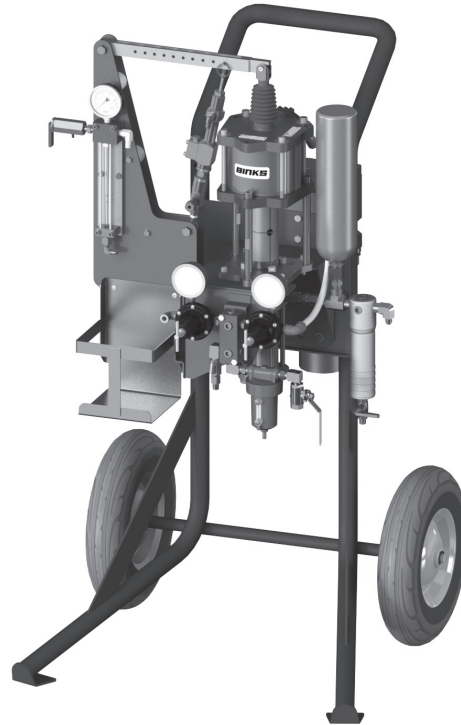




CENTURY™ EXTERNAL MIX GEL COAT SYSTEMS

MODELS: CX2017HC-A000000 AND CX2017HC-B000000

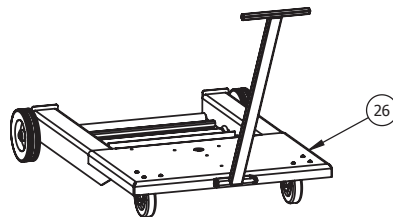
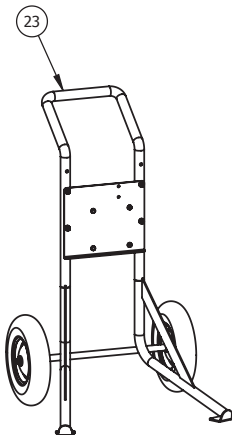
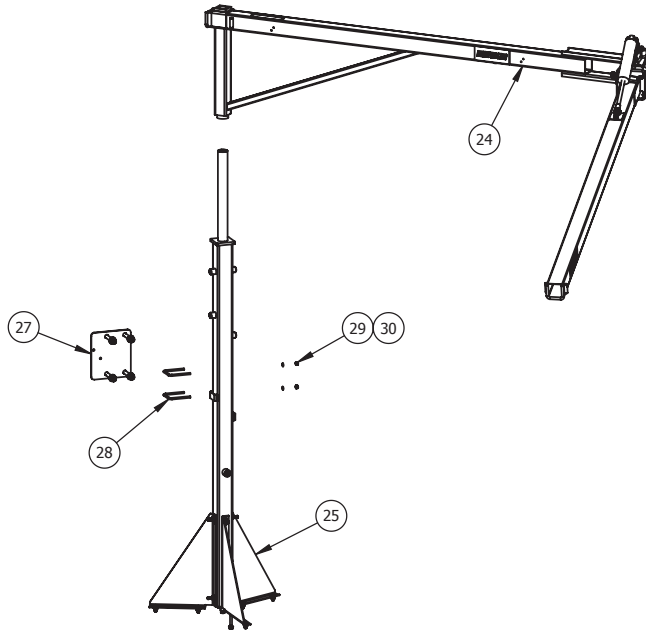
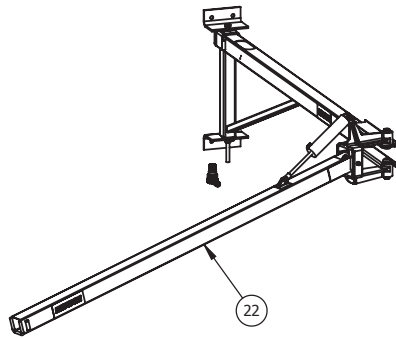
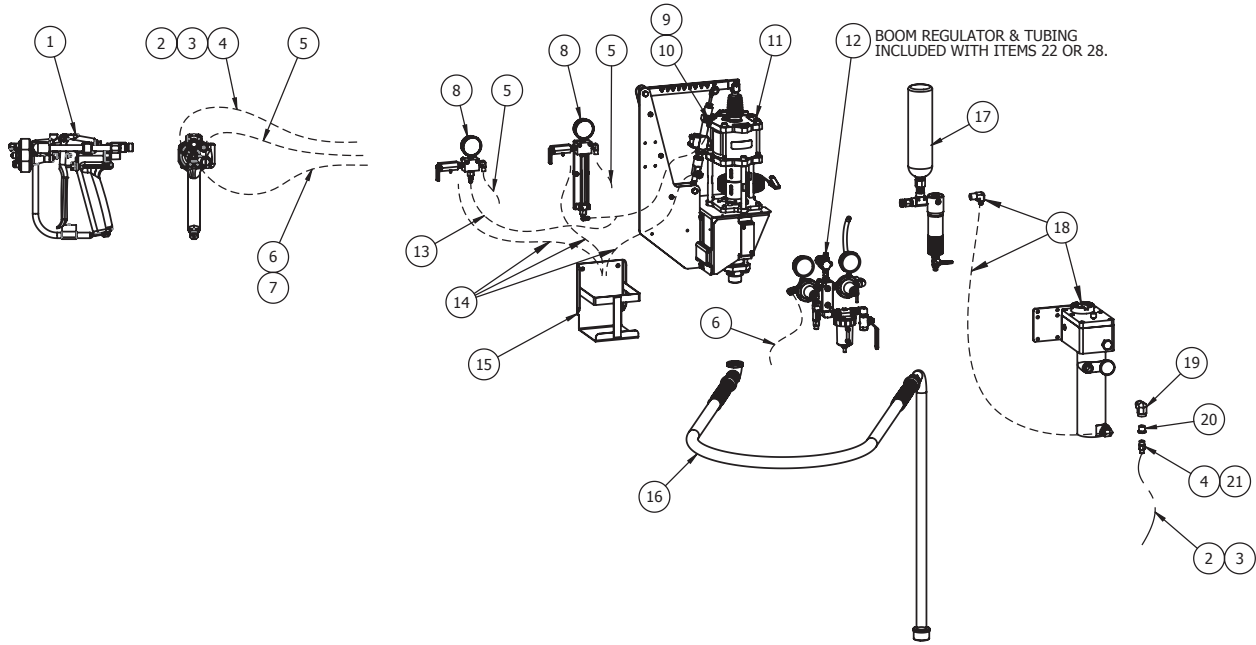


