

## PROBLER GUN TROUBLESHOOTING GUIDE

<b>1</b>	Why did the clip ring on the air piston inside the Probler Gun break (clip ring #16828-01)?	<p>a. Check air pressure to gun. Too much air pressure (over 100psi) can break the clip ring. Regulate gun pressure to 90-100 psi at 10 CFM</p> <p>b. Mixing chamber nozzle was pushed forcefully towards gun body, breaking the clip ring. Causes are dropping the gun or improperly forcing the gun to trigger.</p> <p><b>NOTE...</b>          If Probler Gun will not trigger and gun has required air supply, DO NOT force chamber back into gun to “break it free”. This will result in costly damage to the gun and is the result of poor maintenance or improper shutdown procedure. The Gun needs to be taken apart and properly cleaned.</p>
<b>2</b>	When gun is air purging, I see a mist of ISO (or Poly) coming out the nozzle with the purge air. Why and what should be done?	<p>a. Side block seal is leaking (16811-01 or T4-132 seal). Remove seal assembly #17275-00 and inspect seal, chamber and seal housing (see seal inspection, section 5).</p> <p><b>NOTE...</b>          A raised, sharp edge on the side port of the mixing chamber can damage the seal (mixing chamber 17637-xx or 18375-xx, seal 16911-01 or T4-132). See chamber dressing, section 6.</p> <p><b>NOTE...</b>          When replacing a seal, be sure to inspect the inside of the seal housing (housing 16812-00). If there is build up or contamination it can keep the seal from seating properly.</p>
<b>3</b>	I keep cutting side block seals (16811-01 or T4-132 seals) soon after installation. Why?	<p>a. Check the mixing chamber for burrs or scratches (mixing chamber 17637- xx or 18375-xx). See chamber dressing to recondition mixing chamber.</p> <p><b>NOTE...</b>          If a drill bit is used to clean the side ports of the mixing chamber, a burr can form on the mixing chamber side port. Always inspect the mixing chamber surface after cleaning with a drill bit. It is important to insert the drill bit into the mixing chamber side port as straight as possible. Using an angle, other than 90<sup>0</sup>, can raise an edge on the side port.</p> <p><b>NOTE...</b>          The air purge will clean the chamber, but A and B materials can begin to scale on the side of the mix chamber after continual use. This needs to be cleaned periodically. If build up continues it can become hardened and damage the seals. See chamber dressing, section 6.</p>
<b>4</b>	There are sharp edges on the side ports of the mixing chamber (mix chamber 17637-xx or 18375-xx). How do I remove them?	<p>a. See Chamber Dressing, section 6.</p> <p><b>NOTE...</b>          Cleaning the side port with a drill bit most likely causes this. Always inspect mixing chamber surface after cleaning with a drill bit. Attempt to insert drill bit straight into side port holes. Going in at an angle can raise an edge.</p>

5	There is air to the gun, and air purge is good. When gun is triggered, the piston is sluggish to retract or doesn't move. Why?	<ul style="list-style-type: none"> <li>a. The mixing chamber slides through a guide channel in the front housing of the Probler Gun (housing 16800-00). Remove side blocks (side blocks T4-144 and T4-143) and front housing (housing 16800-00). The mixing chamber should be able to slide freely through the guide channel. Inspect and clean if needed.</li> <li>b. Air starvation. Make sure that the gun is being supplied with 10 CFM at 100 psi.</li> <li>c. Air starvation. If the gun has the required air supply, check the internal air passages in the Probler Gun body. If gun was recently crossed over (crossed over = cured foam in the internal air passages), the vertical passage elbow is most likely restricted. Clean our the air passages with proper sized drill bits (see diagram of Probler Gun air passages).</li> <li>d. The air piston in the back of the gun needs to be well lubricated with white lithium grease. If this area is dry, o-rings can dry out and make for sluggish trigger actuation.</li> </ul>
6	When the side blocks are removed, there is a material build-up around the chamber and where the chamber passes through the gun head. Why and what to do about it?	<ul style="list-style-type: none"> <li>a. Build up is caused by leaking side block seals and/or ball valves (seals 16811-01 and T4-132, ball valves PG-15). See seal inspection.</li> <li>b. Gradual scaling of material on the sides of the mixing chamber is a normal occurrence. See Chamber Dressing, section 6. When cleaned periodically this creates no problem. More frequent gun inspection / cleaning will correct the condition.</li> </ul>
7	All the air passages in the Probler were foamed up (crossed-over). Why and how are they cleaned out?	<ul style="list-style-type: none"> <li>a. The high pressure ball valves were not closed when the bolts holding the side blocks were loosened, causing material to fill the internal gun chambers (ball valves PG-15, side blocks T4-144 and T4-143, bolts 9944-48C).</li> <li>b. Total seal failure (seal 16811-01 or T4-132). This is rare and can be avoided with proper gun maintenance and timely seal replacement.</li> </ul> <p><b>NOTE...</b> To clean the gun, take apart, drill out internal passages and soak in a suitable cleaning solution.</p>
8	The mixing chamber does not line up with the holes in the side block seals when the gun is triggered. Why, and how are they lined up correctly?	<ul style="list-style-type: none"> <li>a. The piston throw set screw (replace) is out of adjustment and needs to be reset (nut 17259-16F). See resetting Piston Throw Adjustment, section 7.</li> </ul> <p><b>NOTE...</b> The piston throw is factory set, and should not be accessed unless the piston is out of adjustment.</p>
9	The high pressure ball valves on the Probler seem loose and may be leaking (valves PG-15). How do I fix them?	<ul style="list-style-type: none"> <li>a. Tighten valve packings. Remove valve handles by loosening allen screws and pulling handles off. This will expose the ball valve packing flats. With a wrench, tighten the packings to snug. Reassemble the gun and perform ball valve seal integrity test (see Ball Valve Seal Integrity Test, section 4.)</li> </ul>
10	The mixing chamber is not smooth and is built up with material. How is it fixed?	<ul style="list-style-type: none"> <li>a. With a new razor blade, shave the mixing chamber surface (mixing chamber 17636-xx or 18375-xx). Be careful not to scratch the surface. If the surface is scratched, see Chamber Dressing, section 6.</li> </ul> <p><b>NOTE...</b> Be careful that your cleaning does not damage the mixing chamber. If build up is severe, consider soaking in a suitable cleaning solution before shaving.</p>
11	There are scores on the mix chamber. Why and how are they fixed?	<ul style="list-style-type: none"> <li>a. Abrasive filler can cause this. Try Glas-Craft hardened mixing chambers for longer life (mixing chambers 17637-G-xx or 18375-G-xx).</li> <li>b. Hardened material on the seal surface can cause this (seal 16811-01 or T4-132). See shutdown procedures.</li> <li>c. Improper cleaning can cause this.</li> </ul> <p>See chamber dressing to recondition mixing chamber, section 6.</p>

