Operations and Parts

Hot Melt Dispense Guns

311209Y

EN

For use with Graco Therm-O-Flow® and Warm Melt Supply Systems for dispensing non-flammable hot melt thermoplastic sealants and adhesives. For professional use only.

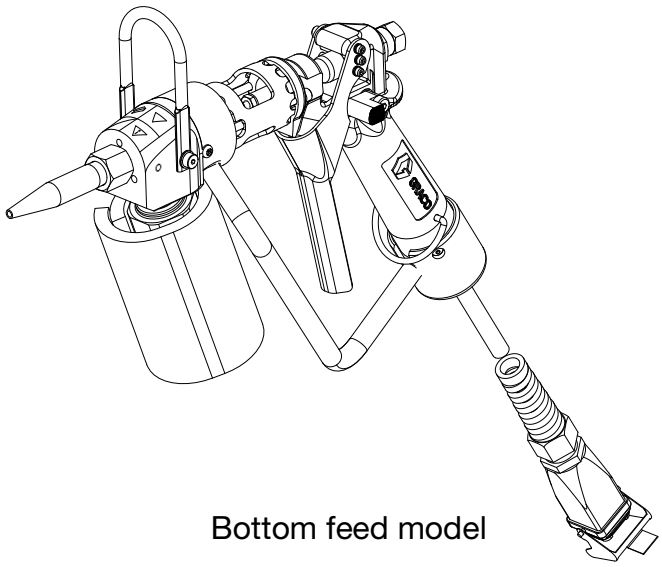
Not approved for use in explosive atmospheres or hazardous (classified) locations.

Maximum Working Pressure 5000 psi (34.5 MPa, 345 bar)

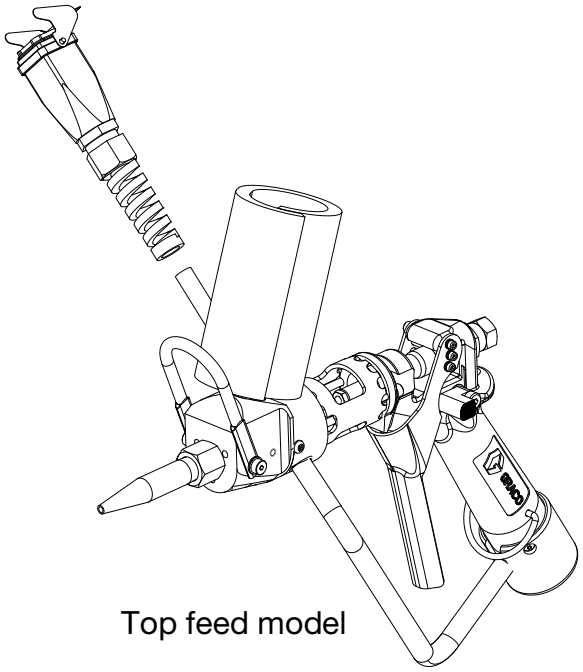
See page 2 for model information.

Important Safety Instructions

Read all warnings and instructions in this manual before using the equipment. Save these instructions.



Bottom feed model



Top feed model

PROVEN QUALITY. LEADING TECHNOLOGY.

Contents

Models

Part	Description
249514, 25R586	Bottom Feed
249512, 25R585	Bottom Feed with Trigger Switch
249515	Top Feed
249513	Top Feed with Trigger Switch

Related Manuals

Manual in English	Description	Manual Reference
334129	Therm-O-Flow® 20, Instructions - Parts	Supply System
334130	Therm-O-Flow 200, Instructions - Parts	Supply System
313296	Warm Melt Supply Systems, Instructions - Parts	Supply System
311513	4-Zone Heat Control, Instructions - Parts List	Temperature Control
3A4241	Hot Melt/Warm Melt Heated Hose, Instructions	Heated Fluid Hose
309160	Hot Melt/Warm Melt Heated Hose, Instructions	Heated Fluid Hose

Warnings

The following warnings are for the setup, use, grounding, maintenance, and repair of this equipment. The exclamation point symbol alerts you to a general warning and the hazard symbols refer to procedure-specific risks. When these symbols appear in the body of this manual or on warning labels, refer back to these Warnings. Product-specific hazard symbols and warnings not covered in this section may appear throughout the body of this manual where applicable.

⚠WARNING

ELECTRIC SHOCK HAZARD

This equipment must be grounded. Improper grounding, setup, or usage of the system can cause electric shock.

- Turn off and disconnect power at main switch before disconnecting any cables and before servicing or installing equipment.
- Connect only to grounded power source.
- All electrical wiring must be done by a qualified electrician and comply with all local codes and regulations.

BURN HAZARD

Equipment surfaces and fluid that is heated can become very hot during operation. To avoid severe burns:

- Do not touch hot fluid or equipment.

PERSONAL PROTECTIVE EQUIPMENT

Wear appropriate protective equipment when in the work area to help prevent serious injury, including eye injury, hearing loss, inhalation of toxic fumes, and burns. Protective equipment includes but is not limited to:

- Protective eyewear, and hearing protection.
- Respirators, protective clothing, and gloves as recommended by the fluid and solvent manufacturer.

⚠WARNING





SKIN INJECTION HAZARD

High-pressure fluid from dispensing device, hose leaks, or ruptured components will pierce skin. This may look like just a cut, but it is a serious injury that can result in amputation. **Get immediate surgical treatment.**

- Engage trigger lock when not dispensing.
- Do not point dispensing device at anyone or at any part of the body.
- Do not put your hand over the fluid outlet.
- Do not stop or deflect leaks with your hand, body, glove, or rag.
- Follow the **Pressure Relief Procedure** when you stop dispensing and before cleaning, checking, or servicing equipment.
- Tighten all fluid connections before operating the equipment.
- Check hoses and couplings daily. Replace worn or damaged parts immediately.




