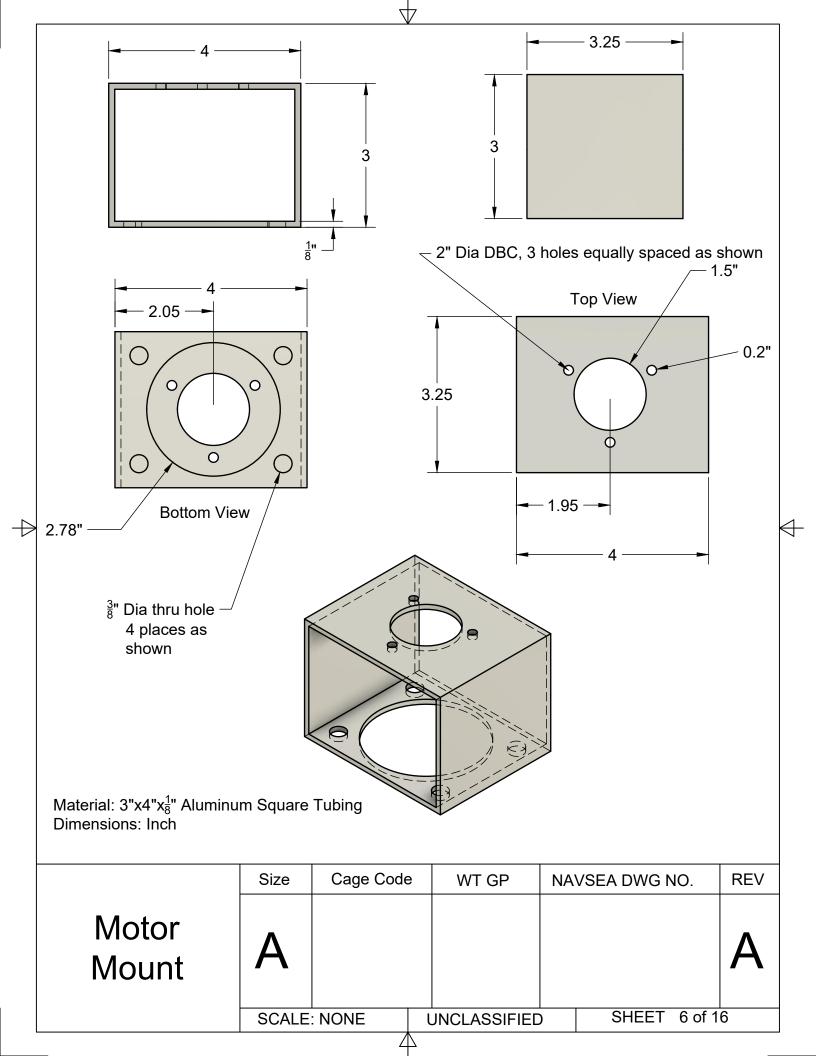
