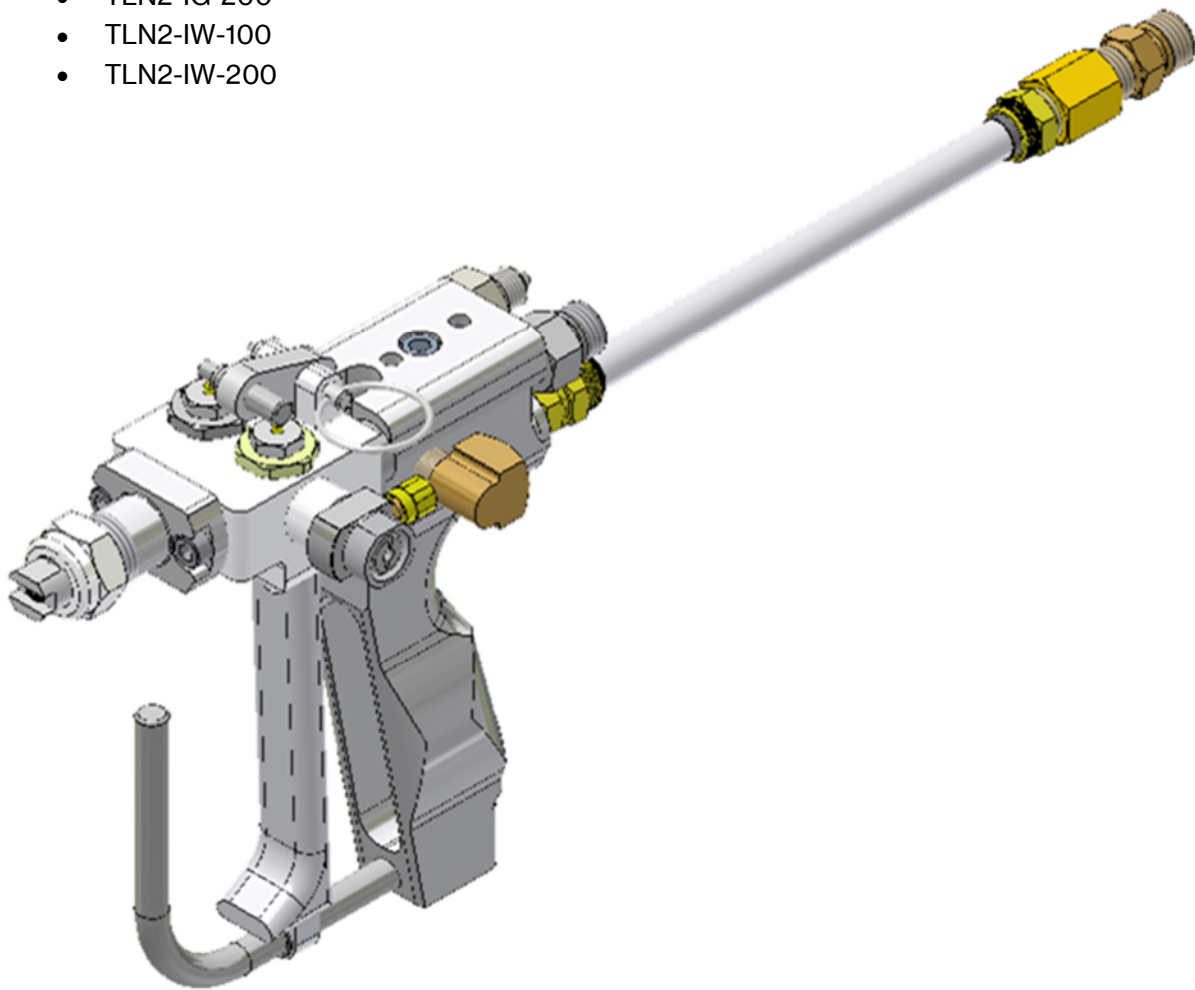


# Internal Mix Talon Gun

## Manual

This manual is applicable to the following models:

- TLN2-IC-100
- TLN2-IC-200
- TLN2-IFC-100
- TLN2-IFC-200
- TLN2-IG-100
- TLN2-IG-200
- TLN2-IW-100
- TLN2-IW-200



Rev. May 2020



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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.

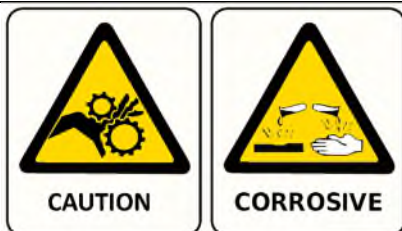
## Safety Precautions

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

<b>Resins</b>		
<b>Composite Component</b>	<b>Organ System Target (Possible Target)</b>	<b>Known (Possible) Health Effect</b>
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)
<b>Reinforcing materials</b>		
<b>Composite Component</b>	<b>Organ System Target (Possible Target)</b>	<b>Known (Possible) Health Effect</b>
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
<b>Hardeners and curing agents</b>		
<b>Composite Component</b>	<b>Organ System Target (Possible Target)</b>	<b>Known (Possible) Health Effect</b>
Diaminodiphenylsulfone	N/A	No known effects with workplace exposure
Methylenedianiline	Liver, skin	Hepatotoxicity, suspect human carcinogen
<b>Other aromatic amines</b>		
<b>Composite Component</b>	<b>Organ System Target (Possible Target)</b>	<b>Known (Possible) Health Effect</b>
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 OR AN ANIMAL.***

**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 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 should be 1 meg ohm ( $10^6$  ohms) or less.



### 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 Internal Mix Talon Gun. The following procedures are included:

- Step-by-step assembly and disassembly
- Troubleshooting information



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.

## During Disassembly

As you disassemble the equipment, lay out the components on a clean surface in the correct order and direction to aid in reassembly. Reference the current parts drawing for your equipment to assist in assembly and find part numbers if needed.

## Required Items

You will need the following tools:

- $\frac{7}{16}$ " socket wrench
- $\frac{11}{16}$ " socket wrench
- Hex wrench/Allen key set
- 8" adjustable wrench
- Flathead screwdriver
- Scribe set

You will need appropriate cleaning materials such as solvent, clean shop towels or rags, a small brush, and empty containers into which you can flush the gun. You will also need the appropriate seal kit for the gun you have and any parts that may need to be replaced. Refer to the parts drawings for the correct part numbers to order.

## Talon Gun Assemblies

This manual covers the following Talon internal mix assemblies:

Choppers	
Part Number	Description
TLN-IC-100	Talon Internal Mix Chop Gun Assembly
TLN-IC-200	Talon Internal Mix Chop Gun Assembly
Filled Resin Choppers	
Part Number	Description
TLN-IFC-100	Talon Internal Mix Filled Chop Gun Assy
TLN-IFC-200	Talon Internal Mix Filled Chop Gun Assembly

<b>Gelcoater</b>	
<b>Part Number</b>	<b>Description</b>
TLN-IG-100	Talon Internal Mix Gel Gun Assembly
TLN-IG-200	Talon Internal Mix Gel Gun Assembly
<b>Wetout</b>	
<b>Part Number</b>	<b>Description</b>
TLN-IW-100	Talon Internal Mix Wetout Gun Assembly
TLN-IW-200	Talon Internal Mix Wetout Gun Assembly
<b>Cartridge Assemblies</b>	
<b>Part Number</b>	<b>Description</b>
TLN-I-CTR-C	Catalyst Cartridge Assembly
TLN-I-CTR-FM	Filled Material Cartridge Assembly
TLN-I-CTR-M	Material Cartridge Assembly
<b>Seal Kits</b>	
<b>Part Number</b>	<b>Description</b>
TLN-IC-F-SK-INT	Seal Kit – FIT Gun (200 Guns)
TLN-IC-SK-INT	Seal Kit Talon Internal Mix Chop - Airless
<b>Miscellaneous Items</b>	
<b>Part Number</b>	<b>Description</b>
5103-01-01	Catalyst Injector Assembly

## Disassembling Gun

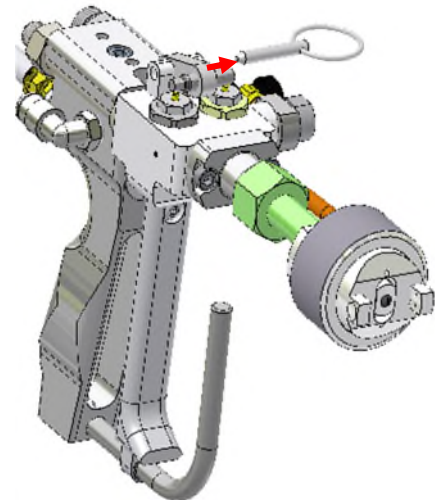


### **WARNING**

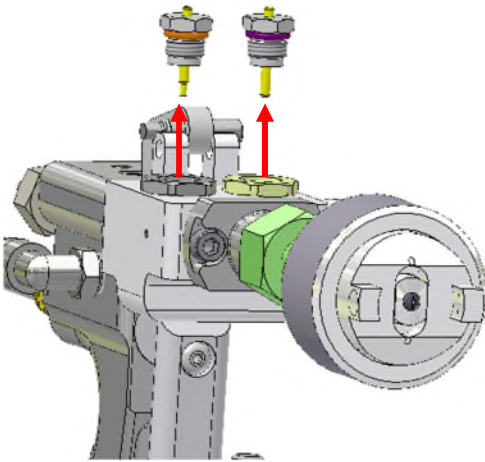
*Always remove air and fluid pressures before disconnecting gun and working on unit.*

### Remove Rod Seal

1. Remove trigger pin and push the trigger arm assembly out of the way.
2. Use a  $\frac{7}{16}$ " wrench to remove the rod seal housing(s).

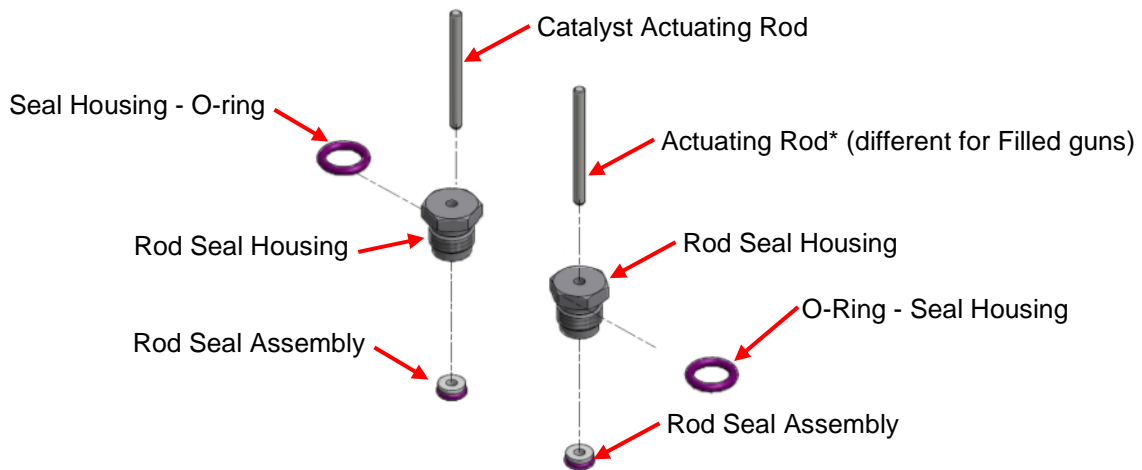






**Note**     *The material rod will come up with the housing.*

3. Remove the rod seal assemblies and housing O-rings.



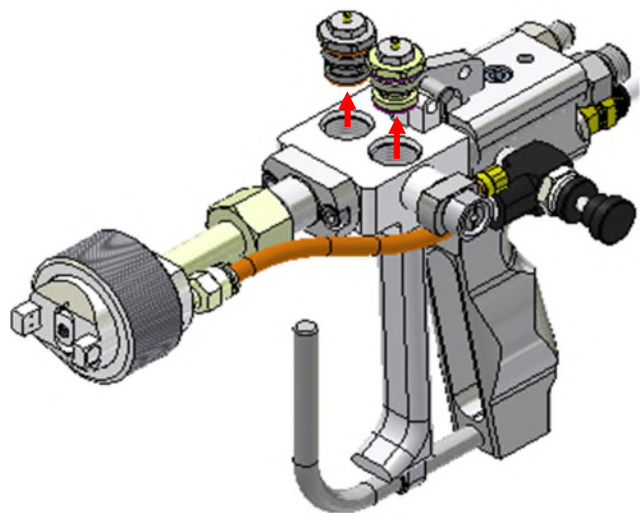
**Note**     *Do not use petroleum based oil or grease on purple O-rings.*

## Remove Cartridge

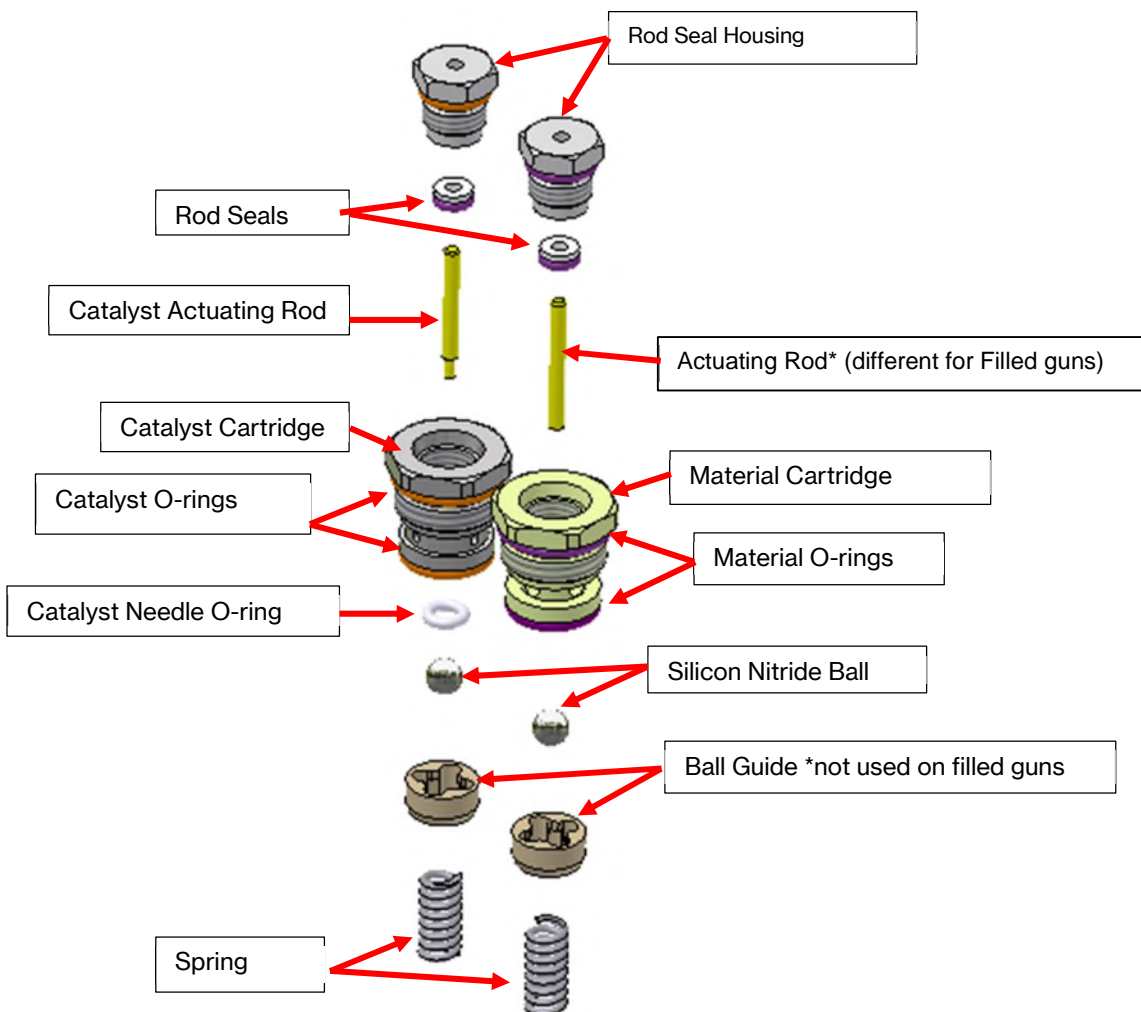
4. Remove trigger quick pin and push the trigger assembly out of the way.
5. Use  $\frac{11}{16}$ " wrench to remove cartridge housings.