FIRE AND EXPLOSION HAZARD

Flammable fumes, such as solvent and paint fumes, in **work area** can ignite or explode. Paint or solvent flowing through the equipment can cause static sparking. To help prevent fire and explosion:

- Use equipment only in well-ventilated area.
- Eliminate all ignition sources, such as pilot lights, cigarettes, portable electric lamps, and plastic drop cloths (potential static sparking).
- Ground all equipment in the work area. See **Grounding** instructions.
- Never spray or flush solvent at high pressure.
- Keep work area free of debris, including solvent, rags and gasoline.
- Do not plug or unplug power cords, or turn power or light switches on or off when flammable fumes are present.
- Use only grounded hoses.
- Hold gun firmly to side of grounded pail when triggering into pail. Do not use pail liners unless they are anti-static or conductive.
- **Stop operation immediately** if static sparking occurs or you feel a shock**.** Do not use equipment until you identify and correct the problem.
- Keep a working fire extinguisher in the work area.

⚠WARNING

EQUIPMENT MISUSE HAZARD

Misuse can cause death or serious injury.

- Do not operate the unit when fatigued or under the influence of drugs or alcohol.
- Do not exceed the maximum working pressure or temperature rating of the lowest rated system component. See **Technical Specifications** in all equipment manuals.
- Use fluids and solvents that are compatible with equipment wetted parts. See **Technical Specifications** in all equipment manuals. Read fluid and solvent manufacturer's warnings. For complete information about your material, request Safety Data Sheets (SDSs) from distributor or retailer.
- Turn off all equipment and follow the **Pressure Relief Procedure** when equipment is not in use.
- Check equipment daily. Repair or replace worn or damaged parts immediately with genuine manufacturer's replacement parts only.
- Do not alter or modify equipment. Alterations or modifications may void agency approvals and create safety hazards.
- Make sure all equipment is rated and approved for the environment in which you are using it.
- Use equipment only for its intended purpose. Call your distributor for information.
- Route hoses and cables away from traffic areas, sharp edges, moving parts, and hot surfaces.
- Do not kink or over bend hoses or use hoses to pull equipment.
- Keep children and animals away from work area.
- Comply with all applicable safety regulations.

TOXIC FLUID OR FUMES HAZARD

Toxic fluids or fumes can cause serious injury or death if splashed in the eyes or on skin, inhaled, or swallowed.

- Read Safety Data Sheets (SDSs) to know the specific hazards of the fluids you are using.
- Store hazardous fluid in approved containers, and dispose of it according to applicable guidelines.

Installation

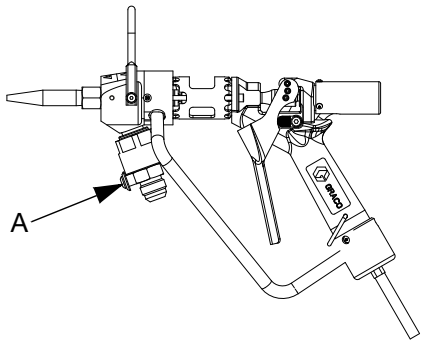
NOTE: Only connect to a Graco supply system with a Graco heated fluid hose. See **Related Manuals** on page 2.

Connect Heated Hose

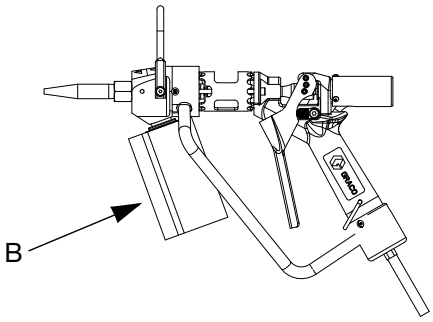
1. An adapter may be required to connect the gun to some hose sizes. If required, secure adapter onto gun swivel (a) and tighten securely.

Part	Adapter	Hose Size
120264	-8 JIC x -10 JIC	-8
- - - - -	Not Required	-10
120265	-10 JIC x -12 JIC	-12

2. Securely connect hose to gun swivel (A).



3. Wrap connection with insulating cuff (B) (119889).



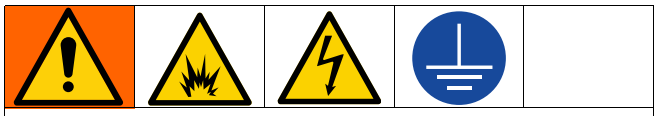
Connect Electrical Cable

1. Wrap hose cable around hose one time. Connect electrical cable from hose to gun cable, engage metal clip on top of connector.

2. Place flat side of cable connection against hose. Make sure the metal clip faces away from the hose. This will prevent damage to the hose from the clip rubbing against it.

3. Fasten Velcro insulation wrap (198422) snugly around the hose. Secure wrap with two Velcro straps (198442) on the ends of the wrap.

Grounding



The equipment must be grounded to reduce the risk of static sparking and electric shock. Electric or static sparking can cause fumes to ignite or explode. Improper grounding can cause electric shock. Grounding provides an escape wire for the electric current.

Hot melt dispense gun: ground through connection to a properly grounded supply system, pump and fluid hose.

Pump: ground as detailed in your separate pump manual.

Supply system: ground as detailed in your separate supply system manual. See **Related Manuals** on page 2.

Fluid hoses: grounded through connection to a properly grounded pump.

Fluid supply container: follow local codes and regulations.

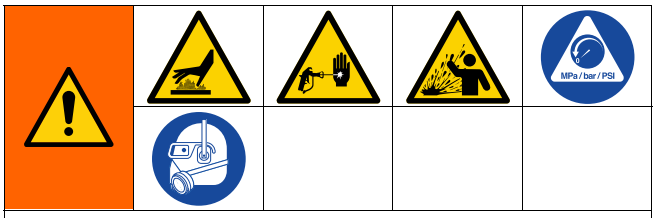
Flammable liquids in the dispense area: must be kept in approved, grounded containers. Do not store more than the quantity needed for one shift.

Solvent pails used when flushing: follow local codes and regulations. Use only conductive metal pails, placed on a grounded surface. Do not place the pail on a nonconductive surface, such as paper or cardboard, which interrupts grounding continuity.