SPECIFICATIONS

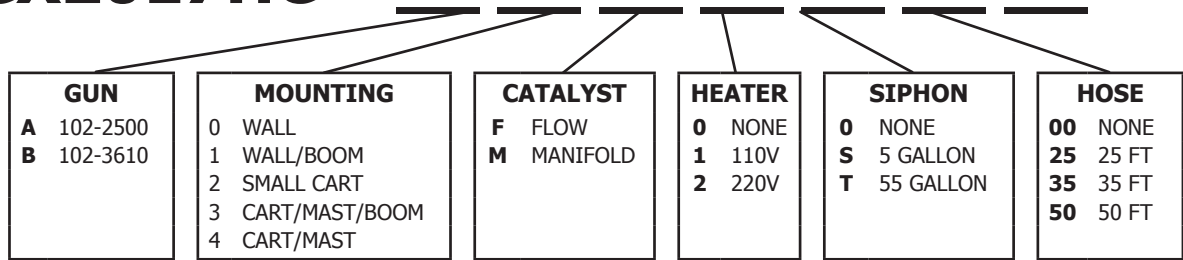
	CX2017HC
Ratio:	17:1
Maximum air inlet pressure:	116 psi (8 bar)
Maximum recommended continuous cycle rate:	20 cycles/min
Air consumption @ 20 cycles/min and 116 psi (8 bar) air inlet pressure:	17.6 SCFM (498 LPM)
Maximum fluid pressure:	1970 psi (136 bar)
Displacement per cycle:	4.3 oz (127 cc)
Output @ 60 cycles/min:	2.0 gal/m (7.6 l/m)
Maximum operating temperature:	160°F (71°C)
Air inlet connection:	3/8" NPT (F)
Piston diameter:	5.5 in (140 mm)
Stroke length:	3 in (75 mm)
Sound level:	97.3 dB
Fluid inlet connection:	1 1/4" NPT (M) & 1" NPT (F)

