

# 248860 Threaded Insert Kit

310767B

For Fusion™ Spray Guns with date code B17 or prior.



Read warnings and instructions in the Fusion gun manuals 309550 or 309856.



## WARNING



Follow **Pressure Relief Procedure** in gun manual 309550 or 309856 before disassembling gun and installing kit.



Before beginning, ensure that the following items are on hand:

- Part No. 15E684 5 Minute® Epoxy (order separately). MSDS sheet MSD027 available at [www.graco.com](http://www.graco.com).
- a thin, clean mixing stick
- a clean rag.


1. Remove the existing threaded insert from the fluid housing, if possible.



If you cannot remove the threaded insert, order a new fluid housing assembly kit (246491 for air purge guns or 248004 for mechanical purge guns).

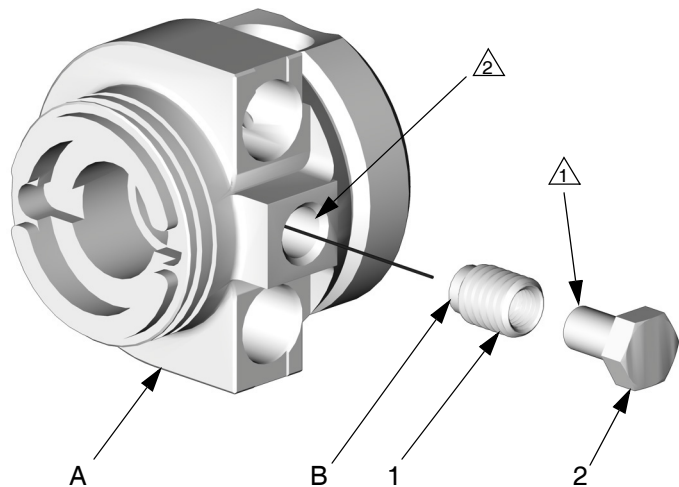
2. Thoroughly clean the threads in the fluid housing (A) with solvent, to remove any grease or oil. Dry threads thoroughly. See the illustration on page 2.
3. Spread a thin layer of lubricant on the end of the bolt (2), to prevent any over-applied epoxy residue from curing on the bolt.
4. With the stepped down diameter (B) of the threaded insert (1) opposite the bolt head, spin the insert onto the bolt until it contacts the bolt head. Keep the outside threads of the insert free of lubricant.


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 Part No. 15E684 Epoxy is a 2 component material which must be mixed by hand. Each dual-barrel cartridge contains enough material for several applications.

5. Break off the end of both epoxy tubes. Hold the dispensing ends up until the air bubbles rise to the end. Dispense onto a disposable surface until all air is expelled. Discard this material; it is not usable. Then dispense equal amounts of air-free epoxy. Mix for 30 sec with a thin, clean mixing stick. Immediately spread a thin, even amount on the first few internal threads of the fluid housing (A) only. Do not apply to the threaded insert (1). Do not over apply. Wipe off excess from the fluid housing top surface.
6. Install the threaded insert (1) within 2 minutes, until the bolt head bottoms out on the fluid housing top surface. Leave the bolt in place to cure for 1 hour minimum.
7. After 1 hour cure time, remove the bolt (2); the insert should remain in place. If the insert comes out, the fluid housing threads were not clean enough or the epoxy was not mixed or applied correctly. If so, repeat the process.

Ref. No.	Description	Qty
1	INSERT, threaded	1
2	BOLT, nylon	1



 Apply lubricant to end of bolt (2).

 Apply epoxy to first few internal threads of fluid housing (A).

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## Graco Information

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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 310767

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