

# Hot Melt Dispense Guns

311209W

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.***

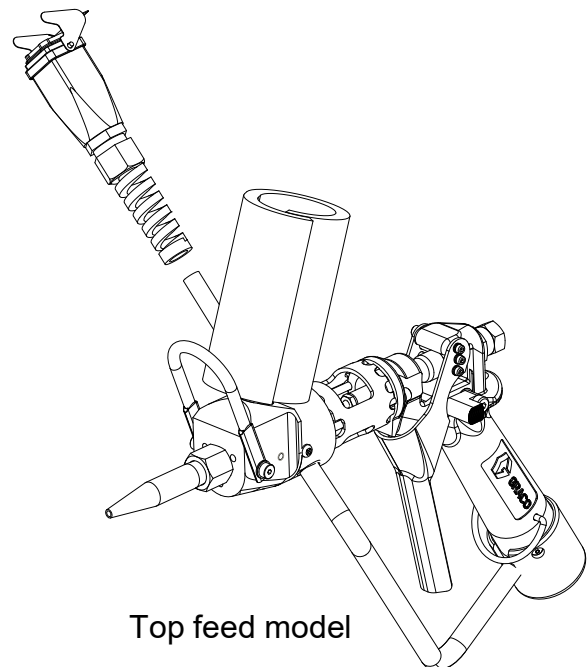
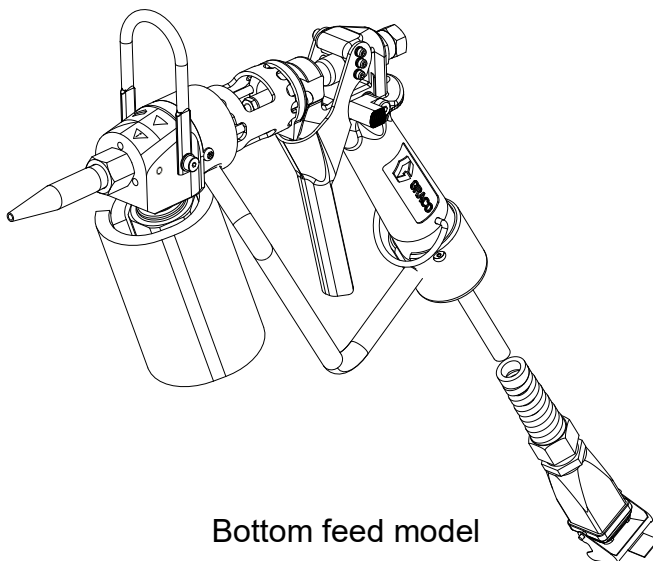
Maximum Working Pressure 5000 psi (34.5 MPa, 345 bar)

See page 2 for model information.



## Important Safety Instructions

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



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## 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 <sup>®</sup> 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.

 <b>WARNING</b>	
 	<p><b>ELECTRIC SHOCK HAZARD</b></p> <p>This equipment must be grounded. Improper grounding, setup, or usage of the system can cause electric shock.</p> <ul style="list-style-type: none"> <li>• Turn off and disconnect power at main switch before disconnecting any cables and before servicing or installing equipment.</li> <li>• Connect only to grounded power source.</li> <li>• All electrical wiring must be done by a qualified electrician and comply with all local codes and regulations.</li> </ul>
	<p><b>BURN HAZARD</b></p> <p>Equipment surfaces and fluid that is heated can become very hot during operation. To avoid severe burns:</p> <ul style="list-style-type: none"> <li>• Do not touch hot fluid or equipment.</li> </ul>
	<p><b>PERSONAL PROTECTIVE EQUIPMENT</b></p> <p>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:</p> <ul style="list-style-type: none"> <li>• Protective eyewear, and hearing protection.</li> <li>• Respirators, protective clothing, and gloves as recommended by the fluid and solvent manufacturer.</li> </ul>