**Note**     *Material rod and catalyst needle will come up with cartridges.*

6. Use a  $\frac{7}{16}$ " wrench to loosen the rod seal housings and remove.
7. Remove and clean the ball, ball guide, and spring (replace as needed).
8. Remove all old O-rings and seals.



## 9. Lubricate new O-rings and seals and reassemble.



**Note**      *Do not use petroleum based oil or grease on purple O-rings.*

## Cartridge Assemblies

The following kits allow for a quick rebuild of the gun, since they include everything other than the ball and spring:

### ***TLN-I-CTR-C (Catalyst Cartridge Assembly)***

- O-A-007                      O-ring
- O-S-011                     O-ring
- O-S-013                     O-ring
- O-S-015                     O-ring
- TLN-1024                   Catalyst Valve Body
- TLN-1041                   Push Rod
- TLN-2021                   Rod Seal Housing
- TLN-2029                   Rod Seal Housing

***TLN-I-CTR-M (Material Cartridge Assembly)***

- O-E-011 O-ring
- O-E-013 O-ring
- O-E-015 O-ring
- TLN-1008-01 Resin Valve Body
- TLN-1036 Push Rod
- TLN-2021 Rod Seal Housing
- TLN-2029 Rod Seal Assembly

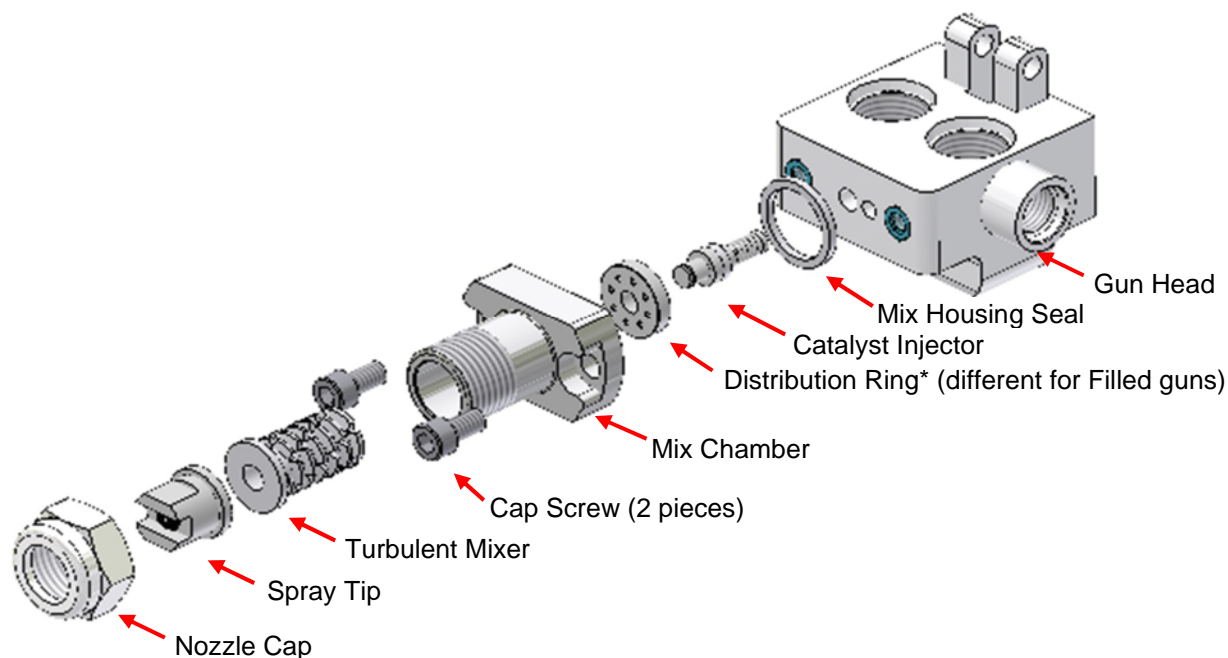
***TLN-I-CTR-FM (Filled Resin Material Cartridge Assembly)***

- O-E-011 O-ring
- O-E-013 O-ring
- O-E-015 O-ring
- TLN-1008F-01 Resin Valve Body
- TLN-1036-TC Push Rod
- TLN-2021 Rod Seal Housing
- TLN-2029 Rod Seal Assembly

## Repair Gun Head

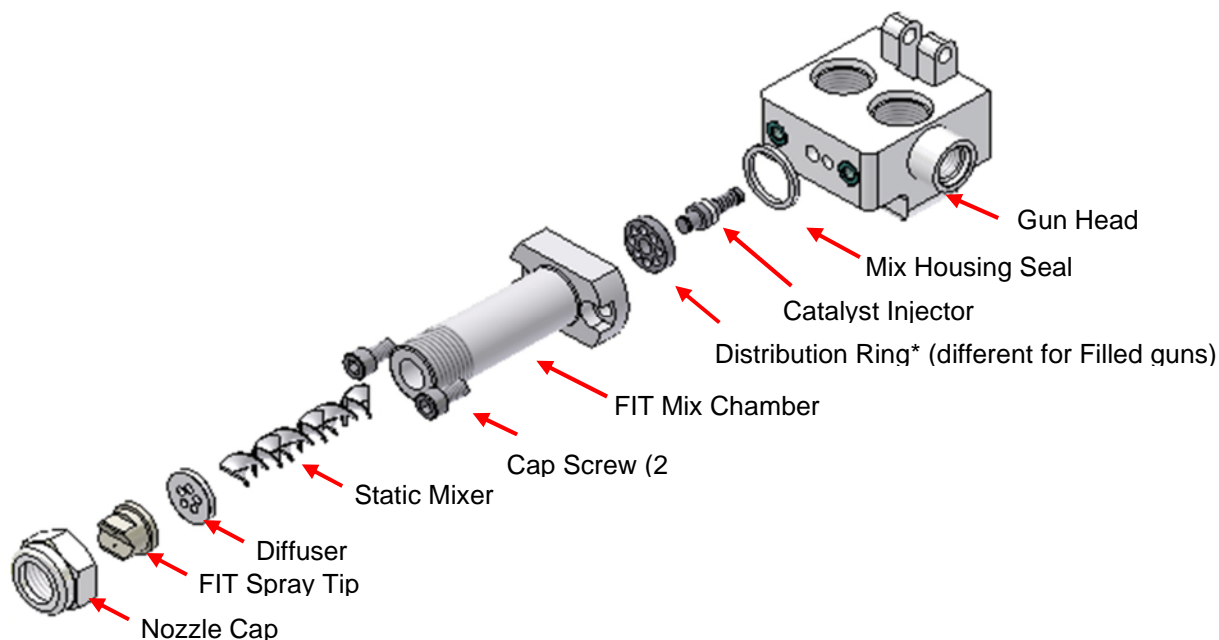
10. Properly clean and flush the mix chamber and spray tip.
11. Unscrew the nozzle cap and remove the spray tip and turbulent mixer.
12. Remove the two cap screws and then the mix chamber from the gun block.
13. Remove the catalyst injector from the gun block or distribution ring.
14. Carefully disassemble, clean, and then reassemble the catalyst injector.
15. Remove the mix housing seal and distribution ring from the mix chamber.
16. Replace seals and damaged parts (if any) and reassemble.

## Chopper or Wetout Gun Front



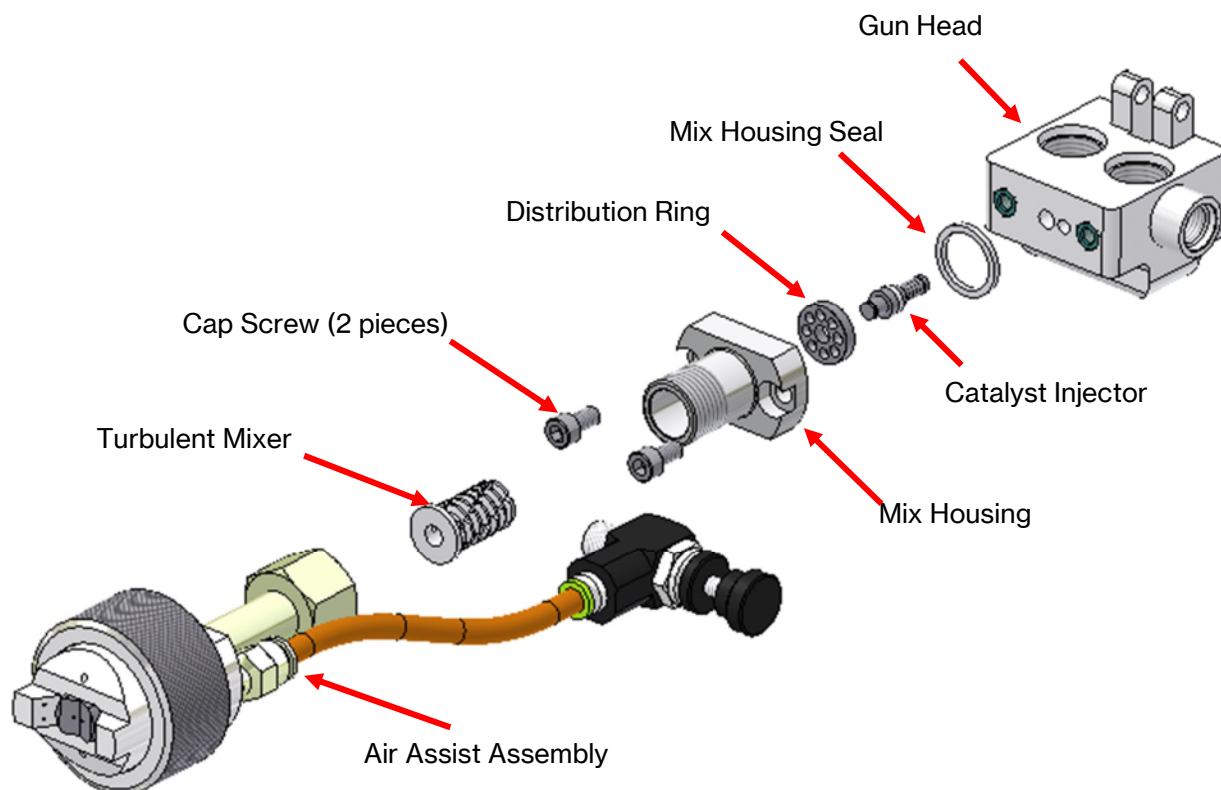
**Note**     *The TLN2-IC-100 and TLN2-IW-100 guns use the FT-XXX or N-XXXXC airless spray tips.*

## FIT Chopper Gun Front



**Note**     *The TLN2-IC-200 and TLN2-IW-200 guns use the VFIT-XXXX FIT spray tips.*

## Gelcoat Gun Front



**Note**     *The TLN2-IG-200 gun uses the VPA-1000-VFIT air assist assembly and VFIT-XXXX spray tips. The TLN2-IG-100 gun uses the VPA-1000 air assist and ATG-XXX spray tips.*

### Mix Housing Options

- Standard Mix Housing (5104-20-1) – use with all turbulent mixers and most applications.
- FIT Mix Housing (VPG-1001) – use with FIT style spray tips. Uses mixer VPG-1003.
- FIT Low Flow Mix Housing (VPG-1001-1/4) – replacement mixer TRT-1018-1/4.
- Ratio Block – Pail Dispenser Mix Housing (58735-1) – separates material streams.

### Distribution Ring Selection

There are three different distribution rings:

- Standard Distribution Ring 5104-17-1 (58607-1) – used for most application where outputs are not critical.
- Filled Resin Distribution Ring 5104-18-1 (58701-1) – used in applications where the resin is filled above 20%. Use with high filler loads and high outputs.
- Critical Mix Distribution Ring 5104-19-1 (58703-1) – use in low output applications where it is important to restrict flow.

### Turbulent Mixer Selection

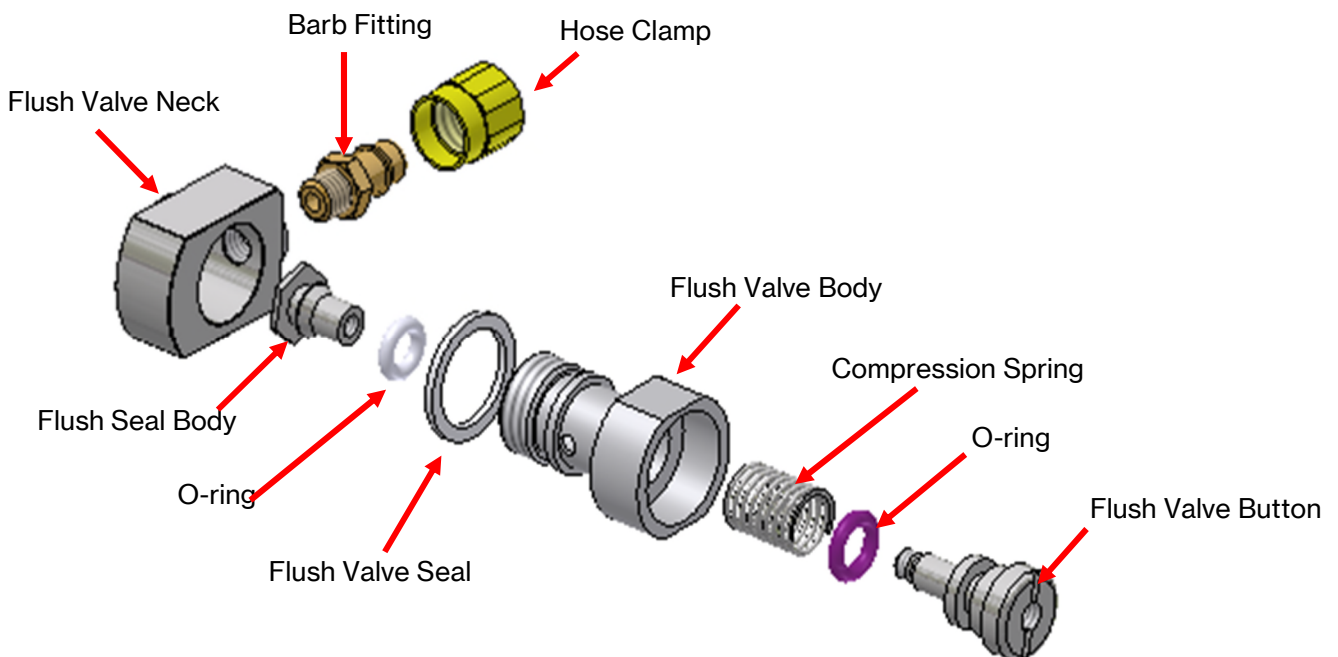
There are two different turbulent mixers in two different materials:

- Standard Turbulent Mixer (5107-27-3) – used for most applications where outputs are not critical. Use with chopper and saturator applications.
- Glass Filled Special Turbulent Mixer (5107-27-4) – used with abrasive materials and filled resin applications where durability is required.
- Critical Mix Turbulent Mixer (5107-27-2) – used for low output applications such as gelcoat. In low flow application the critical mix turbulent mixer works best.
- Glass Filled Critical Mix Turbulent Mixer (5107-27-5) – used in low flow applications where the material is abrasive and durability is required.

## Disassemble Flush Valve

17. Remove the split seal from the flush valve body.
18. Remove the flush valve body from the flush valve neck.
19. Remove the flush valve seal from the flush valve body.
20. Unscrew the flush seal body from the flush valve button.
21. Remove the spring.
22. Use a scribe to remove the O-ring from the flush valve button.
23. Remove the O-ring from the flush seal body.

