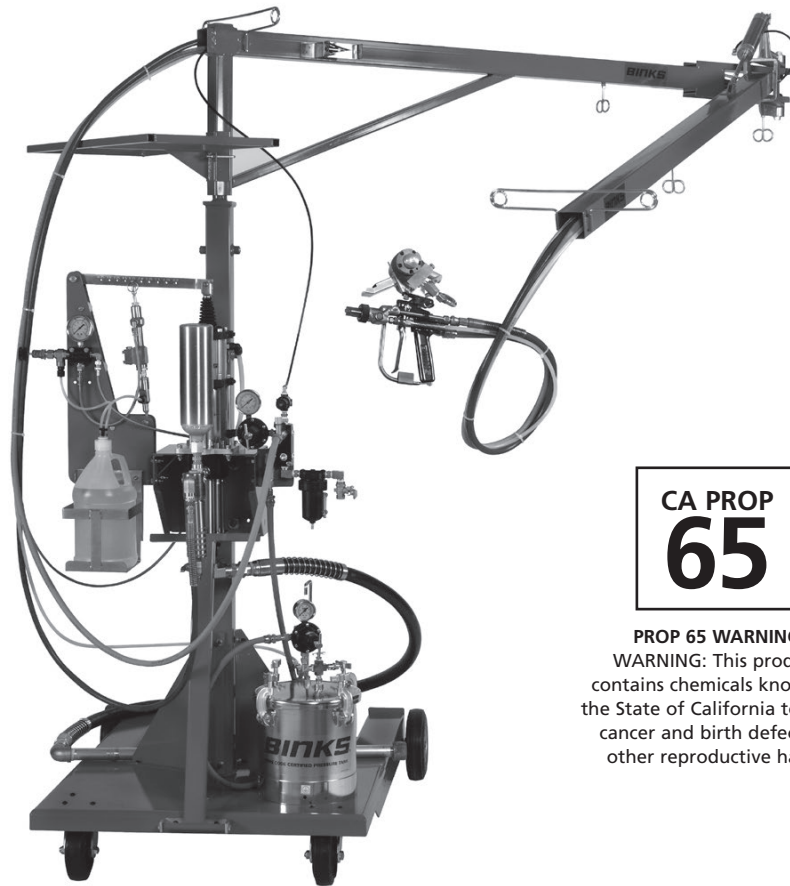


**CENTURY INTERNAL MIX LEL CHOP SYSTEMS**

Models: CX2006HC-U000000, CX2006HC-V000000, CX2017HC-U000000, CX2017HC-V000000



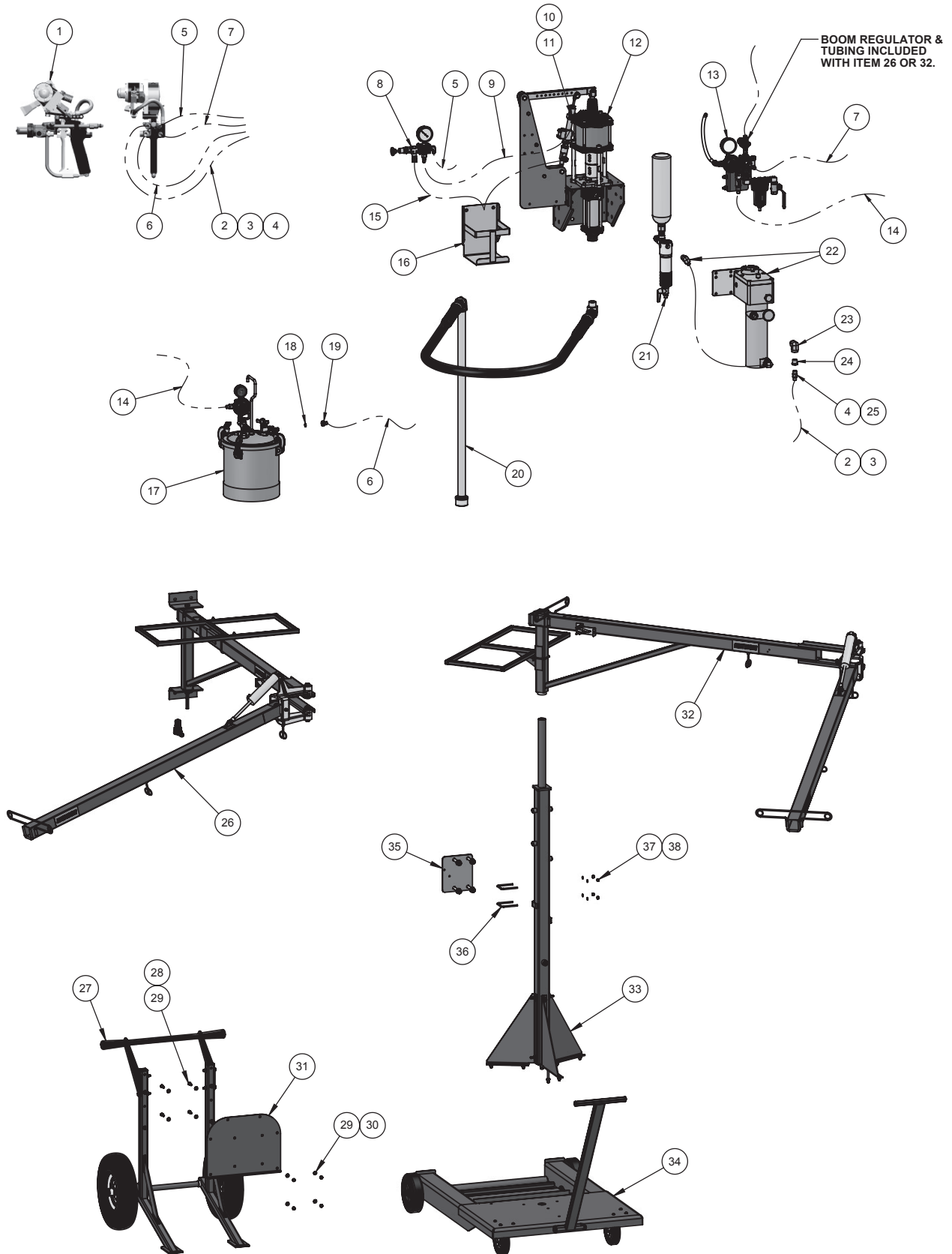
CA PROP  
**65**

**PROP 65 WARNING**  
WARNING: This product contains chemicals known to the State of California to cause cancer and birth defects or other reproductive harm.

SPECIFICATIONS		
	CX2006HC	CX2017HC
Ratio:	6.5:1	17:1
Maximum air inlet pressure:	116 psi (8 bar)	116 psi (8 bar)
Maximum recommended continuous cycle rate:	20 cycles/min	20 cycles/min
Air consumption @ 20 cycles/min and 116 psi (8 bar) air inlet pressure:	5.2 SCFM (147 LPM)	17.6 SCFM (498 LPM)
Maximum fluid pressure:	750 psi (52 bar)	1970 psi (136 bar)
Displacement per cycle:	4.3 oz (127 cc)	4.3 oz (127 cc)
Output @ 60 cycles/min:	2.0 gal/m (7.6 l/m)	2.0 gal/m (7.6 l/m)
Maximum operating temperature:	160°F (71°C)	160°F (71°C)
Air inlet connection:	3/8" NPT (F)	3/8" NPT (F)
Piston diameter:	3.3 in (85 mm)	5.5 in (140 mm)
Stroke length:	3 in (75 mm)	3 in (75 mm)
Sound level:	96.2 dB	97.3 dB
Fluid inlet connection:	1 1/4" NPT (M) & 1" NPT (F)	1 1/4" NPT (M) & 1" NPT (F)