# **WARNING**

    	<p><b>SKIN INJECTION HAZARD</b></p> <p>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. <b>Get immediate surgical treatment.</b></p> <ul style="list-style-type: none"> <li>• Engage trigger lock when not dispensing.</li> <li>• Do not point dispensing device at anyone or at any part of the body.</li> <li>• Do not put your hand over the fluid outlet.</li> <li>• Do not stop or deflect leaks with your hand, body, glove, or rag.</li> <li>• Follow the <b>Pressure Relief Procedure</b> when you stop dispensing and before cleaning, checking, or servicing equipment.</li> <li>• Tighten all fluid connections before operating the equipment.</li> <li>• Check hoses and couplings daily. Replace worn or damaged parts immediately.</li> </ul>
   	<p><b>FIRE AND EXPLOSION HAZARD</b></p> <p>Flammable fumes, such as solvent and paint fumes, in <b>work area</b> can ignite or explode. Paint or solvent flowing through the equipment can cause static sparking. To help prevent fire and explosion:</p> <ul style="list-style-type: none"> <li>• Use equipment only in well-ventilated area.</li> <li>• Eliminate all ignition sources, such as pilot lights, cigarettes, portable electric lamps, and plastic drop cloths (potential static sparking).</li> <li>• Ground all equipment in the work area. See <b>Grounding</b> instructions.</li> <li>• Never spray or flush solvent at high pressure.</li> <li>• Keep work area free of debris, including solvent, rags and gasoline.</li> <li>• Do not plug or unplug power cords, or turn power or light switches on or off when flammable fumes are present.</li> <li>• Use only grounded hoses.</li> <li>• Hold gun firmly to side of grounded pail when triggering into pail. Do not use pail liners unless they are anti-static or conductive.</li> <li>• <b>Stop operation immediately</b> if static sparking occurs or you feel a shock. Do not use equipment until you identify and correct the problem.</li> <li>• Keep a working fire extinguisher in the work area.</li> </ul>

# ! 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

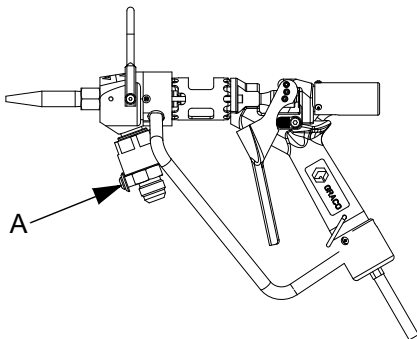
**NOTE:** Only connect to a Graco supply system with a Graco heated fluid hose. See **Related Manuals** on page 2.

## Connect Heated Hose

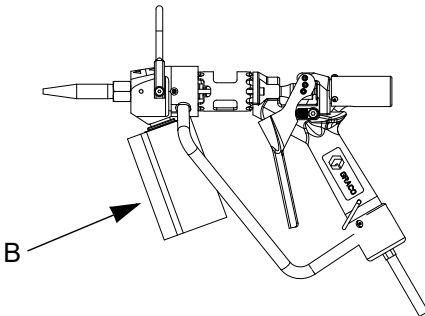
1. An adapter may be required to connect the gun to some hose sizes. If required, secure adapter onto gun swivel (a) and tighten securely.

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.

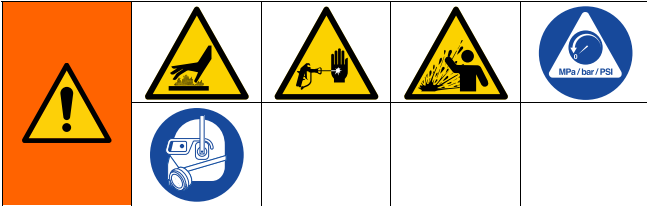
**Solvent pails used when flushing:** follow local codes and regulations. Use only conductive metal pails, placed on a grounded surface. Do not place the pail on a nonconductive surface, such as paper or cardboard, which interrupts grounding continuity.