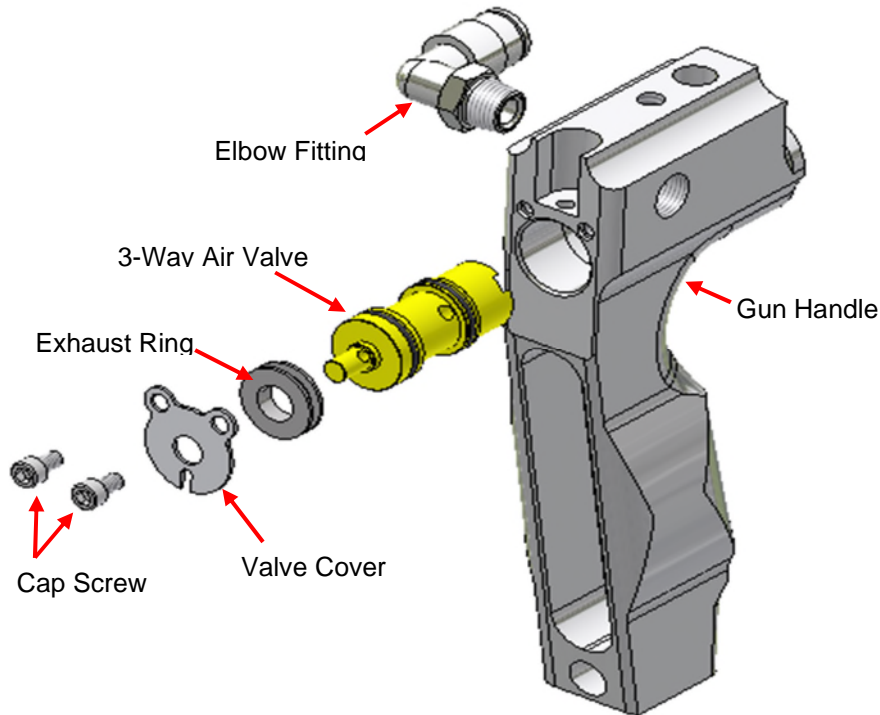
**Note**      ***O-ring O-K-008 can be used to replace the more economical O-ring O-E-008. O-ring O-K-008 is designed for use with all solvents.***





## Repair Handle Air Valve

1. Remove the cap screws holding the valve cover to the gun handle and remove the valve cover.
2. Remove the exhaust ring and 3-way air valve from the handle.
3. Clean or replace the air valve and O-rings as necessary and reassemble.



## Reassembling Components

### Assemble Flush Valve

1. Place the replacement O-ring on the flush valve button.

**Note**     *If you are using O-ring O-K-008, you do not need to replace the O-ring unless it is showing obvious signs of wear or damage. This O-ring is designed for use with all solvents.*

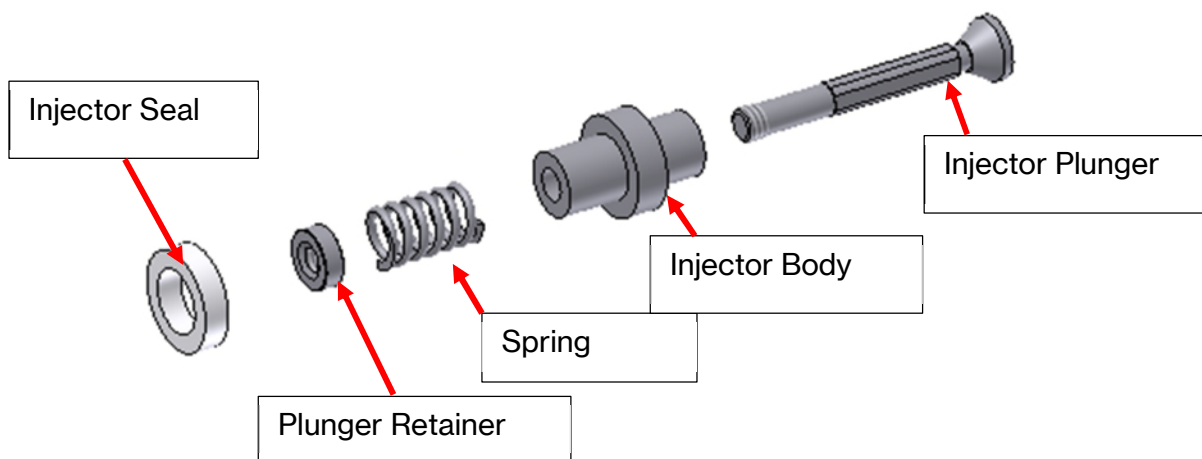
2. Insert the flush valve button into the spring.
3. Push the button and spring into the flush valve body.
4. Replace the O-ring on the flush seal body.

**Note**     *Different O-rings are used on the two assemblies TLN-FV-1000 and TLN-FV-1000-INT. Make sure you order the correct seal kit for the assembly you have.*

5. Insert the flush seal body into the end of the flush valve body and screw it onto the button.
6. Place a flush valve seal on the flush valve body.
7. Install the flush valve body into the flush valve neck.
8. Install the split seal onto the flush valve body.

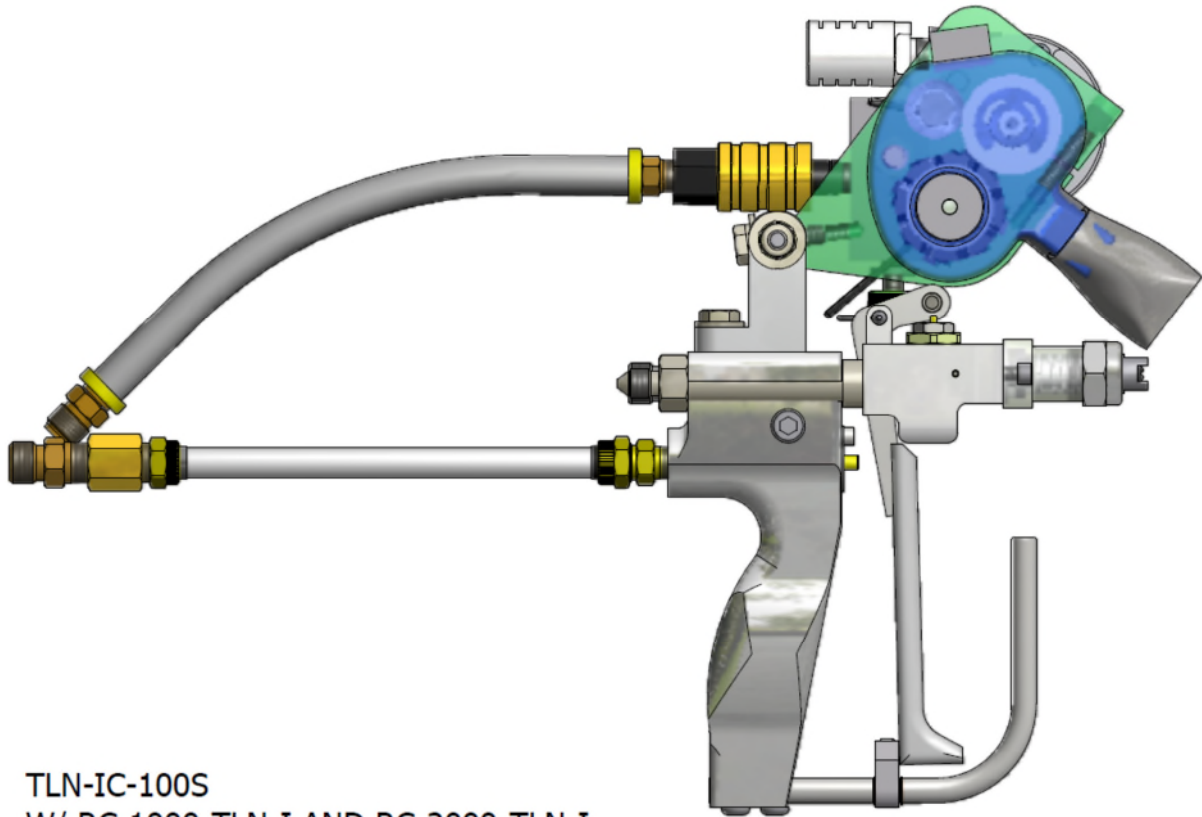
## Assemble Catalyst Injector

9. Reassemble the catalyst injector and reinstall it into the gun.

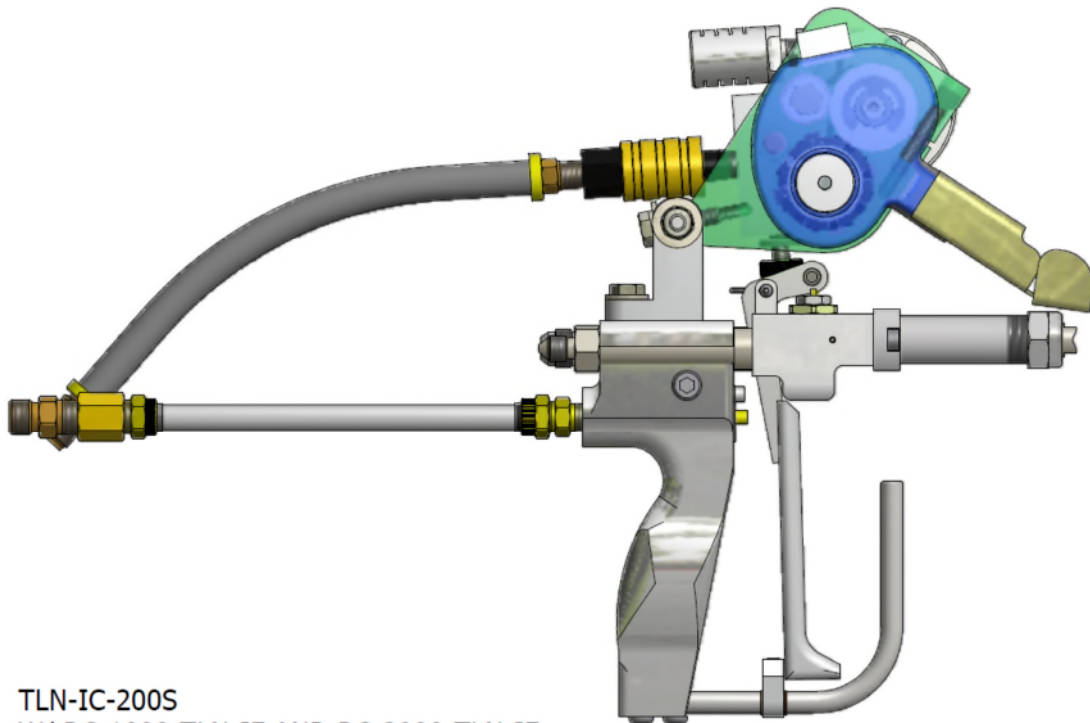




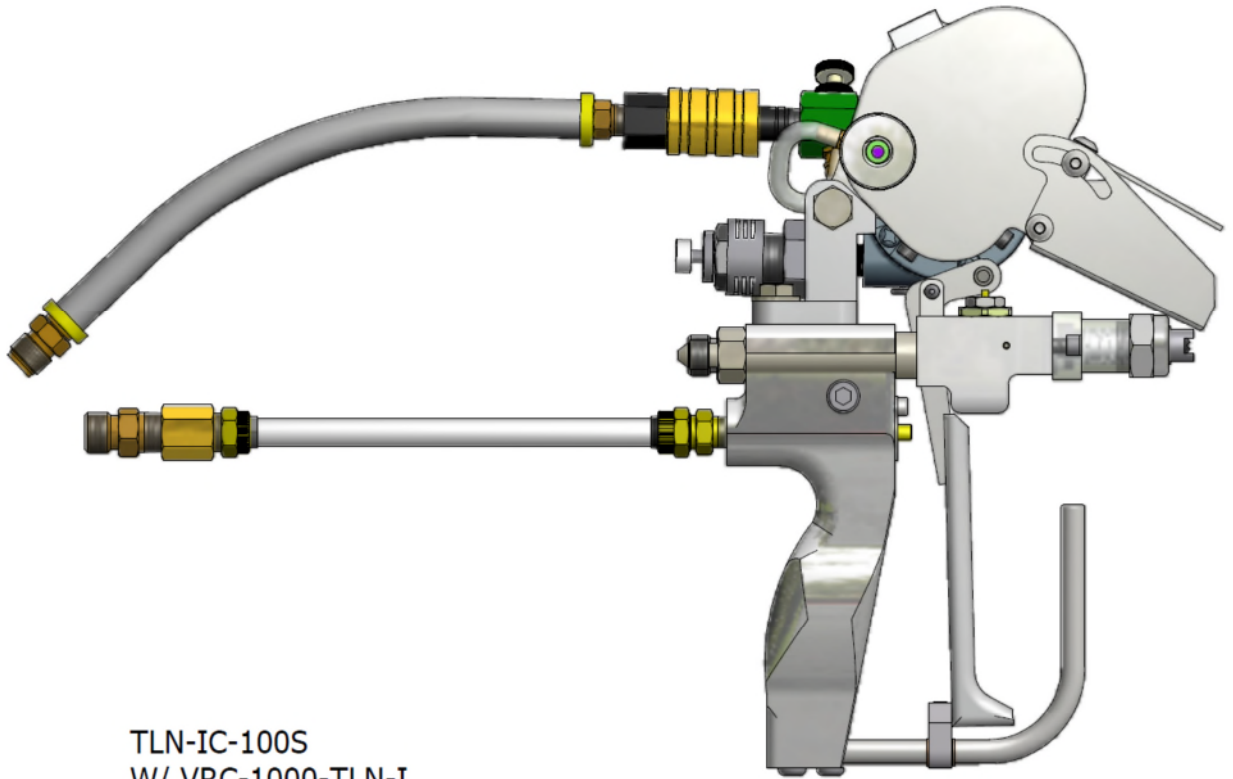
## **Selecting Chopper**



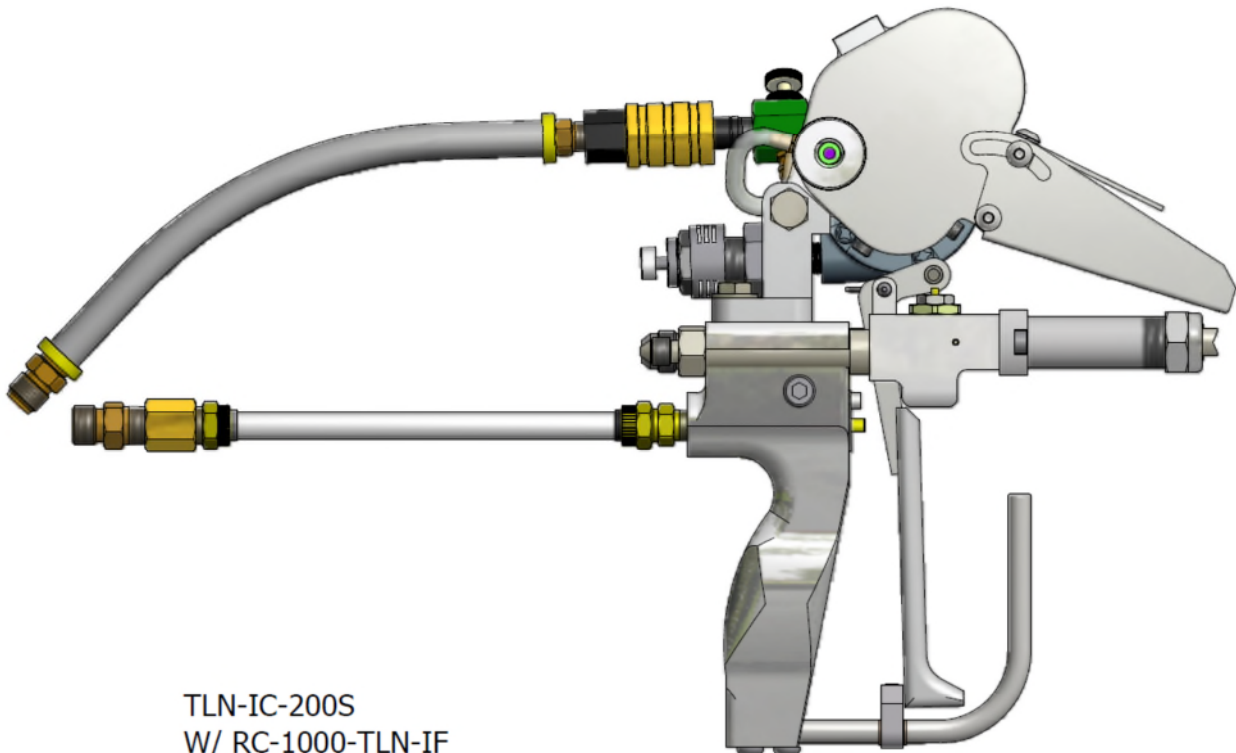
TLN-IC-100S  
W/ RC-1000-TLN-I AND RC-2000-TLN-I