To maintain grounding continuity when flushing or relieving pressure: hold metal part of the gun firmly to the side of a grounded metal pail, then trigger the dispense gun.

Pressure Relief Procedure

Follow the Pressure Relief Procedure whenever you see this symbol.

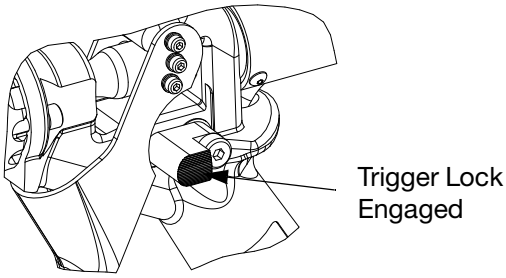


This equipment stays pressurized until pressure is manually relieved. To help prevent serious injury from hot pressurized fluid, such as skin injection or splashing fluid, follow the Pressure Relief Procedure when you stop spraying and before cleaning, checking, or servicing the equipment.

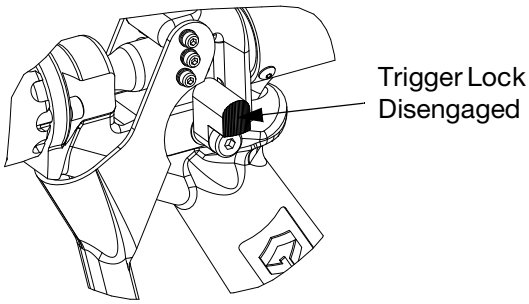
To help prevent serious injury from burns, do not touch hot fluid dispensing from the gun.

NOTE: The dispense gun is intended to be used with materials that are solid and at room temperature. The following procedure can only be performed when the system is hot.

1. Fully release gun trigger and engage gun trigger lock.



2. Shut off fluid supply pump.
3. Hold a metal part of the gun firmly to the side of a grounded metal waste container. Disengage the gun trigger lock, then trigger the gun.

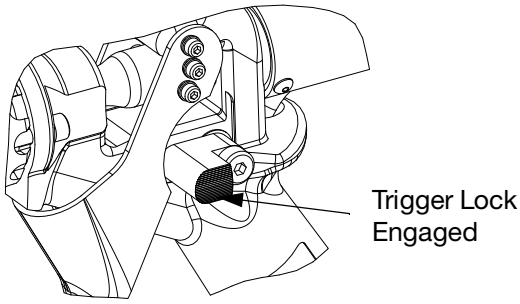


4. Fully release the gun trigger and engage the gun trigger lock.
5. Open the pump drain valve. Triggering the gun to relieve pressure may not be sufficient. Have a container ready to catch drainage.
6. If you suspect pressure has not been fully relieved due to the dispense gun being clogged:
   a. VERY SLOWLY loosen the end coupling from the dispense gun to relieve pressure gradually.
   b. Loosen the coupling completely.
   c. Clear the obstruction in the dispense gun.

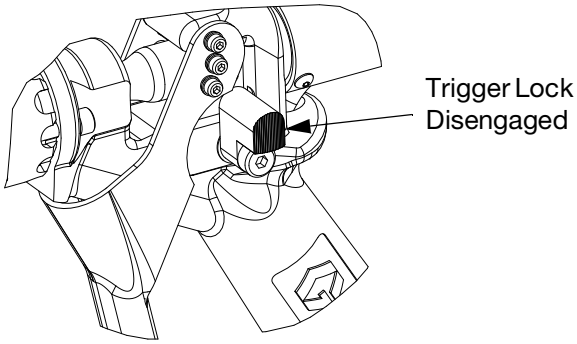
Trigger Lock

Always engage the trigger lock when you stop spraying to prevent the gun from being triggered accidentally by hand or if dropped or bumped.

To engage the trigger lock, release the gun trigger and rotate the lock downward.



To disengage the trigger lock, rotate the lock upward.



Operation

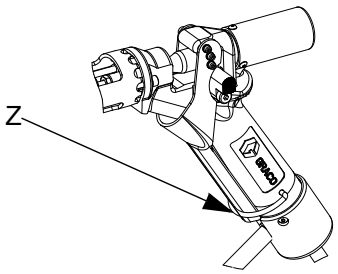
Heat Up

Fluid expands while heating, causing a pressure rise in a closed system. To help prevent serious injury from pressurized fluid such as skin injection and or splashing fluid, a path must be provided to relieve pressure. Lock the gun trigger open when heating up the system form ambient temperature.

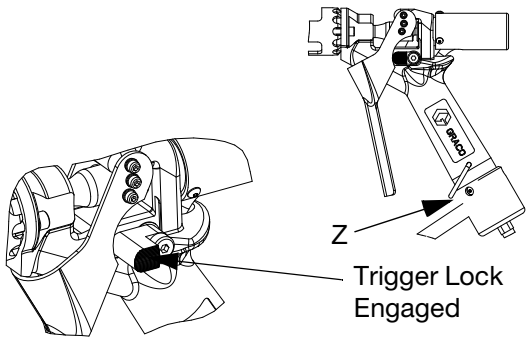
Engage trigger retainer to hold gun open, to prevent excessive pressure buildup.

To help prevent serious injury from burns, do not touch hot fluid from the dispensing gun.

1. Turn on electrical controls to the temperature control system.
2. Place a container under the dispense gun to collect hot material.
3. Lock the dispense gun trigger open by pulling and securing trigger using the trigger retainer (Z).

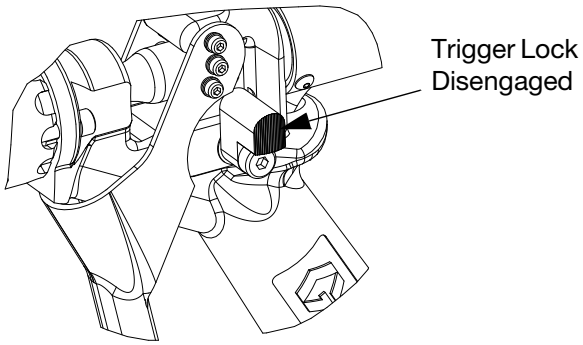


4. After the pump, hose, and gun are up to temperature, release the gun trigger retainer (Z) to close the valve. Engage the gun trigger lock to prevent accidental dispense of high pressure heated fluid.



