

June 30, 2015

**BWX – BIG WILLIE OPERATING INSTRUCTIONS
(SPRAYABLE MATERIALS)**

Note: Operator Responsibility

It is the operator responsibility to insure that the GS MFG system is operated safely. Local codes and operating instructions must be followed. Equipment operators should read and understand local codes and operating instructions before operating this system.

Requirements:

- Air – 120 PSI @ 18-20 CFM
- Lubrication – Dibutyl Phthalate (pump oil reservoir)
- Solvent – Acetone

Note: The pumping system is activated by an air signal sent from gun. This air signal also passes through the in-line level/limit switch attached to the drum ram.

For loading purposes only, use the air valve mounted on the air manifold to activate the pump.

Xgun Operation:

1. The air valve at the rear of the gun activates the trigger. This valve should be “off” when not spraying or dis-assembly or purging of the extension nozzle.
2. Purging of the system should be done with the extension nozzles dis-attached from the gun.
3. Always check for solvent purge flow through the gun before attaching the nozzle. Solvent pump pressure should be set at maximum.
4. Re-attach nozzle extension and adjust material pump pressure as required to develop a spray pattern.
5. After spraying always remember to purge the nozzle clean with solvent. The solvent valve must remain “off” during spraying.

Shut Down:

1. Remove extension nozzles and soak in clean solvent.
2. Purge solvent through the gun with the mixers removed and clean the area at the front of the gun.
3. Install Teflon night plug in the material port at the front of the gun.
4. Dis-connect air supply. Do not relieve the fluid pressure in hoses.

Start Up:

1. Check solvent pail level
2. Check material and MEKP levels
3. Connect air supply
4. Check for solvent purge through the gun
5. Attached nozzles

INITIAL START UP:

1. Connect all hoses as marked
2. Fill solvent tank.
3. Make sure all air regulators are turned off and the ram is in **NEUTRAL POSITION**.
4. Connect air supply
5. Check air purge
6. Check for solvent flow. Pressurize pump 70-90 PSI. Open solvent valve.
7. Dis-connect the MEKP slave arm from the putty pump air motor (move the arm to the side). This will divorce the two material flows, for loading purposes.

Loading Putty:

- A. REFER TO OPERATORS MANUAL FOR 2 POST LIFT/ RAM
- B. Open putty by-pass valve on putty pump fluid section for initially purging of putty in to empty container.
- C. Open the air valve @ the air manifold for pump loading,
- D. Turn on air regulator for the putty pump slowly until material flows from the by-pass valve.
- E. Turn by-pass valve off.
- F. Turn off the air valve at the air manifold.
- G. Trigger the gun and purge putty through the gun.
- H. Close the gun.

PURGING OF MEKP

- A. Use a bucket partially filled with water for purging initial flow of MEKP.
- B. Place MEKP bottle in rack and install lid, pick-up and by-pass hoses in the bottle or use gravity feed bottle.
- C. Remove the MEKP hose from the gun.
- D. Pump slave arm by hand using, short strokes, until MEKP flows out of the hose.
- E. Re-connect the hose to the gun.
- F. Reconnect slave arm to the top of the putty pump.
- G. Turn pump pressure to 35-40 PSI.
- H. Trigger the gun.
- I. Refer to step #4 in the Xgun operation and adjust pump pressure as required.