**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.

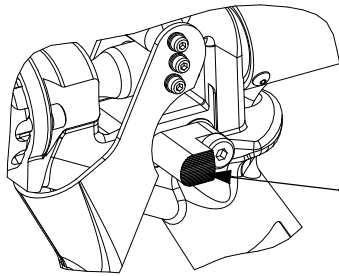


This equipment stays pressurized until pressure is manually relieved. To help prevent serious injury from hot pressurized fluid, such as skin injection or splashing fluid, follow the Pressure Relief Procedure when you stop spraying and before cleaning, checking, or servicing the equipment.

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

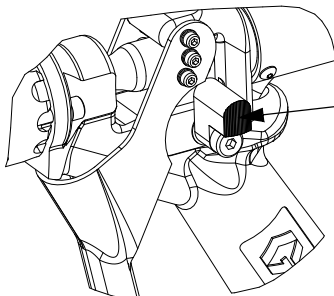
**NOTE:** The dispense gun is intended to be used with materials that are solid and at room temperature. The following procedure can only be performed when the system is hot.

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



Trigger Lock Engaged

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.



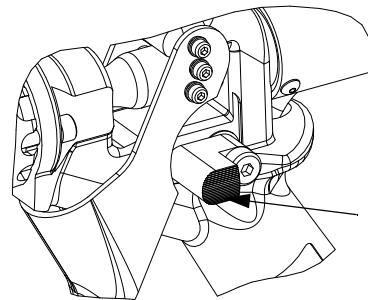
Trigger Lock Disengaged

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

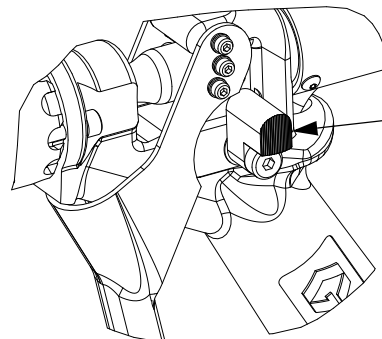
Always engage the trigger lock when you stop spraying to prevent the gun from being triggered accidentally by hand or if dropped or bumped.

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



Trigger Lock Engaged

To disengage the trigger lock, rotate the lock upward.



Trigger Lock Disengaged



# Operation

## Heat Up

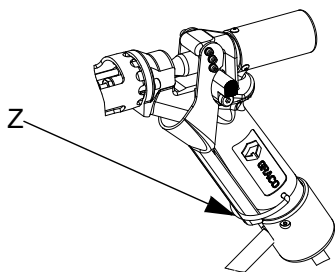


Fluid expands while heating, causing a pressure rise in a closed system. To help prevent serious injury from pressurized fluid such as skin injection and or splashing fluid, a path must be provided to relieve pressure. Lock the gun trigger open when heating up the system from ambient temperature.

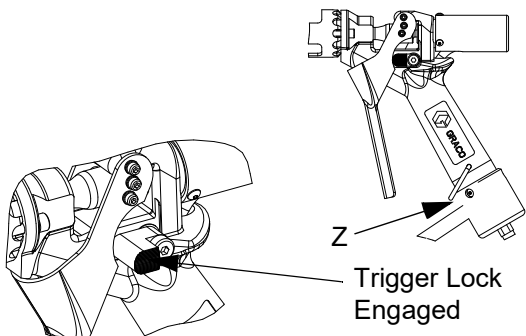
Engage trigger retainer to hold gun open, to prevent excessive pressure buildup.

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).

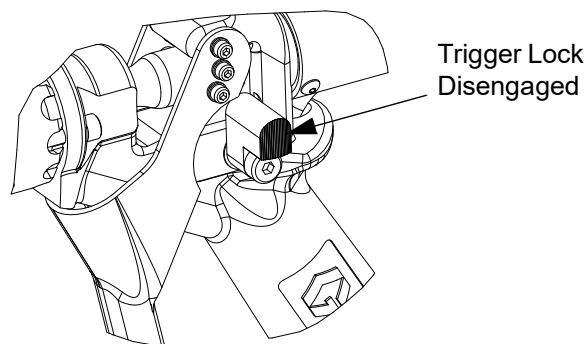


4. After the pump, hose, and gun are up to temperature, release the gun trigger retainer (Z) to close the valve. Engage the gun trigger lock to prevent accidental dispense of high pressure heated fluid.