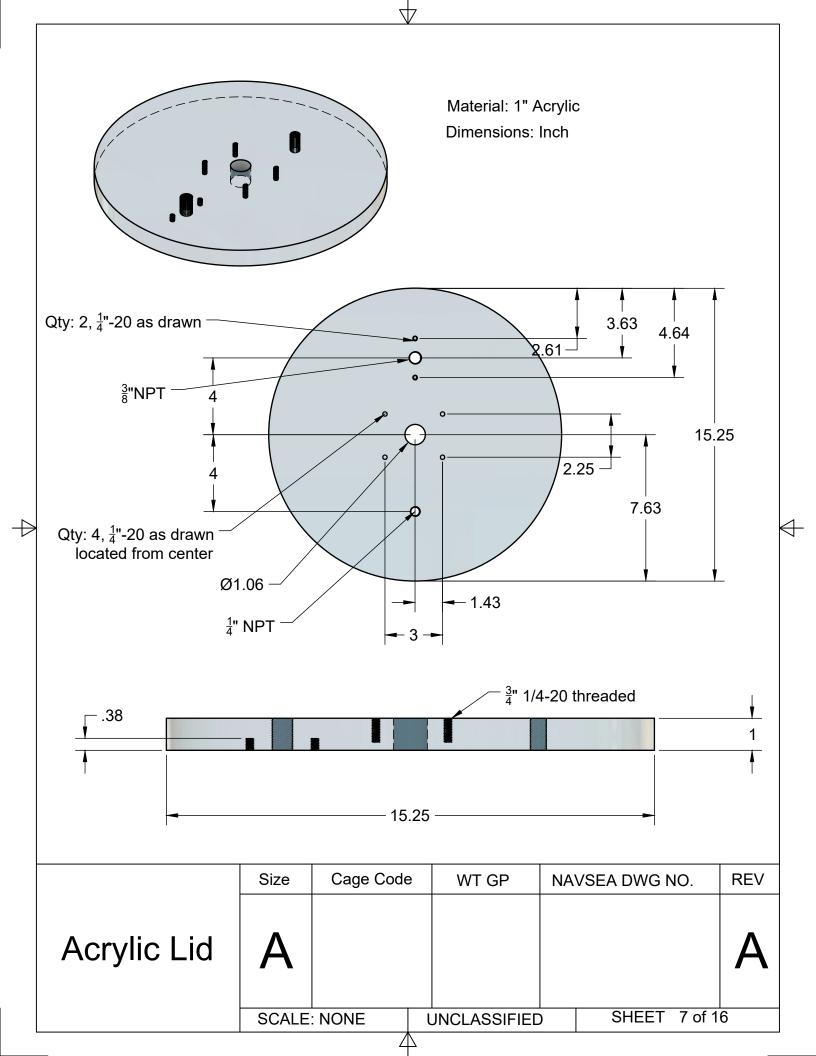
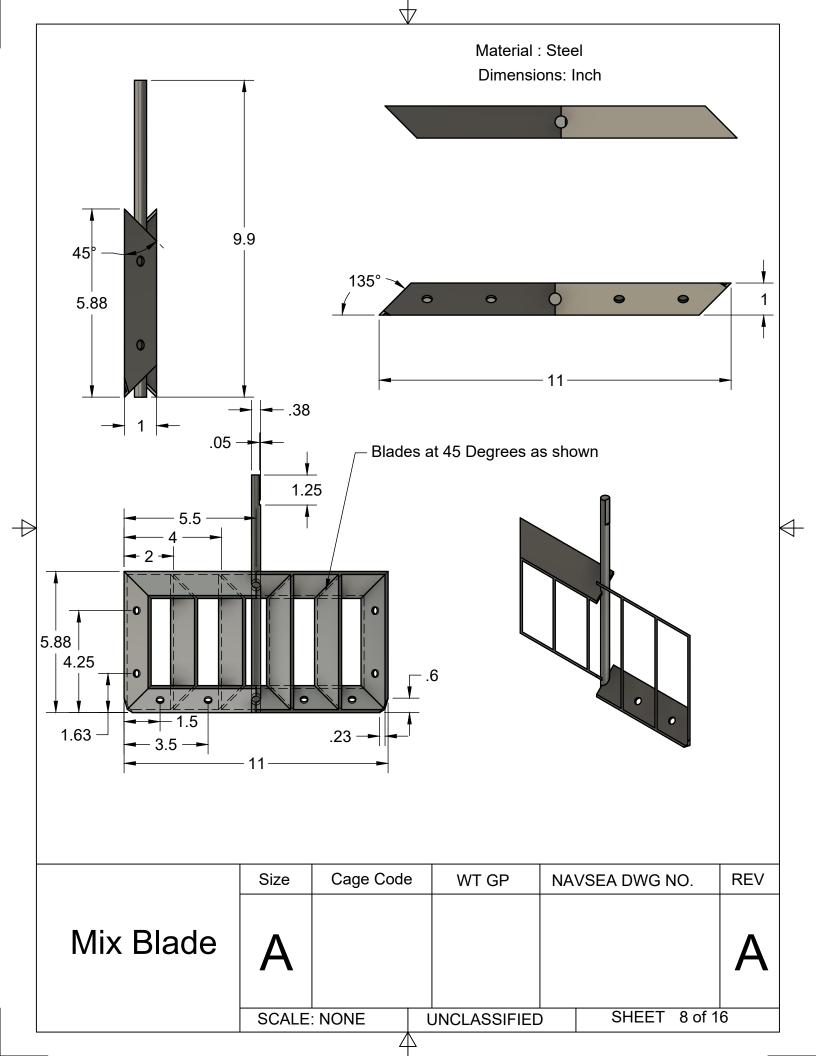
