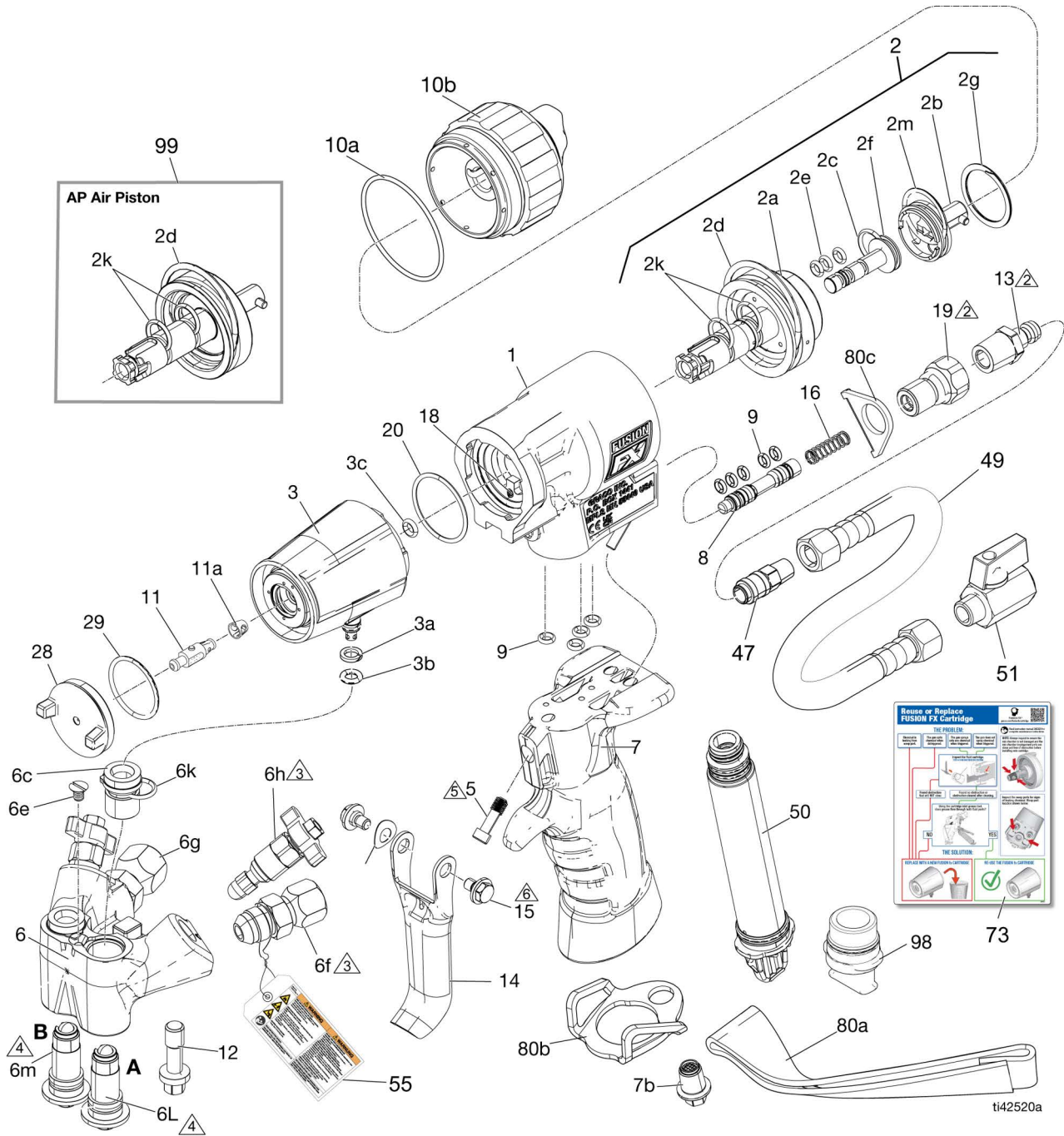


Parts

Fusion FX Gun

See **Detail Views**, page 42 for additional parts and detail views.