## Dispensing

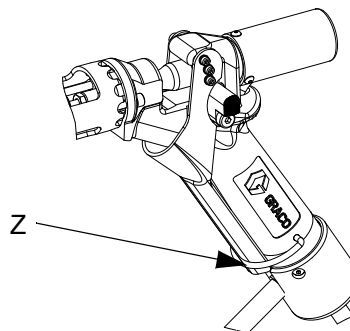
1. Start the pump. Fluid flow rate is controlled at pump. Adjust pump pressure to obtain desired flow rate. Use lowest pressure necessary to dispense fluid. The pressure adjustment depends on hose length, fluid viscosity, and nozzle size.
2. Disengage the gun trigger lock.



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

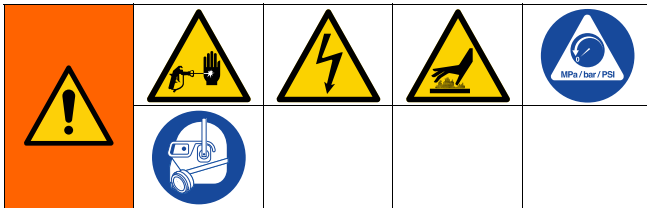
## Shutdown

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.



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# Troubleshooting



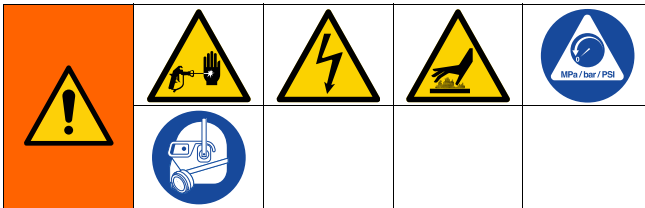
Some solutions require disassembling the gun. To help prevent serious injury, relieve pressure and disconnect the electrical cable before checking or servicing the equipment.

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 <sup>®</sup> 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.

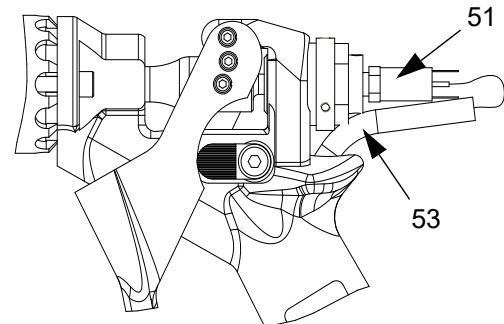
Use Repair Kit 253553 for Manual Hot-Melt Guns 249512, 249513, 249514, 249515, 297273, and 297274.