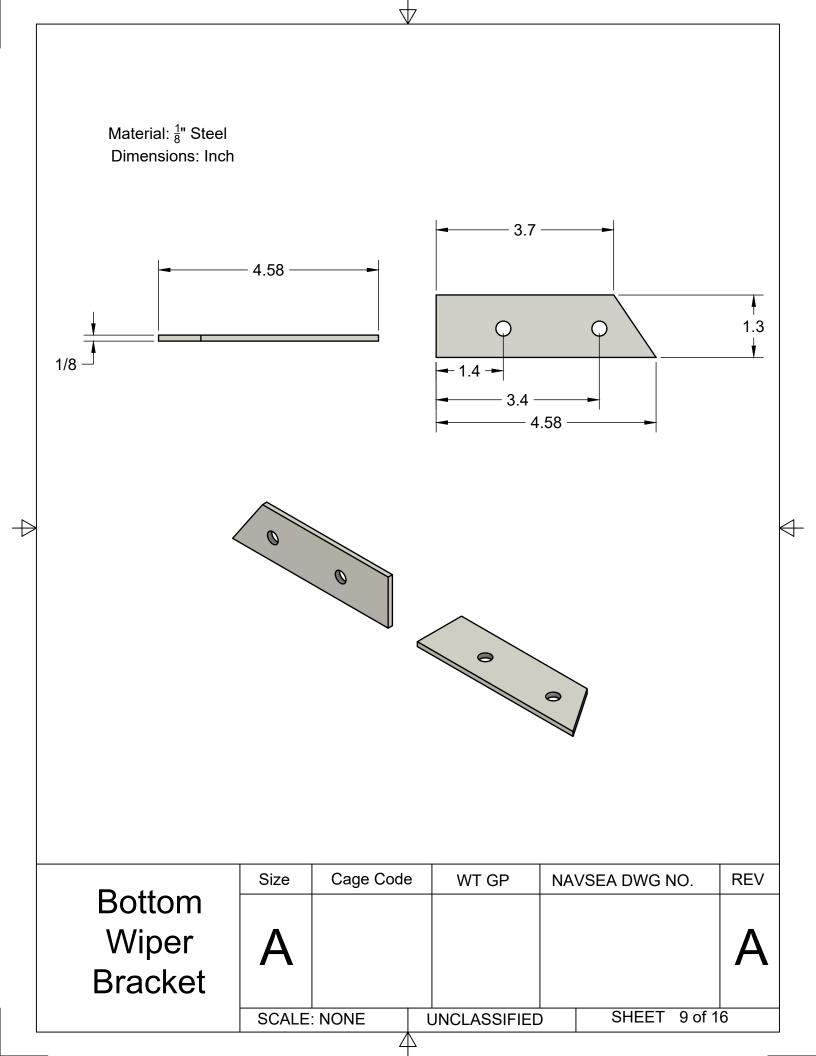


