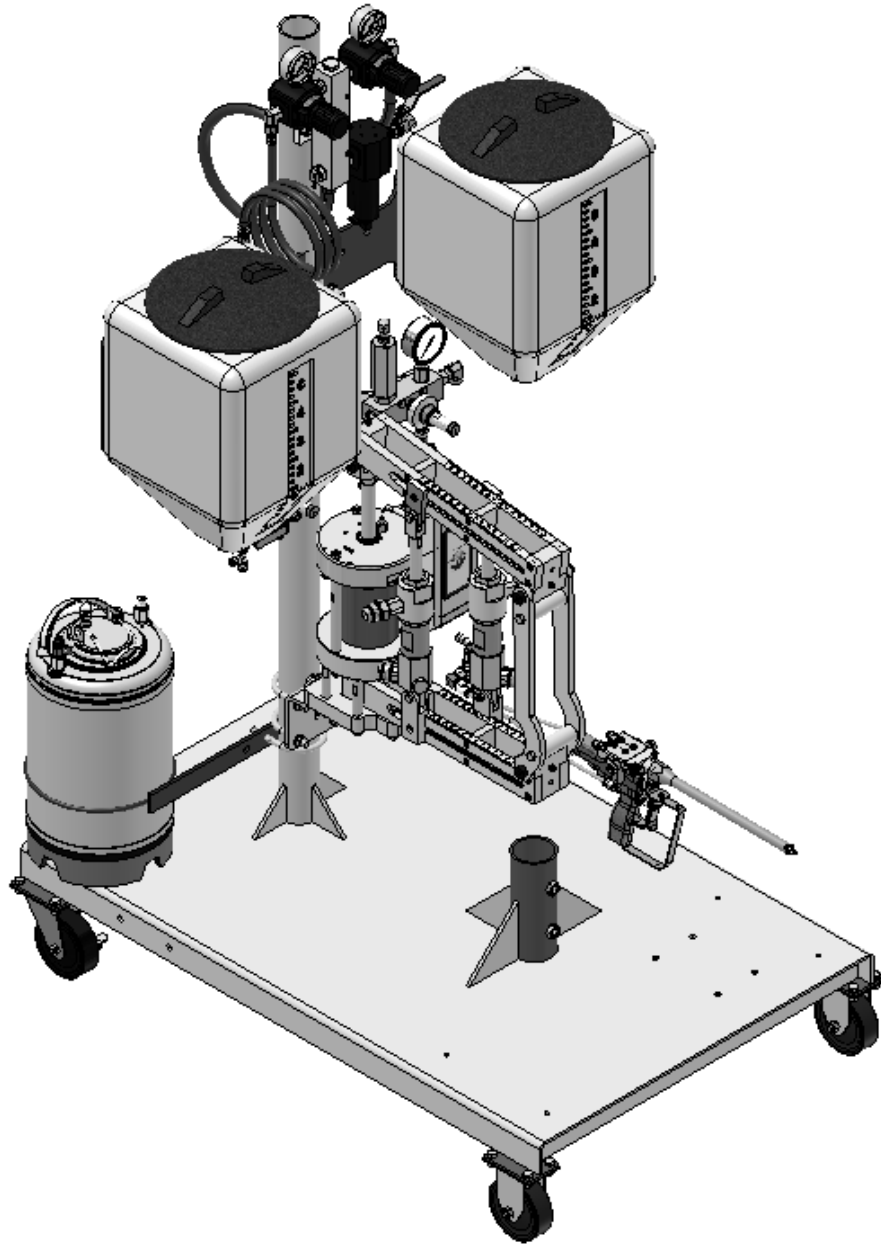


MicroPro Proportioning Unit

Operations Manual

This manual is applicable
to the following models:

- MPRO-BASIC-5
- MPRO-AUTO



Rev. January 2019



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Use of this product confirms that Magnum Venus Products, Inc.'s standard terms and conditions of sale apply.



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Safety & Warning Information

Warnings

Due to the vast number of chemicals that could be used and their varying chemical reactions, the buyer and user of this equipment should determine all factors relating to the fluids used, including any of the potential hazards involved. Particular inquiry and investigation should be made into potential dangers relating to toxic fumes, fires, explosions, reaction times, and exposure of human beings to the individual components or their resultant mixtures. MVP assumes no responsibility for loss, damage, expense or claims for bodily injury or property damage, direct or consequential, arising from the use of such chemical components.

The end user is responsible for ensuring that the end product or system complies with all the relevant laws in the country where it is to be used and that all documentation is adhered to.

Recommended Occupational Safety & Health Act (OSHA) Documentation:

- 1910.94 Pertaining to ventilation
- 1910.106 Pertaining to flammable liquids
- 1910.107 Pertaining to spray finishing operations, particularly paragraph (m), Organic Peroxides and Dual Component Coatings

For Additional information, contact the Occupational Safety and Health Administration (OSHA) at <https://www.osha.gov/about.html>.

Recommended National Fire Protection Association (NFPA) Documentation:

- NFPA No.33 Chapter 14 Organic Peroxides and Dual Component Materials
- NFPA No. 63 Dust Explosion Prevention
- NFPA No. 70 National Electrical Code
- NFPA No. 77 Static Electricity
- NFPA No. 91 Blower and Exhaust System
- NFPA No. 654 Plastics Industry Dust Hazards

Fire Extinguisher – code ABC, rating number 4a60bc using Extinguishing Media –Foam, Carbon Dioxide, Dry Chemical, Water Fog, is recommended for this product and applications.

