

ST1 PLURAL COMPONENT, AIR PURGE SPRAY GUN QUICK START GUIDE



READ THE MANUAL Before operating finishing equipment, read and understand all safety, operation and maintenance information provided in the operation manual.



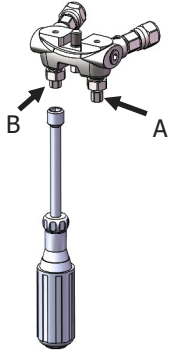
OPERATOR TRAINING All personnel must be trained before operating this equipment.



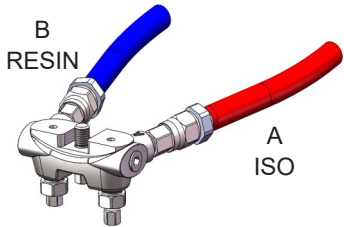
PRESSURE RELIEF PROCEDURE Always follow the pressure relief procedure in the

GETTING STARTED / SET-

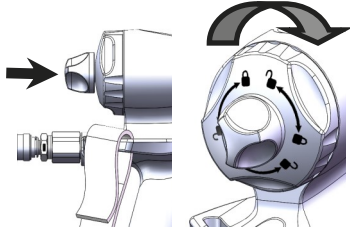
1. Close A-side and B-side shut-off valves.



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



3. Engage safety stop/lock

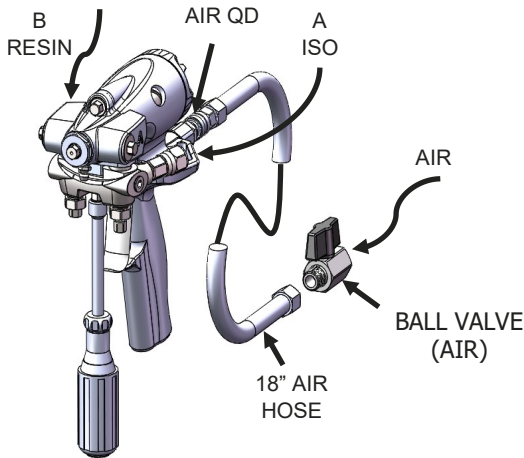


4. Examine check valves if they were removed. Clean as needed. Replace O-rings if damaged. Replace screen if clogged or damaged.

Replace if damaged.

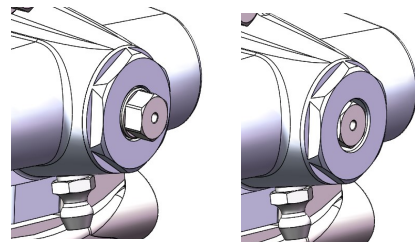


5. Connect manifold (with A and B hoses) to gun. Connect ball valve to 18" air hose and connect main air to ball valve. Use QD Coupler to connect air to gun.



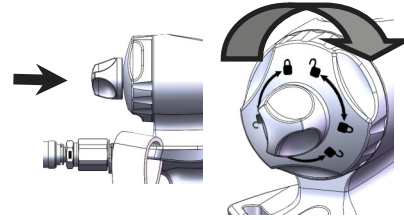
6. Turn on air and open ball valve (air). Air should now flow through the mix tip with gun not triggered.

7. Keep shut-off valves closed. Disengage safety stop/lock and trigger gun. Piston will actuate. Note travel of Mix Tip. The Mix Tip will come approximately flush with the front of the gun when the gun is triggered. Air flow



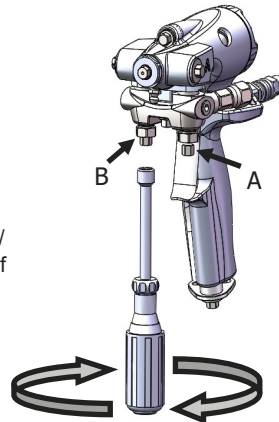
8. Apply layer of lubricant over front of gun to prevent overspray build-up and to aid disassembly.