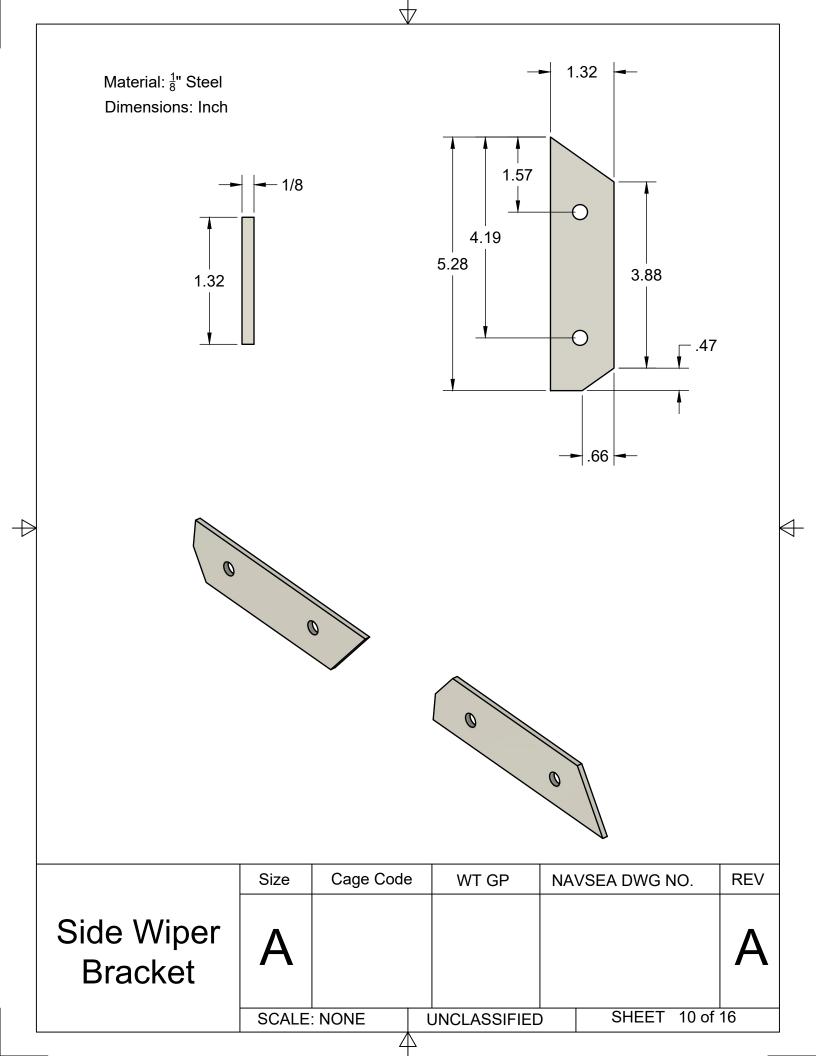
Item Number	Part Name		Manufacturer/Part #		Quantity	Notes		
1	Air Powered Gea	ar Motor		Mcmaster 59795K790		1		
2	Motor Mount		Manufactured		1	See Sheet	t 6	
3	Vacuum Gauge			Mcmaster 3941K123		1		
4	Ball Valve			Mcmaster 4	726K460	1		
5	Pipe Tee			Mcmaster 4	452K432	1		
6	Pipe Nipple			Mcmaster 4	4615K412	1		
7	Ball Valve			Mcmaster 4	7K120	1		
8	Flexible Shaft Co	oupler		Mcmaster 6	208K623	1		
9	Socket Head Ca	p Screw		Mcmaster 9	1251A539	4	$\frac{1}{4}$ "-20 $\frac{3}{8}$ "	
10	Washer			Mcmaster 9	0107A029	4	<u>1</u> 111	
11	Lock Washer			Mcmaster 9	214A029	4	<u>1</u> 111	
12	Vent Diffuser			Manufactured		1	See Sheet	14
13	Socket Head Ca	p Screw		Mcmaster 91251A539		2	½"-20 3"	
14	Vacuum Bearing			FerroTec 132910-SS-375-SLBE -HD-STD		1		
15	Shaft Coupler			Mcmaster 6115K220		1		
16	Socket Head Cap Screw		Mcmaster 91251A340		3	10-32 ³ / ₈ "	-	
17	Washer			Mcmaster 90107A011		3	10-32"	
18	Lid			Manufactured			See Sheet	t 7
19	Mix Bucket O-Ri	ng		Lacotech LGR18B		1		
20	Hose Clamp			LacoTech L	MS8101	1		
21	Mix Bucket			Manufacture	ed	1	See Sheet	13
22	Mix Blade			Manufacture	ed	1	See Sheet	t 8
23	Side Wiper Brac	ket		Manufacture	ed	2	See Sheet	10
24	Side Wiper			Manufacture	ed	2	See Sheet 12	
25	Bottom Wiper Br	acket		Manufactured		2	See Sheet 9	
26	Bottom Wiper			Manufactured		2	See Sheet	11
		Size	C	age Code	WT GP	NAVSEA	A DWG NO.	REV
Par	rts List	Α						A
	ļ	SCALE:	: NO	NE l	JNCLASSIF	IED	SHEET 5 of 1	6