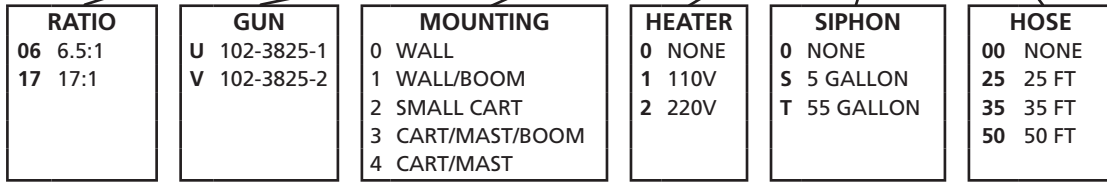
**CENTURY INTERNAL MIX LEL CHOP SYSTEMS**

**Models: CX2006HC-U000000, CX2006HC-V000000, CX2017HC-U000000,  
CX2017HC-V000000**



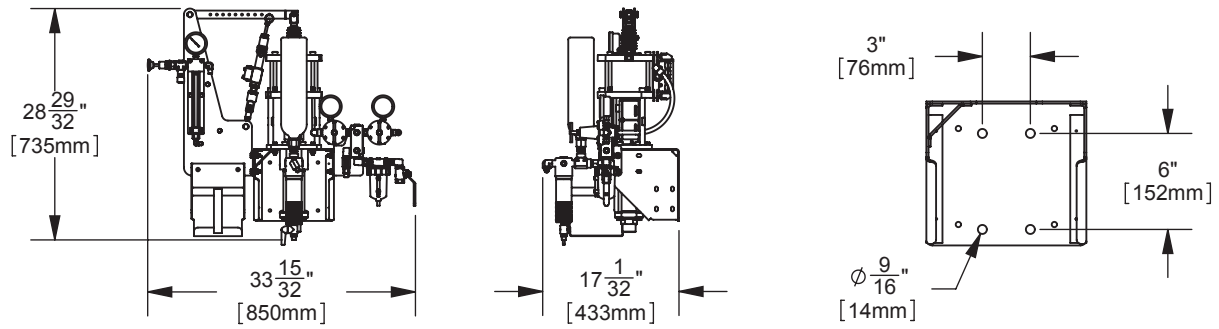
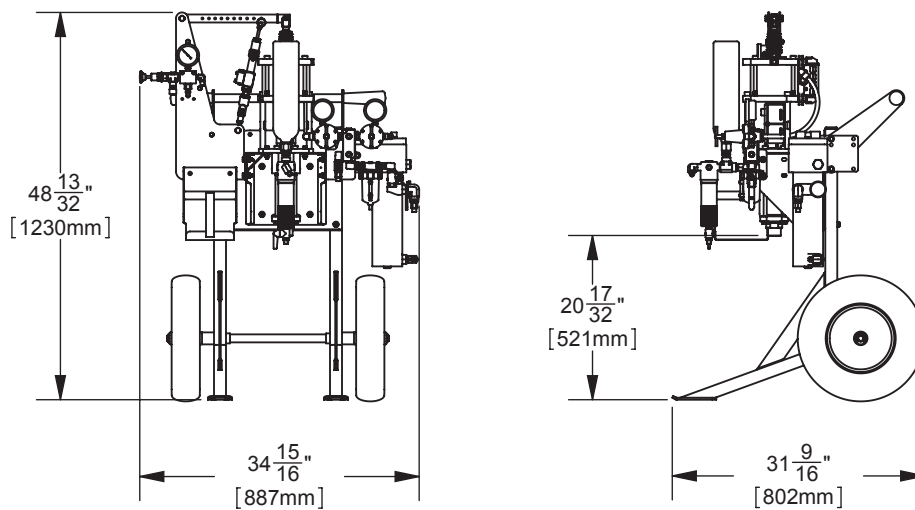
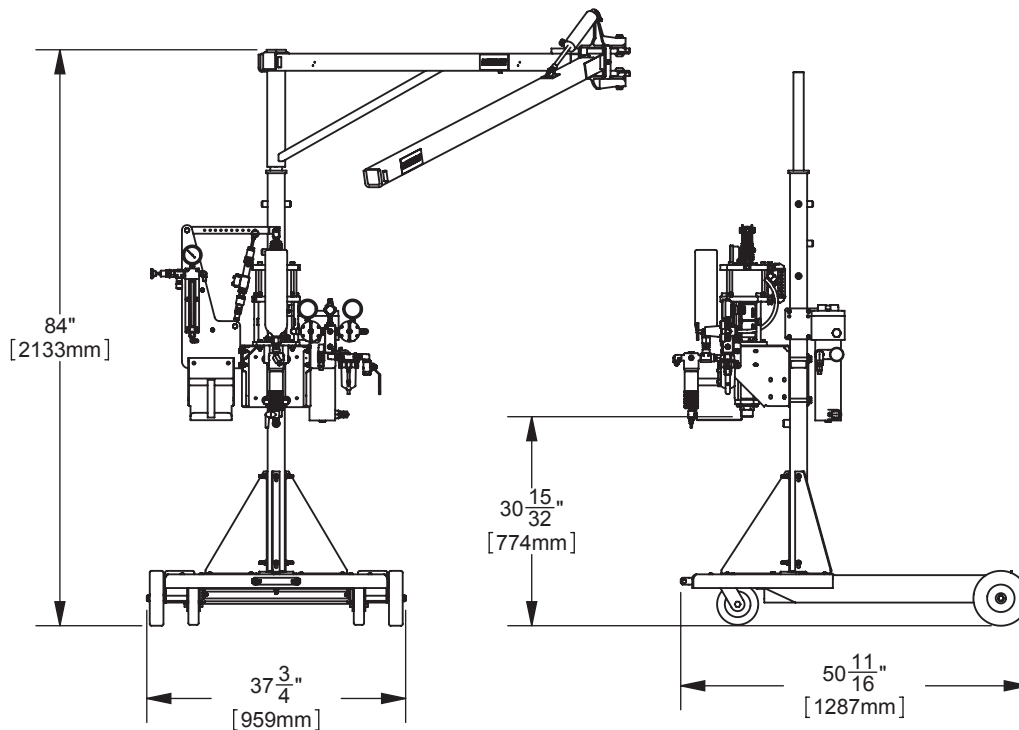
**CENTURY INTERNAL MIX LEL CHOP SYSTEMS**