The following general warnings and guidelines are for the setup, use, grounding, maintenance, and repair of equipment. Additional product-specific warnings may be found throughout this manual as applicable. Please contact your nearest MVP Technical Service Representative if additional information is needed.

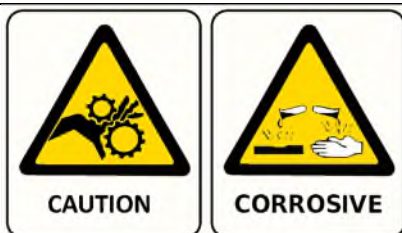
Safety Precautions

- Avoid skin contact and inhalation of all chemicals.
- Review Material Safety Data Sheet (MSDS) to promote the safe handling of chemicals in use.
- Restrict the use of all chemicals to designated areas with good ventilation.
- Chemicals are flammable and reactive.
- Noxious fumes released when combusted.
- Operate equipment in a ventilated environment only.
- Uncured liquid resins are highly flammable unless specifically labeled otherwise.
- Cured laminate, accumulations of overspray, and laminate sandings are highly combustible.
- Do not operate or move electrical equipment when flammable fumes are present.
- Ground all equipment.
- If a spark is seen or felt, immediately halt operation. Do not operate the equipment until the issue has been identified and repaired.
- Contaminated catalyst may cause fire or explosion.
- Containers may explode if exposed to fire / heat.
- Use and store chemicals away from heat, flames, and sparks.
- Do not smoke in work areas or near stored chemicals.
- Do not mix Methyl Ethyl Ketone Peroxide (MEKP) with materials other than polyethylene.
- Do not dilute MEKP.
- Keep food and drink away from work area.



Physical Hazards

- Never look directly into the spray gun fluid tip. Serious injury or death can result.
- Never aim the spray gun at or near another person. Serious injury or death can result.
- Chemical compounds can be severely irritating to the eyes and skin.
- Inhalation, ingestion, or injection may damage internal organs and lead to pulmonary disorders, cancers, lymphomas, and other diseases or health conditions.
- Other potential health effects include: irritation of the eyes and upper respiratory tract, headache, light-headedness, dizziness, confusion, drowsiness, nausea, vomiting, and occasionally abdominal pain.
- Eye contact: Immediately flush with water for at least 15 minutes and seek immediate medical attention.
- Skin Contact: Immediately wash with soap and water and seek immediate medical attention.
- Inhalation: Move the person to fresh air and seek immediate medical attention.
- Do not remove shields, covers, or safety features on equipment that is in use.
- Never place fingers, hands, or any body part near or directly in front of the spray gun fluid tip. The force of the liquid as it exits the spray tip can shoot liquid through the skin.
- Keep hands and body parts away from any moving equipment or components.
- Do not stand under plunger
- An improperly loaded drum may lead to an imbalance, causing a unit to tip over



Personal Protective Equipment (PPE)

- MVP recommends the use of personal safety equipment with all products in our catalog.
- Wear safety goggles, hearing protection, a respirator, and chemical resistant gloves.
- Wear long sleeve shirts or jackets and pants to minimize skin exposure.
- PPE should be worn by operators and service technicians to reduce the risk of injury.



For Additional information, contact the Occupational Safety and Health Administration (OSHA). <https://www.osha.gov/about.html>

Symbol Definitions



Indicates the risk of contact with chemicals that are hazardous, which may lead to injury or death.



Indicates the risk of contact with voltage / amperage that may lead to serious injury or death



Indicates that the materials being used are susceptible to combustion



Indicates the risk of contact with moving components that may lead to serious injury or death.



Indicates that the system or component should be grounded before proceeding with use or repair.



Indicates the use of lit cigarettes or cigars is prohibited, because the materials being used are susceptible to combustion.



Indicates that the materials and/or the process being performed can lead to ignition and explosion.



A recommendation for the use of Personal Protective Equipment (PPE) before using or repairing the product.

Polymer Matrix Materials: Advanced Composites

Potential health hazards associated with the use of advanced composites can be controlled through the implementation of an effective industrial hygiene and safety program.

https://www.osha.gov/dts/osta/otm/otm_iii/otm_iii_1.html#t_iii:1_1

Resins		
Composite Component	Organ System Target (Possible Target)	Known (Possible) Health Effect
Epoxy resins	Skin, lungs, eyes	Contact and allergic dermatitis, conjunctivitis
Polyurethane resins	Lungs, skin, eyes	Respiratory sensitization, contact dermatitis, conjunctivitis
Phenol formaldehyde	Skin, lungs, eyes	As above (potential carcinogen)
Bismaleimides (BMI)	Skin, lungs, eyes	As above (potential carcinogen)
Polyamides	Skin, lungs, eyes	As above (potential carcinogen)
Reinforcing materials		
Composite Component	Organ System Target (Possible Target)	Known (Possible) Health Effect
Aramid fibers	Skin (lungs)	Skin and respiratory irritation, contact dermatitis (chronic interstitial lung disease)
Carbon/graphite fibers	Skin (lungs)	As noted for aramid fibers
Glass fibers (continuous filament)	Skin (lungs)	As noted for aramid fibers
Hardeners and curing agents		
Composite Component	Organ System Target (Possible Target)	Known (Possible) Health Effect
Diaminodiphenylsulfone	N/A	No known effects with workplace exposure
Methylenedianiline	Liver, skin	Hepatotoxicity, suspect human carcinogen
Other aromatic amines		
Composite Component	Organ System Target (Possible Target)	Known (Possible) Health Effect
Meta-phenylenediamine (MPDA)	Liver, skin (kidney, bladder)	Hepatitis, contact dermatitis (kidney and bladder cancer)
Aliphatic and cyclo-aliphatic amines	Eyes, skin	Severe irritation, contact dermatitis
Polyaminoamide	Eyes, skin	Irritation (sensitization)
Anhydride	Eyes, lungs, skin	Severe eye and skin irritation, respiratory sensitization, contact dermatitis

