

May 12, 2023

Technical Memo

Recommended Graco Reactor Preventive Maintenance

The LifeLast Technical Service group has been asked by multiple customers to provide a preventative maintenance schedule which allows end users to have the least amount of down-time and keep their coating and lining machines functioning properly.

Weekly Preventative Maintenance:

- Inspect the Iso flush system lubricant to see if it needs to be changed. If the liquid which is normally clear looks milky, replace it with clean TSL liquid and reprime the system.
- Inspect and clean the inlet Wye strainers.
- Clean outlet manifold canister filters, if present on your system.
- If you have a pneumatic-driven agitator, lubricate it with air tool oil.
- Inspect your desiccant air driers to see if the beads need replacement.
- Check your air filtration system and drain all water from it. If your system has multiple stages of filtration, verify all of them are in proper working order. Dirty, contaminated air can cause all equipment downstream to have shorter service life and it can lead to many defects in the coating.
- If you are using a Graco 5:1 Monark on the polyol side, lubricate the throat packing cup/nut with TSL and check the packing tension.
- Completely disassemble the Graco Fusion gun and hot tank the fluid section parts and replace anything that looks questionable. Inspect and lubricate the o-rings for the air section portion of the gun. (Refer to Technical Memo – Graco Fusion Gun Maintenance)
- If you are not using your system to spray, recirculate the ISO through the entire system to keep it from beginning to crystallize.

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Monthly Maintenance:

- If you are at the 1000hr point on your hydraulic oil and filter, then it is time to change them. Make sure to use ISO 46 hydraulic oil.
- Inspect your drums or totes to verify you are using the same amount material on both sides. If you are constantly running 300-400psi off (or more), you will eventually have a material shortage on one side. Also, it is a good reminder if you need to order more material.
- Verify your inventory of spare parts.

Yearly Maintenance:

- Perform a complete system flush using MEK or Acetone solvent on the ISO-side, followed by filling the ISO-Side of the system with D-limonene, Graco TSL (or DOP/Dioctyl Pthlalate), or hydraulic fluid to eliminate any possibility of hardening the residual ISO left in the system while you are performing the complete system rebuild. The purging or flushing of the Polyol/resin side of the equipment is optional, however it will be easier to clean the parts with the material component flushed out.
- Rebuild both the A and B side supply pumps, replacing any worn-out hard parts (i.e. Cylinder or seats, etc.). Also, inspect the air motor and at minimum: lubricate all parts with air motor grease and possibly replace all soft seals.
- Rebuild the hydraulic pump line and the A and B side displacement pump lowers with new seals/packings. Inspect and replace any worn out hard parts (i.e. cylinder, pump rod, check valve seats, etc.).
- Replace the recirculation ball valves.
- Change the hydraulic oil and filter. Remember to use ISO 46 grade hydraulic oil.
- Inspected the heated hose bundle for any exposed heating elements and areas which may have lost the insulation, tape, and/or protective cover.
- Inspect the cooling fan and filter element for the electronic cabinet section.

Sincerely,

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