CENTURY EXTERNAL MIX GEL COAT SYSTEMS

Models: **CX2017HC-A00000**
CX2017HC-B00000

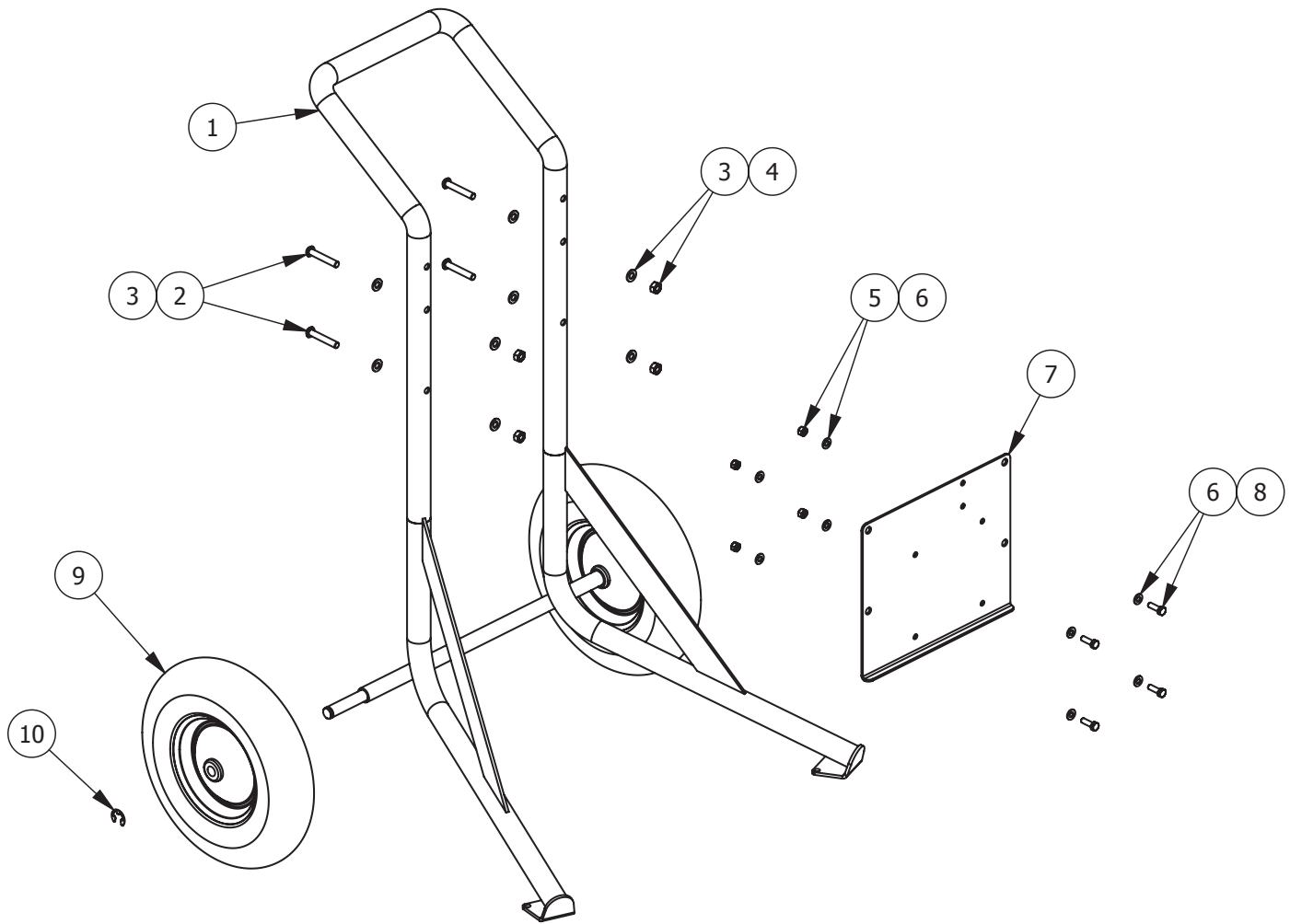


CENTURY EXTERNAL MIX GEL COAT SYSTEMS

CX2017HC –**SYSTEM COMPONENT LIST**

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	PART SHEET
1	102-2500	CENTURY AA EXTERNAL MIX GEL COAT GUN	1 IF GUN = A	77-2520
	102-3610	CENTURY LEL EXTERNAL MIX GEL COAT GUN	1 IF GUN = B	77-2772
2	71-7504	MATERIAL HOSE, 5/16" ID, 25 FT	1 IF HOSE = 25 or 50	
	71-7502	MATERIAL HOSE, 5/16" ID, 10 FT	1 IF HOSE = 35	
3	71-8424	MATERIAL HOSE, 3/8" ID, 25 FT	1 IF HOSE = 35 or 50	
4	83-4233	DM NIPPLE	1 IF HOSE = 25, 35, 50	
5	102-3028	CATALYST HOSE ASSEMBLY, 25 FT	1 IF HOSE = 25	
	102-3029	CATALYST HOSE ASSEMBLY, 35 FT	1 IF HOSE = 35	
	102-3030	CATALYST HOSE ASSEMBLY, 50 FT	1 IF HOSE = 50	
6	54-4989	AIR HOSE ASSEMBLY, 25 FT	1 IF HOSE = 25	
	71-4800	AIR HOSE ASSEMBLY, 35 FT	1 IF HOSE = 35	
	71-4801	AIR HOSE ASSEMBLY, 50 FT	1 IF HOSE = 50	
7	54-4976	TUBE ADAPTER FITTING	1	
8	101-9469-100	LOW PRESSURE MANIFOLD ASSEMBLY	1 IF CATALYST = M	77-2945
	101-9470	FLOW METER ASSEMBLY	1 IF CATALYST = F	
9	107-1646	MALE ELBOW	1	
10	237-908	TUBE CONNECTOR	1	