Catalyst - Methyl Ethyl Ketone Peroxide (MEKP)

MEKP is among the more hazardous materials found in commercial channels. The safe handling of the “unstable (reactive)” chemicals presents a definite challenge to the plastics industry. The highly reactive property which makes MEKP valuable to the plastics industry in producing the curing reaction of polyester resins also produces the hazards which require great care and caution in its storage, transportation, handling, processing and disposal. MEKP is a single chemical. Various polymeric forms may exist which are more or less hazardous with respect to each other. These differences may arise not only from different molecular structures (all are, nevertheless, called “MEKP”) and from possible trace impurities left from the manufacture of the chemicals, but may also arise by contamination of MEKP with other materials in its storage or use. Even a small amount of contamination with acetone, for instance, may produce an extremely shock-sensitive and explosive compound.



WARNING

Contamination with promoters, materials containing promoters (such as laminate sandings), or with any readily oxidizing material (such as brass or iron) will cause exothermic redox reactions which can be explosive in nature. Heat applied to MEKP or heat buildup from contamination reactions can cause the material to reach its Self-Accelerating Decomposition Temperature (SADT).

Researchers have reported measuring pressure rates-of-rise well over 100,000 psi per second when certain MEKP's reach their SADT. For comparison, the highest-pressure rate-of-rise listed in NFPA Bulletin NO.68, “Explosion Venting”, is 12,000 psi per second for an explosion of 12% acetylene and air. The maximum value listed for a hydrogen explosion is 10,000 psi per second. Some forms of MEKP, if allowed to reach their SADT, will burst even an open topped container. This suggests that it is not possible to design a relief valve to vent this order of magnitude of pressure rate-of-rise. The user should be aware that any closed container, be it a pressure vessel, surge chamber, or pressure accumulator, could explode under certain conditions. There is no engineering substitute for care by the user in handling organic peroxide catalysts. If, at any time, the pressure relieve valve on top of the catalyst tank should vent, the area should be evacuated at once and the fire department called. The venting could be the first indication of a heat, and therefore, pressure build-up that could eventually lead to an explosion. Moreover, if a catalyst tank is sufficiently full when the pressure relief valve vents, some catalyst may spray out, which could cause eye injury. For this reason, and many others, anyone whose job puts them in an area where this vented spray might go, should always wear full eye protection even when laminating operations are not taking place.

Safety in handling MEKP depends to a great extent on employee education, proper safety instructions, and safe use of the chemicals and equipment. Workers should be thoroughly informed of the hazards that may result from improper handling of MEKP, especially regarding contamination, heat, friction and impact. They should be thoroughly instructed regarding the proper action to be taken in the storage, use, and disposal of MEKP and other hazardous materials used in the laminating operation. In addition, users should make every effort to:

- Store MEKP in a cool, dry place in original containers away from direct sunlight and away from other chemicals.
- Keep MEKP away from heat, sparks, and open flames.
- Prevent contamination or MEKP with other materials, including polyester over spray and sandings, polymerization accelerators and promoters, brass, aluminum, and non-stainless steels.

- Never add MEKP to anything that is hot, since explosive decomposition may result.
- Avoid contact with skin, eyes, and clothing. Protective equipment should be worn at all times. During clean-up of spilled MEKP, personal safety equipment, gloves, and eye protection must be worn. Firefighting equipment should be at hand and ready.
- Avoid spillage, which can heat up to the point of self-ignition.
- Repair any leaks discovered in the catalyst system immediately, and clean-up the leaked catalyst at once in accordance with the catalyst manufacturer's instructions.
- Use only original equipment or equivalent parts from Magnum Venus Products in the catalyst system (i.e.: hoses, fitting, etc.) because a dangerous chemical reaction may result between substituted parts and MEKP.
- Catalyst accumulated from the purging of hoses or the measurement of fluid output deliveries should never be returned to the supply tank, such catalyst should be diluted with copious quantities of clean water and disposed of in accordance with the catalyst manufacturer's instructions.

The extent to which the user is successful in accomplishing these ends and any additional recommendations by the catalyst manufacturer determines largely the safety that will be present in his operation.

Clean-Up Solvents and Resin Diluents



WARNING

A hazardous situation may be present in your pressurized fluid system! Hydro carbon solvents can cause an explosion when used with aluminum or galvanized components in a closed (pressurized) fluid system (pump, heaters, filters, valves, spray guns, tanks, etc.). An explosion could cause serious injury, death, and/or substantial property damage. Cleaning agents, coatings, paints, etc. may contain Halogenated Hydrocarbon solvents. Some Magnum Venus Products spray equipment includes aluminum or galvanized components and will be affected by Halogenated Hydrocarbon solvents.