**CX20      HC –      M**



**SYSTEM COMPONENT LIST**

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	PART SHEET
1	102-3825-1	CENTURY INTERNAL MIX LEL CHOP GUN (1" MIXER)	1 IF GUN = U	77-2914
	102-3825-2	CENTURY INTERNAL MIX LEL CHOP GUN (2" MIXER)	1 IF GUN = V	
2	71-7504	MATERIAL HOSE, 5/16" ID, 25 FT	1 IF HOSE = 25 or 50	
	71-7502	MATERIAL HOSE, 5/16" ID, 10 FT	1 IF HOSE = 35	
3	71-8424	MATERIAL HOSE, 3/8" ID, 25 FT	1 IF HOSE = 35 or 50	
4	83-4233	DM NIPPLE	1 IF HOSE = 25, 35, 50	
5	207-12305-4	CATALYST HOSE ASSEMBLY, 25 FT	1 IF HOSE = 25	
	207-12305-7	CATALYST HOSE ASSEMBLY, 35 FT	1 IF HOSE = 35	
	207-12305-6	CATALYST HOSE ASSEMBLY, 50 FT	1 IF HOSE = 50	
6	207-11512-3	SOLVENT HOSE ASSEMBLY, 25 FT	1 IF HOSE = 25	
	207-11512-5	SOLVENT HOSE ASSEMBLY, 35 FT	1 IF HOSE = 35	
	207-11512-8	SOLVENT HOSE ASSEMBLY, 50 FT	1 IF HOSE = 50	
7	71-31101	CHOP AIR HOSE ASSEMBLY, 25 FT	1 IF HOSE = 25	
	71-31104	CHOP AIR HOSE ASSEMBLY, 35 FT	1 IF HOSE = 35	
	71-31102	CHOP AIR HOSE ASSEMBLY, 50 FT	1 IF HOSE = 50	
8	101-9469-1000	MEDIUM PRESSURE MANIFOLD ASSEMBLY	1 IF RATIO = 06	77-2945
	101-9469-2000	HIGH PRESSURE MANIFOLD ASSEMBLY	1 IF RATIO = 17	
9	207-12305-9	CATALYST HOSE, 17"	1	
10	107-1646	MALE ELBOW	1	
11	237-908	TUBE CONNECTOR	1	
12	CX2006HC	CX2006HC PUMP ASSEMBLY	1 IF RATIO = 06	77-2940
	CX2017HC	CX2017HC PUMP ASSEMBLY	1 IF RATIO = 17	
13	103-1901-C	AIR CONTROL ASSEMBLY	1	77-2944
14	71-1201	AIR HOSE ASSEMBLY, 5 FT	1	
15	207-11972	CATALYST SIPHON/RETURN HOSE ASSEMBLY	1	
16	101-9435-K	CATALYST SUPPLY BOTTLE BRACKET KIT	1	
17	83C-210	PT CODE PRESSURE TANK ASSEMBLY	1	SBBI-21-044
18	54-1439	GASKET	1	
19	72-55	ADAPTER FITTING	1	
20	103-1068	55 GAL. SIPHON KIT ASSEMBLY	1 IF SIPHON = T	77-2126
	103-1093	5 GAL. SIPHON KIT ASSEMBLY	1 IF SIPHON = S	
21	207-12259-1	FILTER ASSEMBLY (60 MESH)	1	77-2807
22	207-12351	HEATER KIT (120V)	1 IF HEATER = 1	77-2812
	207-12352	HEATER KIT (220V)	1 IF HEATER = 2	
23	20-3340-1	STREET ELBOW	1 IF HOSE = 25, 35, 50	
24	20-3823-1	BUSHING	1 IF HOSE = 25, 35, 50	
25	72-998	DM NIPPLE	1 IF HOSE = 35 or 50	
26	203-1609	WALL MOUNTED CHOP BOOM ASSEMBLY	1 IF MOUNT = 1	77-2311
27	41-28050	CART ASSEMBLY	1 IF MOUNT = 2	77-2902
28	20-376-1	HEX HEAD CAP SCREW	4 IF MOUNT = 2	
29	20-264-1	FLAT WASHER	8 IF MOUNT = 2	
30	237-205	NYLOK HEX NUT	4 IF MOUNT = 2	
31	101-9445	CART ADAPTER BRACKET	1 IF MOUNT = 2	
32	103-1601	CHOP BOOM ASSEMBLY	1 IF MOUNT = 3	77-2311
33	103-1602	AIR MANIFOLD ASSEMBLY	1 IF MOUNT = 3 or 4	77-2311
34	103-1603	PORTA-CART ASSEMBLY	1 IF MOUNT = 3 or 4	77-2311
35	101-9475	MAST MOUNTING BRACKET KIT	1 IF MOUNT = 3 or 4	
36	207-10619	U-BOLT	2 IF MOUNT = 3 or 4 & HEATER = 1 or 2	
37	20-263-1	FLAT WASHER	4 IF MOUNT = 3 or 4 & HEATER = 1 or 2	
38	20-6042	NYLOK HEX NUT	4 IF MOUNT = 3 or 4 & HEATER = 1 or 2	

**CENTURY INTERNAL MIX LEL CHOP SYSTEMS****WALL MOUNT DIMENSIONS****SMALL CART DIMENSIONS****CART, MAST, AND BOOM DIMENSIONS**