11	CX2017HC	CX2017HC PUMP ASSEMBLY	1	77-2940
12	103-1900	AIR CONTROL ASSEMBLY	1	77-2944
13	207-12305-9	CATALYST HOSE, 17"	1	
14	207-11972	CATATLST SIPHON/RETURN HOSE ASSEMBLY	1	
15	101-9435-K	CATALYST SUPPLY BOTTLE BRACKET KIT	1	
16	103-1068	55 GAL. SIPHON KIT ASSEMBLY	1 IF SIPHON = T	77-2126
	103-1093	5 GAL. SIPHON KIT ASSEMBLY	1 IF SIPHON = S	
17	207-12259-2	FILTER ASSEMBLY (100 MESH)	1	77-2807
18	207-12351	HEATER KIT (120V)	1 IF HEATER = 1	77-2812
	207-12352	HEATER KIT (220V)	1 IF HEATER = 2	
19	20-3340-1	STREET ELBOW	1 IF HOSE = 25, 35, 50	
20	20-3823-1	BUSHING	1 IF HOSE = 25, 35, 50	
21	72-998	DM NIPPLE	1 IF HOSE = 35 or 50	
22	203-1610	WALL MOUNTED GEL COAT BOOM ASSEMBLY	1 IF MOUNT = 1	77-2311
23	103-1905	CART ASSEMBLY	1 IF MOUNT = 2	
24	203-1607	GEL COAT BOOM ASSEMBLY	1 IF MOUNT = 3	77-2311
25	103-1602	AIR MANIFOLD ASSEMBLY	1 IF MOUNT = 3 or 4	77-2311
26	103-1603	PORTA-CART ASSEMBLY	1 IF MOUNT = 3 or 4	77-2311
27	101-9475	MAST MOUNTING BRACKET KIT	1 IF MOUNT = 3 or 4	
28	207-10619	U-BOLT	2 IF MOUNT = 3 or 4 & HEATER = 1 or 2	
29	20-263-1	FLAT WASHER	4 IF MOUNT = 3 or 4 & HEATER = 1 or 2	
30	20-6042	NYLOK HEX NUT	4 IF MOUNT = 3 or 4 & HEATER = 1 or 2	