12	When a new side block seal is put in material seeps around the shoulder of the seal between the seal and housing. Why and how do I fix it?	<p>a. The honed inside of the seal housing is scratched (housing 16812-00). Replace housing.</p> <p><b>NOTE...</b> The scratch is most likely from a previous cleaning with a sharp object. Use care when cleaning this housing. The inside surface is honed to give a high pressure seal to the shoulder of the seal (seal 16811-01 or T4-132, housing 16800-00).</p> <p>b. There is material build up on inside of seal housing and it is not letting the seal seat properly (housing 16812-00). Soak housing in a suitable cleaning solvent to remove build-up. Be careful not to scratch the inside surface when cleaning, see Seal Inspection, section 5.</p>
13	The piston rod is bent. What causes it?	<p>a. The gun was dropped.</p> <p>b. The gun mix chamber was improperly forced towards the gun body by means of a hammer or pushing the nozzle against a solid surface.</p>
14	The Probler continuously leaks air from the bottom of the handle. Why?	<p>a. The middle o-ring on the trigger assembly is cut (o-ring 7554-53, trigger T4-171). Replace o-ring.</p> <p>b. The trigger adjustment nut is out too far (nut 16839-00). Adjust by tightening nut until leaking stops.</p> <p><b>NOTE...</b> If the trigger nut is adjusted <i>out</i> too far it will not allow the spring return to shuttle the trigger spool to its normal position. If the trigger nut is adjusted <i>in</i> too far, the gun will not trigger properly.</p>
15	There is air leaking from the trigger button (trigger button PG-16). Why?	<p>a. The front o-ring on the trigger assembly is cut and needs to be replaced (o-ring 7554-53, trigger assembly T4-171).</p>
16	There is air leaking from the trigger retaining nut (nut 16839-00). Why?	<p>a. The back o-ring on the trigger assembly is cut and needs to be replaced (o-ring 7554-53, trigger assembly T4-171).</p>
17	There is air leaking around the side block and gun head. Why and how to stop it?	<p>a. There is material build up on the side blocks and/or the front housing of the gun (side blocks T4-144 and T4-143, housing 16800-00). Using a new razor blade, shave off the build up. Finish with a fine grit wet/dry sandpaper (1,200 or finer grit).</p>
18	When the gun is triggered, the purge air stays on. Why and how is it stopped?	<p>a. An o-ring on the air piston is cut or damaged and needs to be replaced (o-ring 7554-03, 7554-05 or 7554-29). Remove air piston assembly and replace damaged o-rings (Air piston assembly 16820-00). This can be caused by a scar in the air passage, debris in the air passage or solvent contamination causing the o-ring to swell and be cut during operation.</p>
19	There is air leaking from the air on/off slide valve (slide valve 16832-00 assembly). Why and how is it fixed?	<p>a. The slide valve o-rings are cut or damaged and need to be replaced (o-rings 7554-09).</p>
20	The Probler is leaking air from between the gun body and the front housing (gun body 16867-00 and housing 16800-00). Why and how is it fixed?	<p>a. The o-ring that seals between these two parts is damaged and needs to be replaced (o-ring 7554-12).</p>