## 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.

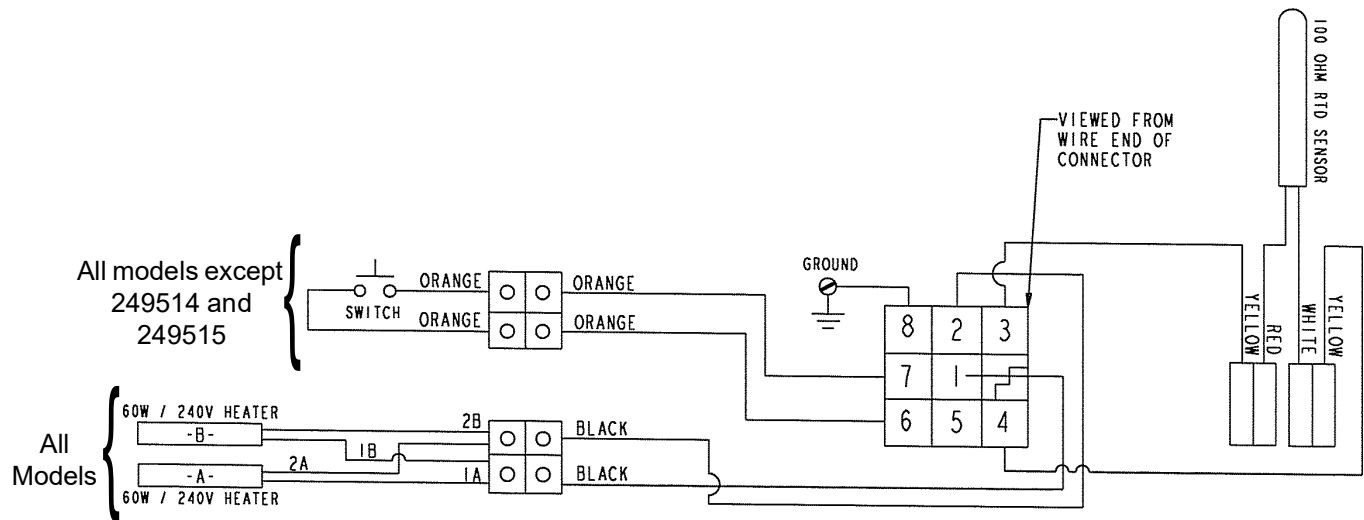


6. Replace covers (9 and 16).

## Electrical Schematic

Use an ohmmeter to check:

- Heater pins 1 to 2,  $445 \Omega \pm 35 \Omega$ .
- RTD sensor pin 3 to 4,  $108 \Omega \pm 1 \Omega$  at  $70^\circ\text{F}$  ( $21^\circ\text{C}$ ).
- 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:

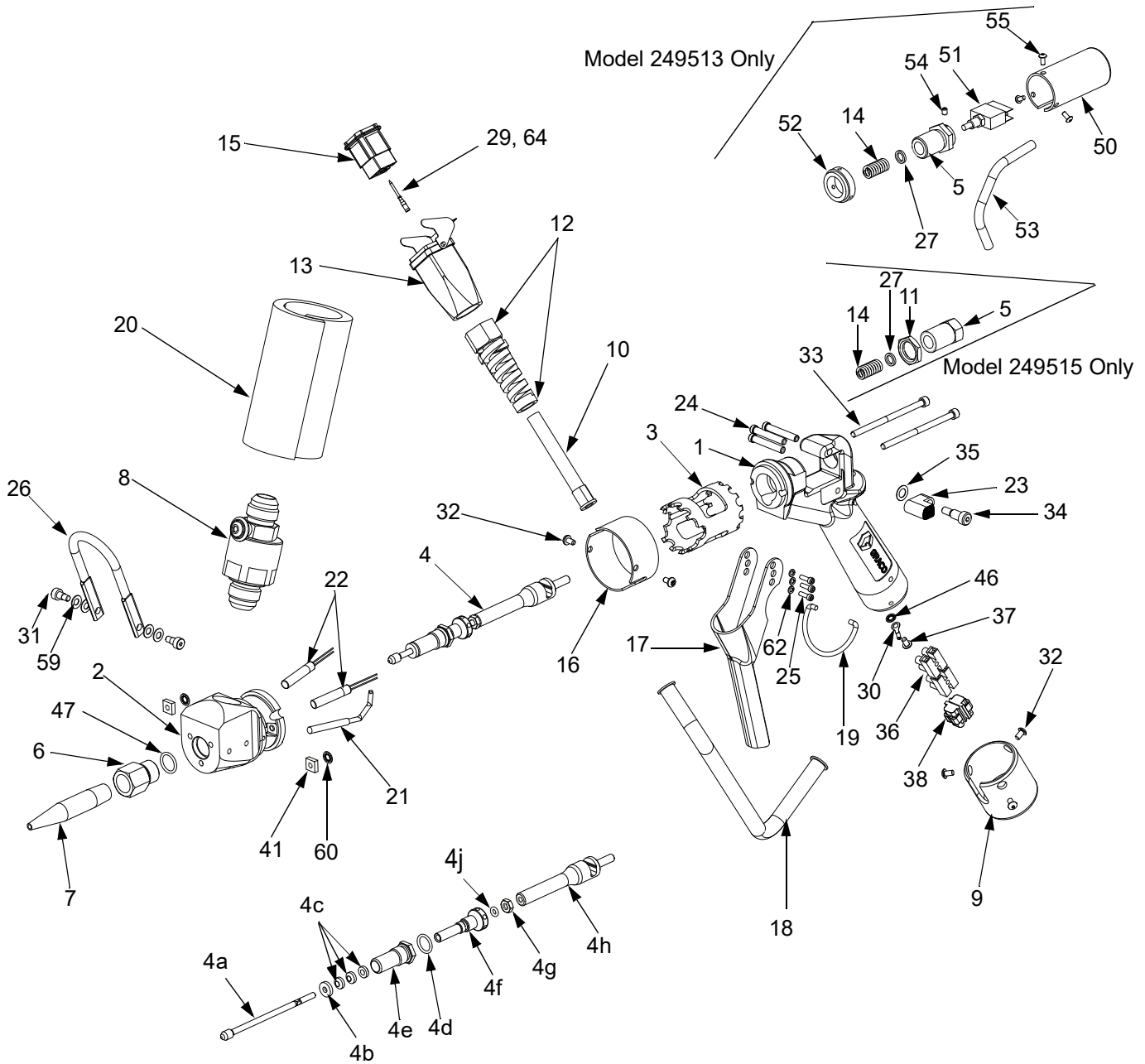
1. Follow the Pressure Relief Procedure in your supply system manual (see **Related Manuals** on page 2).
2. Disconnect from power source and wait for the unit to cool.
3. Disconnect the gun from the hose.
4. Remove cover (16), and then slide the heater cartridge and sensor cartridge out of body (2).
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**.