1 Torque to 30 - 40 in-lb (3.4 - 4.5 N•m).

2 Torque to 125 - 135 in-lb (14.1 - 15.2 N•m).

3 Torque to 13 - 15 ft-lb (17.6 - 20.3 N•m).

4 Torque to 25 - 30 in-lb (2.8 - 3.4 N•m).

5 Torque to 22 - 26 in-lb (2.5 - 2.9 N•m).

6 Torque to 28 - 30 in-lb (3.1 - 3.4 N•m).

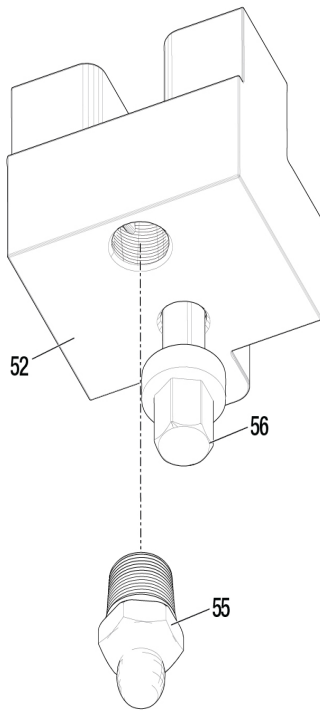
Parts List - FX Fusion Gun FX9000

Ref.	Part	Description	Qty.	Ref.	Part	Description	Qty.
1	2000973	BODY, air section, fusion fx	1	7b	2000981	PLUG, breather	1
2	2000978	PISTON, cs, complete assembly	1	8	2000980	VALVE, spool, fusion fx, assy	1
2a	2001166	KIT, air piston, CS, w/ o-rings	1	9❖		O-RING	4
2b	2001032	STOP, stem, safety, fusion fx	1		119421	QTY: 1	
2c❖		PACKING, o-ring	1		2991152	QTY: 10	
	2005697	QTY: 5			25M239	QTY: 50	
2d❖❖		O-RING, 129	1	10	2000971	CAP, safety, rear, fusion fx	1
	2006158	QTY: 5		10a★❖	131971PKG	O-RING, 031, fx75	1
2e❖		O-RING	3	11	-----	CHAMBER, mix, fusion (See Mix Chamber Kits on page 43)	1
	119421	QTY: 1		11a		SEAL, mix chamber	1
	2991152	QTY: 10			2005366	QTY: 10	
	25M239	QTY: 50		12	2001170	BOLT, manifold, fusion fx	1
2f	2001031	PISTON, dosing, fusion fx	1	13	117509	FITTING, line, air, 1/4 npt	1
2g	2001167	RING, retaining, spiral	1	14	2000976	TRIGGER, fusion fx	1
2k❖❖		O-RING	2	15	2001153	KIT, bolt, trigger, fusion fx	2
	118594	QTY: 1		16	117485	SPRING, compression	1
	2005699	QTY: 10		19	2001148	FITTING, air valve, fusion fx	1
	25M247	QTY: 25		20❖		PACKING, o-ring, 024, fx90	1
2m❖		O-RING	1		17V093	QTY: 1	
	117559	QTY: 1			2001150	QTY: 5	
	2005698	QTY: 5		28	2000788	AIR CAP, front, fusion fx, w/ o-ring	1
3	2000810	CARTRIDGE, replaceable, fusion fx	1	29❖		PACKING, O-RING, 022	1
3a†		O-RING, back-up, PTFE, 008, non-split	1		121370	QTY: 1	
		O-RING	1		256773	QTY: 5	
3b†		O-RING	1	47	117510	COUPLER, line, air, 1/4 npt	1
3c	2007251	KIT, O-Rings, CS check	1	49	15B772	HOSE, air, 18 in.	1
5	2001151	KIT, bolt, handle	1	51	15B565	VALVE, ball	1
6	2000974	MANIFOLD, hose, assembly, fusion fx	1	55▲	172479	TAG, warning	1
6c	2001168	KIT, housing check manifold	2	73	-----	LABEL, instructions	1
6d	2001151	FILTER, housing, assembly, fusion	2	80	2000716	KIT, strap with brackets	1
6e	2001169	SCREW, 8-32 x 0.25, flat head	1	80a		STRAP	1
6f	127597	FITTING, swivel, #5 jic x #5 jic, m x f	1		2007692	QTY: 3	
6g	127596	FITTING, swivel, #6 jic x #6 jic, m x f	1	80b	2006912	BRACKET, lower	1
6h	2000975	KIT, valve, fluid, fusion fx	2	80c	2006911	BRACKET, upper	1
6k❖		O-RING	2	98	2000715	CPS PLUG	1
	118594	QTY: 1		99	2000979	PISTON, assembly, <i>includes 2d, 2k, 2h</i>	1
	2005699	QTY: 10					
	25M247	QTY: 25					
6l	2001025	FILTER HOUSING, A-side, fusion fx	1				
6m	2001026	FILTER HOUSING, B-side, fusion fx	1				
7	2000972	HANDLE, fusion fx, cs, overmold	1				