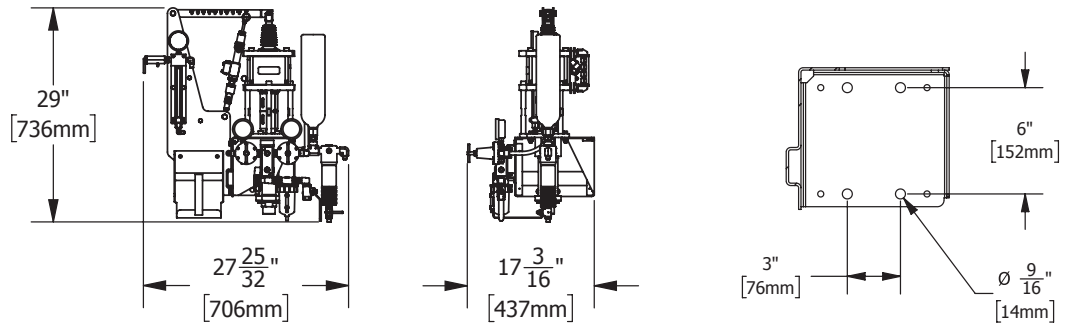
103-1905 CX SMALL CART ASSEMBLY



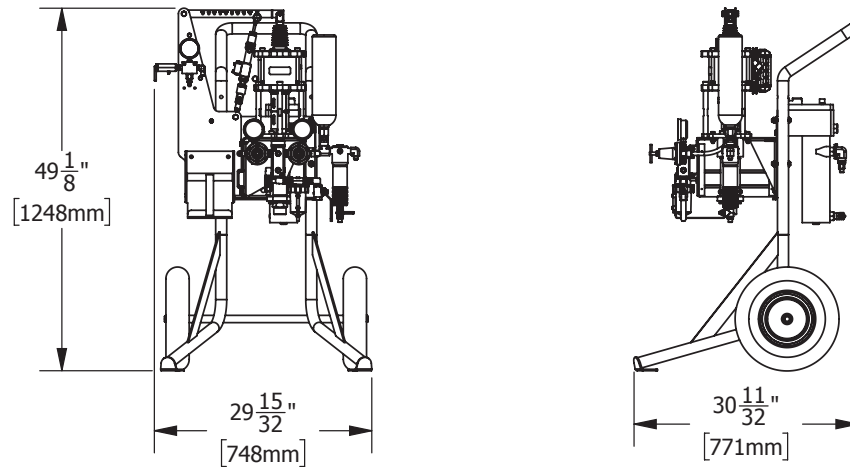
PARTS LIST			
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	193372	BASIC CART FRAME	1
2	177014	SOCKET HEAD BUTTON SCREW (M10 x 60mm)	4
3	165135	FLAT WASHER (10mm)	8
4	163127	HEX NUT (10mm)	4
5	237-205	NYLOK HEX NUT (5/16" - 18)	4
6	20-264-1	FLAT WASHER (5/16")	8
7	41-28279	CX ADAPTER PLATE	1
8	20-376-1	CAP SCREW (5/16" - 18 x 1")	4
9	193380	14" WHEEL	2
10	20-6836	RETAINING RING	2