TLN-IC-200S  
W/ RC-1000-TLN-IF AND RC-2000-TLN-IF



TLN-IC-100S  
W/ VRC-1000-TLN-I



TLN-IC-200S  
W/ RC-1000-TLN-IF

# Troubleshooting

Catalyst Problems		
Symptom	Possible Cause	Remedy
Catalyst leaking around catalyst actuating rod	Rod seal housing loose	Tighten rod seal housing
	Damaged rod seal assembly	Replace rod seal assembly
	Damaged catalyst actuating rod	Check and replace catalyst actuating rod as needed
Catalyst leaking around rod seal housing	Rod seal housing loose	Tighten rod seal housing
	Damaged O-ring on rod seal housing	Replace O-ring
Catalyst leaking around catalyst cartridge	Catalyst cartridge loose	Tighten the catalyst cartridge into gun head
	Damaged O-ring on catalyst cartridge	Replace O-rings and check gun head for damage
Catalyst leaking around catalyst fitting	Catalyst fitting loose	Tighten catalyst fitting into gun head
	Damaged O-ring on catalyst fitting	Replace O-ring and check gun head for damage
Catalyst leaking from front of gun block	Damaged O-ring in catalyst cartridge	Replace O-ring
	Damaged or dirty ball in catalyst cartridge	Clean or replace catalyst ball as necessary
	Damaged compression spring	Check and replace compression spring
Catalyst leaking from front of gun block	Catalyst actuation rod holding ball open	Check that catalyst needle is moving freely and not being pressed down by handle, adjust as needed
Catalyst getting into resin side of gun	No resin pressure	Check resin pump for proper operation (refer to your system manual)
		Check and fill resin supply as needed
		Do not prime catalyst with spray tip in place
	Catalyst leaking through cartridge valve	Repair valve as needed
		Nightly remove mix chamber and hang gun front down
		Release catalyst pressure nightly or at shutdown
No catalyst from gun	Stuck or damaged catalyst actuating rod	Check and repair catalyst rod as necessary
		Check the catalyst ball and spring for damage or blockage; clean or replace as needed
	Gun head porting blocked	Check and clean gun head porting
	Blocked catalyst hose or fitting	Check the catalyst hose and fitting, clear or replace as needed
	Damaged or blocked catalyst injector	Repair or replace catalyst injector as needed

**Catalyst Problems**

Symptom	Possible Cause	Remedy
	Catalyst pump not working correctly	Repair catalyst pump as needed
	Catalyst pump disconnected from slave drive	Connect catalyst pump to slave drive and set to proper percentage
		Connect slave drive to the pump
	Catalyst ball valve or relief valve open on the catalyst manifold	Check ball valve and relief valve and close or repair as needed
	Damaged/crushed turbulent mixer lip	Replace turbulent mixer

**Resin Problems**

Symptom	Possible Cause	Remedy
Resin leaking around catalyst actuating rod	Rod seal housing loose	Tighten rod seal housing
	Damaged rod seal assembly	Replace rod seal assembly
	Damaged actuating rod	Check and replace actuating rod as needed
Resin leaking around rod seal housing	Rod seal housing loose	Tighten rod seal housing
	Damaged O-ring on rod seal housing	Replace O-ring
Resin leaking around material cartridge	Material cartridge loose	Tighten the material cartridge into gun head
	Damaged O-ring on material cartridge	Replace O-rings and check gun head for damage

**Resin Problems**

Symptom	Possible Cause	Remedy
Resin leaking around resin fitting	Resin fitting loose	Tighten resin fitting into gun head
	Damaged O-ring on catalyst fitting	Replace O-ring and check gun head for damage
Resin leaking from spray tip	Damaged turbulent mixer or spray tip	Clean and replace the turbulent mixer as needed and check the spray tip for damage
	Nozzle cap loose	Tighten the nozzle cap slightly – do not overtighten or the turbulent mixer will be damaged
	Damaged or dirty ball in the material cartridge	Clean or replace material ball as needed
	Damaged or dirty material seat in material cartridge	Remove the material cartridge and check and clean the ball seat
	Actuating rod holding ball open	Check that the actuating rod is moving freely and not being pressed down by the handle, adjust as needed
	Stuck or damaged actuating rod	Repair or replace actuating rod as needed

**Resin Problems**

Symptom	Possible Cause	Remedy
	Damaged compression spring	Check and replace the compression spring in the material cartridge
No Resin from gun	Blocked spray tip	Clean or replace spray tip
	Actuating rod not opening material ball	Check actuating rod for damage and then check material cartridge and ball; replace as needed
	Gun head porting blocked	Check and clean gun head porting
	Blocked resin hose or fitting	Check resin hose and fitting and clear as needed
	Resin pump not working correctly	Repair resin pump as needed
	Resin return ball valve open	Close ball valve located below resin filter

**Flush Problems**

Symptom	Possible Cause	Remedy
Solvent leaking around flush neck	Flush body loose	Tighten flush valve body a little – do not overtighten
	Damaged split seal	Replace split seal
	Dirty or damaged gun block	Check and clean gun block around flush port
Solvent leaking between the flush neck and flush body	Flush body loose	Tighten flush valve body a little into the gun block – do not overtighten
	Damaged flush valve seal	Replace flush valve seal
	Damaged flush valve body or neck	Check the flush valve body and neck for damage and replace as needed
Solvent leaking around flush button	Damaged O-ring on the flush button	Replace O-ring on flush button. Make sure new O-ring is compatible with solvent
	Damaged flush valve body	Replace flush valve body
Solvent leaking around barb fitting	Loose barb fitting	Tighten barb fitting into flush neck
	Damaged seal	Replace nylon seal
Solvent leaking from front of gun block or mix chamber	Seal body O-ring damaged	Replace O-ring
	Dirty or damaged flush valve body	Clean or replace flush valve body as needed
	Solvent pressure too high	Reduce solvent tank pressure
	Flush seal body loose or off the button	Connect and tighten the flush seal body onto the button
Resin leaking into the solvent supply tube / flush tank	Damaged flush seal O-ring	Replace the O-ring on the flush seal
	Flush seal body loose or off button	Connect and tighten the flush seal body onto the button

**General Problems**

Symptom	Possible Cause	Remedy
	Damaged O-ring on air valve	Replace O-ring

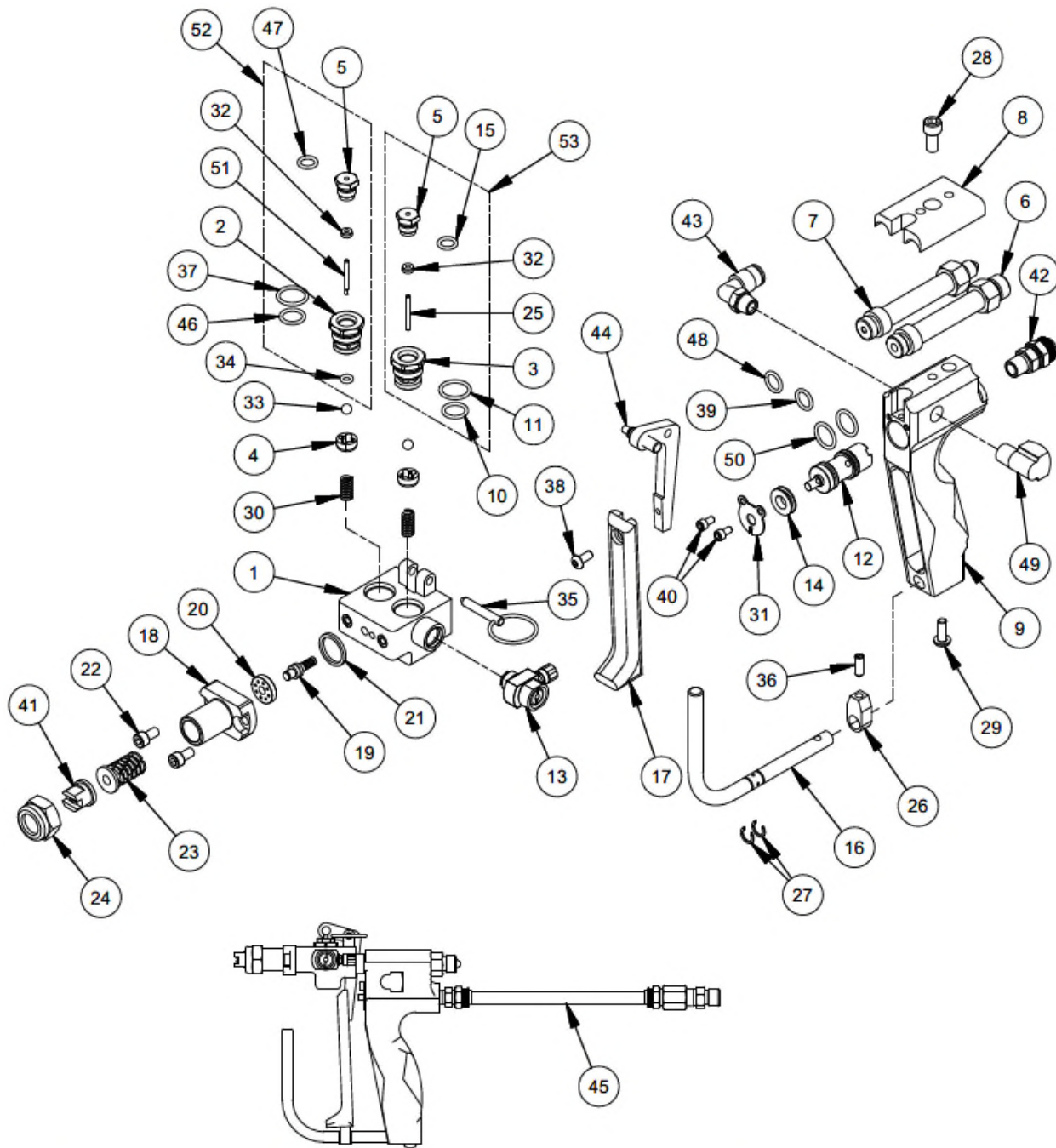
General Problems		
Symptom	Possible Cause	Remedy
Air leaking around air valve		Check inside handle for scratches or damage, replace parts as needed to avoid future damage to O-rings
Air constantly leaking around 3-way valve shaft	Faulty 3-way valve	Replace valve
Air constantly leaking from exhaust port		
Material leaking around mix chamber	Loose mix housing	Tighten cap screws holding mix housing in place
	Damaged mix housing seal or gun block	Replace mix housing seal
		Check gun block for scratches or damage and replace parts as needed

## Parts Drawings

The following drawings are included in this manual for your reference:

Parts Drawings	
Part Number	Description
TLN2-IC-100	Talon Internal Mix Chop Gun Assembly
TLN2-IC-200	Talon Internal Mix Chop Gun Assembly
TLN2-IFC-100	Talon Internal Mix Filled Chop Gun Assembly
TLN2-IFC-200	Talon Internal Mix Filled Chop Gun Assembly
TLN2-IG-100	Talon Internal Mix Gel Gun Assembly
TLN2-IG-200	Talon Internal Mix Gel Gun Assembly
TLN2-IW-100	Talon Internal Mix Wetout Gun Assembly
TLN2-IW-200	Talon Internal Mix Wetout Gun Assembly
TLN-FV-1000	Talon Flush Valve
TLN-IC-F-SK-INT	Seal Kit – FIT Gun Assemblies
TLN-IC-SK-INT	Seal Kit - International
TLN-I-CTR-C	Catalyst Cartridge Assembly
TLN-I-CTR-FM	Filled Material Cartridge Assembly
TLN-I-CTR-M	Material Cartridge Assembly
5104-03-01	Catalyst Injector Assembly





# MAGNUM VENUS PLASTECH

TALON INTERNAL MIX CHOP GUN

TLN2-IC-100

REV:-

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10/14/2019

Parts List				REPAIR KIT	
ITEM	PART NUMBER	QTY	DESCRIPTION	* TLN-IC-SK-INT (KIT INCLUDES ITEMS IN SUBASSEMBLIES)	
1	TLN-1001-01	1	GUN BLOCK		
2	TLN-1024	1	CATALYST VALVE BODY		
3	TLN-1008-01	1	RESIN VALVE BODY		
4	TLN-1007	2	BALL GUIDE		
5	TLN-2021	2	ROD SEAL HOUSING		
6	TLN-1005	1	RESIN FITTING		
7	TLN-1006	1	CATALYST FITTING		
8	TLN-1002	1	TOP PLATE		
9	TLN-1003	1	GUN HANDLE		
* 10	O-E-013	1	O-RING		
* 11	O-E-015	1	O-RING		
12	TLN-1033	1	3 WAY VALVE		
13	TLN-FV-1000-INT	1	FLUSH VALVE ASSEMBLY		
14	TLN-1044	1	EXHAUST RING		
* 15	O-E-011	1	O-RING		
16	TLN-1009	1	TRIGGER GUARD		
17	TLN-2025	1	TRIGGER		
18	5104-20-1	1	MIX HOUSING		
19	5104-03-01	1	INJECTOR ASSY		
20	5104-17-1	1	DISTRIBUTION RING		
* 21	5104-12-1	1	MIX HOUSING SEAL		
22	F-CS-1024-06	2	CAP SCREW		
* 23	5107-27-3	1	TURBULENT MIXER		
24	8704-4-1	1	NOZZLE CAP		
25	TLN-1036	1	PUSH ROD		
26	TLN-1028	1	TRIGGER STOP		
27	TLN-1031	2	RETAINING RING		
28	F-CS-04C-08	1	CAP SCREW		
29	F-BHCS-1032-08	1	BUTTON HEAD CAP SCREW		
30	TLN-2044	2	SPRING		
31	TLN-1037	1	VALVE COVER		
* 32	TLN-2029	2	ROD SEAL ASSEMBLY		
33	TLN-2043	2	CERAMIC BALL		
* 34	O-A-007	1	O-RING		
35	F-QP-03-12	1	QUICK RELEASE PIN		
36	LWG-6527	1	SPRING PLUNGER		
* 37	O-S-015	1	O-RING		
38	F-BHCS-832-06	1	BUTTON HEAD CAP SCREW		
* 39	O-E-012	1	O-RING		
40	F-CS-632-04-SS	2	CAP SCREW		
41	FT-552	1	FLAT TIP		
42	7701-6-4	1	POLY FITTING		
43	MPH-2539	1	MALE ELBOW		
44	TLN-1120-01	1	TRIGGER ARM		
45	6506-1-0.5	1	POLY AIR WHIP		
* 46	O-S-013	1	O-RING		
* 47	O-S-011	1	O-RING		
* 48	O-S-012	1	O-RING		
49	PF-SE-02-05T	1	ELBOW		
* 50	O-B-014	2	O-RING		
51	TLN-1041	1	CATALYST PUSH ROD		

## AVAILABLE SEPARATELY

44A	TLN-1220-01	TRIGGER ARM - SYMMETRICAL ACTUATION
52	TLN-I-CTR-C	CATALYST CARTRIDGE ASSEMBLY
53	TLN-I-CTR-M	MATERIAL CARTRIDGE ASSEMBLY