Dispensing

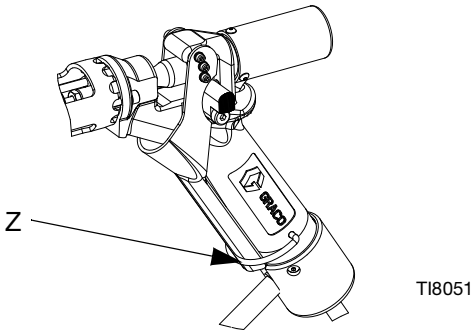
1. Start the pump. Fluid flow rate is controlled at pump. Adjust pump pressure to obtain desired flow rate. Use lowest pressure necessary to dispense fluid. The pressure adjustment depends on hose length, fluid viscosity, and nozzle size.
2. Disengage the gun trigger lock.



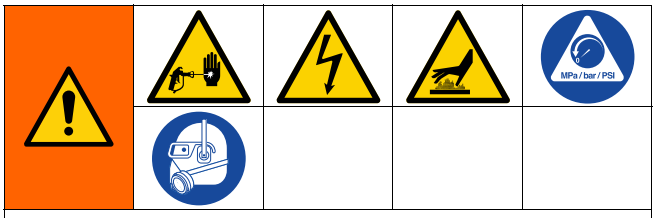
3. Squeeze the trigger in all the way. Fluid flow begins with the slightest pressure on trigger and stops when trigger is released.

Shutdown

1. Turn off all heat at the controller.
2. Shut off the fluid supply pump.
3. Trigger the gun to relieve pressure while the system is still hot.
4. Hold the gun over a waste container and use trigger retainer (Z) to hold the gun trigger open.



Troubleshooting



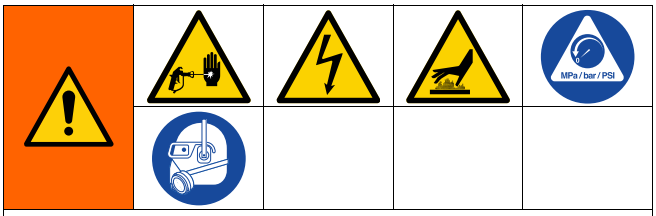
Some solutions require disassembling the gun. To help prevent serious injury, relieve pressure and disconnect the electrical cable before checking or servicing the equipment.

To help prevent serious injury from burns, do not touch hot fluid dispensing from the gun.

1. Follow **Pressure Relief Procedure**, page 8, before checking or repairing the gun.
2. Check all possible problems and causes before disassembling gun.
3. Disconnect the electrical cable.

Problem	Cause(s)	Solution(s)
Material leaks from front of gun body	Seat or packing is worn	Replace the seat (6) or packing (47).
	Obstruction inside gun	Remove the seat (6). Check and replace if necessary.
	Worn needle	Check and replace needle (4a) if necessary.
Material leaks from back of gun body	Needle seal or packing is worn	Replace seals (4c) or packing (4d).
Gun does not shut off	Needle or seat is worn	Replace needle (4a) or seat (6).
	Spring is broken or not installed correctly	Check and replace spring (14) if necessary.
	Obstruction inside gun	Remove the seat (6). Check and replace if necessary.
Gun does not heat material	Loose heater wires	Check and reconnect wire connections.
	Loose sensor wires	Check and reconnect wire connections.
	Heater cartridge failed	Replace failed heater.
	Sensor failed	Replace failed sensor.
	Temperature controller failed	See your Therm-O-Flow® 200 manual.
	No power to heating circuitry	

Service



Some solutions require disassembling the gun. To help prevent serious injury, relieve pressure and disconnect the electrical cable before checking or servicing the equipment.

To help prevent serious injury from burns, do not touch hot fluid dispensing from the gun.

Adjusting Dispensing Gun

1. Follow **Pressure Relief Procedure**, page 8, before checking or repairing the gun.
2. Check all possible problems and causes before disassembling the gun.
3. Disconnect the electrical cable.

Pull terminal blocks (36) and insulation displacem

If fluid continues to flow after the trigger is released:

- the gun valve may need adjustment,
- the gun valve may be obstructed or damaged,
- needle assembly (4) or seat (6) may be worn or damaged.

Replace needle assembly (4) or seat (6). See **Adjust Needle Assembly** on page 13.

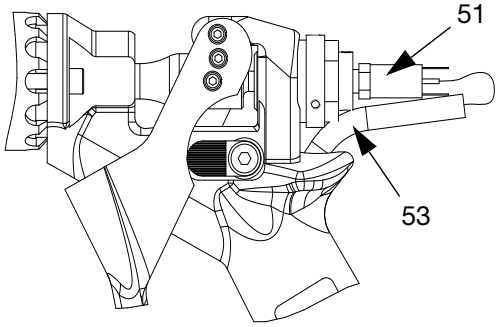
Use Repair Kit 253553 for Manual Hot-Melt Guns 249512, 249513, 249514, 249515, 297273, and 297274.

Install New Heater Cartridge, RTD Sensor, or Switch

1. Follow **Pressure Relief Procedure**, page 8, then disconnect the electrical cable and hoses.
2. Remove covers (9 and 16).
3. Pull terminal blocks (36) and insulation displacement connectors (IDC) (38) out of the handle. Loosen the screw in the terminal block or cut off the IDC to disconnect lead wires of failed components.
4. Gently slide new heater(s) or sensor into the appropriate hole.
5. Feed new wires through the conduit to the correct terminal block or IDC. If using a terminal block, cut wires to length and strip insulation before connecting.

   If using an IDC, insert one new RTD wire and one yellow wire through the IDC holes until the ends can be seen in the window on the opposite side. Use pliers to press down insert, then close the IDC cover.