9. Engage safety stop/lock.

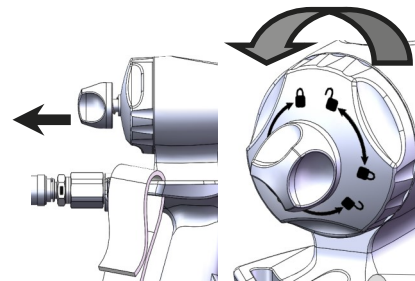


10. Turn on the proportioner. Follow all manufacturer's instructions for starting

11. Fully open B (RESIN) shut-off valve. Then open A (ISO) shut-off valve.



12. Dis-engage safety stop/lock.



13. Test spray onto cardboard or plastic. Adjust pressure and temperature to get desired results.

14. When pressure and temperature are set, and the foam is satisfactory, the gun is ready to spray.

CAUTION

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

GROUNDING

Check local electrical code and proportioner manual for grounding instructions.

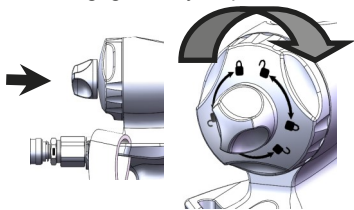
Ground spray gun through connection to a Carlisle approved grounded fluid supply hose.

PRESSURE RELIEF AND SHUT DOWN

WARNING

Relieve pressure before cleaning or repairing gun.

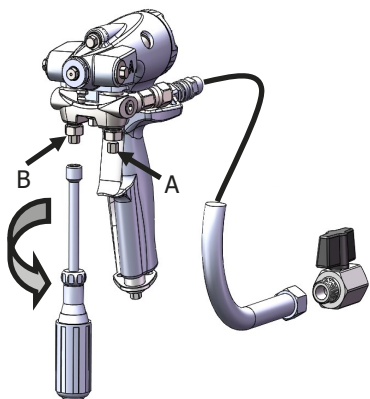
1. Engage safety stop/lock.



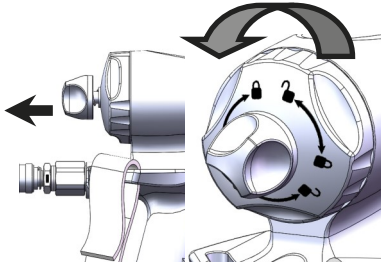
CAUTION

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

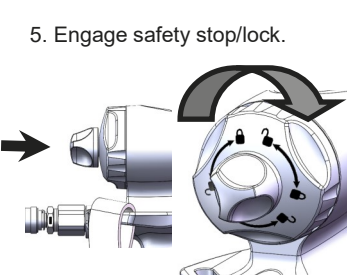
2. Close shut-off valves A and B. Leave air valve open.



3. Dis-engage safety stop/lock.



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

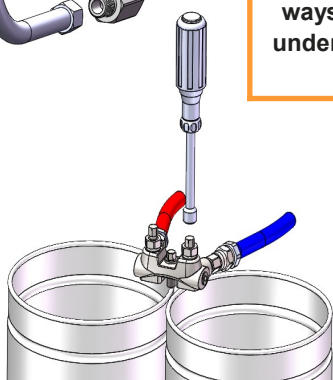


5. Engage safety stop/lock.

WARNING

Fluid in the hose and proportioner is still under pressure. Follow the Pressure Relief Procedure in the proportioner manual.

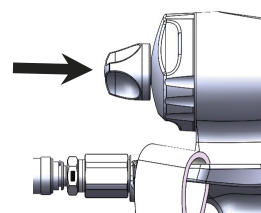
To relieve pressure in the hose after the gun is removed, place the fluid manifold over containers, facing away from you. Very carefully open the shut-off valves. Be aware that the fluid will spray sideways from the fluid ports when under pressure. OPEN SLOWLY.