**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.	Ref.	Part	Description	Qty.
				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
1	15G017	HANDLE	1	34	108483	SCREW, shoulder	1
2	---	BODY, gun	1	35	C20565	WASHER, spring washer	1
3	15G006	SPACER, thermal, isolator	1	36	15X093	BLOCK, terminal	2
4◆	287734	NEEDLE, assembly, includes 4a-4j	1	37	102975	SCREW, 6-32 x .25	1
4a	15G531	NEEDLE	1	38	122341	CONNECTOR, pigtail, IDC	2
4b	C27053	SUPPORT, packing	1	39‡*	C07535	TUBE, heat shrink	1
4c*	C27060	SEAL, needle	3	40*	C34137	INSULATOR, fiberglass	1
4d*	103338	PACKING, o-ring	1	41	122433	NUT, square	2
4e	15F993	NUT, packing	1	42*	065366	WIRE, silver-coated copper	1
4f	15F991	SCREW, adjustment	1	43*	C33049	TAPE, adhesive, fiberglass	1
4g	C19284	NUT, hex	1	44*	198422	WRAP, Velcro	1
4h	15F997	YOKE, gun	1	45*	198442	STRAP, Velcro	2
4j*	106560	PACKING, o-ring	1	46	100272	WASHER, #6, internal lock	1
5		RETAINER, spring		47*◆	103610	PACKING, o-ring	1
	C27037	Model 249514	1	48	116807	SCREW, 10-24 x .25	1
	15G004	Model 249512	1	49*	617836	SLEEVE, fiberglass braid, #10 blk	2
6◆	15G001	ADAPTER, seat	1	50‡	15G003	COVER, switch	1
7	C32003	NOZZLE	1	51‡	C32370	SWITCH	1
8‡	---	SWIVEL, assembly (in-line with stop)	1	52‡	15G019	SPACER, cover mounting	1
9	15G018	COVER, gun handle	1	53‡	122335	TUBE, 1/4 O.D.	1
10	119876	CONDUIT, flex	1	54‡	102273	SCREW, set, 6-32 x .19	1
11‡	C27036	NUT, lock	1	55‡	122338	SCREW, cap, socket button hd.	3
12	116673	BUSHING, strain relief	1	57*‡	065379	WIRE, silver-coated copper, orange	1
13	116637	CONNECTOR, cable coupler hood	1	58*	065380	WIRE, silver-coated copper, yellow	1
14	C00020	SPRING	1	59	122339	WASHER, Belleville	4
15	115860	INSERT, male	1	60	157021	WASHER, lock	2
16	15F989	COVER, gun wires	1	61*	070269	SEALANT, anaerobic	AR
17	C27051	TRIGGER, gun	1	62	C19208	WASHER, lock	3
18	15G022	TUBE	1	63*	101369	WRENCH, hex	1
19	C32368	RING	1	64		CONNECTOR, male, crimp	
20	119889	COVER, swivel	1		116640	Model 249514	4
21	C32255	SENSOR, temperature	1		116640	Model 249512	6
22	17K470	CARTRIDGE, heater	2	*	<i>Parts included in Seal Kit 253553 (purchase separately).</i>		
23	C34009	TRIGGER, lock	1	◆	<i>Parts included in Repair Kit 289901 (purchase separately).</i>		
24	15X116	PIN, trigger	3	‡	<i>Model 249514 only.</i>		
25	C19950	SCREW, Cap	3	‡	<i>Model 249512 only.</i>		
26	15G020	HANGER	1	*	<i>Not shown.</i>		
27	15G121	WASHER, gun	1				
28*	065337	WIRE, copper, electric	1				