   When replacing switch (51) ensure tube (53) protrudes from the back of the handle with its end near the center of the switch body. Gently push wires through the tube into the gun handle.

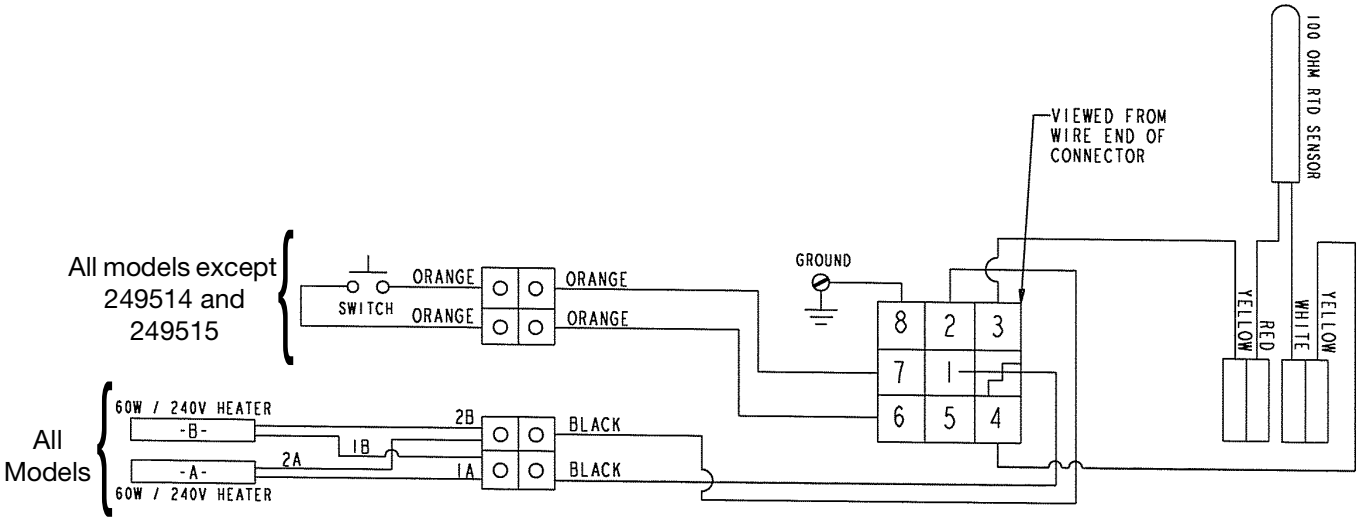


6. Replace covers (9 and 16).

Electrical Schematic

Use an ohmmeter to check:

- Heater pins 1 to 2, 445 Ω +/- 35 Ω.
- RTD sensor pin 3 to 4, 108 Ω +/-1 Ω at 70°F (21°C).
- Continuity to gun body from pin 8.
- No continuity from pins 1-7 to gun body or connector shell, or ground pin 8.



Inspection Frequency

Dispense Gun

Inspect the dispense gun at every use for leakage or other visible damage.

Heater

Every two weeks, check the heater for proper resistance. Resistance should be approximately 890 ohms, +/- 70 ohms for the 240V valves. Replace the heater if necessary. See **Electrical Schematic** on page 12 for test point.

Also inspect the heater when performing regular maintenance procedures.

Sensor

Every two weeks, check the sensor resistance. Resistance should be 108 ohms at 70° F (21° C). Replace the sensor if necessary.

Also inspect the sensor when performing regular maintenance procedures.

Adjust Needle Assembly

The trigger travel and corresponding valve opening are factory set. To adjust this setting, use the following procedure.

1. Follow the pressure relief procedure in your supply system manual (see **Related Manuals** on page 2).
2. Disconnect from power source and wait for the unit to cool.
3. Disconnect the gun from the hose.
4. Use a 11/32 in. wrench to loosen hex nut (4g).
5. Trigger the gun and use a 1/8 in. open-end wrench on the flats of the needle to turn the needle (4a) clockwise one turn as viewed from the handle end of the gun.
6. Release the trigger; a slight free play of the trigger handle should occur.
7. Repeat Step 4 until free play occurs.
8. Tighten hex nut (4g) to lock the adjustment.