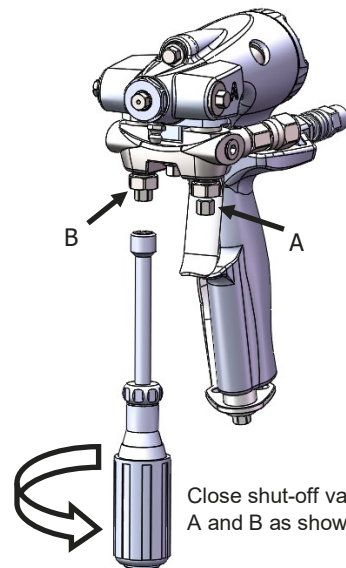
LOSS OF AIR PRESSURE

WARNING

In event of loss of air pressure, gun will continue to spray. To shut off gun, engage the safety stop/lock and/or close both shut-off valves.



Push in knob and turn to the right to lock and stop fluid.



Close shut-off valves A and B as shown.

AIR PRESSURE KEEPS GUN IN TRIGGERED POSITION

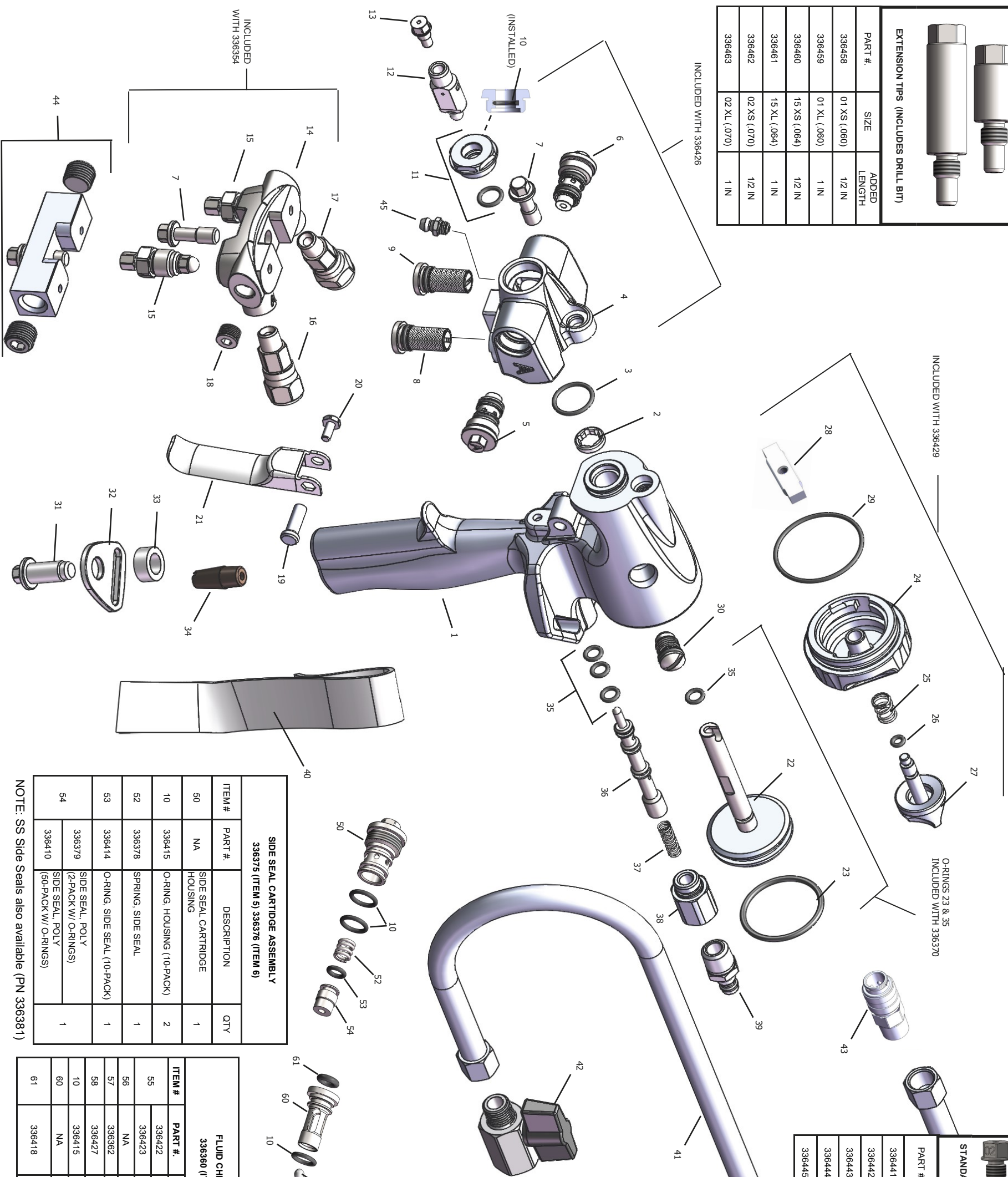
WARNING

A DAMAGED O-RING IN THE AIR VALVE CAN CAUSE THE GUN TO KEEP SPRAYING. SHUT OFF THE AIR IMMEDIATELY!

Then engage safety stop. Push knob in and turn clockwise. Shut off manual valves.

ST1 PLURAL COMPONENT, AIR PURGE SPRAY GUN—COMPONENTS

| EXTENSION TIPS (INCLUDES DRILL BIT) | | |
|-------------------------------------|--------------|--------------|
| PART #. | SIZE | ADDED LENGTH |
| 336458 | 01 XS (.060) | 1/2 IN |
| 336459 | 01 XL (.060) | 1 IN |
| 336460 | 15 XS (.064) | 1/2 IN |
| 336461 | 15 XL (.064) | 1 IN |
| 336462 | 02 XS (.070) | 1/2 IN |
| 336463 | 02 XL (.070) | 1 IN |



INCLUDED WITH 336429

O-RINGS 23 & 35
INCLUDED WITH 336370

INCLUDED WITH 336426

| STANDARD MIX CHAMBER & MIX TIP COMBOS (INCLUDES DRILL BITS) | | | |