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

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

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

† Model 249515 only.

‡ Model 249513 only.

\* Not shown.

## Accessories

<b>Part No.</b>	<b>Description</b>
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

<b>Part No.</b>	<b>Description</b>
15X385	Gun body repair kit.

# Technical Specifications

<b>Hot Melt Dispense Guns</b>		
	<b>U.S.</b>	<b>Metric</b>
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	
<b>Notes:</b>		
All trademarks or registered trademarks are the property of their respective owners.		

## California Proposition 65

### CALIFORNIA RESIDENTS

 **WARNING:** Cancer and reproductive harm – [www.P65warnings.ca.gov](http://www.P65warnings.ca.gov).

# Graco Standard Warranty

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.

This warranty does not cover, and Graco shall not be liable for general wear and tear, or any malfunction, damage or wear caused by faulty installation, misapplication, abrasion, corrosion, inadequate or improper maintenance, negligence, accident, tampering, or substitution of non-Graco component parts. Nor shall Graco be liable for malfunction, damage or wear caused by the incompatibility of Graco equipment with structures, accessories, equipment or materials not supplied by Graco, or the improper design, manufacture, installation, operation or maintenance of structures, accessories, equipment or materials not supplied by Graco.

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.

**THIS WARRANTY IS EXCLUSIVE, AND IS IN LIEU OF ANY OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING BUT NOT LIMITED TO WARRANTY OF MERCHANTABILITY OR WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE.**

Graco's sole obligation and buyer's sole remedy for any breach of warranty shall be as set forth above. The buyer agrees that no other remedy (including, but not limited to, incidental or consequential damages for lost profits, lost sales, injury to person or property, or any other incidental or consequential loss) shall be available. Any action for breach of warranty must be brought within two (2) years of the date of sale.

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In no event will Graco be liable for indirect, incidental, special or consequential damages resulting from Graco supplying equipment hereunder, or the furnishing, performance, or use of any products or other goods sold hereto, whether due to a breach of contract, breach of warranty, the negligence of Graco, or otherwise.

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For patent information, see [www.graco.com/patents](http://www.graco.com/patents).

**TO PLACE AN ORDER**, contact your Graco distributor or call to identify the nearest distributor.

**Phone:** 612-623-6921 **or Toll Free:** 1-800-328-0211, **Fax:** 612-378-3505

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Original instructions. This manual contains English. MM 311209

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