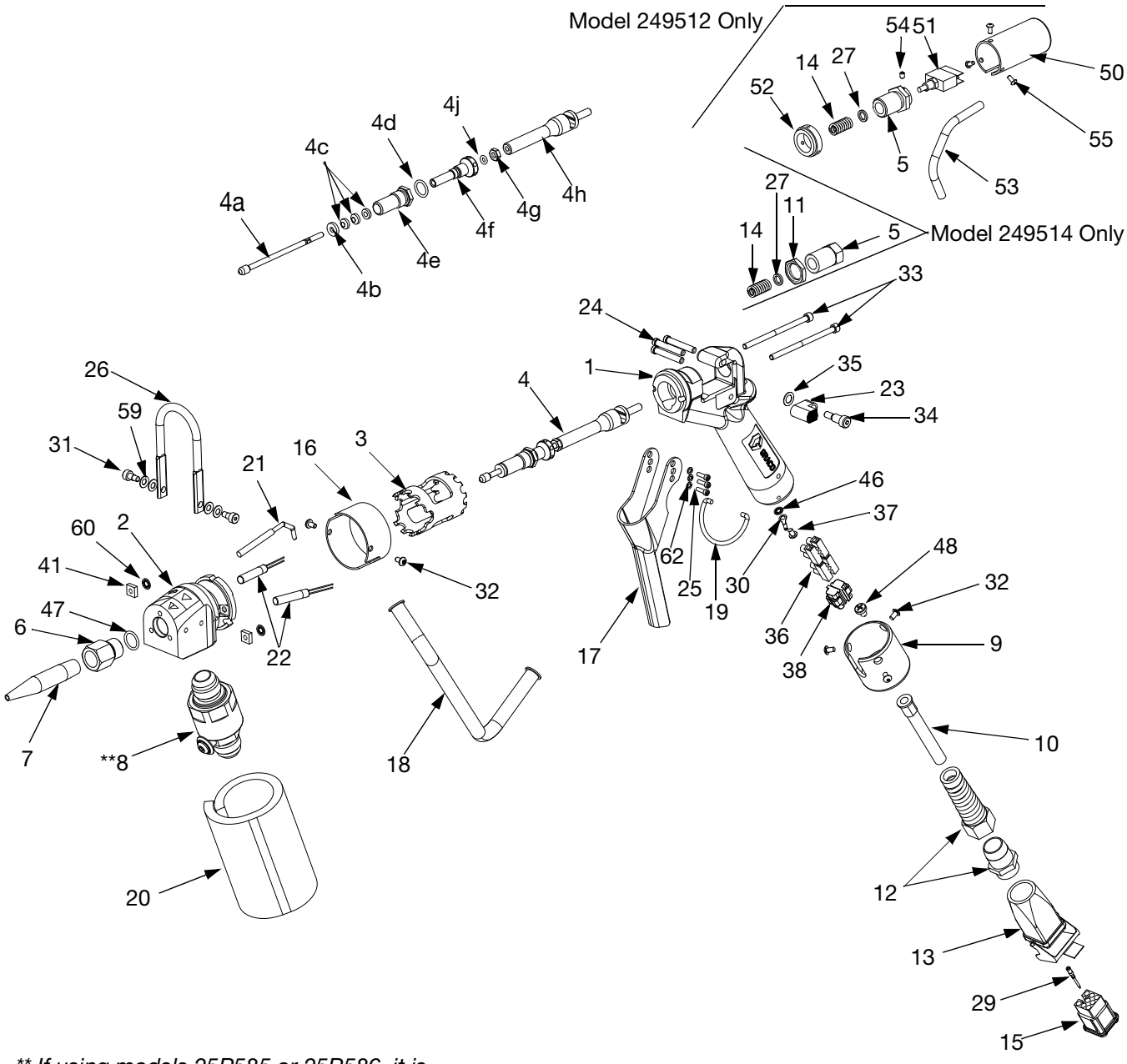
Service Valve Stem and Seal

If fluid leaks past seal (4c), the seal or needle (4a) may be worn or damaged. To replace the seal or valve stem, use the following procedure:

1. Follow the Pressure Relief Procedure in your supply system manual (see **Related Manuals** on page 2).
2. Disconnect from power source and wait for the unit to cool.
3. Disconnect the gun from the hose.
4. Remove cover (16), and then slide the heater cartridge and sensor cartridge out of body (2).
5. Loosen the needle nut.
6. Remove screws (33).
7. Unscrew the needle with the body from the yoke.
8. Remove the seal-cartridge assembly from the body and replace seals and/or needle. Repack the grease area of the packing nut prior to reassembly.
9. Reassemble in reverse order and follow **Adjust Needle Assembly**.

Parts

Models 249514, 249512, 25R585 and 25R586, Hot Melt Guns



*** If using models 25R585 or 25R586, it is recommended to use a Dimethacrylate Ester for this fitting.*

Model 249514
Manual Hot Melt Gun, Bottom Feed, Extrude, No Switch
Model 249512
Manual Hot Melt Gun, Bottom Feed, Extrude, with Switch

Ref.	Part	Description	Qty.
1	15G017	HANDLE	1
2▲	---	BODY, gun	1
3	15G006	SPACER, thermal, isolator	1
4◆	287734	NEEDLE, assembly, includes 4a-4j	1
4a	15G531	NEEDLE	1
4b	C27053	SUPPORT, packing	1
4c*	C27060	SEAL, needle	3
4d*	103338	PACKING, o-ring	1
4e	15F993	NUT, packing	1
4f	15F991	SCREW, adjustment	1
4g	C19284	NUT, hex	1
4h	15F997	YOKE, gun	1
4j*	106560	PACKING, o-ring	1
5		RETAINER, spring	
	C27037	Model 249514	1
	15G004	Model 249512	1
6◆	15G001	ADAPTER, seat	1
7	C32003	NOZZLE	1
8†‡▲	---	SWIVEL, assembly (in-line with stop)	1
9	15G018	COVER, gun handle	1
10	119876	CONDUIT, flex	1
11†	C27036	NUT, lock	1
12	116673	BUSHING, strain relief	1
13	116637	CONNECTOR, cable coupler hood	1
14	C00020	SPRING	1
15	115860	INSERT, male	1
16	15F989	COVER, gun wires	1
17	C27051	TRIGGER, gun	1
18	15G022	TUBE	1
19	C32368	RING	1
20	119889	COVER, swivel	1
21	C32255	SENSOR, temperature	1
22	17K470	CARTRIDGE, heater	2
23	C34009	TRIGGER, lock	1
24	15X116	PIN, trigger	3
25	C19950	SCREW, Cap	3
26	15G020	HANGER	1
27	15G121	WASHER, gun	1
28✳	065337	WIRE, copper, electric	1
29	115862	CONNECTOR, male, crimp	
		Model 249514	1
		Model 249512	1
30	C78160	TERMINAL	1
31	122340	SCREW, shoulder, socket hd.	2
32	122337	SCREW, cap, socket button hd.	5
33▲	124779	SCREW, cap, socket hd.	2
34	108483	SCREW, shoulder	1
35	C20565	WASHER, spring washer	1
36	15X093	BLOCK, terminal	2
37	102975	SCREW, 6-32 x .25	1
38	122341	CONNECTOR, pigtail, IDC	2
39‡✳	C07535	TUBE, heat shrink	1
40✳	C34137	INSULATOR, fiberglass	1
41▲	122433	NUT, square	2
42✳	065366	WIRE, silver-coated copper	1
43✳	C33049	TAPE, adhesive, fiberglass	1
44✳	198422	WRAP, Velcro	1
45✳	198442	STRAP, Velcro	2
46	100272	WASHER, #6, internal lock	1
47*◆	103610	PACKING, o-ring	1
48	116807	SCREW, 10-24 x .25	1
49✳	617836	SLEEVE, fiberglass braid, #10 blk	2
50‡	15G003	COVER, switch	1
51‡	C32370	SWITCH	1
52‡	15G019	SPACER, cover mounting	1
53‡	122335	TUBE, 1/4 O.D.	1
54‡	102273	SCREW, set, 6-32 x .19	1
55‡	122338	SCREW, cap, socket button hd.	3
57✳‡	065379	WIRE, silver-coated copper, orange	1
58✳	065380	WIRE, silver-coated copper, yellow	1
59	122339	WASHER, Belleville	4
60▲	157021	WASHER, lock	2
61✳	070269	SEALANT, anaerobic	AR
62	C19208	WASHER, lock	3
63✳	101369	WRENCH, hex	1
64		CONNECTOR, male, crimp	
	116640	Model 249514	4
	116640	Model 249512	6

