

GRACO REACTOR – PROPORTIONER TROUBLESHOOTING

Proportioning System



Before performing any troubleshooting procedures:

1. Relieve pressure, page 28.

2. Turn main power OFF
3. Allow equipment to cool.



Problems

Try the recommended solutions in the order given for each problem, to avoid unnecessary repairs. Also, determine that all circuit breakers, switches, and controls are properly set and wiring is correct before assuming there is a problem.

PROBLEM	CAUSE	SOLUTION
Proportioning pump does not hold pressure when stalled.	Pump piston or intake valve leaking.	<ol style="list-style-type: none"> 1. Observe gauges to determine which pump is losing pressure. 2. Determine in which direction the pump has stalled by observing which directional valve indicator light is on. See Table 2, page 26 to isolate the problem. 3. Repair the valve; see pump manual 312068.
Material imbalance. See Pressure/Material Imbalance , page 26.	Restriction at the gun.	Clean the gun; see your separate gun manual.
	Inadequate flow from pump; cavitation.	Increase fluid supply to proportioning pump: <ul style="list-style-type: none"> • Use 2:1 supply pump • Use minimum 3/4 in. (19 mm) ID supply hose, as short as practical
		Fluid is too thick. Consult your material supplier for the recommended fluid temperature to maintain a viscosity of 250 to 1500 centipoise. Clean inlet strainer screen, page 45.
Pressure relief/circulation valve leaking back to supply.	Remove return line and determine if flow is present while in SPRAY mode.	



PROBLEM	CAUSE	SOLUTION
Pumps do not reverse direction or pumps do not move.	Bent or loose activator plate, rocker arm, or reversing switch.	See Pumps Do Not Reverse Direction , page 27.
	Loose piston packing bolt.	See Pumps Do Not Reverse Direction , page 27.
	Faulty directional valve.	See Pumps Do Not Reverse Direction , page 27.
Erratic pump movement.	Pump cavitation.	Feed pump pressure is too low. Adjust pressure to maintain 100 psi (0.7 MPa, 7 bar) minimum.
		Fluid is too thick. Consult your material supplier for recommended fluid temperature to maintain a viscosity of 250 to 1500 centipoise.
	Loose activator plate, rocker arm, or reversing switch.	See Pumps Do Not Reverse Direction , page 27.
	Faulty directional valve.	Replace directional valve.
Pump output low.	Obstructed fluid hose or gun; fluid hose ID too small.	Open, clear; use hose with larger ID.
	Worn piston valve or intake valve in displacement pump.	See pump manual 312068.
	Inadequate feed pump pressure.	Check feed pump pressure and adjust to 100 psi (0.7 MPa, 7 bar) minimum.
Fluid leak at pump rod seal.	Worn throat seals.	Replace. See pump manual 312068.
No pressure on one side.	Fluid leaking from pump outlet rupture disk (216).	Check if heater (2) and PRESSURE RELIEF/SPRAY valve (SA or SB) are plugged. Clear. Replace rupture disk (216) with a new one; do not replace with a pipe plug.
	Inadequate feed pump pressure.	Check feed pump pressure and adjust to 100 psi (0.7 MPa, 7 bar) minimum.