**CHOP SYSTEM START-UP PROCEDURES FOR  
CX2006HC-U000000, CX2006HC-V000000  
CX2017HC-U000000, CX2017HC-V000000**

**IT IS IMPORTANT TO READ THROUGH THESE INSTRUCTIONS ENTIRELY AND  
UNDERSTAND THEM PRIOR TO OPERATING THE EQUIPMENT.**

1. Ensure all hose connections are tight, all valves are in the “closed” position, and all regulators are backed off to zero pressure. Attach ground wire to an earth ground.
2. Attach a 1/2” or 3/8” air line, using main line air pressure, to the inlet ball valve of the air control assembly. Make sure the ball valve is in the closed position. Air requirement is 20 CFM minimum.
3. Check solvent, catalyst and resin quantities. Ensure enough for one shift of operation.
4. Have a sufficient amount (5 gal) of appropriate solvent (acetone) for clean up and initial flush of pump.
5. Remove solvent tank lid and pour 2 gallons of solvent (acetone) into tank. Replace lid and tighten clamps.
6. Add throat lube to inside of packing nut at top of resin pump. Stop when packing nut is half-full.
7. Open the main air ball valve until fully open. During this procedure air will leak from the ball valve bleed hole, this is ok.
8. Open ball valve on air control to start flow of air to solvent tank. Use tank regulator to increase pressure in solvent tank to 40 psi. Check tank, solvent hose, and gun connections for leaks.
9. Check performance of the gun’s flush valve by pushing valve button briefly. Be sure to always flush the gun into a grounded metal container and touch a part of the gun to the container while flushing.
10. **NOTE: always flush the gun after dispensing resin and / or catalyst through the gun head!**
11. Disengage catalyst pump from the ratio arm by removing the quick release pin.
12. Insert the catalyst pick up tube into a one-gallon catalyst container and tighten the screw cap. Be sure the inlet screen is positioned at the bottom of the catalyst container.
13. Remove the retaining ring, tip retainer, nozzle (spray tip), mixer housing, and catalyst valve from the spray gun. Move the trigger lock to the down or “OFF” position, aim the gun into an approved, grounded container and pull the trigger. Touch the gun to the side of the container or connect the gun to an earth ground.
14. Have a helper manually pump the catalyst pump to prime the pump, manifold, hose, and gun. Do this until catalyst is flowing freely from the end of the spray gun without “spitting”.
15. Release the spray gun trigger, engage trigger lock and wipe off any catalyst that may have collected on the gun head. **Flush the gun.**
16. Install the night plug in the gun. Secure the night plug with the retaining ring.
17. Rest the catalyst pump against the side of the bracket; do NOT re-connect the pump to the ratio arm at this time.
18. Insert the resin pump pick-up tube into a container of acetone or other appropriate solvent.
19. Release trigger lock and aim the gun into an approved, grounded container, pull the trigger.
20. Slowly turn the pump regulator “T” handle clockwise until the pump starts to run. This may take a bit of adjusting by increasing and decreasing the pump air pressure. The pump will run fast at first but as solvent is pulled into the resin pump it will slow down. Keep the pump running slowly until solvent is flowing freely out of the gun.
21. Release the gun trigger and engage trigger lock then wipe off head of gun.
22. Lift siphon tube out of solvent and let solvent bleed back into container.
23. Back off pump air regulator to zero pressure.
24. Open the drain valve on the fluid filter and drain completely, when finished, close the drain valve.
25. Insert the pick-up tube into container of resin.
26. Repeat steps 19 and 20.
27. Release the gun trigger and engage trigger lock. **Flush the gun.**
28. Remove night plug and wipe off head of gun.
29. Install (in this order) catalyst valve, mixer housing (with static mixer inside), tip, tip retainer, and retaining ring. Do not over-tighten retaining ring. Lube all o-rings with Devilbiss gun lube or Binks gunners mate for easy installation without pinching or cutting the o-rings.
30. Operate the catalyst pump by hand to put approximately 100 to 200 lbs of pressure on the catalyst gauge. Re-connect the catalyst pump to the ratio arm with the quick release pin.
31. With the spray gun aimed at an appropriate surface, release the trigger lock, pull the trigger and have someone turn the “T” handle clockwise on the “PUMP” regulator until the pressure is at 30 lbs.
32. 30 lbs of pump pressure is a starting point and will need to be adjusted for your individual situation. When making adjustments always use 3 to 5 lb increments at a time and check the results. When properly adjusted, spray a sample surface and check for gel time.
33. The catalyst pump will automatically adjust pressure to permit catalyst flow and mixing with resin. There is no need to adjust catalyst pressure with an internal mix system.
34. Remove oiler cap (oiler is located on air control), add 8 to 10 drops of air motor oil to oiler, and replace cap. Open cutter air ball valve on air control and on gun. Test cutter by triggering the cutter valve trigger. NOTE: cutter may be triggered without spraying resin if cutter trigger is pulled alone.
35. Thread glass roving through guides and roving brake (if using boom). Bring end of roving to cutter and feed into center hole. Trigger cutter to pull roving into cutter. Adjust cutter speed and blower air for correct glass flow and dispersion.
36. If the system has a fluid heater, set the thermostat to 90 to 100°F.