|---|-------------|---------|------------|
| PART # | MIX CHAMBER | MIX TIP | EQUIVALENT |
| 336441 | B | 01 | 4242 |
| 336442 | C | 15 | 4747 |
| 336443 | D | 02 | 5252 |
| 336444 | E | 03 | 6060 |
| 336445 | F | 04 | 7070 |

| INDIVIDUAL MIX CHAMBERS (INCLUDES IMPINGEMENT DRILL BIT) | | | |
|--|------|--------------------------|--|
| PART # | SIZE | STD. IMP SIZE EQUIVALENT | |
| 336447 | B | 01 (.042) | |
| 336448 | C | 15 (.047) | |
| 336449 | D | 02 (.052) | |
| 336450 | E | 03 (.060) | |
| 336451 | F | 04 (.070) | |

| INDIVIDUAL MIX TIPS (INCLUDES DRILL BIT) | | |
|--|-----------|--|
| PART #. | SIZE | |
| 336452 | 00 (.052) | |
| 336453 | 01 (.060) | |
| 336454 | 15 (.064) | |
| 336455 | 02 (.070) | |
| 336456 | 03 (.086) | |
| 336457 | 04 (.093) | |

| SIDE SEAL CARTRIDGE ASSEMBLY 336375 (ITEM 5) 336376 (ITEM 6) | | | |
|---|------------------|---|-----|
| ITEM # | PART #. | DESCRIPTION | QTY |
| 50 | NA | SIDE SEAL CARTRIDGE HOUSING | 1 |
| 10 | 336415 | O-RING, HOUSING (10-PACK) | 2 |
| 52 | 336378 | SPRING, SIDE SEAL | 1 |
| 53 | 336414 | O-RING, SIDE SEAL (10-PACK) | 1 |
| 54 | 336379 336410 | SIDE SEAL, POLY (2-PACK W/ O-RINGS) SIDE SEAL, POLY (50-PACK W/ O-RINGS) | 1 |