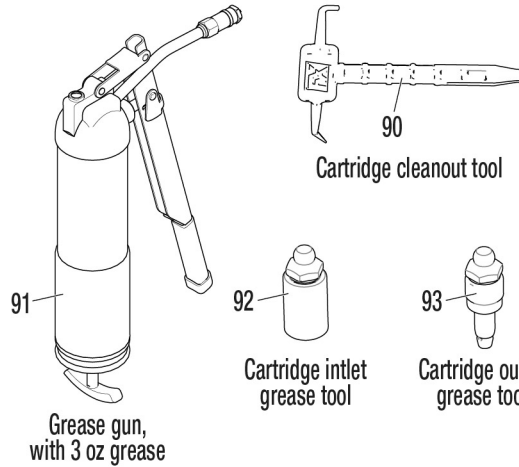
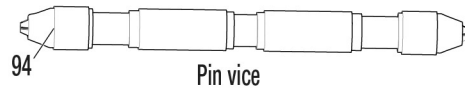
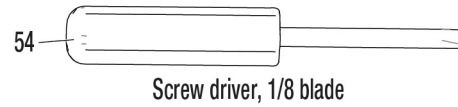
▲ Replacement safety labels, tags, and cards are available at no cost.

Symbol	Kit	Description	Included in Kit: Ref. (Qty.)
★	2000971	ASSEMBLY, safety stop	10a (1)
◆	2001033	KIT, O-ring, air-piston, fusion fx	2d, 2k (2)
†	2001029	KIT, O-ring, inlet check, fusion fx	3a (2), 3b (2)
❖	2001307	KIT, Fusion FX O-ring repair	2c, 2d, 2e, 2k, 2m, 6k, 9, 10a, 20, 29 (1)

Detail Views



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Ref.	Part	Description	Qty.
52	2000660	MANIFOLD, gun flush	1
53	117642	NUT DRIVER, hex, 5/16	1
54	118575	SCREWDRIVER, 1/8 blade	1
55	100054	FITTING, grease	1
56	2001170	BOLT, manifold	1

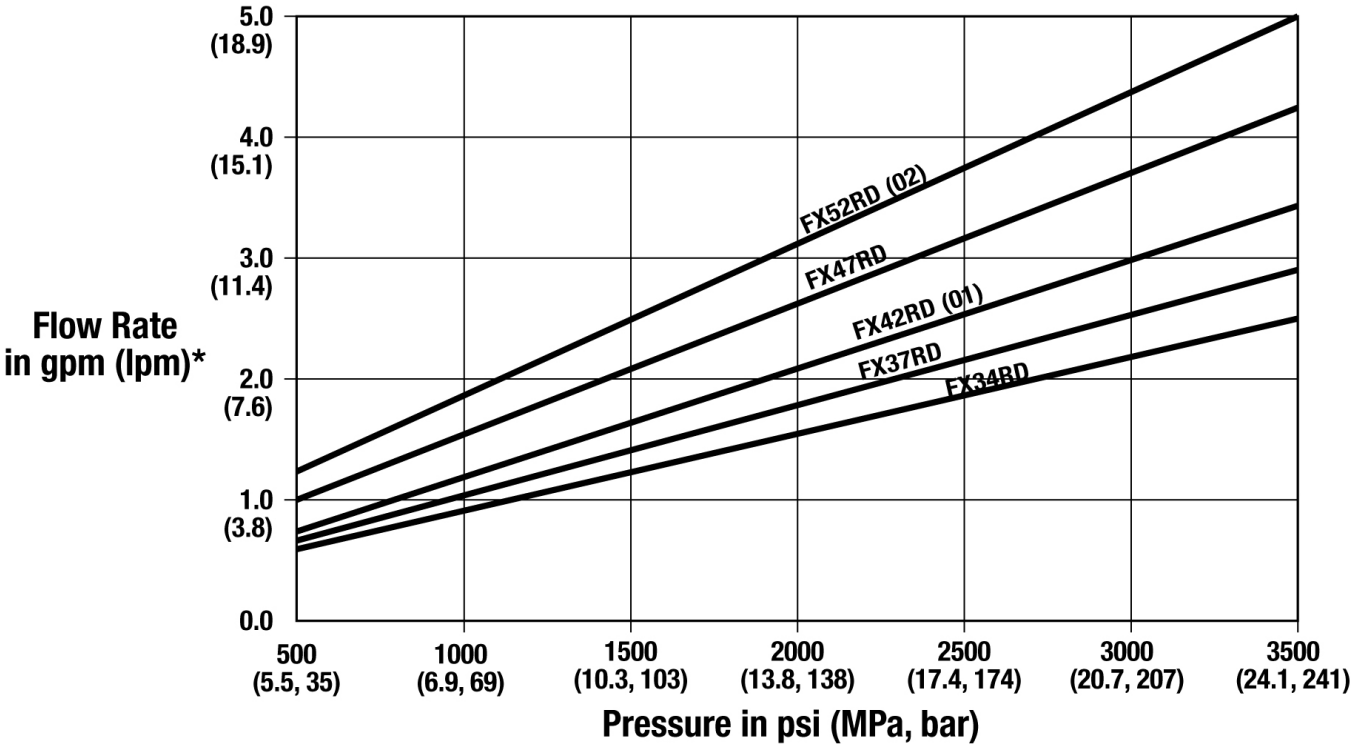
Ref.	Part	Description	Qty.
90	2005061	TOOL, cleanout, cartridge (Kit quantity 5)	1
91	117792	GUN, grease, 3 oz.	1
92	2004345	KIT, tool, grease	1
93	2004344	KIT, grease, cartridge	1