There are three key elements to the Halogenated Hydrocarbon (HHC) solvent hazard.

- | | |
|--|--|
| 1. The presence of HHC solvents. | 1,1,1 – Trichloroethane and Methylene Chloride are the most common of these solvents. However, other HHC solvents are suspect if used; either as part of paint or adhesives formulation, or for clean-up flushing. |
| 2. Aluminum or Galvanized Parts. | Most handling equipment contains these elements. In contact with these metals, HHC solvents could generate a corrosive reaction of a catalytic nature. |
| 3. Equipment capable of withstanding pressure. | When HHC solvent contact aluminum or galvanized parts inside a closed container such as a pump, spray gun, or fluid handling system, the chemical reaction can, over time, result in a build-up of heat and pressure, which can reach explosive proportions. When all three elements are present, the result can be an extremely violent explosion. The reaction can be sustained with very little aluminum or galvanized metal; any amount of aluminum is too much. |

- The reaction is unpredictable. Prior use of an HHC solvent without incident (corrosion or explosion) does NOT mean that such use is safe. These solvents can be dangerous alone (as a clean-up or flushing agent) or when used as a component or a coating material. There is no known inhibitor that is effective under all circumstances. Mixing HHC solvents with other materials or solvents such as MEKP, alcohol, or toluene may render the inhibitors ineffective.
- The use of reclaimed solvents is particularly hazardous. Reclaimers may not add any inhibitors. The possible presence of water in reclaimed solvents could also feed the reaction.
- Anodized or other oxide coatings cannot be relied upon to prevent the explosive reaction. Such coatings can be worn, cracked, scratched, or too thin to prevent contact. There is no known way to make oxide coatings or to employ aluminum alloys to safely prevent the chemical reaction under all circumstances.
- Several solvent suppliers have recently begun promoting HHC solvents for use in coating systems. The increasing use of HHC solvents is increasing the risk. Because of their exemption from many state implementation plans as Volatile Organic Compounds (VOCs), their low flammability hazard, and their not being classified as toxic or carcinogenic substances, HHC solvents are very desirable in many respects.

**WARNING**

Do not use Halogenated Hydrocarbon (HHC) solvents in pressurized fluid systems having aluminum or galvanized wetted parts.

Magnum Venus Products is aware of NO stabilizers available to prevent HHC solvents from reaction under all conditions with aluminum components in closed fluid systems. HHC solvents are dangerous when used with aluminum components in a closed fluid system.

- Consult your material supplier to determine whether your solvent or coating contains Halogenated Hydrocarbon solvents.
- Magnum Venus Products recommends that you contact your solvent supplier regarding the best non-flammable clean-up solvent with the heat toxicity for your application.
- If, however, you find it necessary to use flammable solvents, they must be kept in approved, electrically grounded containers.
- Bulk solvent should be stored in a well-ventilated, separate building, 50 feet away from your main plant.
- You should only allow enough solvent for one day's use in your laminating area.
- NO SMOKING signs must be posted and observed in all areas of storage or where solvents and other flammable materials are used.
- Adequate ventilation (as covered in OSHA Section 1910.94 and NFPA No.91) is important wherever solvents are stored or used, to minimize, confine and exhaust the solvent vapors.
- Solvents should be handled in accordance with OSHA Section 1910.106 and 1910.107.

Catalyst Diluents

Magnum Venus Products spray-up and gel-coat systems currently produced are designed so that catalyst diluents are not required. Magnum Venus Products therefore recommends that diluents not be used to avoid possible contamination which could lead to an explosion due to the handling and mixing of MEKP and diluents. In addition, it eliminates any problems from the diluent being contaminated through rust particles in drums, poor quality control on the part of the diluents suppliers, or any other reason. If diluents are absolutely required, contact your catalyst supplier and follow his instructions explicitly. Preferably the supplier should premix the catalyst to prevent possible “on the job” contamination while mixing.



WARNING

If diluents are not used, remember that catalyst spillage and gun, hose, and packing leaks are potentially more hazardous since each drop contains a higher concentration of catalyst and will therefore react more quickly with overspray and the leak.

Cured Laminate, Overspray and Laminate Sandings Accumulation

- Remove all accumulations of overspray, Fiberglass Reinforced Plastic (FRP) sandings, etc. from the building as they occur. If this waste is allowed to build up, spillage of catalyst is more likely to start a fire; in addition, the fire would burn hotter and longer.
- Floor coverings, if used, should be non-combustible.
- Spilled or leaked catalyst may cause a fire if it comes in contact with an FRP product, oversprayed chop or resin, FRP sandings or any other material with MEKP.

