

May 11, 2023

Technical Memo

LifeLast Graco Fusion Gun Maintenance Recommendations

The Technical service group at LifeLast with our over 40 years of experience with plural components has come up with a gun maintenance program for the Graco Fusion series impingement mix spray guns. This has been asked for by our customers to help their employees have the best success possible spraying Polyurethanes on many different types of substrates.

Best Practices:

- Always have several spares of all the o-rings in the fluid section of the gun. It is also recommended to have backups of all the hard parts in the gun (ie: air cap, side seals, check valves, tips, mix chambers/modules, etc.)
- Have a Crock pot (slow cooker) with NMP (Normal Methylpyrrolidone), Dynasolve, or Cirr-D-Bond Gun Cleaner to dissolve any hardened ISO or mixed material on the fluid section parts. Follow safety PPE and ventilation guidelines in the use of these chemicals. Do not use cooker above medium temperature setting.
- Have multiple spare tips at the ready to switch out every so often to maintain a good spray pattern. Clean the used parts and prepare them to be re-used.
- Have the proper brushes, picks, solvents, and a razor knife to assist in cleaning the gun properly. The use of improper tools is the number one cause for damage to the fluid section parts. Nylon bristle brushes work very well and do not scratch. If the core of the brush is steel or metal, be extremely careful not to scratch especially the anodized aluminum gun head.
- Always have a complete spare gun at the ready in case of catastrophic failure or material crossover. It would also be very helpful to have a spare gun head.

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Hourly Gun Maintenance:

- Clean the spray tip & air cap when bearding or build-up is noticed. This may be noticed more often than hourly, of course. A simple way to perform this is by using a razor knife with the “clean off air” turned off. Use the knife to remove the large portion of build-up, followed by brushing the spray tip to remove the residual dried material from the V groove of the spray tip. In addition, every hour or two if you are in a high production spray environment and you are using the Air Purge spray gun, remove the spray tip and drill out the center-bore of the mix chamber.

Daily Gun Maintenance:

- At the end of a shift, remove the spray gun and disassemble the fluid section completely. Clean all parts with MEK or Acetone solvent, being careful not to over-expose the o-rings to the solvent which can dry up or swell them. Once all parts have been cleaned to a like-new state, inspect the wear parts for any damage that may have happened to them. In addition, inspect all the o-rings for nicks, cuts, or flat spots. If damage is found replace the seal before reassembling. Use only a light amount of fusion gun grease residue to reassemble the fluid section (most greases are known to cause fisheyes on the coated substrate).

Weekly Maintenance:

- Completely disassemble the spray gun including the air section. Soak all the fluid section parts after removing the o-rings in the crockpot with NMP or other solvents known to breakdown Isocyanates and hardened Polyurethanes. Inspect all the o-rings in the air section for flat spots. Once it is determined there is not any damage, lubricate the o-rings of the air section and reassemble. Clean all the parts that were soaked in the Crock pot to a like-new state. Inspect all cleaned parts for damage and replace anything that is even questionable in nature. Reassemble the fluid section using a light amount of Graco Fusion gun grease on the o-rings. It is acceptable to use a more generous amount of the lubricant in the air section of the gun.

Sincerely,

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