Mix Chamber Kits

Round Pattern

Mix Chamber Kit (includes drill bit)	Nozzle Orifice Size	Nozzle Drill Bit Size, in. (mm)	Nozzle Drill Part Number	Impingement Port Size	Impingement Port Drill Part Number	Impingement Port Drill Part Number
FX34RD	0.058	0.057 (1.45)	2006559	0.034	0.032 (0.8)	2006555
FX37RD	0.065	0.0635 (1.61)	2006548	0.038	0.037 (0.94)	2006553
FX42RD	0.067	0.065 (1.65)	2006560	0.042	0.041 (1.04)	2006552
FX47RD	0.074	0.073 (1.85)	2006546	0.047	0.046 (1.18)	2006550
FX52RD	0.08	0.0785 (2.0)	2007722	0.052	0.0492 (1.25)	2007723

Round Pattern Mix Chambers by Pressure and Flow Rate



* To calculate flow rate in lb/min., multiply gpm rate by 10.
 Example: 2 gpm x 10 = 20 lpm

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Check Valve Filter Screen Kits

Each kit includes ten filter screens.

The gun is shipped with 40 mesh filter screens.

Part	Description
24R894	40 mesh (0.015 in., 375 micron)
2001433	60 mesh (0.010 in., 238 micron)
2001434	80 mesh (0.007 in., 175 micron)

Cleanout Drill Kit

2001346

Kit includes all 4 drill bits of extra long length needed to clean out the air passages.

Acceptable FX Fluid Cartridge Storage Liquids

Storage Liquid	Part
TSL	206994, 206995, 206996
ISO Pump Oil	217374, 218656

FX Fluid Cartridge Kits

Part	Description	Qty.
2000810	KIT, Fusion FX. cartridge, 1pack	1
2000811	KIT, Fusion FX, cartridge, 3 pack	3
2000812	KIT, Fusion FX, cartridge, 5 pack	5

Fusion FX Fluid Cartridge Clean-Out Tool

2005061

Kit includes a quantity of five clean-out tools.

Metal Handle Kit

2001045

Kit includes aluminum handle, handle bolt, muffler, and handle air port o-rings.

Handle CS Plug Kit

2000715

Kit includes CS plug for handle with o-ring assembled.

Manifold Check Valve Repair Kit

2007204

Kit includes check ball and spring only.