To prevent spillage and leakage, you should:

- | | |
|--|---|
| 1. Maintain your Magnum Venus Products System. | Check the gun several times daily for catalyst and resin packing or valve leaks. REPAIR ALL LEAKS IMMEDIATELY. |
| 2. Never leave the gun hanging over or lying inside the mold. | A catalyst leak in this situation would certainly damage the part, possibly the mold, and may cause a fire. |
| 3. Inspect resin and catalyst hoses daily for wear or stress at the entry and exits of the boom sections and at the hose and fittings. | Replace if wear or weakness is evident or suspected. |
| 4. Arrange the hoses and fiberglass roving guides so that the fiberglass strands DO NOT rub against any of the hoses at any point. | If allowed to rub, the hose will be cut through, causing a hazardous leakage of material which could increase the danger of fire. Also, the material may spew onto personnel in the area. |

Toxicity of Chemicals

- Magnum Venus Products recommends that you consult OSHA Sections 1910.94, 1910.106, 1910.107 and NFPA No.33, Chapter 14, and NFPA No.91.
- Contact your chemical supplier(s) and determine the toxicity of the various chemicals used as well as the best methods to prevent injury, irritation and danger to personnel.
- Also determine the best methods of first aid treatment for each chemical used in your plant.

Equipment Safety

Magnum Venus Products suggest that personal safety equipment such as EYE GOGGLES, GLOVES, EAR PROTECTION, and RESPIRATORS be worn when servicing or operating this equipment. Ear protection should be worn when operating a fiberglass chopper to protect against hearing loss since noise levels can be as high as 116 dB (decibels). This equipment should only be operated or serviced by technically trained personnel!



CAUTION

Never place fingers, hands, or any body part near or directly in front of the spray gun fluid tip. The force of the liquid as it exits the spray tip can cause serious injury by shooting liquid through the skin. NEVER LOOK DIRECTLY INTO THE GUN SPRAY TIP OR POINT THE GUN AT OR NEAR ANOTHER PERSON.



DANGER

Contaminated catalyst may cause fire or explosion. Before working on the catalyst pump or catalyst accumulator, wash hands and tools thoroughly. Be sure work area is free from dirt, grease, or resin. Clean catalyst system components with clean water daily.



DANGER

Eye, skin, and respiration hazard. The catalyst MEKP may cause blindness, skin irritation, or breathing difficulty. Keep hands away from face. Keep food and drink away from work area.

Treatment of Chemical Injuries



CAUTION

Refer to your catalyst manufacturer's safety information regarding the safe handling and storage of catalyst. Wear appropriate safety equipment as recommended.

Great care should be used in handling the chemicals (resins, catalyst and solvents) used in polyester systems. Such chemicals should be treated as if they hurt your skin and eyes and as if they are poison to your body. For this reason, Magnum Venus Products recommends the use of protective clothing and eye wear in using polyester systems. However, users should be prepared in the event of such an injury.

Precautions include:

1. Know precisely what chemicals you are using and obtain information from your chemical supplier on what to do in the event the chemical gets onto your skin or into the eyes, or if swallowed.
2. Keep this information together and easily available so that it may be used by those administering first aid or treating the injured person.
3. Be sure the information from your chemical supplier includes instructions on how to treat any toxic effects the chemicals have.

**WARNING**

Contact your doctor immediately in the event of an injury. If the product's MSDS includes first aid instructions, administer first aid immediately after contacting a doctor.

Fast treatment of the outer skin and eyes that contact chemicals generally includes immediate and thorough washing of the exposed skin and immediate and continuous flushing of the eyes with lots of clean water for at least 15 minutes or more. These general instructions of first aid treatment may be incorrect for some chemicals; you must know the chemicals and treatment before an accident occurs. Treatment for swallowing a chemical frequently depends upon the nature of the chemical.

Emergency Stop Procedure

In an emergency, follow these steps to stop a UPS System:

1. The ball valve located where the air enters the power head of the resin pump, should be moved to the "OFF" or closed position.

Note ***The "open" or "on" position is when the ball valve handle is parallel (in line) with the ball valve body. The "closed" or "off" position is when the ball valve handle is perpendicular (across) the ball valve body.***

2. Turn all system regulators to the "OFF" position (counter-clockwise) position.
3. Verify / secure the catalyst relief line, located on the catalyst relief valve.
4. Verify / secure the resin return line, located on the resin filter.
5. Place a container under the resin pump ball valve to catch ejected resin.
6. Locate the ball valve on the resin pump.
7. Rotate the ball valve 90 degrees to the "On" or open position.

Grounding

Grounding an object means providing an adequate path for the flow of the electrical charge from the object to the ground. An adequate path is one that permits charge to flow from the object fast enough that it will not accumulate to the extent that a spark can be formed. It is not possible to define exactly what will be an adequate path under all conditions since it depends on many variables. In any event, the grounding means should have the lowest possible electrical resistance.

Grounding straps should be installed on all loose conductive objects in the spraying area. This includes material containers and equipment. Magnum Venus Products recommends grounding straps be made of AWG No.18 stranded wire as a minimum and the larger wire be used where possible. NFPA Bulletin No77 states that the electrical resistance of such a leakage path may be as low as 1 meg ohm (10 ohms) but that resistance as high as 10,000 meg ohms will produce an adequate leakage path in some cases.

CAUTION



Whenever flammable or combustible liquids are transferred from one container to another, or from one container to the equipment, both containers or container and equipment shall be effectively bonded and grounded to dissipate static electricity. For further information, see National Fire Protection Association (NFPA) 77, titled “Recommended Practice on Static Electrical”. Refer especially to section 7-7 titled “Spray Application of Flammable and Combustible Materials”.

Introduction

This manual provides information for the operation, maintenance, and simple repair of the MVP MicroPro Proportioning Unit. The following procedures are included:

- Step-by-step assembly and disassembly
- Installation, start-up, and shut-down instructions
- Step-by-step operation instructions



Please read this manual carefully and retain for future reference. Follow the steps in the order given, otherwise you may damage the equipment or injure yourself.

