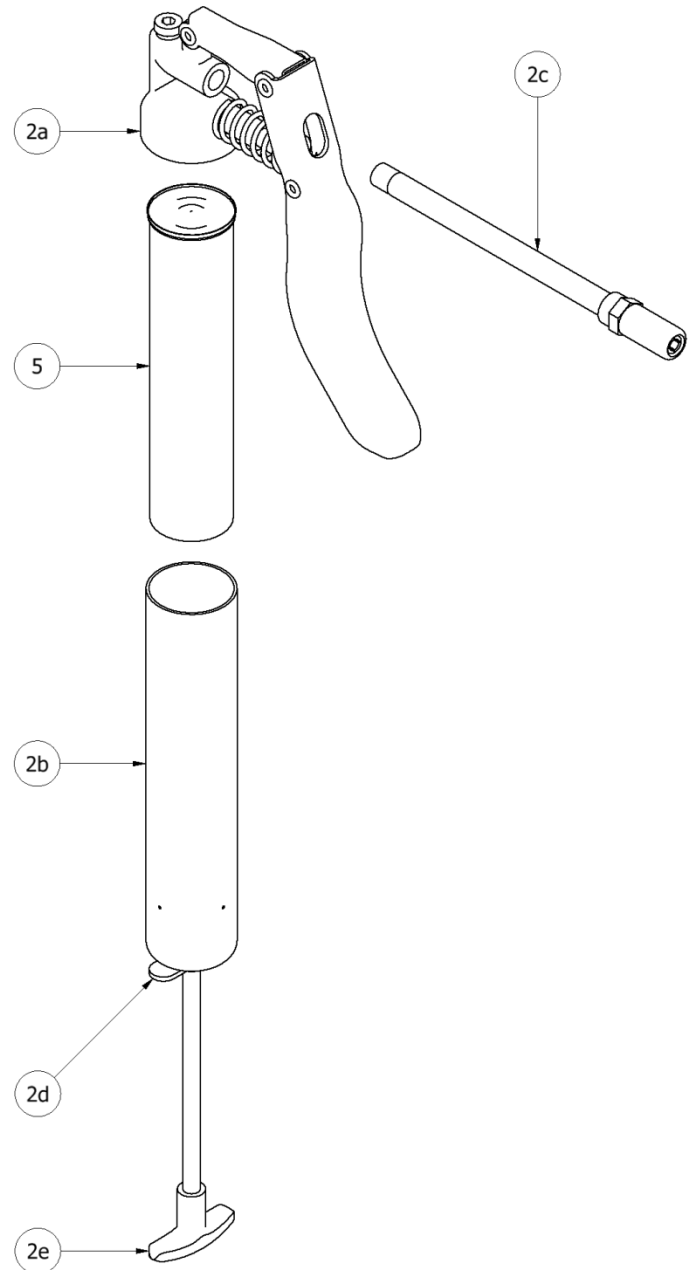
PCT FLAT TIP RETAINER ASSEMBLY (GU-815-52)

ITEM	PART NUMBER	DESCRIPTION	QTY
1	200712	DRILL, 3.10mm, (.1220"/3.10mm)	1
2	GU-03054	DRILL, #50, (.0700"/1.78mm)	1
3	GU-815-52-1	FLAT TIP ADAPTER BODY	1
4	GU-815-52-2	PCT FLAT TIP GASKET	1
5	GU-815-52-3	PCT FLAT TIP RETAINER	1
6	OR-00042A	O-RING, VITON, -016	2

APPENDIX

GREASE GUN ASSEMBLY

1. Screw the rod (2c) into the top of the grease gun (2a) so that the final assembly represents the assembled grease gun (page 8).
2. Unscrew the top of the grease gun (2a) from the bottom of the grease gun (2b).
3. Pull the handle (2e) on the bottom of the grease gun (2b) so that it resembles the picture.
4. Remove the tape and cap from the grease tube (5) and insert the uncapped end of the grease tube (5) into the bottom of the grease gun (2b).
5. Remove the foil from the grease tube (5).
6. Screw the top of the grease gun (2a) back on to the bottom of the grease gun (2b).
7. Push down on the latch (2d) to release the plunger and push plunger completely back in.



MIXING CHAMBER FLOW RATES				
Chamber	lbs/min @ 1000 psi	kg/min @ 69 bar	lbs/min @ 2000 psi	kg/min @ 138 bar
GU-814-000	4	2	6	3
GU-814-00	7	3	11	5
GU-814-00X	8	3.5	13.5	6
GU-814-01	9	4	16	7
GU-814-01X	10.5	4.5	19	8.5
GU-814-02	12	5	22	10
GU-814-02X	15	7.5	27	12
GU-814-03	18	8	32	14
GU-814-04	25	11	47	21
200920	28	20	50	23

*Flow rates will vary depending on viscosity, hose length and machine efficiency.

CHAMBER/ORIFICE COMPARISON CHART			
Competitive Air Purge		PMC Air Purge	
Chamber Number	Orifice Size	Chamber Number	Orifice Size
000 (AR2020)	0.0200	000	0.0280
00 (AR2929)	0.0290	00	0.0350
NOT AVAILABLE		00X	0.0380
01 (AR4242)	0.0420	01	0.0410
NOT AVAILABLE		01X	0.0440
02 (AR5252)	0.0520	02	0.0520
NOT AVAILABLE		02X	0.0550
03 (AR6060)	0.0600	03	0.0610
04 (AR7070)	0.0700	04	0.0690
05 (AR8686)	0.0860	05	0.0860

