

SYSTEM TROUBLESHOOTING GUIDE

SYMPTON	PROBLEM	CAUSE	
White spray and/or soft foam Alternate white bursts and/or soft foam Dark spray and/or brittle foam Alternate dark bursts and/or brittle foam	INCORRECT RATIO	Lacking Isocyanate <input type="checkbox"/> restriction <input type="checkbox"/> starvation Intermittent lack of Isocyanate <input type="checkbox"/> intermittent starvation Lacking Polyol <input type="checkbox"/> restriction <input type="checkbox"/> starvation Intermittent lack of Polyol <input type="checkbox"/> intermittent starvation	<input type="checkbox"/> if high pressure on Isocyanate pressure gauge check between gun and console <input type="checkbox"/> check from console to material supply system <input type="checkbox"/> check pumps on Isocyanate side <input type="checkbox"/> if high pressure on Polyol pressure gauge, check between gun and console <input type="checkbox"/> check from console to material supply system <input type="checkbox"/> check pumps on Polyol side
Stream of material not a spray Foam not fully expanded Popcorn appearance on foam surface	INCORRECT TEMPERATURE	Low temperature <input type="checkbox"/> incorrect setting <input type="checkbox"/> electrical fault Low temperature <input type="checkbox"/> incorrect setting <input type="checkbox"/> electrical fault High temperaute <input type="checkbox"/> incorrect setting <input type="checkbox"/> electrical fault	<input type="checkbox"/> increase as necessary <input type="checkbox"/> troubleshoot electrically <input type="checkbox"/> increase as necessary <input type="checkbox"/> troubleshoot electrically <input type="checkbox"/> reduce as necessary <input type="checkbox"/> troubleshoot electrically
Large droplets, small spray pattern Foam not fully expanded	INCORRECT MIXING	Low pressure <input type="checkbox"/> incorrect setting <input type="checkbox"/> starvation <input type="checkbox"/> pump fault Low pressure <input type="checkbox"/> incorrect setting <input type="checkbox"/> starvation <input type="checkbox"/> pump fault	<input type="checkbox"/> increase air pressure to proportioning unit <input type="checkbox"/> check from console to material supply system <input type="checkbox"/> repair as necessary <input type="checkbox"/> increase air pressure to proportioning unit <input type="checkbox"/> check from console to material supply system <input type="checkbox"/> repair as necessary

OFF RATION CONDITIONS

- Verify that the Heaters and Hose Heat are working properly
- A = ISO
- B = POLY

CAUSE		SOLUTION
A-side RICH (gauge high or normal)		B-side LACKING (gauge low)
<ul style="list-style-type: none"> ■ B-side Pump will not pickup material 	<ul style="list-style-type: none"> <input type="checkbox"/> Check fittings in-bound <input type="checkbox"/> If Transfer Pumps are used <input type="checkbox"/> Check B-side Transfer Pump Filter <input type="checkbox"/> Check B-side Main Pump 	<ul style="list-style-type: none"> <input type="checkbox"/> if they are loose, they will pull in air <input type="checkbox"/> verify that B Transfer Pump is properly operating <input type="checkbox"/> see if it is holding pressure on the up and down stroke <ul style="list-style-type: none"> a. If there is no pressure on the upstroke, check the Upper Ball, P/N APS-113 and Seat, P/N FS-112 b. If there is no pressure on the down stroke, check the Lower Ball, P/N APS-128 and Seat, P/N APS-199 c. If there is no pressure on either stroke, check the seal, P/N APS-305Y
A-side RICH (gauge low or normal)		B-side LACKING (gauge high)
<ul style="list-style-type: none"> ■ Restriction on B-side of system 	<ul style="list-style-type: none"> <input type="checkbox"/> Check Gun for cross-over in B-side block <input type="checkbox"/> Check for kinked Hose or debris in the system from out-bound side of Heater to Gun 	
A-side LACKING (gauge low)		B-side RICH (gauge high or normal)
<ul style="list-style-type: none"> ■ A-side Pump will not pickup material 	<ul style="list-style-type: none"> <input type="checkbox"/> Check fittings in-bound <input type="checkbox"/> Check Filter Screen in A-side of gun <input type="checkbox"/> If Transfer Pumps are used <input type="checkbox"/> Check A-side Transfer Pump Filter <input type="checkbox"/> Check A-side Main Pump 	<ul style="list-style-type: none"> <input type="checkbox"/> if they are loose, they will pull in air <input type="checkbox"/> verify that A Transfer Pump is properly operating <input type="checkbox"/> see if it is holding pressure on the up and down stroke <ul style="list-style-type: none"> a. If there is no pressure on the upstroke, check the Upper Ball, P/N APS-113 and Seat, P/N FS-112 b. If there is no pressure on the down stroke, check the Lower Ball, P/N APS-128 and Seat, P/N APS-199 c. If there is no pressure on either stroke, check the seal, P/N APS-305Y
A-side LACKING (gauge high or normal)		B-side RICH (gauge low)
<ul style="list-style-type: none"> ■ Restriction on A-side of system 	<ul style="list-style-type: none"> <input type="checkbox"/> Check Gun for cross-over in A-side block <input type="checkbox"/> Check Filter Screen in A-side of Gun <input type="checkbox"/> Check for kinked Hose or debris in the system from out-bound side of Heater to Gun 	