Component Assemblies

MVP's MicroPro Proportioning Unit consists of multiple components. Each component has its own detailed manual and drawings. For complete repair and maintenance instructions, refer to the appropriate manuals.

- ☐ 1:1 CLASSIC PRO GUN REPAIR MANUAL
- ☐
- ☐ MPR-PH-3250 3.25" POWERHEAD ASSEMBLY – MICROPRO 10:1
- ☐ OR
- ☐ MPR-PH-5000 5" POWERHEAD ASSEMBLY – MICROPRO
- ☐
- ☐ VHPC-1200 METERING PUMP
- ☐ DEPENDING ON UNIT CONFIGURATION ON OF THE FOLLOWING:
- ☐ VHPC-2200 METERING PUMP
- ☐ VHPC-3200 METERING PUMP
- ☐ VHPC-4200 METERING PUMP

Ratios

The chart below shows the possible ratios with the different metering pump options:

Powerhead	Fixed Fluid Section	Variable Fluid Section	Power Ratio	Material Ratio Range		Output
				High	Low	
Ratios						
MP-5-12-12	VHPC-1200	VHPC-1200	19 : 1	1 : 1	4.6 : 1	0.53 – 0.87 GPM
MP-5-12-22	VHPC-1200	VHPC-2200	21 : 1	1.3 : 1	5.8 : 1	0.51 – 0.78 GPM
MP-5-12-32	VHPC-1200	VHPC-3200	26 : 1	2.2 : 1	10.4 : 1	0.48 – 0.63 GPM
MP-5-12-42	VHPC-1200	VHPC-4200	32 : 1	5 : 1	21.5 : 1	0.46 – 0.52 GPM
MP-5-22-22	VHPC-2200	VHPC-2200	21 : 1	1 : 1	4.6 : 1	0.42 – 0.69 GPM
MP-5-22-32	VHPC-2200	VHPC-3200	31 : 1	1.8 : 1	8.25 : 1	0.39 – 0.54 GPM
MP-4.25-22-42	VHPC-2200	VHPC-4200	27 : 1	4 : 1	18.6 : 1	0.36 – 0.43 GPM
MP-4.25-32-32	VHPC-3200	VHPC-3200	31 : 1	1 : 1	4.6 : 1	0.23 – 0.38 GPM
MP-3.25-32-42	VHPC-3200	VHPC-4200	25 : 1	2.2 : 1	10.4 : 1	0.21 – 0.28 GPM
MP-3.25-42-42	VHPC-4200	VHPC-4200	40 : 1	1 : 1	4.6 : 1	0.10 – 0.17 GPM

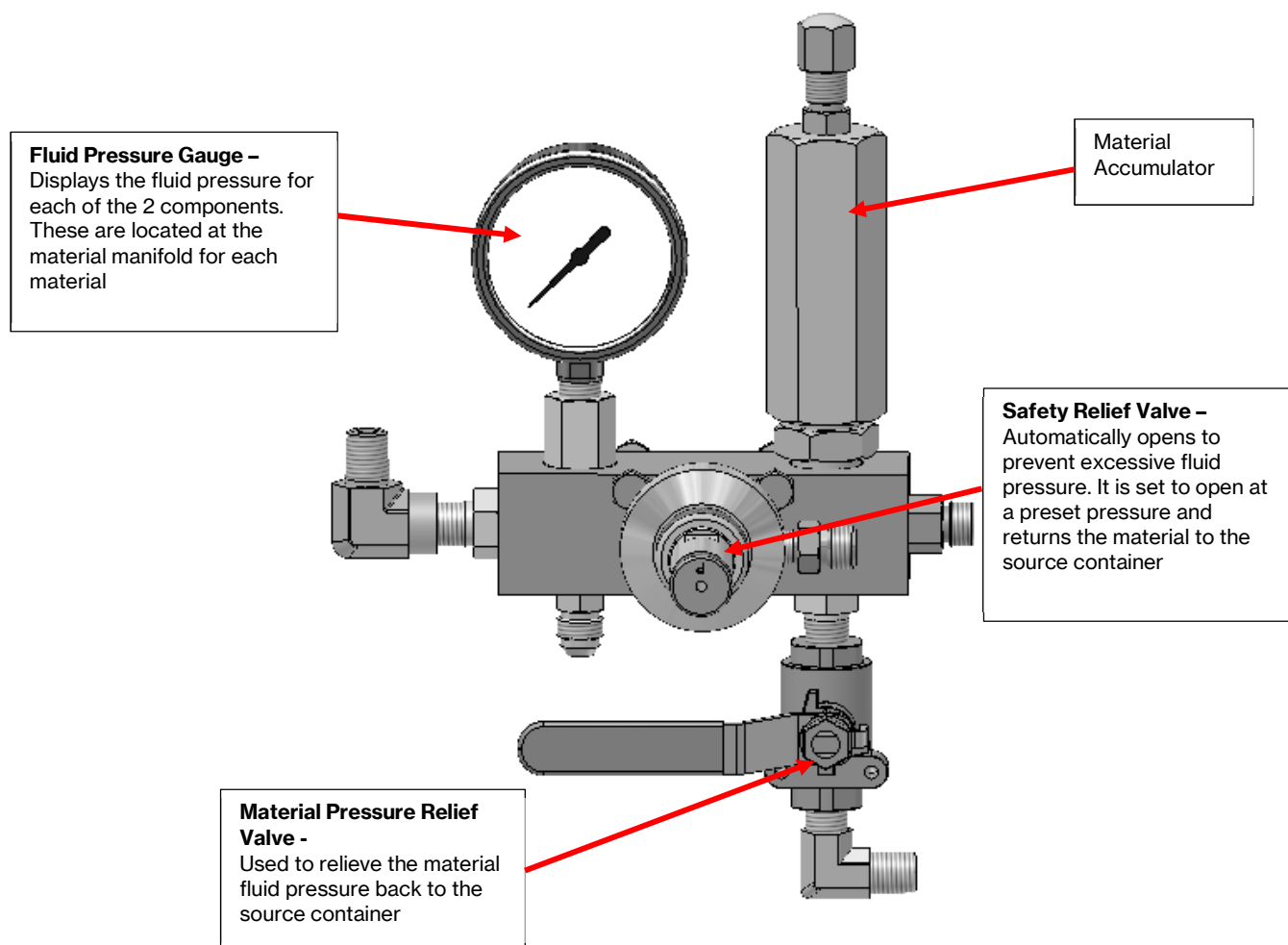
Note **Outputs listed are the minimum and maximum in gallons per minute (GPM).**

