Set Up and Functions of a Manual Proportioning Unit

Contents:
- Operator Manual
- Maintenance
- Warranty Policy
- Parts List
Components of The Manual Proportioning Unit

- Pump assembly (2)
  - Glass cylinders
  - Spring energized piston

- Discharge check valve assembly (2)
  - One for each pump

- Product selector shut off valves (2)
  - Front pump only

- Wetting Cup

- Suction check valve assembly (2)
  - One for each pump

- Material suction hoses (3)

- Can Clamps (3)
Set Up and Functions of The Manual Proportioning Unit

- Place all three suction hoses in a container of Acetone. Be sure to submerge the hose ends.
- Turn both of the product selector shut off valves for the front cylinder to the OPEN position (horizontal).
- Remove the wetting cup from the dispensing head assembly and place an empty container beneath the machine.
- Starting with the pump handle in the lowest position, apply very small quick pump strokes (about an inch of piston movement) upward to prime the pumps with Acetone.
- Slowly lift the pump handle to its full upward position, this will fill both glass cylinders with Acetone.
- Pull the pump handle down to dispense the Acetone out of the two tubes at the front of the machine.
- You are now ready to install the cans of product.
Based on the product that is intended for use, select the proper orientation of the cylinders to achieve the desired ratio. Make sure that both pistons bottom out after adjusting the ratio by adjusting the height of the clevis (P0436 - See page 11).
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Operating the proportioning unit:
(with a 2:1 ratio)

You have a choice of three speeds of clear coat:

- With only the left product selector open... This is the fast clear.
- With only the right product selector open... This is the slow clear.
- With both product selectors open... This is the medium clear.

- Before changing to a new selection of clear, make sure the pump handle is in the lowest position.

- Always finish the dispensing with the pump handle in the lowest position.

- If you require less then 5 fl. Oz. do not lift the handle fully.

- Do not try to operate with both product selector valves off (vertical).
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Priming Instructions:

1. Make sure that the two product selector shut off valves are in the open position (horizontal).

2. Unscrew and remove the wetting cup from the dispensing head assembly, and place an empty container beneath the machine.

3. Starting with the pump handle in the lowest position, apply very quick pump strokes (about an inch of piston movement) upward to prime the pumps with product.

4. Once both cylinders are drawing material without a gap between the fluid and the piston, the unit is primed.
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Priming Instructions continued:

*Please refer to the technical data sheet to select the correct choice of product.*

You are now ready to use the Manual Proportioning Unit. Place the desired products into position under the cylinders.

- By turning the left product selector valve open (horizontal) and the right selector valve in the closed position (vertical) you can draw from the can in the front left position.

- By turning the left product selector valve closed (vertical) and the right selector valve in the open position (horizontal) you can draw from the can in the front right position.

Make sure to run enough product through the unit to flush out the Acetone used for the initial prime.
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Operating the proportioning unit:
(These required steps are extremely important to the longevity of the machine.)

After every dispensing:
- The two product selector valves must be in the closed position (vertical).
- Make sure the pump arm is in the lowest position.
- Add ¼ to ½ inch of Acetone to the wetting cup and screw the cup on the dispensing head assembly.

At the end of every work day:
- The two product selector valves must be in the closed position (vertical).
- Make sure the pump arm is in the lowest position.
- Clean the wetting cup and add ¼ to ½ inch Acetone and screw the wetting cup on the dispensing head assembly.

Note: DO NOT fill the wetting cup enough to submerge the dispensing tube openings. Solvent MUST be below dispensing tips to allow vapor inside the tubes.
Preventative Maintenance:

- Check the cylinders to ensure that no material is above the piston.
  - If material has gotten above the piston, clean the cylinder immediately to prevent damage to components.

- Be sure to use the wetting cup at the end of each day.

- If material is not being drawn into the cylinders:
  - Remove check valve and soak in Acetone.
  - Clean valve and attempt to actuate by pressing here:
  - Once confirmed that the valve is operating correctly, reassemble valve to unit (using Loctite 567 thread sealant) in the same orientation as originally installed.