CENTURY EXTERNAL MIX GEL COAT SYSTEMS

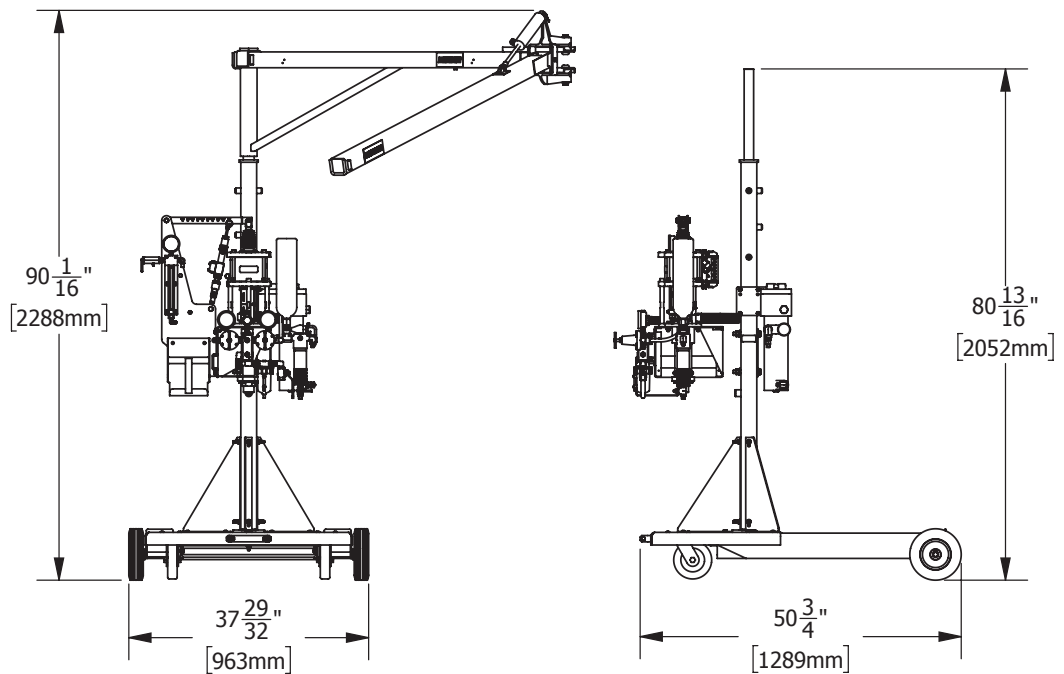
WALL MOUNT DIMENSIONS



SMALL CART DIMENSIONS



CART, MAST, AND BOOM DIMENSIONS



GELCOAT SYSTEM START-UP PROCEDURES FOR CX2017HC-A000000 & CX2017HC-B000000

IT IS IMPORTANT TO READ THROUGH THESE INSTRUCTIONS ENTIRELY AND UNDERSTAND THEM PRIOR TO OPERATING THE EQUIPMENT.

1. Ensure all hose connections are tight, all valves are in the "closed" position, and all regulators are backed off to zero pressure. Attach ground wire to an earth ground.
2. Attach a 1/2" or 3/8" air line, using main line air pressure, to the inlet ball valve of the air control assembly. Make sure the ball valve is in the closed position. Air requirement is 20 CFM minimum.
3. Check catalyst and resin quantities. Ensure enough for one shift of operation.
4. Have a sufficient amount (5 gal) of appropriate solvent (acetone) for clean up and initial flush of pump.
5. Add throat lube to inside of packing nut at top of resin pump. Stop when packing nut is half-full.
6. Disengage catalyst pump from the ratio arm by removing the quick release pin.
7. Insert the catalyst pick up tube and screw cap into a one-gallon catalyst container and tighten the cap.
8. With the air cap, front end o-rings, and nozzle (spray tip) removed from the spray gun, move the trigger lock to the down or "OFF" position, aim the gun into an approved, grounded container and pull the trigger. Touch the gun to the side of the container or connect the gun to an earth ground.
9. Manually pump the catalyst pump to prime the pump, manifold, hose, and gun. Do this until catalyst is flowing freely from the end of the spray gun without "spitting".
10. Release the trigger of the spray gun, engage trigger lock and wipe off any catalyst that may have collected on the gun head.
11. Install the front head o-rings and night cap on the gun. Secure the night cap with the retaining ring.
12. Rest the catalyst pump against the side of the bracket; do NOT re-connect the pump to the ratio arm at this time.
13. Insert the resin pump pick-up tube into a container of acetone or other appropriate solvent.
14. Open the main air ball valve until fully open. During this procedure air will leak from the ball valve bleed hole, this is ok.
15. Release trigger lock and aim the gun into an approved, grounded container, pull the trigger.
16. Slowly turn the pump regulator "T" handle clockwise until the pump starts to run. This may take a bit of adjusting by increasing and decreasing the pump air pressure. The pump will run fast at first but as solvent is pulled into the resin pump it will slow down. Keep the pump running slowly until solvent is flowing freely out of the gun.
17. Release the gun trigger and engage trigger lock then wipe off head of gun.
18. Lift siphon tube out of solvent and let solvent bleed back into container.
19. Close main air inlet ball valve. Back off pump air regulator to zero pressure.
20. Open the relief or drain valve on the fluid filter and drain completely, when finished, close the drain valve.
21. Insert the pick-up tube into container of gel coat.
22. Repeat steps 15 and 16.
23. Release the gun trigger and engage trigger lock.
24. Remove night cap and wipe off head of gun.
25. Install tip:
 - a. For LEL guns: Lube tip o-ring (20-5919) with Devilbiss gun lube or Binks gunners mate. Install tip on o-ring.
 - b. For AA guns: Hold gun vertically (nose up) and place spray tip with installed tip seal on front of head insert.
26. Install air cap:
 - a. For LEL guns: Place the 102-3609 air baffle into the air cap. Place the air cap over the tip making sure the flats and holes in the tip and air cap line up. Screw the retaining ring onto the gun head and align the tip and air cap to the desired position before tightening the ring fully.
 - b. For AA guns: Place the air cap over the tip, aligning the flats on each part. Screw the retaining ring onto the gun head and align the tip and air cap to the desired position before tightening the ring fully.
27. Operate the catalyst pump by hand to put approximately 20 lbs of pressure on the catalyst gauge. Re-connect the catalyst pump to the ratio arm with the quick release pin.
28. Turn the "T" handle on the catalyst shaping air regulator until 25 lbs. is indicated on the air gauge.
29. With the spray gun aimed at an appropriate surface, release the trigger lock, pull the trigger and have someone turn the "T" handle clockwise, on the "PUMP" regulator until the pressure is at 30 lbs.
30. The pressures of 25 lbs on the catalyst shaping air and 30 lbs of pump pressure are starting points and will need to be adjusted for your individual situation. When making adjustments always use 3 to 5 lb increments at a time and check the results. When properly adjusted, spray a sample surface and check for gel time.
31. If the system has a fluid heater, set the thermostat to 90 to 100°F.