Overview of Controls

Following is a brief description of the air manifold main controls and their function.

Air Manifold	
Description	Function
Main Air Inlet Valve	This is where the air supply to the unit is connected. The valve turns the air supply to the unit on or off.
Pump Pressure Gauge and Regulator	This is the regulator used to control the air pressure for the powerhead and the gauge to monitor the amount of pressure in use.
Air Purge Gauge and Regulator	This gauge and regulator are used to set and monitor the pressure used to air purge the gun, mix chamber, and mixer.
Solvent Tank Gauge and Regulator	This gauge and regulator are used to set the solvent flush pressure.
Priming Button	The priming button is used to operate the pump without the gun being open. The button sends an air signal to the safety override valve to operate the air motor and pump while the gun remains closed.

Fluid Pressure – Material Manifolds



Setting Up the Unit



CAUTION

Always use proper safety gear, gloves, and safety glasses.



WARNING

Follow all pressure relief procedures in this manual. Clean all tools to be used for repair of grease or other material that can react with the material being pumped.

1. Turn all regulators counterclockwise to zero and make sure the main air inlet valve is closed before connecting the main air supply.
2. Connect air supply to the system that is capable of 90 – 100 psi (6 – 7 bar) of clean, dry air.
3. Open the main air inlet valve in one fast stroke.

Note ***The main air supply inlet valve is a safety ball valve and must be all the way closed or all the way open. When the ball valve is closed, the air pressure remaining in the air manifold and system is released.***

4. Check for air leaks and repair as necessary.
5. Fill solvent container no more than $\frac{2}{3}$ full with desired solvent (non-flammable solvents are recommended).
6. Adjust the air regulator on the flush tank to pressurize the solvent container to between 40 – 60 psi (3 – 4 bar).
7. Check for solvent leaks and repair as necessary.
8. Set the air purge regulator to between 40 – 60 psi (3 – 4 bar).

Note ***This is the air pressure used when air purging the gun and mixer.***

9. Locate the 3-way ball valve on the hose set by the gun.
10. Rotate the ball valve handle to the flush position (pointing to the yellow tubing).
11. Test solvent flush by pushing the flush buttons on either side of the gun block.
12. Rotate the ball valve handle to point to the clear tubing.
13. Push the flush buttons on the gun block to air purge the mixer housing.
14. Rotate the ball valve handle to the neutral position (center) when flushing and air purge are complete.

Prime Metering Pumps

15. Install ratio block onto gun head to keep the two materials separate for priming.

Note ***Keeping the two materials separate will prevent material waste when performing priming and ratio checks.***

16. Set both pumps for the longest pump stroke.

Note ***If either tank or pump completely runs out of material, never re-prime fluid section with static mixer attached. This could result in material cross-over inside the gun.***

17. Pour throat seal oil (TSL) into the packing nut reservoirs until they are $\frac{3}{4}$ full to prevent materials from drying on the piston rod and adversely affecting the life of the piston rod packings.
18. Fill both containers with materials.

Note ***Always keep the ISO tank lid on the tank and slightly snug tighten to avoid moisture contamination and/or crystals from forming. Crystallized ISO will plug the fluid filter and affect metering of the system.***

19. Check to make sure the pump pressure regulator is set to zero.

20. Have two clean containers available to catch the materials as they are dispensed from the ratio block.
21. Position the gun so that the ratio block separates the two materials into the containers to prevent cross contamination.
22. Pull the trigger on the gun and turn the pump pressure regulator clockwise to begin cycling the pumping system.
23. Once a steady flow of both materials is achieved, note the fluid pressure for both materials.

Note ***Minimal fluid pressure is required for ratio checks, but the fluid gauge needle should come off its stop even if an exact reading is unobtainable.***

24. Perform a ratio check or gel test.

Setting Pump Ratio

The resin pump is normally fixed at the longest pump stroke length and is not used for adjusting ratios. The hardener pump is used to set the proper ratio by loosening the cap screw and sliding the upper and lower slide clevis on the top and bottom of the metering pump in the slotted track to the desired setting, then retightening the cap screw. Use the indicator stickers on the top and bottom of the slotted track for a reference indicator when setting ratios.