* *Parts included in Seal Kit 253553 (purchase separately).*

◆ *Parts included in Repair Kit 289901 (purchase separately).*

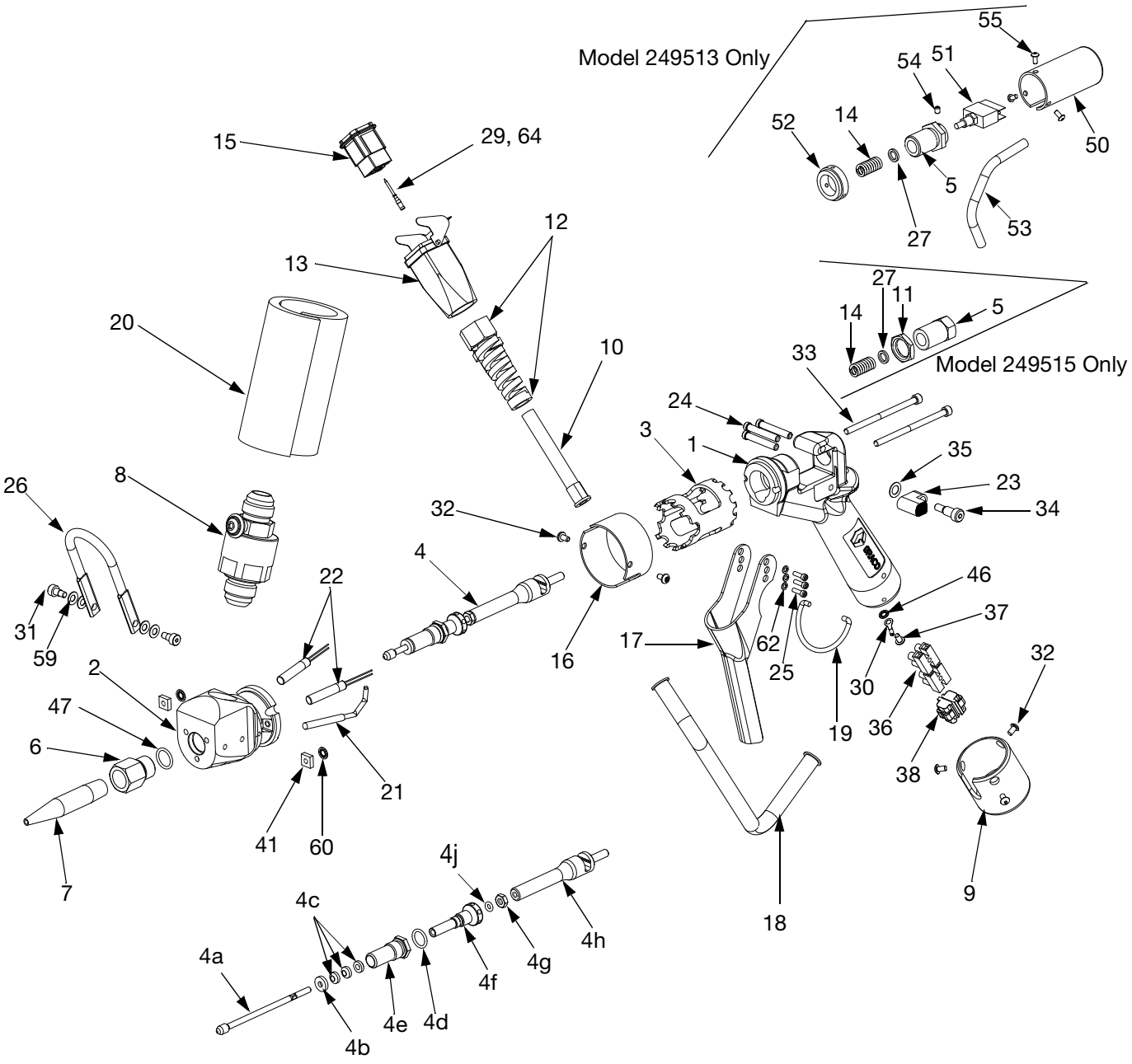
† *Model 249514 only.*

‡ *Model 249512 only.*

▲ *Parts included in Gun body repair kit 15X385*

✳ *Not shown.*

Models 249515 and 249513, Hot Melt Guns



Model 249515
Manual Hot Melt Gun, Top Feed, Extrude, No Switch

Model 249513
Manual Hot Melt Gun, Top Feed, Extrude, with Switch

Ref.	Part	Description	Qty.
1	15G017	HANDLE	1
2▲	---	BODY, gun	1
3	15G006	SPACER, thermal, isolator	1
4◆	287734	NEEDLE, assy, includes 4a-4j	1
4a	15G531	NEEDLE	1
4b	C27053	SUPPORT, packing	1
4c*	C27060	SEAL, needle	3
4d*	103338	PACKING, o-ring	1
4e	15F993	NUT, packing	1
4f	15F991	SCREW, adjustment	1
4g	C19284	NUT, hex	1
4h	15F997	YOKE, gun	1
4j*	106560	PACKING, o-ring	1
5		RETAINER, spring	1
	C27037	Model 249515	
	15G004	Model 249513	
6◆	15G001	ADAPTER, seat	1
7	C32003	NOZZLE	1
8▲	---	SWIVEL, assembly (inline with stop)	1
9	15G018	COVER, gun handle	1
10	119876	CONDUIT, flex	1
11†	C27036	NUT, lock	1
12	116673	BUSHING, strain relief	1
13	116637	CONNECTOR, cable coupler hood	1
14	C00020	SPRING	1
15	115860	INSERT, male	1
16	15F989	COVER, gun wires	1
17	C27051	TRIGGER, gun	1
18	15G022	TUBE	1
19	C32368	RING	1
20	119889	COVER, swivel	1
21	C32255	SENSOR, temperature	1
22	17K470	CARTRIDGE, heater	2
23	C34009	TRIGGER, lock	1
24	15X116	PIN, trigger	3
25	C19950	SCREW, cap	3
26	15G020	HANGER	1
27	15G121	WASHER, gun	1
28⁕	065337	WIRE, copper, electric	1
29	115862	CONNECTOR, male, crimp	
		Model 249515	1
		Model 249513	1
30	C78160	TERMINAL	1
31	122340	SCREW, shoulder, socket hd.	2
32	122337	SCREW, cap, socket button hd.	5
33▲	124779	SCREW, cap, socket hd.	2
34	108483	SCREW, shoulder	1
35	C20565	WASHER, spring washer	1
36	15X093	BLOCK, terminal	2
37	102975	SCREW, 6-32 x .25	1
38	122341	CONNECTOR, pigtail, IDC	2
39‡⁕	C07535	TUBE, heat shrink	1
40⁕	C34137	INSULATOR, fiberglass	1
41▲	122433	NUT, square	2
42⁕	065366	WIRE, silver-coated copper	1
43⁕	C33049	TAPE, adhesive, fiberglass	1
44⁕	198422	WRAP, Velcro	1
45⁕	198442	STRAP, Velcro	2
46	100272	WASHER, #6 internal lock	1
47*◆	103610	PACKING, o-ring	1
49⁕	617836	SLEEVE, fiberglass braid,#10 blk	2
50‡	15G003	COVER, switch	1
51‡	C32370	SWITCH	1
52‡	15G019	SPACER, cover mounting	1
53‡	122335	TUBE, 1/4 O.D.	1
54‡	102273	SCREW, 6-32 x .19	1
55‡	122338	SCREW, cap, socket button hd.	3
56⁕	065379	WIRE, silver-coated copper, orange	1
57⁕	065380	WIRE, silver-coated copper, yellow	1
59	122339	WASHER, Belleville	4
60▲	157021	WASHER, lock	2
61⁕	070269	SEALANT, anaerobic	AR
62	C19208	WASHER, lock	3
63⁕	101369	WRENCH, hex	1
64		CONNECTOR, male, crimp	
	116640	Model 249515	4
	116640	Model 249513	6

** Parts included in Seal Kit 253553 (purchase separately).*

◆ Parts included in Repair Kit 289901 (purchase separately).

† Model 249515 only.

‡ Model 249513 only.