## MAGNUM VENUS PLASTECH

TALON INTERNAL MIX CHOP GUN

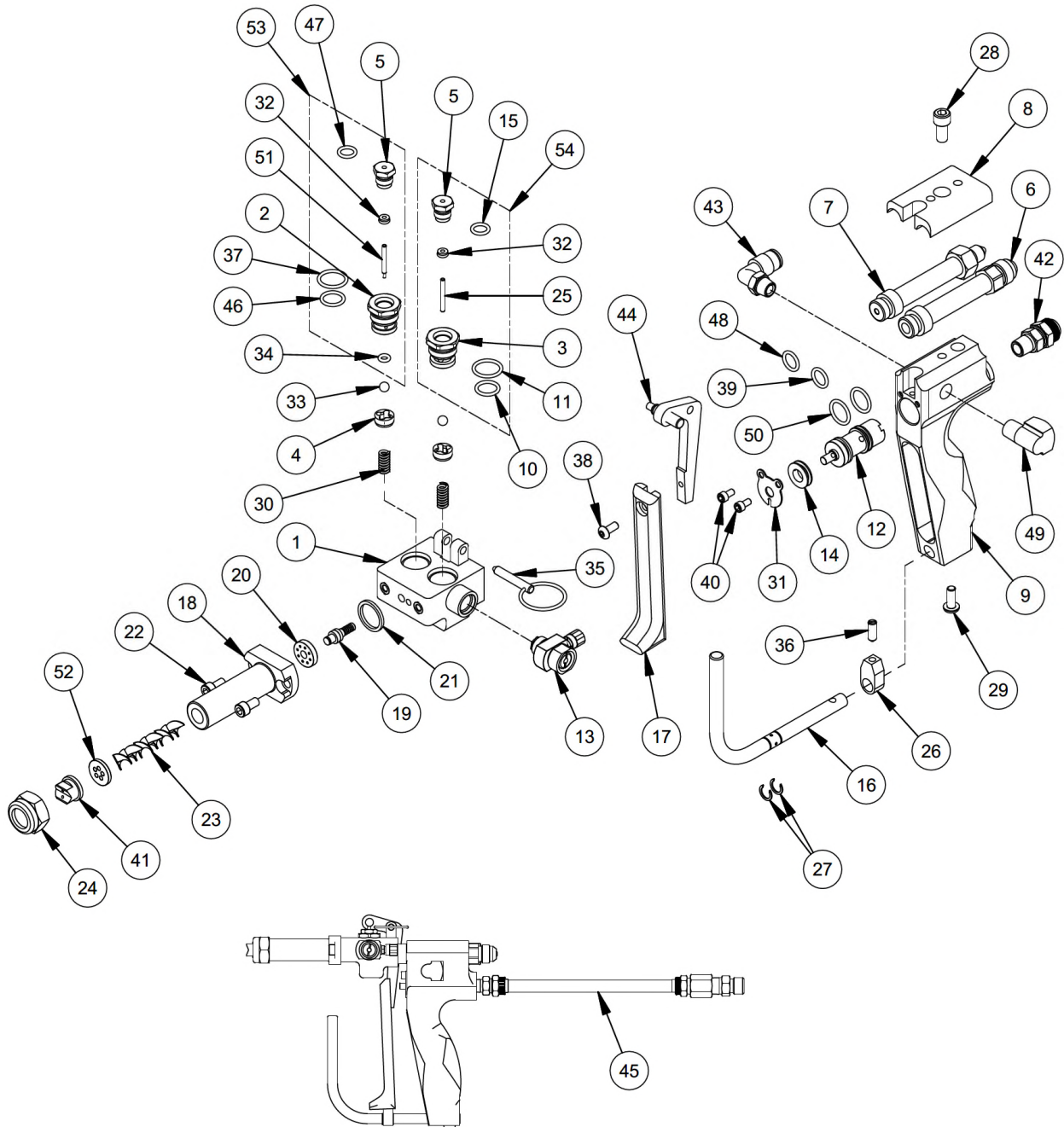
TLN2-IC-100

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# MAGNUM VENUS PLASTECH

TALON INTERNAL MIX CHOP GUN

TLN2-IC-200

REV:-

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Parts List				REPAIR KIT	
ITEM	PART NUMBER	QTY	DESCRIPTION	* TLN-IC-F-SK-INT (KIT INCLUDES ITEMS IN SUBASSEMBLIES)	
1	TLN-1001-01	1	GUN BLOCK		
2	TLN-1024	1	CATALYST VALVE BODY		
3	TLN-1008-01	1	RESIN VALVE BODY		
4	TLN-1007	2	BALL GUIDE		
5	TLN-2021	2	ROD SEAL HOUSING		
6	TLN-1005-F	1	FIT RESIN FITTING		
7	TLN-1006	1	CATALYST FITTING		
8	TLN-1002	1	TOP PLATE		
9	TLN-1003	1	GUN HANDLE		
* 10	O-E-013	1	O-RING		
* 11	O-E-015	1	O-RING		
12	TLN-1033	1	3 WAY VALVE		
13	TLN-FV-1000-INT	1	FLUSH VALVE ASSEMBLY		
14	TLN-1044	1	EXHAUST RING		
* 15	O-E-011	1	O-RING		
16	TLN-1009	1	TRIGGER GUARD		
17	TLN-2025	1	TRIGGER		
18	VPG-1001	1	MIXER ADAPTER		
19	5104-03-01	1	INJECTOR ASSY		
20	5104-17-1	1	DISTRIBUTION RING		
* 21	5104-12-1	1	MIX HOUSING SEAL		
22	F-CS-1024-06	2	CAP SCREW		
* 23	VPG-1003	1	STATIC MIXER		
24	8704-4-1	1	NOZZLE CAP		
25	TLN-1036	1	PUSH ROD		
26	TLN-1028	1	TRIGGER STOP		
27	TLN-1031	2	RETAINING RING		
28	F-CS-04C-08	1	CAP SCREW		
29	F-BHCS-1032-08	1	BUTTON HEAD CAP SCREW		
30	TLN-2044	2	SPRING		
31	TLN-1037	1	VALVE COVER		
* 32	TLN-2029	2	ROD SEAL ASSEMBLY		
33	TLN-2043	2	CERAMIC BALL		
* 34	O-A-007	1	O-RING		
35	F-QP-03-12	1	QUICK RELEASE PIN		
36	LWG-6527	1	SPRING PLUNGER		
* 37	O-S-015	1	O-RING		
38	F-BHCS-832-06	1	BUTTON HEAD CAP SCREW		
* 39	O-E-012	1	O-RING		
40	F-CS-632-04-SS	2	CAP SCREW		
41	VFIT-6025	1	FIT SPRAY TIP		
42	7701-6-4	1	POLY FITTING		
43	MPH-2539	1	MALE ELBOW		
44	TLN-1120-01	1	TRIGGER ARM		
45	6506-1-0.5	1	POLY AIR WHIP		
* 46	O-S-013	1	O-RING		
* 47	O-S-011	1	O-RING		
* 48	O-S-012	1	O-RING		
49	PF-SE-02-05T	1	ELBOW		
* 50	O-B-014	2	O-RING		
51	TLN-1041	1	CATALYST PUSH ROD		
* 52	VPG-1002	1	DIFFUSER		

## AVAILABLE SEPARATELY

44A	TLN-1220-01	TRIGGER ARM - SYMMETRICAL ACTUATION
53	TLN-I-CTR-C	CATALYST CARTRIDGE ASSEMBLY
54	TLN-I-CTR-M	MATERIAL CARTRIDGE ASSEMBLY

# MAGNUM VENUS PLASTECH

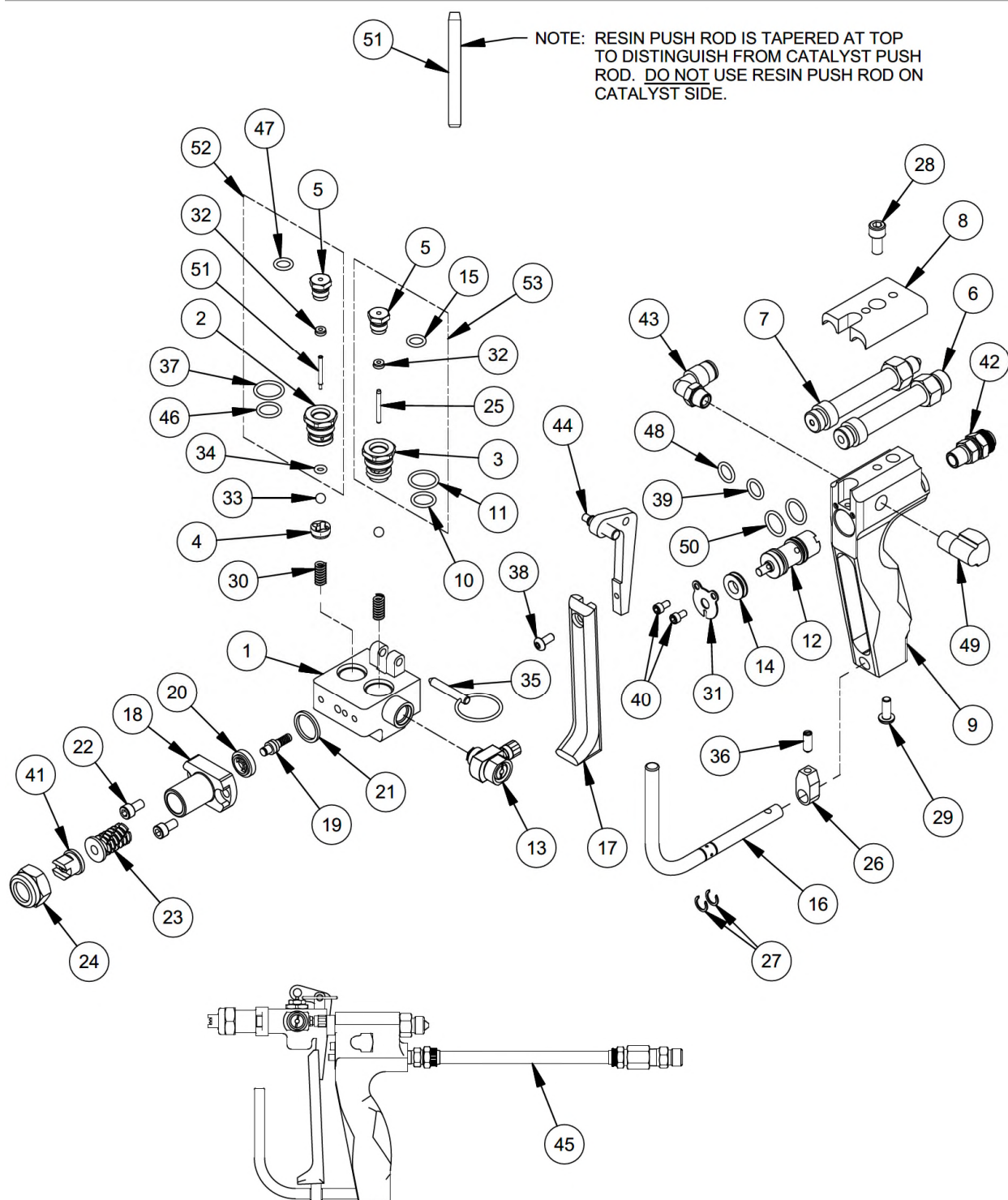
TALON INTERNAL MIX CHOP GUN

TLN2-IC-200

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# MAGNUM VENUS PLASTECH

TALON INTERNAL MIX FILLED RESIN CHOP GUN

TLN2-IFC-100

REV:-

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Parts List			
ITEM	PART NUMBER	QTY	DESCRIPTION
1	TLN-1001-01-SS	1	GUN BLOCK
2	TLN-1024	1	CATALYST VALVE BODY
3	TLN-1008F-01	1	RESIN VALVE BODY
4	TLN-1007	1	BALL GUIDE
5	TLN-2021	2	ROD SEAL HOUSING
6	TLN-1005	1	RESIN FITTING
7	TLN-1006	1	CATALYST FITTING
8	TLN-1002	1	TOP PLATE
9	TLN-1003	1	GUN HANDLE
* 10	O-E-013	1	O-RING
* 11	O-E-015	1	O-RING
12	TLN-1033	1	3 WAY VALVE
13	TLN-FV-1000-INT	1	FLUSH VALVE ASSEMBLY
14	TLN-1044	1	EXHAUST RING
* 15	O-E-011	1	O-RING
16	TLN-1009	1	TRIGGER GUARD
17	TLN-2025	1	TRIGGER
18	5104-20-1	1	MIX HOUSING
19	5104-03-01	1	INJECTOR ASSY
20	5104-18-1	1	FILLED RESIN DISTRIBUTION RING
* 21	5104-12-1	1	MIX HOUSING SEAL
22	F-CS-1024-06	2	CAP SCREW
* 23	5107-27-3	1	TURBULENT MIXER
24	8704-4-1	1	NOZZLE CAP
25	TLN-1036-TC	1	RESIN PUSH ROD
26	TLN-1028	1	TRIGGER STOP
27	TLN-1031	2	RETAINING RING
28	F-CS-04C-08	1	CAP SCREW
29	F-BHCS-1032-08	1	BUTTON HEAD CAP SCREW
30	TLN-2044	2	SPRING
31	TLN-1037	1	VALVE COVER
* 32	TLN-2029	2	ROD SEAL ASSEMBLY
33	TLN-2043	2	CERAMIC BALL
* 34	O-A-007	1	O-RING
35	F-QP-03-12	1	QUICK RELEASE PIN
36	LWG-6527	1	SPRING PLUNGER
* 37	O-S-015	1	O-RING
38	F-BHCS-832-06	1	BUTTON HEAD CAP SCREW
* 39	O-E-012	1	O-RING
40	F-CS-632-04-SS	2	CAP SCREW
41	FT-552	1	FLAT TIP
42	7701-6-4	1	POLY FITTING
43	MPH-2539	1	MALE ELBOW
44	TLN-1120-01	1	TRIGGER ARM
45	6506-1-0.5	1	POLY AIR WHIP
* 46	O-S-013	1	O-RING
* 47	O-S-011	1	O-RING
* 48	O-S-012	1	O-RING
49	PF-SE-02-05T	1	ELBOW
* 50	O-B-014	2	O-RING
51	TLN-1041	1	CATALYST PUSH ROD

## REPAIR KIT

\* TLN-IC-F-SK-INT (KIT INCLUDES ITEMS IN SUBASSEMBLIES)

## AVAILABLE SEPARATELY

44A TLN-1220-01 TRIGGER ARM - SYMMETRICAL ACTUATION  
 52 TLN-I-CTR-C CATALYST CARTRIDGE ASSEMBLY  
 53 TLN-I-CTR-FM MATERIAL CARTRIDGE ASSEMBLY