During priming of the fluid sections, if one of the fluid sections shows no pressure because of a low viscosity material, add a smaller diameter hose onto the ratio block to restrict the flow in order to create fluid pressure. If both fluids read pressure proceed with setting ratios.

To set the ratio, you will need an accurate scale or volumetric beakers.

1. Pull the trigger on the gun, allowing for both materials to begin flow out of the ratio block.
2. Slide two pre-weighted containers under the resin streams.
3. Allow no less than 10 pump reversals before removing the containers.
4. Release the trigger on the gun.
5. Weigh the containers and subtract container weights to find the ratio.

Note ***Some material manufacturers may only give a volumetric ratio rather than weight. In this case, if you prefer to set the ratio by weight measurement, you will need the **specific gravity** of each material to convert weight to volume in cubic centimeters (cc's).***

Example ***The poly resin (material A) weight is 500 grams and has a specific gravity of 1.09, which requires dividing the sample weight by specific gravity (500/1.09 = 458.71 cc's).***

6. To adjust the ratio, loosen the cap screw to adjust the pump stroke length on the ISO hardener fluid section (the shorter/lower slave arm number).
7. Tighten the cap screw before checking the ratio again.
8. Make notes of each setting that the ratios were taken from on the indicator sticker until the desired ratio is set.

Note ***Make notes of all settings during ratio checks, including pump pressures and material temperatures. At the start of each work week, perform another ratio check. This is even more important when using fillers mixed into the poly resin to assure filler settling has not occurred in the poly resin filter or pump.***

9. Once the material ratio has been set, flush the ratio block by pushing in the flush valves and selecting between solvent or air purge with the 3-way valve.

Dispensing Material

1. Install the mix chamber, spring, and ball checks.

Note ***It is sometimes easier to install the mix block first and then remove the plugs on the front of the mix block to install the ball and springs.***

2. Attach the static mixer to the mix chamber.
3. Pull the trigger on the gun and dispense material into a waste container.
4. Make note of the fluid pressures for both materials, then release the trigger on the gun and flush the gun and mixer.

Note ***The fluid pressures do not have to match exactly, but there should not be a huge difference. 300 psi for the resin and 150 psi for the hardener would be acceptable in most cases. In some cases, the pump may run so slow that it is difficult to read an exact pressure. As long as both pressure gauge needles come off of their stops you will achieve proper ball seating when gravity feeding.***

Performing Daily Tasks

Daily Start Up

1. Inspect levels of resin, hardener, and solvent to determine if you have sufficient amounts to begin production; replace or refill as needed.
2. Close the relief valve on top of the solvent tank.
3. Open the main air inlet supply to the system.
4. Install the spring and balls into the mix housing, then install the mix housing.
5. Set the desired pump ratio and check as necessary.
6. Press the priming button while adjusting the pump air pressure control to the desired setting.
7. Pull the trigger on the gun and allow several pump strokes into a waste container.
8. Install the mixer and prepare the work area for operation.
9. Periodically include a ratio check and material gel test in your daily start up routine.

Daily Shut Down

Note ***For shut down, the fluid pump shafts should be in the bottom of the stroke to avoid any material from drying on the shafts. Not following this procedure will have a negative effect on piston rod seal life.***

10. Release the trigger on the gun to stop the pump just before the pumps reach the bottom reversal.
11. Flush both sides of the mix chamber into a waste container and air purge dry.
12. Remove the mixer from the mix housing.
13. Inspect the static mixer to make sure that it has been completely cleaned of metered materials.
14. Remove mix housing, spring, and balls and inspect for any set-up materials.

Note ***Depending on the resin systems used it may not be necessary to remove mix housing for shut down every day, however the static mixer should always be removed for daily shut down.***

15. Turn off the main air inlet valve.
16. Remove the flush tank pressure by lifting the relief valve ring.
17. Open the fluid pressure relief valves on the material manifolds to release fluid pressure and then close.

Maintenance

18. Drain water from trap as needed and inspect trap daily.
19. Inspect pump piston shafts for material build up and clean as needed.
20. Check inline filters and clean as needed.
21. Replace the return and relief tubing on the material manifold as needed to prevent blockage.

Long-Term Shut Down

22. Depending on how much material is in the tanks and if you want to save it, place a container for each material under each port of the ratio block of the gun.
23. Pull the trigger on the gun and adjust the pump pressure control so the pumps are moving slowly and evenly.
24. When the majority of the material is out of the both tanks and air is spitting from the ports of the ratio block, release the trigger of the gun.
25. Remove lids from feed containers and pour 1 to 2 liters of solvent into them, then clean the container walls with a brush.
26. Place the gun over a waste container and pull the trigger on the gun.
27. Adjust the pump pressure to purge the dirty solvent into a waste container through the front of the gun.

28. Repeat steps - with clean solvent in each of the two containers until it comes out of the gun clean, then run pump until solvent flow has stopped.
29. When the fluid sections are at the bottom of the stroke, release the trigger.
30. Inspect throat seal oil at the top of the pump; clean and add as needed.
31. Replace the return and relief valve tubing on the material manifold as needed to prevent blockage.