## CHOP SYSTEM SHUT-DOWN PROCEDURES

### SHORT-TERM SHUT DOWN:

1. **IMPORTANT: always stop the pump in the “down” position, to prevent resin from drying on the pump rod and to keep it wet with throat lube.**
2. Engage trigger lock on spray gun. **Flush gun.**
3. Turn off main air valve. The air will bleed out of the pump, manifold, and solvent tank.
4. Pull catalyst relief valve knob to bleed catalyst pressure.
5. Open drain ball valve on filter to relieve resin pressure.
6. Remove retaining ring and all front end parts from the head of the gun. Wipe gun head with appropriate clean solvent. Lubricate the threads on the head of the gun and install the night plug, reinstall retaining ring and tighten.
7. Clean gun front end parts in solvent but do not let the red o-rings soak in acetone; they will swell.
8. Wipe gun with clean solvent. Oil all trigger parts, needles and exposed threads.
9. Leave gun hanging with head facing in the down position.

### LONGER TERM SHUT DOWN:

1. Engage trigger lock on spray gun. Turn off cutter air ball valve. **Flush gun.**
2. Back off the pump regulator to zero pressure. Air will bleed from air motor.
3. Pull catalyst relief valve knob to bleed catalyst pressure.
4. Open drain ball valve on filter to relieve resin pressure.
5. Make sure you have enough solvent (acetone) to completely flush the resin pump, filter, hose, and gun.
6. Remove pin to disengage catalyst pump from ratio arm.
7. Remove retaining ring, air cap, spray tip, and front end gun o-rings. Wipe front end of gun clean.
8. Remove siphon from resin supply. Let drain into supply and wipe clean.
9. Remove catalyst siphon from supply bottle. Trigger gun into grounded waste container and pump catalyst pump by hand to purge catalyst from pump, manifold, hose, and gun. For further cleaning for longer term storage, a soapy-water solution should be pumped through the system to purge it of all catalyst. At this time do not re-connect the catalyst pump to the ratio arm. **NEVER pump acetone through the catalyst pump or allow acetone to mix with raw catalyst.**
10. Trigger gun into grounded waste container.
11. Open main air supply valve. Increase pressure on pump regulator until pump starts to run, drawing air into the pump. Continue to run pump until air pushes most of the resin from the system. Control the speed of the pump by varying the air pressure to the motor.
12. Stop pump by backing off the air pressure. Release gun trigger. **Flush gun.**
13. Place siphon pick-up tube in the container of solvent.
14. Trigger the gun into grounded waste container. Re-start pump, drawing solvent into the pump and through the gun into the waste container. Occasionally open drain ball valve to clean filter bowl with solvent.
15. Optional: When the solvent flowing from the gun is reasonably clear, recirculate solvent through the system by triggering the gun into the solvent supply, if possible. Follow this flush sequence with clean solvent for a final flush.
16. When solvent flowing from gun is clear, stop pump and release gun trigger.
17. **IMPORTANT: always stop the pump in the “down” position, to keep the displacement rod wet with throat lube.**
18. Completely back off pump regulator to zero pressure. Close main air valve, allowing pressure to bleed from air control and solvent tank. Open drain ball valve to relieve fluid pressure.
19. Solvent may be left in pump for shutdown period. For longer term storage solvent should be replaced with a mineral oil or other compatible fluid to keep seals and metal parts lubricated and free from moisture.

NOTES

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## WARRANTY

This product is covered by Binks' 1 Year Limited Warranty.

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**Binks Sales and Service: [www.binks.com](http://www.binks.com)**

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***BINKS***

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**77-2953R Revisions:** Trademark updates;  
(P1) Added Prop 65 warning; (P8) Updated  
contact information.