GELCOAT SYSTEM SHUT-DOWN PROCEDURES

SHORT-TERM SHUT DOWN:

1. **IMPORTANT: always stop the pump in the "down" position, to prevent resin from drying on the pump rod and to keep it wet with throat lube.**
2. Engage trigger lock on spray gun.
3. Turn off main air valve. The air will bleed out of the pump and manifold.
4. Pull catalyst relief valve knob to bleed catalyst pressure.
5. Open drain ball valve on filter to relieve resin pressure.
6. Remove retaining ring, air cap and tip from the head of the gun, keeping track of the o-rings, do not let the red o-rings soak in acetone; they will swell. Wash gun head in appropriate clean solvent. Lubricate with gun lube or petroleum jelly and reinstall the o-rings. Lubricate the threads on the head of the gun and install the nightcap, reinstall retaining ring and tighten.
7. Clean air cap, baffle and tip in clean solvent, dry and store in clean dry place.
8. Clean gun with clean solvent. Oil all trigger parts, needles and exposed threads.
9. Leave gun hanging with head facing in the down position.

LONGER TERM SHUT DOWN:

1. Engage trigger lock on spray gun.
2. Shut main air valve. Air will bleed out of the pump and manifold. Back off the pump regulator to zero pressure. Back off shaping / atomizing air regulator to zero pressure.
3. Pull catalyst relief valve knob to bleed catalyst pressure.
4. Open drain ball valve on filter to relieve gel coat pressure.
5. Make sure you have enough solvent (acetone) to completely flush the gel coat pump, filter, hose, and gun.
6. Remove pin to disengage catalyst pump from ratio arm.
7. Remove retaining ring, air cap, spray tip, and front end gun o-rings. Wipe front end of gun clean.
8. Remove siphon from gel coat supply. Let drain into supply and wipe clean.
9. Remove catalyst siphon from supply bottle. Trigger gun into grounded waste container and pump catalyst pump by hand to purge catalyst from pump, manifold, hose, and gun. For further cleaning for longer term storage, a soapy-water solution should be pumped through the system to purge it of all catalyst. At this time do not re-connect the catalyst pump to the ratio arm. NEVER pump acetone through the catalyst pump or allow acetone to mix with raw catalyst.
10. Again wipe front end of gun clean. Lubricate front end o-rings and re-install, then install night cap and retaining ring.
11. Trigger gun into grounded waste container.
12. Open main air supply valve. Increase pressure on pump regulator until pump starts to run, drawing air into the pump. Continue to run pump until air pushes most of the gel coat from the system. Control the speed of the pump by varying the air pressure to the motor.
13. Stop pump by backing off the air pressure. Release gun trigger.
14. Place siphon pick-up tube in the container of solvent.
15. Trigger the gun into grounded waste container. Restart pump, drawing solvent into the pump and out through the gun into the waste container. Occasionally open drain ball valve to clean filter bowl with solvent.
16. Optional: When the solvent flowing from the gun is reasonably clear, recirculate solvent through the system by triggering the gun into the solvent supply, if possible. Follow this flush sequence with clean solvent for a final flush.
17. When solvent flowing from gun is clear, stop pump and release gun trigger.
18. **IMPORTANT: always stop the pump in the "down" position, to keep the displacement rod wet with throat lube or solvent.**
19. Completely back off pump regulator to zero pressure. Close main air valve. Open drain ball valve to relieve pressure.
20. Solvent may be left in pump for shutdown period. For longer term storage solvent should be replaced with a mineral oil or other compatible fluid to keep seals and metal parts lubricated and free from moisture.

WARRANTY POLICY

This product is covered by Carlisle Fluid Technologies' materials and workmanship limited warranty. The use of any parts or accessories, from a source other than Carlisle Fluid Technologies, will void all warranties. Failure to reasonably follow any maintenance guidance provided may invalidate any warranty.

For specific warranty information please contact Carlisle Fluid Technologies.

For technical assistance or to locate an authorized distributor, contact one of our international sales and customer support locations.

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