# MAGNUM VENUS PLASTECH

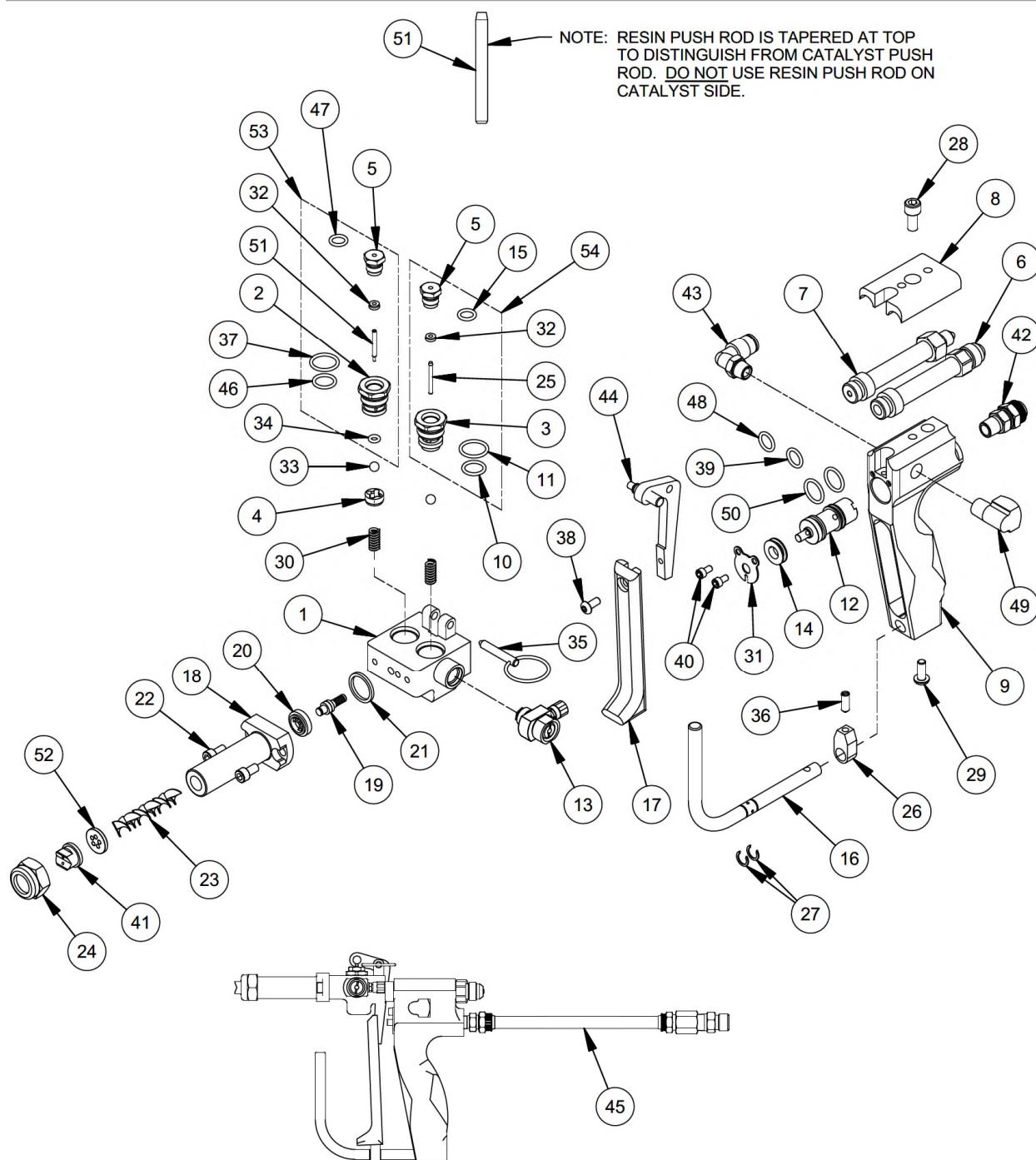
TALON INTERNAL MIX FILLED RESIN CHOP GUN

TLN2-IFC-100

REV:-

SHEET 2 / 2

10/17/2019



# MAGNUM VENUS PLASTECH

TALON INTERNAL MIX FILLED RESIN CHOP GUN

TLN2-IFC-200

REV:-

SHEET 1 / 2

10/17/2019

Parts List			
ITEM	PART NUMBER	QTY	DESCRIPTION
1	TLN-1001-01-SS	1	GUN BLOCK
2	TLN-1024	1	CATALYST VALVE BODY
3	TLN-1008F-01	1	RESIN VALVE BODY
4	TLN-1007	1	BALL GUIDE
5	TLN-2021	2	ROD SEAL HOUSING
6	TLN-1005-F	1	FIT RESIN FITTING
7	TLN-1006	1	CATALYST FITTING
8	TLN-1002	1	TOP PLATE
9	TLN-1003	1	GUN HANDLE
* 10	O-E-013	1	O-RING
* 11	O-E-015	1	O-RING
12	TLN-1033	1	3 WAY VALVE
13	TLN-FV-1000-INT	1	FLUSH VALVE ASSEMBLY
14	TLN-1044	1	EXHAUST RING
* 15	O-E-011	1	O-RING
16	TLN-1009	1	TRIGGER GUARD
17	TLN-2025	1	TRIGGER
18	VPG-1001	1	MIXER ADAPTER
19	5104-03-01	1	INJECTOR ASSY
20	5104-18-1	1	FILLED RESIN DISTRIBUTION RING
* 21	5104-12-1	1	MIX HOUSING SEAL
22	F-CS-1024-06	2	CAP SCREW
* 23	VPG-1003	1	STATIC MIXER
24	8704-4-1	1	NOZZLE CAP
25	TLN-1036-TC	1	RESIN PUSH ROD
26	TLN-1028	1	TRIGGER STOP
27	TLN-1031	2	RETAINING RING
28	F-CS-04C-08	1	CAP SCREW
29	F-BHCS-1032-08	1	BUTTON HEAD CAP SCREW
30	TLN-2044	2	SPRING
31	TLN-1037	1	VALVE COVER
* 32	TLN-2029	2	ROD SEAL ASSEMBLY
33	TLN-2043	2	CERAMIC BALL
* 34	O-A-007	1	O-RING
35	F-QP-03-12	1	QUICK RELEASE PIN
36	LWG-6527	1	SPRING PLUNGER
* 37	O-S-015	1	O-RING
38	F-BHCS-832-06	1	BUTTON HEAD CAP SCREW
* 39	O-E-012	1	O-RING
40	F-CS-632-04-SS	2	CAP SCREW
41	VFIT-6025	1	FIT SPRAY TIP
42	7701-6-4	1	POLY FITTING
43	MPH-2539	1	MALE ELBOW
44	TLN-1120-01	1	TRIGGER ARM
45	6506-1-0.5	1	POLY AIR WHIP
* 46	O-S-013	1	O-RING
* 47	O-S-011	1	O-RING
* 48	O-S-012	1	O-RING
49	PF-SE-02-05T	1	ELBOW
* 50	O-B-014	2	O-RING
51	TLN-1041	1	CATALYST PUSH ROD
* 52	VPG-1002	1	DIFFUSER

## REPAIR KIT

\* TLN-IC-F-SK-INT (KIT INCLUDES ITEMS IN SUBASSEMBLIES)

## AVAILABLE SEPARATELY

44A TLN-1220-01 TRIGGER ARM - SYMMETRICAL ACTUATION  
 53 TLN-I-CTR-C CATALYST CARTRIDGE ASSEMBLY  
 54 TLN-I-CTR-FM MATERIAL CARTRIDGE ASSEMBLY

# MAGNUM VENUS PLASTECH

TALON INTERNAL MIX FILLED RESIN CHOP GUN

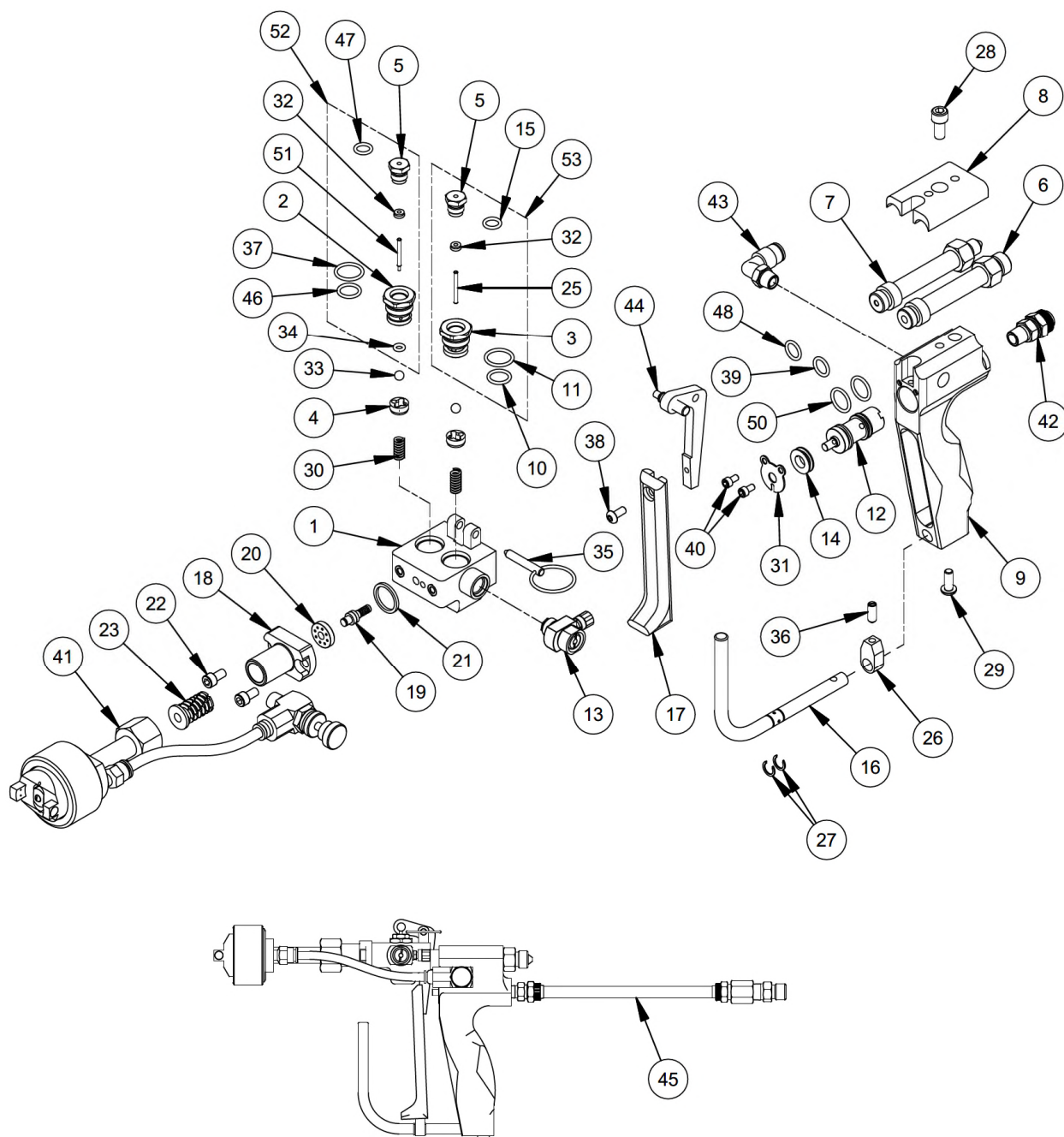
TLN2-IFC-200

REV:-

SHEET 2 / 2

10/17/2019





# MAGNUM VENUS PLASTECH

TALON INTERNAL MIX GELCOAT GUN

TLN2-IG-100

REV:-

SHEET 1 / 2

10/14/2019

Parts List				REPAIR KIT	
ITEM	PART NUMBER	QTY	DESCRIPTION	* TLN-IG-SK-INT (KIT INCLUDES ITEMS IN SUBASSEMBLIES)	
1	TLN-1001-01	1	GUN BLOCK		
2	TLN-1024	1	CATALYST VALVE BODY		
3	TLN-1008-01	1	RESIN VALVE BODY		
4	TLN-1007	2	BALL GUIDE		
5	TLN-2021	2	ROD SEAL HOUSING		
6	TLN-1005	1	RESIN FITTING		
7	TLN-1006	1	CATALYST FITTING		
8	TLN-1002	1	TOP PLATE		
9	TLN-1003	1	GUN HANDLE		
* 10	O-E-013	1	O-RING		
* 11	O-E-015	1	O-RING		
12	TLN-1033	1	3 WAY VALVE		
13	TLN-FV-1000-INT	1	FLUSH VALVE ASSEMBLY		
14	TLN-1044	1	EXHAUST RING		
* 15	O-E-011	1	O-RING		
16	TLN-1009	1	TRIGGER GUARD		
17	TLN-2025	1	TRIGGER		
18	5104-20-1	1	MIX HOUSING		
19	5104-03-01	1	INJECTOR ASSY		
20	5104-17-1	1	DISTRIBUTION RING		
* 21	5104-12-1	1	MIX HOUSING SEAL		
22	F-CS-1024-06	2	CAP SCREW		
* 23	5107-27-2	1	TURBULENT MIXER		
25	TLN-1036	1	PUSH ROD		
26	TLN-1028	1	TRIGGER STOP		
27	TLN-1031	2	RETAINING RING		
28	F-CS-04C-08	1	CAP SCREW		
29	F-BHCS-1032-08	1	BUTTON HEAD CAP SCREW		
30	TLN-2044	2	SPRING		
31	TLN-1037	1	VALVE COVER		
* 32	TLN-2029	2	ROD SEAL ASSEMBLY		
33	TLN-2043	2	CERAMIC BALL		
* 34	O-A-007	1	O-RING		
35	F-QP-03-12	1	QUICK RELEASE PIN		
36	LWG-6527	1	SPRING PLUNGER		
* 37	O-S-015	1	O-RING		
38	F-BHCS-832-06	1	BUTTON HEAD CAP SCREW		
* 39	O-E-012	1	O-RING		
40	F-CS-632-04-SS	2	CAP SCREW		
41	VPA-1000	1	AIR ASSIST ASSEMBLY		
42	7701-6-4	1	POLY FITTING		
43	MPH-2539	1	MALE ELBOW		
44	TLN-1120-01	1	TRIGGER ARM		
45	6506-1-0.5	1	POLY AIR WHIP		
* 46	O-S-013	1	O-RING		
* 47	O-S-011	1	O-RING		
* 48	O-S-012	1	O-RING		
* 50	O-B-014	2	O-RING		
51	TLN-1041	1	CATALYST PUSH ROD		

## AVAILABLE SEPARATELY

44A	TLN-1220-01	TRIGGER ARM - SYMMETRICAL ACTUATION
52	TLN-I-CTR-C	CATALYST CARTRIDGE ASSEMBLY
53	TLN-I-CTR-M	MATERIAL CARTRIDGE ASSEMBLY

