



EQUIPMENT START UP and SHUTDOWN



Daily Startup

- Pre-condition material to 70-90°F.
- Thoroughly mix both "A" and "B" components.
- Switch the main circuit breaker and hose heat circuit breaker on and allow to heat to specified temperature.
- Check both low pressure (inlet) filters and high pressure (out bound) filters. Clean as required.

Daily Startup

(con't)

- Check wet cups - Replace plasticizer as required
- Open both material supply valves and pressurize the transfer pumps.
- Switch on all material heaters and insure they are set to the proper temperature.

Daily Startup

(con't)

- Turn proportioner on and set to required pressures. Insure that the "A" and "B" gauges are at approximately equal pressures (on "Gusmer" equipment, the pump switch should be in the normal position).
- When hose heat is up to temperature, open the material valves at the spray gun and check for leaks.
- Test spray until a good spray pattern and cure is obtained.

Daily Shutdown

- Switch off the power supply.
- Switch off the hose and primary heater circuit breakers.
- Switch off the main circuit breaker.
- Shut off material at the spray gun.
- Remove gun from gun block and reduce fluid pressure to 500-1000 psi.

Daily Shutdown

(con't)

- Insure that the pump shafts are in the full down position or are completely inside the cylinder or that the proportioner is in the retract position.
- Flush gun, tear down and clean thoroughly.
- Seal material drums with either a nitrogen or desiccated air blanket to insure no moisture contamination.

Long- Term Shutdown

When equipment will not
be used for 1-2 weeks
or longer

Long-Term Shutdown

(con't)

- Remove transfer pumps and clean.
- Use the clean transfer pumps to flush clean solvent through one side of the equipment at a time.
- Heaters and hose heat must be off.
- Flush until solvent is clean.
- Check and clean all filters and replace as necessary.
- Recirculate each side through a filter bag or cloth until the system is completely clean.

Long-Term Shutdown

(con't)

- Insure that the proportioning pump shafts are fully retracted.
- Wet cups must be clean and filled with clean plasticizer.
- Insure air and power sources have been disconnected.
- Insure that partial containers have been purged with nitrogen and properly stored.

Long- Term Shutdown

(con't)

- Completely disassemble the fluid sections of the spray gun(s), clean, grease, reassemble and store properly.
- Using the transfer pumps; flush plasticizer (such as Pliabrac 521) through the system and leave under pressure.
- Place the transfer pumps into 4" diameter x 36" long tubes filled with plasticizer.
- Coil hoses and store the equipment in a dry area.

**WHAT HAPPENS IF
PROPER
SHUTDOWN
PROCEDURES ARE
NOT USED?**

PUMPS

→ ISO will react and harden on the transfer and proportioning pump shafts causing them to stick or damage the pump packings as the pump shafts move up and down.

HOSES

- Over time, moisture can penetrate through a hose lining and cause a crystalline layer to form on the inside of the hose. This layer will eventually break free and cause clogging at the gun screens when put back into use.
- The system must always be closed and under pressure to prevent contamination from air.
- If solvent is used instead of plasticizer, pigments and fillers can settle out and can cause problems when put back into service.
- MEK may have some moisture in it's make up and could cause gelling on the ISO side.

QUESTIONS