- Make sure suction screens are clear to allow for unrestricted flow of material.
Dedoes Industries warrants the following parts against defects of workmanship and materials for the following periods:

36 Months: Frame

30 Days: Glass cylinders, pistons, check valves, and stainless steel fittings

This warranty covers these parts when defective or damaged due to equipment operational errors. This warranty does not cover any item that has been damaged due to mutilation, alteration, misuse, or abuse. Corrosion due to neglect or chemicals is not covered by this warranty. Dedoes Industries will not be responsible for loss of time, inconvenience, or other consequential damages.

Under no circumstances should the unit or any part there-of be returned to the factory for inspection, replacement, and/or repair without the express written consent of Dedoes Industries, Inc. This is the only warranty on Dedoes products and no other expressed warranty by anyone other than Dedoes, in writing, will be binding on the manufacturer. This warranty is non transferable.

IMPORTANT: USE ONLY DEDOES REPLACEMENT PARTS OR WARRANTY IS VOID.
## Part's List And Break Down of The Manual Proportioning Unit

**Discharge Assembly Components**
- P0441C
  - DISCHARGE HOSE FRONT
- P0441D
  - DISCHARGE HOSE REAR
- P0463M
  - REDUCER 3/8"-1/2" MODIFIED
- P0459M
  - WETTING CUP CAP DRILLED
- F500288
  - INNER CAP MOUNT
- P0453A
  - DISCHARGE TUBE
- P0461
  - WETTING CUP

**Front Suction Assembly Components**
- P0440
  - SPRING CLIP
- P1225
  - COMPRESSION SPRING
- P0449
  - GROMMET
- P1109
  - PAINT CAP (Not Included)
- P0454
  - SUCTION HOSE
- P0440
  - SPRING CLIP
- P0458
  - SUCTION HOSE BARB
- P0464
  - SUCTION SCREEN ASSEMBLY

**Back Suction Assembly Components**
- P0459M
  - REDUCER 3/8"-1/2" MODIFIED
- F500288
  - INNER CAP MOUNT
- P0453A
  - DISCHARGE TUBE
- P0454
  - GROMMET

**SA0091 Suction Hose Kit**
- P0440
  - SPRING CLIP
- P1225
  - COMPRESSION SPRING
- P0449
  - GROMMET

**SA0256 Suction Check Valve Replacement**
- P1225
  - COMPRESSION SPRING
- P0449
  - GROMMET

**SA0215 Rear Discharge Hose Kit**
- P0441D
  - DISCHARGE CHECK VALVE
- P1892
  - CONNECTOR FEMALE NPT
- P1889
  - TEE 1/4 NPT STAINLESS
- P0446
  - PIPE NIPPLE 1/4"
- P0456
  - BALL VALVE
- P1890
  - STREET ELBOW
- P0451
  - HOSE BARB DOUBLE PUMP

**SA0216 Front Discharge Hose Kit**
- P0441C
  - DISCHARGE HOSE FRONT
- P0453A
  - DISCHARGE TUBE
- P0463M
  - REDUCER
- P0454
  - SUCTION HOSE
Part's List And Break Down of The Manual Proportioning Unit

- SA0256 Suction Check Valve
- P1891 Bottom Pump Cap
- SA0255 Discharge Check Valve
- P0467 Glass Cylinder Tube
- P0436 Clevis
- P0465 Pump Top Cap
- P0472 Piston Rod
- P0466 Top Seal
- P0468 Tie Rod
- P0467 Glass Cylinder Tube
- SA0255 Discharge Check Valve
- P0439 Compression Fitting
- P1888 Acorn Nut 1/4-20
- P0465 Pump Top Cap
- P0472 Piston Rod
- P0466 Top Seal
- P0468 Tie Rod
- P0470 Bottom O-Ring Seal
- P1893 Cylinder Plunger
- SA0154 Spring Energized Piston
- P0476 Plunger Washer
- P0477 Allen Bolt 1/4-28
- P0478 Jam Nut 5/16-24
- P1891 Bottom Pump Cap
- SA0256 Suction Check Valve