## MAGNUM VENUS PLASTECH

TALON INTERNAL MIX GELCOAT GUN

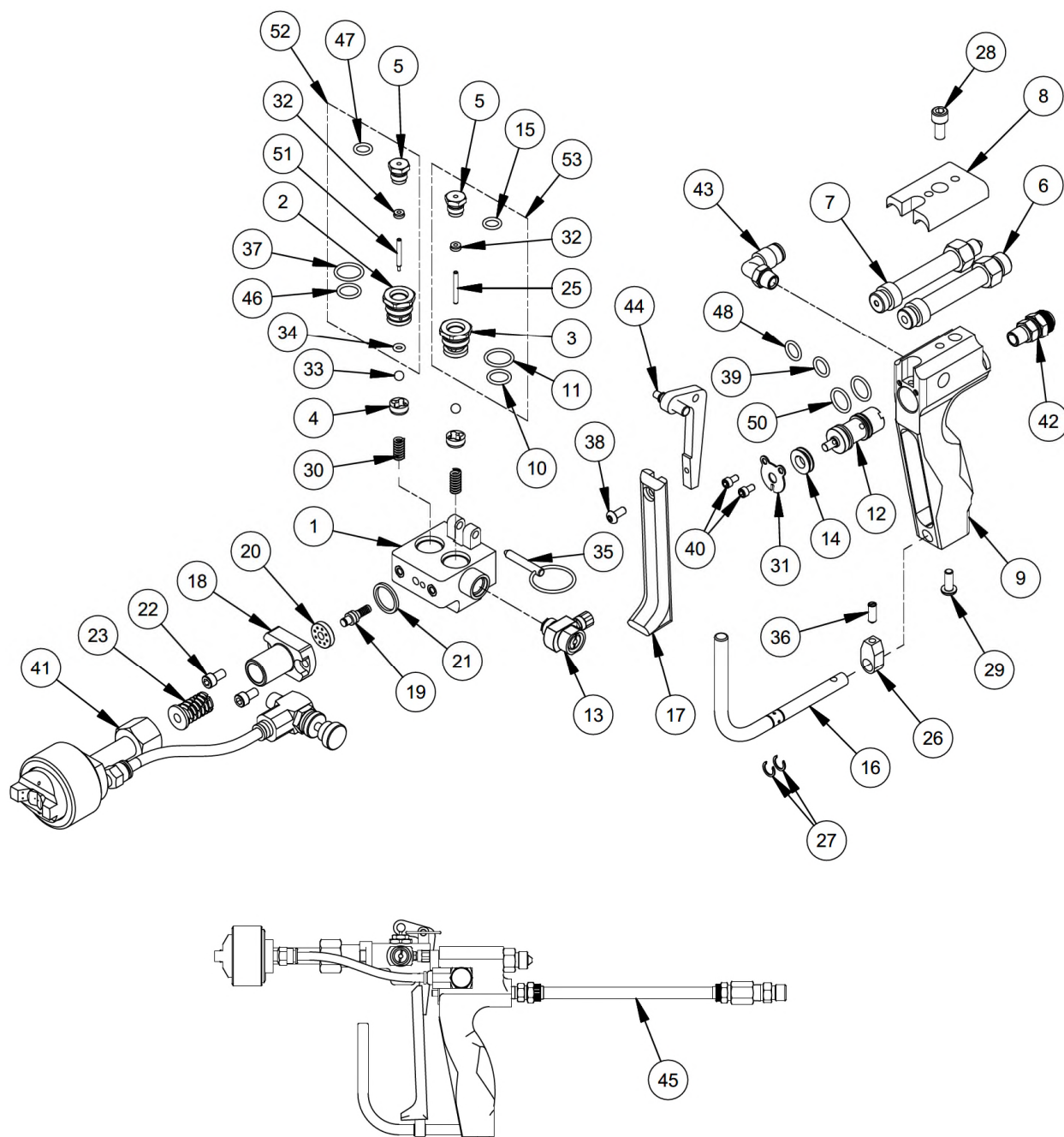
TLN2-IG-100

REV:-

SHEET 2 / 2

10/14/2019





# MAGNUM VENUS PLASTECH

TALON INTERNAL MIX GELCOAT GUN

TLN2-IG-200

REV:-

SHEET 1 / 2

10/14/2019

Parts List				REPAIR KIT	
ITEM	PART NUMBER	QTY	DESCRIPTION	* TLN-IG-SK-INT (KIT INCLUDES ITEMS IN SUBASSEMBLIES)	
1	TLN-1001-01	1	GUN BLOCK		
2	TLN-1024	1	CATALYST VALVE BODY		
3	TLN-1008-01	1	RESIN VALVE BODY		
4	TLN-1007	2	BALL GUIDE		
5	TLN-2021	2	ROD SEAL HOUSING		
6	TLN-1005	1	RESIN FITTING		
7	TLN-1006	1	CATALYST FITTING		
8	TLN-1002	1	TOP PLATE		
9	TLN-1003	1	GUN HANDLE		
* 10	O-E-013	1	O-RING		
* 11	O-E-015	1	O-RING		
12	TLN-1033	1	3 WAY VALVE		
13	TLN-FV-1000-INT	1	FLUSH VALVE ASSEMBLY		
14	TLN-1044	1	EXHAUST RING		
* 15	O-E-011	1	O-RING		
16	TLN-1009	1	TRIGGER GUARD		
17	TLN-2025	1	TRIGGER		
18	5104-20-1	1	MIX HOUSING		
19	5104-03-01	1	INJECTOR ASSY		
20	5104-17-1	1	DISTRIBUTION RING		
* 21	5104-12-1	1	MIX HOUSING SEAL		
22	F-CS-1024-06	2	CAP SCREW		
* 23	5107-27-2	1	TURBULENT MIXER		
25	TLN-1036	1	PUSH ROD		
26	TLN-1028	1	TRIGGER STOP		
27	TLN-1031	2	RETAINING RING		
28	F-CS-04C-08	1	CAP SCREW		
29	F-BHCS-1032-08	1	BUTTON HEAD CAP SCREW		
30	TLN-2044	2	SPRING		
31	TLN-1037	1	VALVE COVER		
* 32	TLN-2029	2	ROD SEAL ASSEMBLY		
33	TLN-2043	2	CERAMIC BALL		
* 34	O-A-007	1	O-RING		
35	F-QP-03-12	1	QUICK RELEASE PIN		
36	LWG-6527	1	SPRING PLUNGER		
* 37	O-S-015	1	O-RING		
38	F-BHCS-832-06	1	BUTTON HEAD CAP SCREW		
* 39	O-E-012	1	O-RING		
40	F-CS-632-04-SS	2	CAP SCREW		
41	VPA-1000-VFIT	1	AIR ASSIST ASSEMBLY		
42	7701-6-4	1	POLY FITTING		
43	MPH-2539	1	MALE ELBOW		
44	TLN-1120-01	1	TRIGGER ARM		
45	6506-1-0.5	1	POLY AIR WHIP		
* 46	O-S-013	1	O-RING		
* 47	O-S-011	1	O-RING		
* 48	O-S-012	1	O-RING		
* 50	O-B-014	2	O-RING		
51	TLN-1041	1	CATALYST PUSH ROD		

## AVAILABLE SEPARATELY

44A	TLN-1220-01	TRIGGER ARM - SYMMETRICAL ACTUATION
52	TLN-I-CTR-C	CATALYST CARTRIDGE ASSEMBLY
53	TLN-I-CTR-M	MATERIAL CARTRIDGE ASSEMBLY

## MAGNUM VENUS PLASTECH

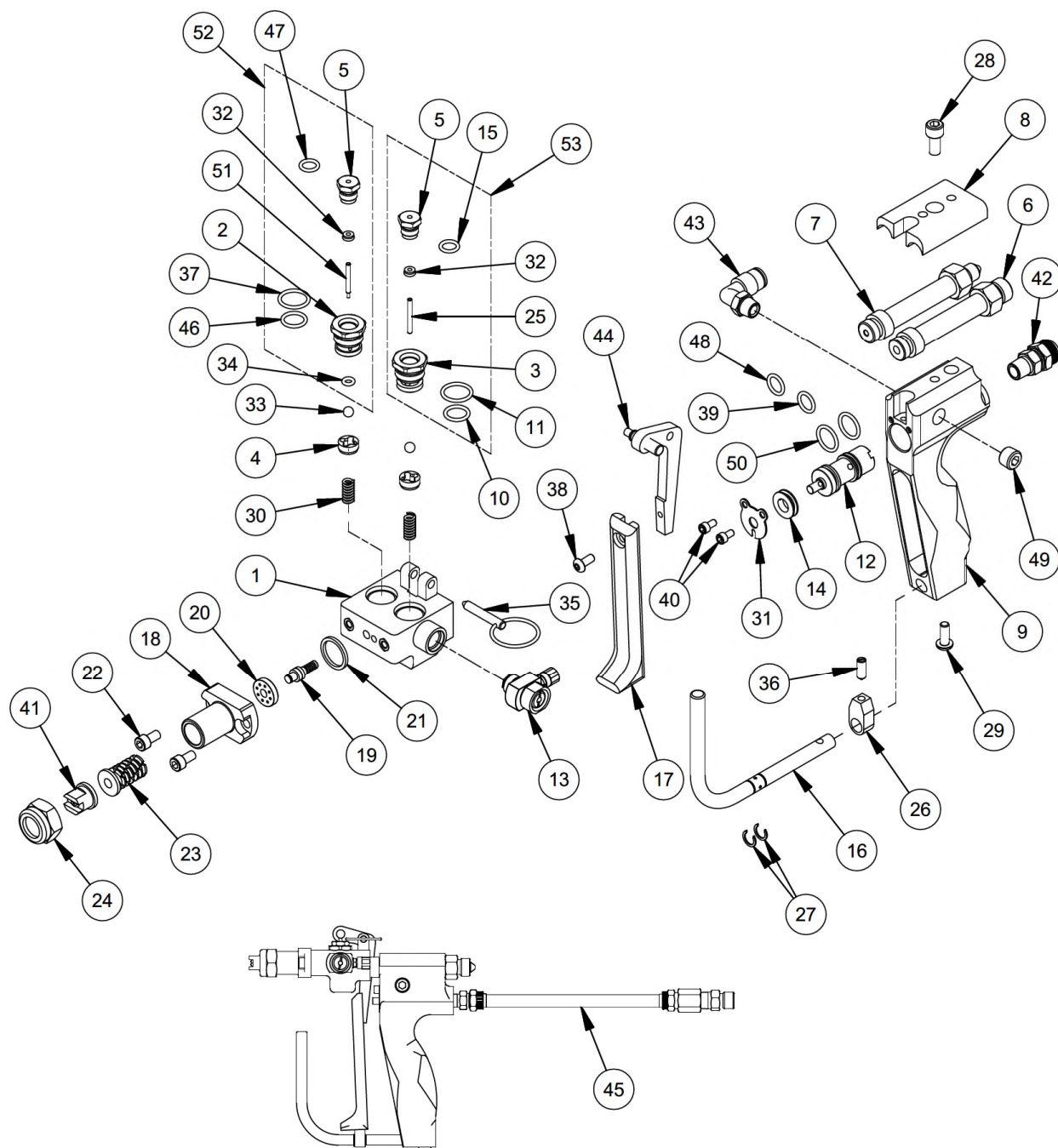
TALON INTERNAL MIX GELCOAT GUN

TLN2-IG-200

REV:-

SHEET 2 / 2

10/14/2019



# MAGNUM VENUS PLASTECH

TALON INTERNAL MIX CHOP GUN

TLN2-IW-100

REV:-

SHEET 1 / 2

10/14/2019



Parts List				REPAIR KIT	
ITEM	PART NUMBER	QTY	DESCRIPTION	* TLN-IC-SK-INT (KIT INCLUDES ITEMS IN SUBASSEMBLIES)	
1	TLN-1001-01	1	GUN BLOCK		
2	TLN-1024	1	CATALYST VALVE BODY		
3	TLN-1008-01	1	RESIN VALVE BODY		
4	TLN-1007	2	BALL GUIDE		
5	TLN-2021	2	ROD SEAL HOUSING		
6	TLN-1005	1	RESIN FITTING		
7	TLN-1006	1	CATALYST FITTING		
8	TLN-1002	1	TOP PLATE		
9	TLN-1003	1	GUN HANDLE		
* 10	O-E-013	1	O-RING		
* 11	O-E-015	1	O-RING		
12	TLN-1033	1	3 WAY VALVE		
13	TLN-FV-1000-INT	1	FLUSH VALVE ASSEMBLY		
14	TLN-1044	1	EXHAUST RING		
* 15	O-E-011	1	O-RING		
16	TLN-1009	1	TRIGGER GUARD		
17	TLN-2025	1	TRIGGER		
18	5104-20-1	1	MIX HOUSING		
19	5104-03-01	1	INJECTOR ASSY		
20	5104-17-1	1	DISTRIBUTION RING		
* 21	5104-12-1	1	MIX HOUSING SEAL		
22	F-CS-1024-06	2	CAP SCREW		
* 23	5107-27-3	1	TURBULENT MIXER		
24	8704-4-1	1	NOZZLE CAP		
25	TLN-1036	1	PUSH ROD		
26	TLN-1028	1	TRIGGER STOP		
27	TLN-1031	2	RETAINING RING		
28	F-CS-04C-08	1	CAP SCREW		
29	F-BHCS-1032-08	1	BUTTON HEAD CAP SCREW		
30	TLN-2044	2	SPRING		
31	TLN-1037	1	VALVE COVER		
* 32	TLN-2029	2	ROD SEAL ASSEMBLY		
33	TLN-2043	2	CERAMIC BALL		
* 34	O-A-007	1	O-RING		
35	F-QP-03-12	1	QUICK RELEASE PIN		
36	LWG-6527	1	SPRING PLUNGER		
* 37	O-S-015	1	O-RING		
38	F-BHCS-832-06	1	BUTTON HEAD CAP SCREW		
* 39	O-E-012	1	O-RING		
40	F-CS-632-04-SS	2	CAP SCREW		
41	FT-552	1	FLAT TIP		
42	7701-6-4	1	POLY FITTING		
43	MPH-2539	1	MALE ELBOW		
44	TLN-1120-01	1	TRIGGER ARM		
45	6506-1-0.5	1	POLY AIR WHIP		
* 46	O-S-013	1	O-RING		
* 47	O-S-011	1	O-RING		
* 48	O-S-012	1	O-RING		
49	PF-AP-02	1	PIPE PLUG		
* 50	O-B-014	2	O-RING		
51	TLN-1041	1	CATALYST PUSH ROD		

## AVAILABLE SEPARATELY

44A	TLN-1220-01	TRIGGER ARM - SYMMETRICAL ACTUATION
52	TLN-I-CTR-C	CATALYST CARTRIDGE ASSEMBLY
53	TLN-I-CTR-M	MATERIAL CARTRIDGE ASSEMBLY

## MAGNUM VENUS PLASTECH

TALON INTERNAL MIX CHOP GUN

TLN2-IW-100

REV:-

SHEET 2 / 2

10/14/2019

## TLN2-IW-200

10/14/2019

Parts List				REPAIR KIT	
ITEM	PART NUMBER	QTY	DESCRIPTION	* TLN-IC-F-SK-INT (KIT INCLUDES ITEMS IN SUBASSEMBLIES)	
1	TLN-1001-01	1	GUN BLOCK		
2	TLN-1024	1	CATALYST VALVE BODY		
3	TLN-1008-01	1	RESIN VALVE BODY		
4	TLN-1007	2	BALL GUIDE		
5	TLN-2021	2	ROD SEAL HOUSING		
6	TLN-1005-F	1	FIT RESIN FITTING		
7	TLN-1006	1	CATALYST FITTING		
8	TLN-1002	1	TOP PLATE		
9	TLN-1003	1	GUN HANDLE		
* 10	O-E-013	1	O-RING		
* 11	O-E-015	1	O-RING		
12	TLN-1033	1	3 WAY VALVE		
13	TLN-FV-1000-INT	1	FLUSH VALVE ASSEMBLY		
14	TLN-1044	1	EXHAUST RING		
* 15	O-E-011	1	O-RING		
16	TLN-1009	1	TRIGGER GUARD		
17	TLN-2025	1	TRIGGER		
18	VPG-1001	1	MIXER ADAPTER		
19	5104-03-01	1	INJECTOR ASSY		
20	5104-17-1	1	DISTRIBUTION RING		
* 21	5104-12-1	1	MIX HOUSING SEAL		
22	F-CS-1024-06	2	CAP SCREW		
* 23	VPG-1003	1	STATIC MIXER		
24	8704-4-1	1	NOZZLE CAP		
25	TLN-1036	1	PUSH ROD		
26	TLN-1028	1	TRIGGER STOP		
27	TLN-1031	2	RETAINING RING		
28	F-CS-04C-08	1	CAP SCREW		
29	F-BHCS-1032-08	1	BUTTON HEAD CAP SCREW		
30	TLN-2044	2	SPRING		
31	TLN-1037	1	VALVE COVER		
* 32	TLN-2029	2	ROD SEAL ASSEMBLY		
33	TLN-2043	2	CERAMIC BALL		
* 34	O-A-007	1	O-RING		
35	F-QP-03-12	1	QUICK RELEASE PIN		
36	LWG-6527	1	SPRING PLUNGER		
* 37	O-S-015	1	O-RING		
38	F-BHCS-832-06	1	BUTTON HEAD CAP SCREW		
* 39	O-E-012	1	O-RING		
40	F-CS-632-04-SS	2	CAP SCREW		
41	VFIT-6025	1	FIT SPRAY TIP		
42	7701-6-4	1	POLY FITTING		
43	MPH-2539	1	MALE ELBOW		
44	TLN-1120-01	1	TRIGGER ARM		
45	6506-1-0.5	1	POLY AIR WHIP		
* 46	O-S-013	1	O-RING		
* 47	O-S-011	1	O-RING		
* 48	O-S-012	1	O-RING		
49	PF-AP-02	1	PIPE PLUG		
* 50	O-B-014	2	O-RING		
51	TLN-1041	1	CATALYST PUSH ROD		
* 52	VPG-1002	1	DIFFUSER		

## AVAILABLE SEPARATELY

44A	TLN-1220-01	TRIGGER ARM - SYMMETRICAL ACTUATION
53	TLN-I-CTR-C	CATALYST CARTRIDGE ASSEMBLY
54	TLN-I-CTR-M	MATERIAL CARTRIDGE ASSEMBLY