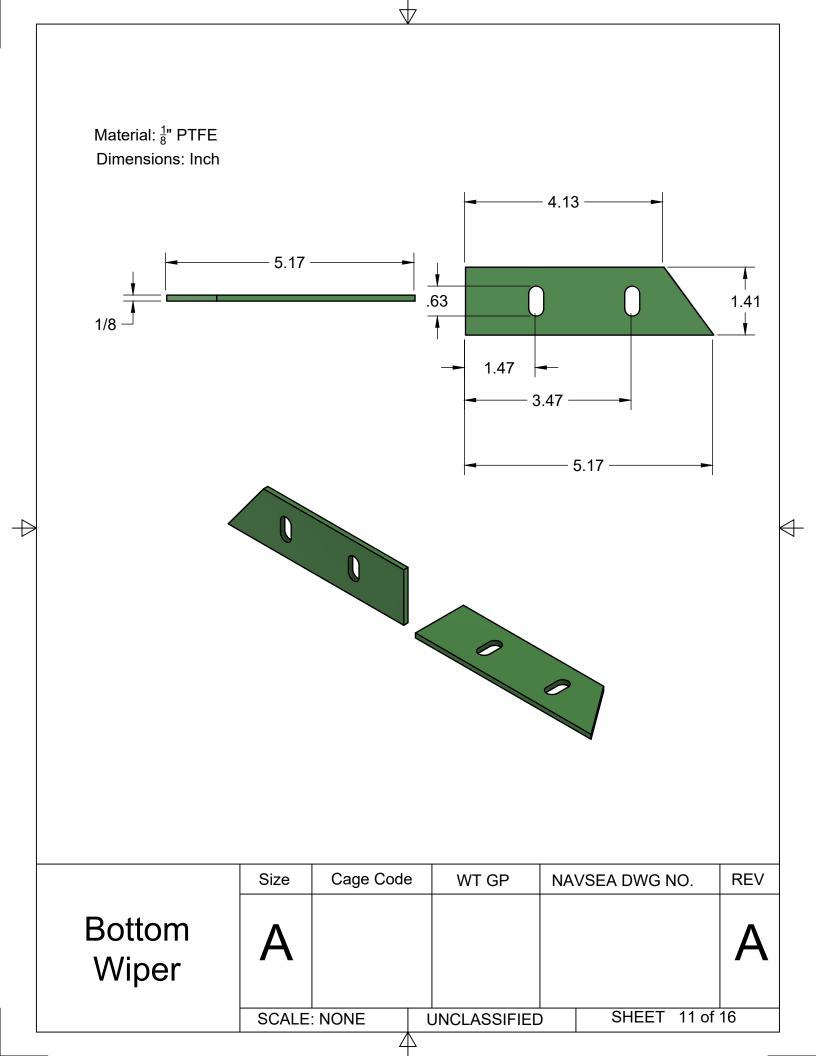


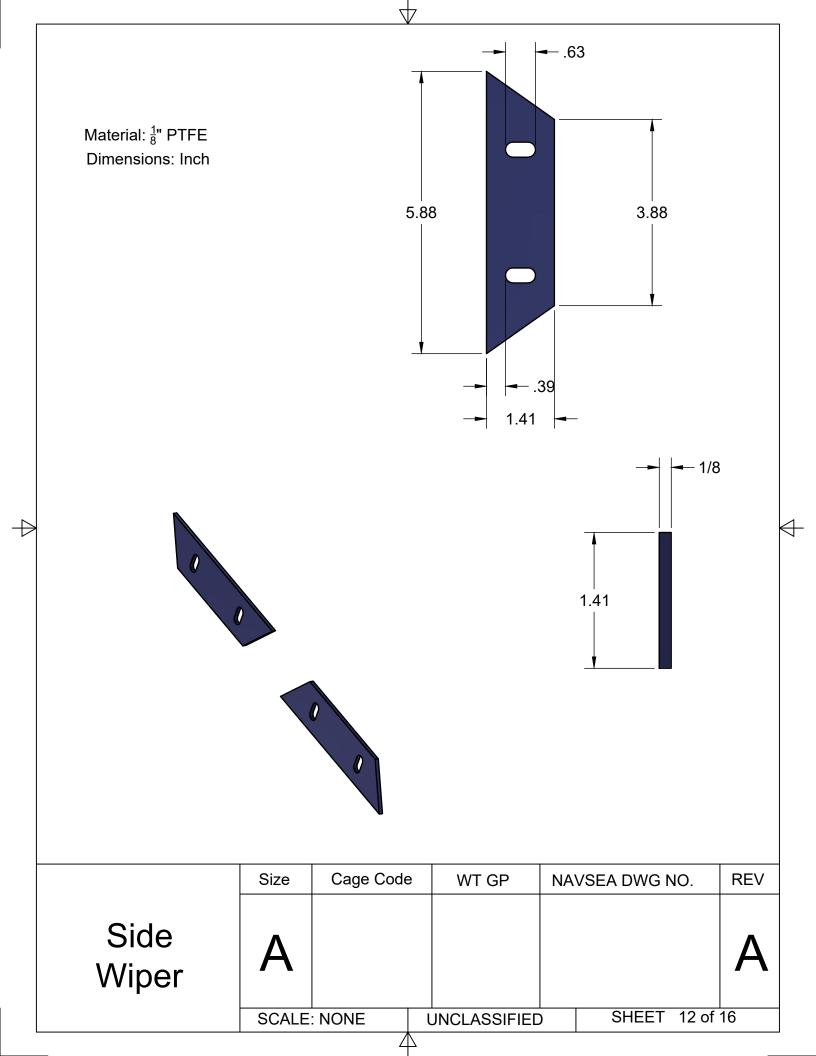


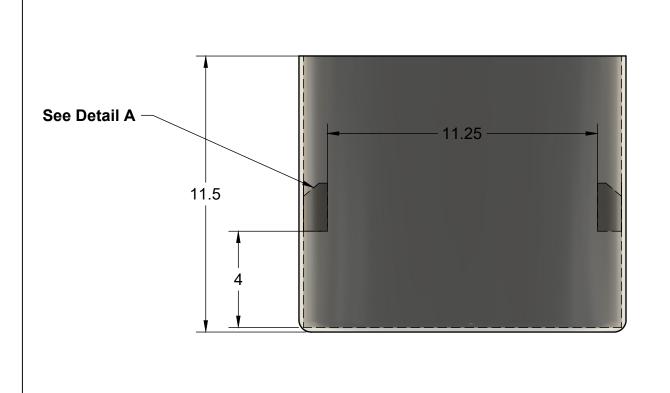


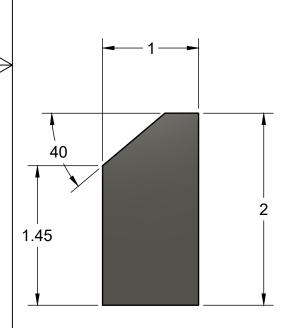


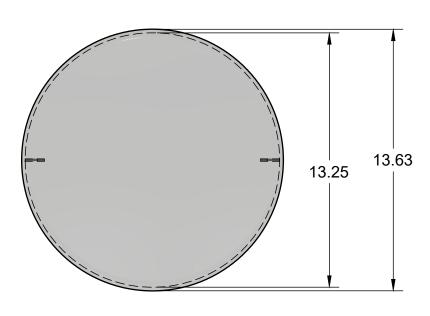








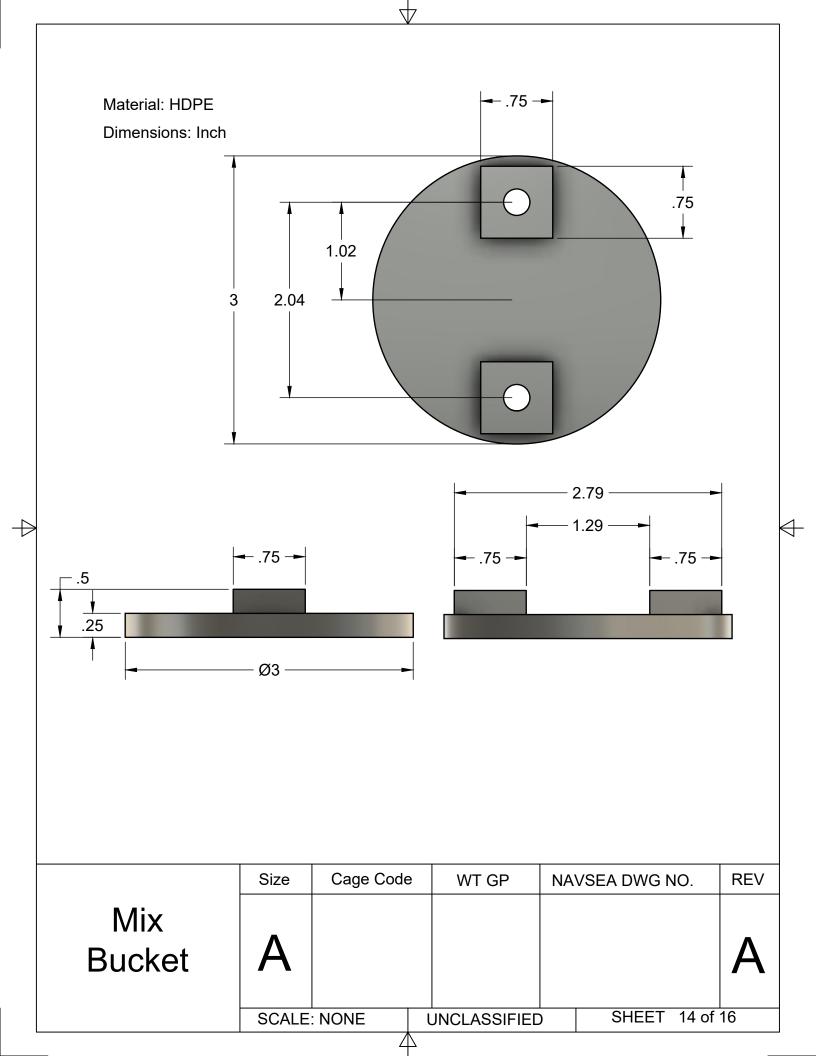




Detail A: Weld In Bucket Tab

	Size	Cage Code	WIGP	NAVSEA DWG N	IU. REV
Mix Bucket	Α				A
	SCALE: NONE		UNCLASSIFIE	SHEET	13 of 16

4



Safety

Wear gloves and eye protection when removing and installing fittings, valves, and hoses. Ensure all connections are tight.

Wear gloves and eye protection when operating mixer.

Inspection

Perform visual check of mix pot to ensure pneumatic hose, vacuum hose, and fittings are not damaged, frayed, or worn. Place lid on mix pot.