▲ Parts included in Gun body repair kit 15X385

⁕ Not shown.

Accessories

Part No.	Description
C34137	Fitting insulation, 1/8 in. thick x 2 in. wide. Sold by the foot.
C33049	Adhesive tape, high temp for securing insulation (C34137), 1 in. x 108 ft.
198422	Wrap, velcro, 10 in. x 10 in. Covers electrical connection on heated hose.
198442	Strap, velcro. Use two around ends of wrap (198422) for security.

Rebuild Kit

Part No.	Description
15X385	Gun body repair kit.

Technical Specifications

Hot Melt Dispense Guns		
	U.S.	**Metric**
Maximum operating temperature	400 °F	204 °C
Maximum fluid working pressure	5000 psi	34.5 MPa, 345 bar
Outlet port size	5/8-18 UNF-2B	
Inlet port size on gun housing	7/8-14 UNF- 2B	
Inlet port size on fluid swivel	7/8-14 JIC(m)	
Voltage	230/240 Vac	
Wattage	120 W	
Resistance temperature detector (platinum RTD; 0.00385 ohm/ohm/°)	108.2 ohms @ 70 °F	108.2 ohms @ 21 °C
Heater resistance	Individually: 890 ohms, +/- 70 ohms Wired in parallel: 445 ohms, +/- 35ohms	
Weight	Without swivel: 2.7 lb With swivel: 3.4 lb	Without swivel: 1.2 kg With swivel: 1.5 kg
Dimensions	Height: 7.5 in. Width: 3.0 in. Length: Models 249514 and 249515: 9.0 in. Models 249512 and 249513: 10.5 in.	Height: 191 mm Width: 76 mm Length: Models 249514 and 249515: 229 mm Models 249512 and 249513: 267 mm
Wetted parts	Aluminum, fluorocarbon rubber, stainless steel, PTFE, carbon steel, brass	
Notes:		
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California Proposition 65

CALIFORNIA RESIDENTS

⚠ **WARNING:** Cancer and reproductive harm – www.P65warnings.ca.gov.

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Graco warrants all equipment referenced in this document which is manufactured by Graco and bearing its name to be free from defects in material and workmanship on the date of sale to the original purchaser for use. With the exception of any special, extended, or limited warranty published by Graco, Graco will, for a period of twelve months from the date of sale, repair or replace any part of the equipment determined by Graco to be defective. This warranty applies only when the equipment is installed, operated and maintained in accordance with Graco's written recommendations.

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This warranty is conditioned upon the prepaid return of the equipment claimed to be defective to an authorized Graco distributor for verification of the claimed defect. If the claimed defect is verified, Graco will repair or replace free of charge any defective parts. The equipment will be returned to the original purchaser transportation prepaid. If inspection of the equipment does not disclose any defect in material or workmanship, repairs will be made at a reasonable charge, which charges may include the costs of parts, labor, and transportation.

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