# MAGNUM VENUS PLASTECH

TALON INTERNAL MIX WETOUT GUN

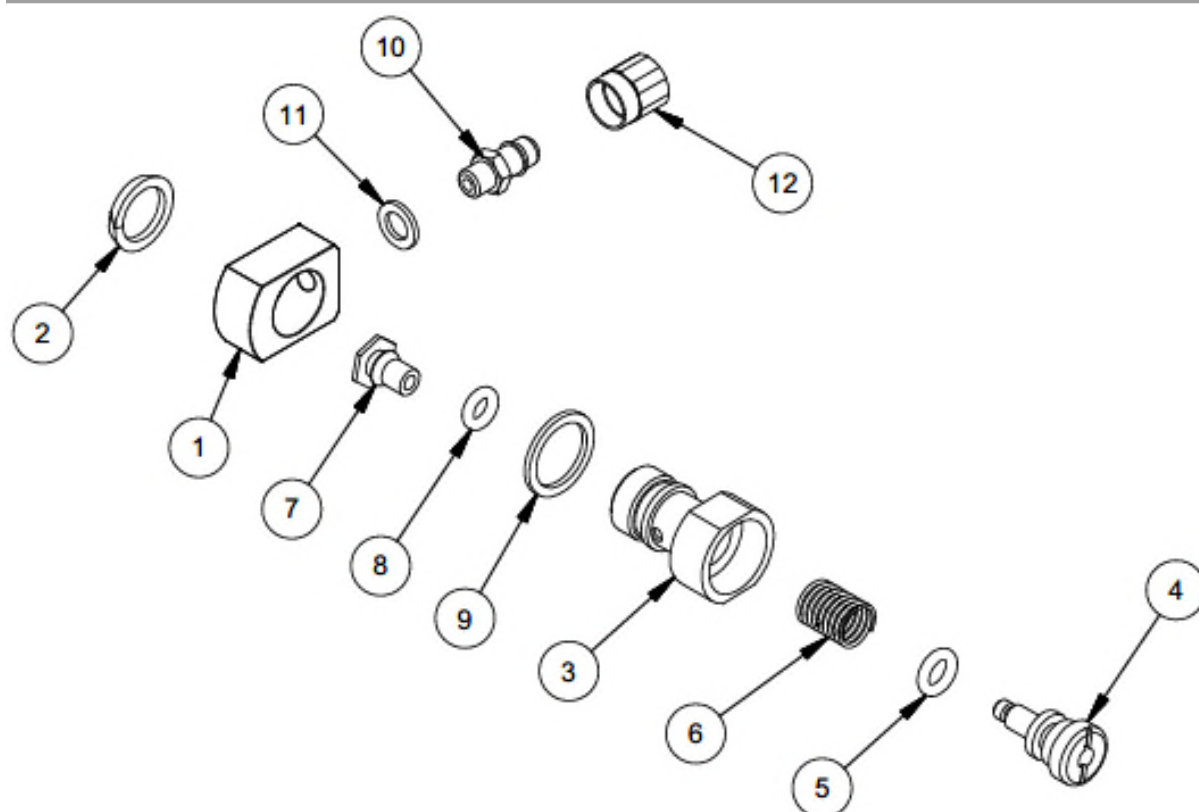
TLN2-IW-200

REV:-

SHEET 2 / 2

10/14/2019





Parts List			
ITEM	PART NUMBER	QTY	DESCRIPTION
1	5104-22-1	1	FLUSH VALVE NECK
2	5104-21-1	1	FLUSH VALVE SPLIT SEAL
3	5104-24-1	1	FLUSH VALVE BODY
4	5104-25-1	1	FLUSH VALVE BUTTON
5	O-E-008	1	O-RING
6	9203-2-3	1	COMPRESSION SPRING
7	5104-23-1	1	FLUSH SEAL BODY
8	O-A-007	1	O-RING
9	5104-26-1	1	FLUSH VALVE SEAL
10	7701-6-3	1	10-32 BARBED FITTING
11	7304-3-1	1	NYLON SEAL
12	7701-2-1	1	HOSE CLAMP - POLY TUBE

## MAGNUM VENUS PLASTECH

FLUSH VALVE





















TLN-FV-1000-INT

REV:













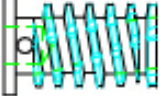






SHEET 1 / 1

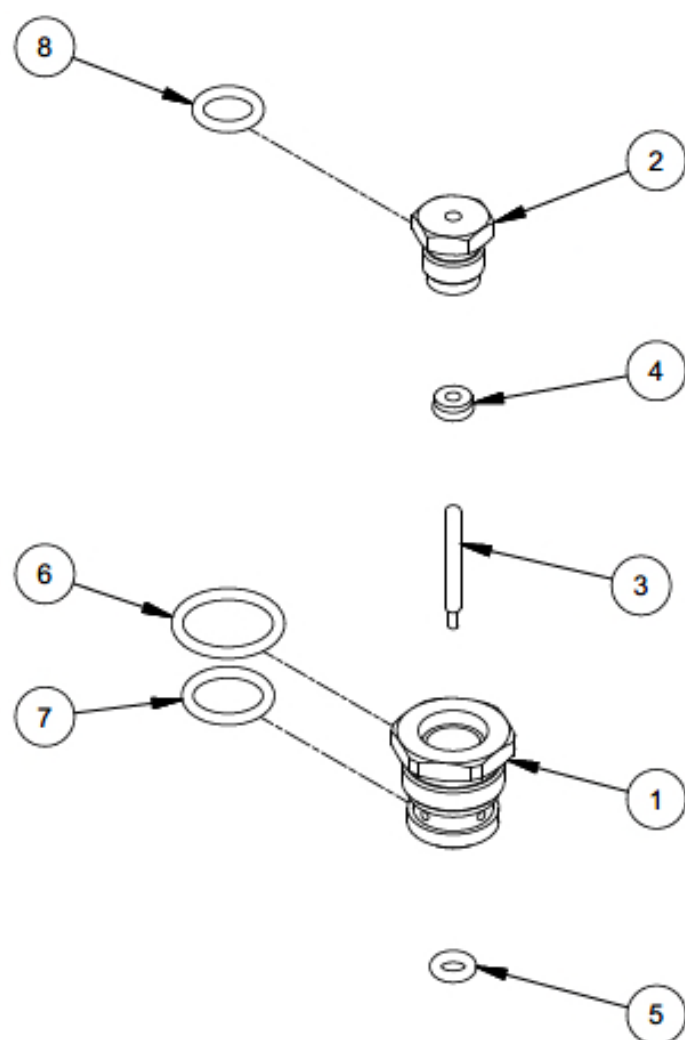
1/25/2013

TLN-IC-F-SK-INT  
SEAL KIT – TALON INTERNAL MIX CHOP – FIT

2 PC		O-A-007 O-RING	1 PCS		7304-3-1 NYLON SEAL
2 PC		O-B-014 O-RING	1 PC		5104-26-1 FLUSH VALVE SEAL
1 PC		O-E-008 O-RING	1 PC		5104-12-1 MIX HOUSING SEAL
1 PC		O-E-011 O-RING	TOP VIEW		2 PCS TLN-2029 SEAL
1 PC		O-E-012 O-RING			
1 PC		O-E-013 O-RING	1 PC		VPG-1003 MIXER ELEMENT
1 PC		O-E-015 O-RING	1 PC		VPG-1002 DIFFUSER
1 PC		O-S-011 O-RING			
1 PC		O-S-012 O-RING			
1 PC		O-S-013 O-RING			
1 PC		O-S-015 O-RING			
1 PC		5104-13-1 INJECTOR SEAL			
1 PC		5104-21-1 SPLIT SEAL			

TLN-IC-SK-INT  
SEAL KIT – TALON INTERNAL MIX CHOP – AIRLESS

2 PCS		O-A-007 O-RING	1 PCS		7304-3-1 NYLON SEAL
2 PC		O-B-014 O-RING	1 PC		5104-26-1 FLUSH VALVE SEAL
1 PC		O-E-008 O-RING	1 PC		5104-12-1 MIX HOUSING SEAL
1 PC		O-E-011 O-RING			
1 PC		O-E-012 O-RING	TOP VIEW		2 PCS
1 PC		O-E-013 O-RING	SIDE VIEW		TLN-2029 SEAL
1 PC		O-E-015 O-RING	1 PC		5107-27-3 TURBULENT MIXER
1 PC		O-S-011 O-RING			
1 PC		O-S-012 O-RING			
1 PC		O-S-013 O-RING			
1 PC		O-S-015 O-RING			
1 PC		5104-13-1 INJECTOR SEAL			
1 PC		5104-21-1 SPLIT SEAL			



## MAGNUM VENUS PLASTECH

CATALYST CARTRIDGE ASSEMBLY

TLN-I-CTR-C

REV: A 06/17/2014

SHEET 1 / 2

3/6/2014

Parts List			
ITEM	PART NUMBER	QTY	DESCRIPTION
1	TLN-1024	1	CATALYST VALVE BODY
2	TLN-2021	1	ROD SEAL HOUSING
3	TLN-1041	1	CATALYST PUSH ROD
4	TLN-2029	1	ROD SEAL ASSEMBLY
5	O-A-007	1	O-RING
6	O-S-015	1	O-RING
7	O-S-013	1	O-RING
8	O-S-011	1	O-RING

## MAGNUM VENUS PLASTECH

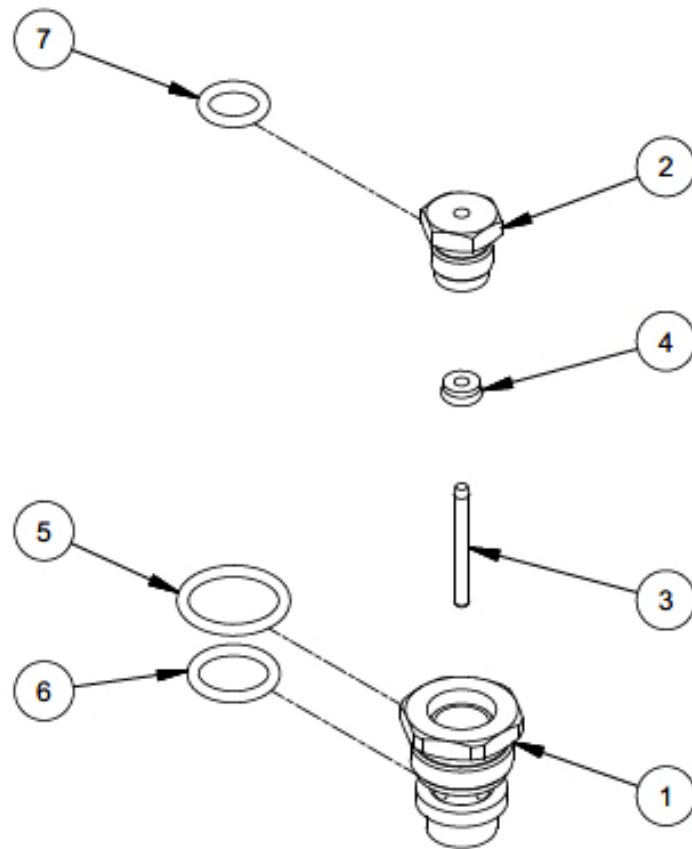
CATALYST CARTRIDGE ASSEMBLY

TLN-I-CTR-C

REV: A 06/17/2014

SHEET 2 / 2

3/6/2014



## MAGNUM VENUS PLASTECH

FILLED MATERIAL CARTRIDGE ASSEMBLY

TLN-I-CTR-FM

REV:

SHEET 1 / 2

3/7/2014



Parts List			
ITEM	PART NUMBER	QTY	DESCRIPTION
1	TLN-1008F-01	1	RESIN VALVE BODY
2	TLN-2021	1	ROD SEAL HOUSING
3	TLN-1036-TC	1	RESIN PUSH ROD
4	TLN-2029	1	ROD SEAL ASSEMBLY
5	O-E-015	1	O-RING
6	O-E-013	1	O-RING
7	O-E-011	1	O-RING

## MAGNUM VENUS PLASTECH

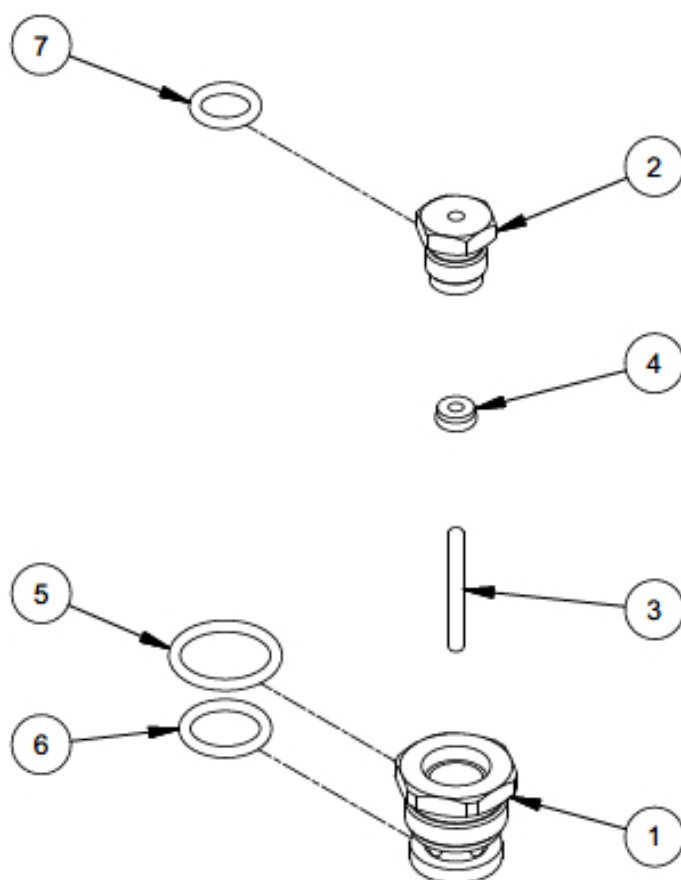
FILLED MATERIAL CARTRIDGE ASSEMBLY

TLN-I-CTR-FM

REV:

SHEET 2 / 2

3/7/2014



## MAGNUM VENUS PLASTECH

MATERIAL CARTRIDGE ASSEMBLY

TLN-I-CTR-M

REV:

SHEET 1 / 2

3/6/2014

Parts List			
ITEM	PART NUMBER	QTY	DESCRIPTION
1	TLN-1008-01	1	RESIN VALVE BODY
2	TLN-2021	1	ROD SEAL HOUSING
3	TLN-1036	1	PUSH ROD
4	TLN-2029	1	ROD SEAL ASSEMBLY
5	O-E-015	1	O-RING
6	O-E-013	1	O-RING
7	O-E-011	1	O-RING

## MAGNUM VENUS PLASTECH

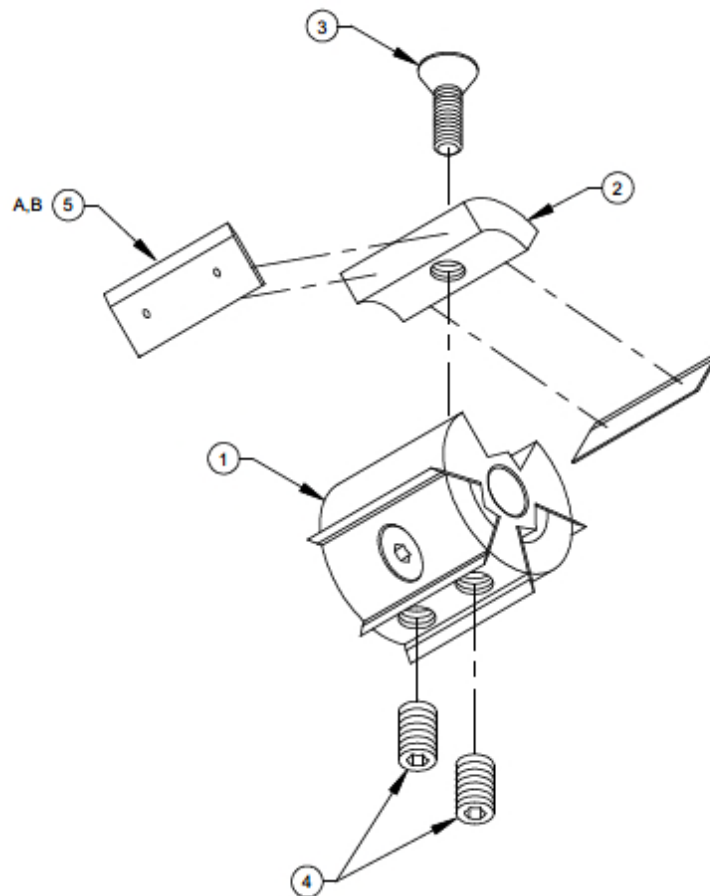
MATERIAL CARTRIDGE ASSEMBLY

TLN-I-CTR-M

REV:

SHEET 2 / 2

3/6/2014



## MAGNUM VENUS PRODUCTS

6-BLADE WEDGE ROTOR ASSY - RC1S1

5103-04-01

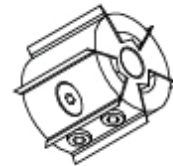
D5103-04-1 REV. - 3/20/00

**6-Blade Wedge Rotor Assy - RC1S1 5103-04-01****PARTS LIST**

ITEM	PART NO.	QTY	DESCRIPTION
1	5103-30-1	1	ROTOR HUB - 6-BLADE
2	5103-31-1	3	WEDGE INSERT - 6-BLADE
3	7102-13-6	3	SOCKET FLAT HEAD SCREW
4	7102-11-6	2	SOCKET CUT POINT SET SCREW
5	5103-8-1	6	CHOPPER BLADE
6	D5103-04-1	1	6-BLADE WEDGE ROTOR ASSY - RC1S1 DWG

**ASSOCIATED PARTS AND ASSEMBLIES**

ITEM	PART NO.	QTY	DESCRIPTION
5A	9210-1-100	1	BLADES (PACKAGE OF 100)
5B	5103-8-1000	1	BLADES (PACKAGE OF 1000)

**FIGURE 1-1**



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