Mix Pot Set-Up

- 1. Verify all screws on the mix blade coupling are tight.
- 2. Connect the air, vacuum, and exhaust muffler hoses as shown in Figure (1).
- 3. Fully extend exhaust hose away from work area.
- 4. Place lid on mix pot.

NOTE: Prior to mixing material, verify operation of the mixer.

NOTE: Do not remove mix blade.

Set Up and System Check

- 1. Turn air valve on and open air pressure regulator (clockwise direction) to increase air pressure to 30-50 psi.
- 2. Reduce pressure to zero and close the valve.
- 3. Turn the vacuum valve on and verify a minimum of 28 in. Hg is achieved. Close the valve. If 28 in. Hg cannot be achieved, check connections, hoses for leaks, and gasket on top edge of mix pot.
- 4. SLOWY open the vacuum vent valve located on the side of the pot to release vacuum from the mix pot.
- 5. Remove the mix pot lid. Mix pot is ready to mix a 2.5 gallon kit of Versathane Neat Primer.

	Size	Cage Code	WT GP	NA	VSEA DWG N	IO.	REV
Set-Up and Safety Check	Α						Α
	SCALE: NONE		UNCLASSIFIED	Ò	SHEET	15 of	16

MIX POT OPERATING PROCEDURES (Aug 2016)

NOTE: Gloves and Eye Protection shall be worn prior to mixing

- 1. Prior to mixing, verify that the temperature of Inspect Part B for formation of snowballs or frosty white appearance which indicates material is frozen. Also, inspect pails for dents or damage. If dents are identified that will negatively impact placement of the pail in the mix pot, transfer material to a new or recently used cleaned pail.
- 2. If Part B is frozen, thaw by heating pails in an oven for 2 hours at 140 degrees For 4 hours at 120 degrees F. Upon removal from the oven, condition the material until it reaches 75-90 degrees F.
- 3. Place a pail of the state of the mix pot. (The handles of the pail should rest against the two vertical guides.)
- 4. Pour two premeasured bottles of the pail containing
- Place the lid on the mix pot.
- 6. Set the pressure regulator to zero. (counterclockwise direction).
- 7. Open air valve and slowly open air pressure regulator (clockwise direction) until mix blade moves and completes 2-3 rotations which will align the mix pot and lid. Keep the mixer on at a slow speed to prevent it from stalling when the vacuum is turned on.
- 8. Turn the vacuum valve on (lid may require pressure applied around edges to ensure contact for vacuum to be initiated). When 25 in. Hg is obtained, slowly increase air pressure as vacuum increases to maintain a mixer speed between 30-50 psi. Monitor pot to ensure material does not overflow. May need to vent the vacuum to prevent overflow and/or adjust mixer speed by opening/closing the airline valve. Slight movement of the pail is acceptable during the mixing.
- 9. while maintaining air pressure between (30-50) psi the industrial will rice are
- 10. After mixing is complete, turn the air and vacuum valves off.
- 11. SLOWLY open the vacuum vent valve located on the side of the mix pot to release vacuum from the mix pot.
- 12. Carefully lift the lid with the mix blade. While keeping the mix blade over the pail, wipe down the mix blade using wooden tongue depressors, plastic squeegee or equivalent.

Note: Do not use metal, since blade surfaces and the mix pot are Teflon coated.

13. Place the lid with mix blade on a piece of cardboard or mat to collect the extra mixed material.

14.

15. Upon completing mixing the last pail, begin the cleaning process.

Note: Do not scrape the bottom and sides of the pail.

Mix Pot Cleaning

16. Use IPA with clean rags to wipe down mix pot, blade, and other areas of the mix pot assembly that were splattered with Versathane Neat Primer. The lid should not require cleaning. However, if cleaning is required, use IPA. DO NOT use Acetone on the lid.

	Size	Cage Code	WT GP	NAVSEA DWG	NO. REV		
Mix Pot Operation	A				Α		
	SCALE: NONE		UNCLASSIFIE	SHEET	SHEET 16 of 16		