| FLUID CHECK VALVE ASSEMBLY 336360 (ITEM 8) 336361 (ITEM 9) | | | |
|---|---------|------------------------------------|-----|
| ITEM # | PART #. | DESCRIPTION | QTY |
| 55 | 336422 | SCREEN, 40 MESH (10-PACK) | 1 |
| | 336423 | SCREEN, 60-MESH (10-PACK) | |
| 56 | NA | SPRING RETAINER | 1 |
| 57 | 336362 | SPRING, CHECK VALVE | 1 |
| 58 | 336427 | BALL, CHECK VALVE (10-PACK) | 1 |
| 10 | 336415 | O-RING, HOUSING (10-PACK) | 1 |
| 60 | NA | HOUSING (A/ B SIDE) | 1 |
| 61 | 336418 | O-RING, CHECK VALVE FACE (10-PACK) | 1 |

| ITEM # | PART # | DESCRIPTION | QTY. |
|--------|--------|--|------|
| 1 | 336352 | HANDLE | 1 |
| 2 | 336359 | SHAFT GUIDE | 1 |
| 3 | 336417 | O-RING, HEAD AND HANDLE JOINTION (2-PACK) | 1 |
| 4 | 336353 | HEAD | 1 |
| 5 | 336375 | SIDE SEAL CARTRIDGE ASSEMBLY, A-SIDE | 1 |
| 6 | 336376 | SIDE SEAL CARTRIDGE ASSEMBLY, B-SIDE | 1 |
| 7 | 336356 | MANIFOLD SCREW | 2 |
| 8 | 336360 | CHECK VALVE, A-SIDE | 1 |
| 9 | 336361 | CHECK VALVE, B-SIDE | 1 |
| 10 | 336415 | O-RING, GUIDE AND HOUSING (10-PACK) | 1 |
| 11 | 336437 | GUIDE (INCLUDES ITEM 10) | 1 |
| 12 | 336446 | MIX CHAMBER | 1 |
| 13 | 336452 | MIX TIP | 1 |
| 14 | 336355 | FLUID MANIFOLD | 1 |
| 15 | 336372 | MANUAL VALVE | 2 |
| 16 | 336357 | SWIVEL ADAPTER, A-SIDE | 1 |
| 17 | 336358 | SWIVEL ADAPTER, B-SIDE | 1 |
| 18 | 336335 | PIPE PLUG, 1/8 NPT 303 SS | 2 |
| 19 | 336364 | TRIGGER STUD | 1 |
| 20 | 336365 | TRIGGER SCREW | 1 |
| 21 | 336363 | TRIGGER | 1 |
| 22 | 336370 | ROD & PISTON ASSEMBLY | 1 |
| 23 | 336413 | O-RING, AIR PISTON (2-PACK) | 1 |
| 24 | 336373 | END CAP | 1 |
| 25 | 336735 | SPRING | 1 |
| 26 | 336413 | O-RING, SAFETY STOP (2-PACK) | 1 |
| 27 | 336737 | SAFETY STOP KNOB | 1 |
| 28 | 336736 | LOCK ARM | 1 |
| 29 | 336420 | O-RING, END CAP (2-PACK) | 1 |
| 30 | 336394 | CHECK VALVE ASSY, AIR | 1 |
| 31 | 336401 | STUD | 1 |
| 32 | 336399 | CLIP | 1 |
| 33 | 336400 | SPACER | 1 |
| 34 | 336374 | MUFFLER | 1 |
| 35 | 336412 | O-RING, AIR VALVE AND PISTON ROD (10-PACK) | 4 |
| 36 | 336366 | VALVE STEM | 1 |
| 37 | 336367 | SPRING | 1 |
| 38 | 336395 | OD BASE | 1 |
| 39 | 336396 | OD STEM | 1 |
| 40 | 336398 | STRAP | 1 |
| 41 | 336643 | HOSE | 1 |
| 42 | 336408 | BALL VALVE | 1 |
| 43 | 336397 | OD COUPLER | 1 |
| 44 | 336436 | FLUSH MANIFOLD ASSEMBLY | 1 |
| 45 | 336738 | GREASE FITTING | 1 |