Fusion FX Spare Parts

2006566

Kit includes:

2001033 KIT QTY: 2 QTY: 1 	2001307 KIT QTY: 7 QTY: 6 QTY: 3 QTY: 1 QTY: 1 QTY: 1 QTY: 1	2007251 KIT QTY: 1 	25E647 KIT QTY: 6 																		
2001150 KIT QTY: 1 	2000788 KIT AIR CAP QTY: 1 	2001026 QTY: 1 	24R894 QTY: 1 	2001152 QTY: 1 QTY: 10 	2001025 QTY: 1 	2005697 QTY: 1 	20B488 QTY: 1 	2001029 QTY: 2 	19C499 QTY: 1 												
131971 QTY: 6 	256773 QTY: 6 	2007204 QTY: 2 	20B217 QTY: 1 	117485 QTY: 1 	117509 QTY: 1 	117510 QTY: 1 															
21A011 QTY: 1 	20B336 QTY: 1 	117661 QTY: 1 		2001346 		<table border="1"> <thead> <tr> <th>DRILL SIZE</th> <th>DECIMAL EQUIVALENT</th> <th>QTY</th> </tr> </thead> <tbody> <tr> <td>#60</td> <td>0.0400</td> <td>1ea</td> </tr> <tr> <td>3/32</td> <td>0.0938</td> <td>1ea</td> </tr> <tr> <td>1/8</td> <td>0.1250</td> <td>1ea</td> </tr> <tr> <td>9/32</td> <td>0.2810</td> <td>1ea</td> </tr> </tbody> </table>	DRILL SIZE	DECIMAL EQUIVALENT	QTY	#60	0.0400	1ea	3/32	0.0938	1ea	1/8	0.1250	1ea	9/32	0.2810	1ea
DRILL SIZE	DECIMAL EQUIVALENT	QTY																			
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9/32	0.2810	1ea																			



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Fusion FX Air Section Cleanout Drills

2006569

Shuttle Valve Kits

2001028

Kit includes 10 shuttle valves.

2001027

Kit includes 2 shuttle valves and 1 shuttle valve yoke.

Drill Bit Kits

For cleaning gun ports and orifices. Actual length may vary.

Kit Part	Qty.	Drill Bit Size			Where Used
		nominal	in.	mm	
2006555	6	#67	0.032	0.81	FX34RD Mix Chamber Impingement Bore
2006553	6	#63	0.037	0.94	FX37RD Mix Chamber Impingement Bore
2006552	6	#59	0.041	1.04	FX42RD Mix Chamber Impingement Bore
2006550	6	#56	0.0465	1.18	FX47RD Mix Chamber Impingement Bore
2007723	6	1.25 mm	0.049	1.25	FX52RD Mix Chamber Impingement Bore
2006559	6	1.45 mm	0.057	1.45	FX34RD Mix Chamber Nozzle
2006548	6	#52	0.635	1.61	FX37RD Mix Chamber Nozzle
2006560	6	1.65 mm	0.065	1.65	FX42RD Mix Chamber Nozzle
2006546	6	#49	0.073	1.85	FX47RD Mix Chamber Nozzle
2007722	6	#47	0.0785	1.99	FX52RD Mix Chamber Nozzle
246624	3	3/32	0.094	2.38	Gun Body Passages
249115	6	1/8	0.125	3.18	Gun Body Passages

Accessories

Extension Tip Kits

Kit includes extension air cap, o-ring, cleanout drill bit, and instructions.

Kit	Hole Diameter x Length, in. (mm)	Recommended Mix Chambers	Spray Distance. ft. (m)	Pattern Diameter, in. (mm)
2005266	0.053 x 1.00 (1.35 x 25.4)	FX34-FX42	12 (3.66)	5 (127)
2005267	0.061 x 1.00 (1.55 x 25.4)	FX37-FX47	12 (3.66)	6 (152)
2005268	0.071 x 1.00 (1.80 x 25.4)	FX52	8 (2.44)	7 (178)

Gun Cleaning Kit

15D546

Kit includes eleven tools and brushes to clean the gun.

Pour Nozzle Kit

2005269

To convert air purge gun for pour applications. Includes nozzle, tubing, and cleanout drill bits.

Lubricant for Gun Rebuild

248279, 4 oz (113 gram) (Qty. 10)

High adhesion, water resistant, lithium-based lubricant. SDS available at www.graco.com

Grease Cartridge for Gun Shutdown

2007352 Cartridge, 3 oz (Qty. 10)

Specially formulated low viscosity grease flows easily through gun passages, to prevent two component curing and keep fluid passages clean.

Flush Manifold

2000660 Flush Manifold

2004345 FX Fluid Cartridge Inlet Grease Tool

2004344 FX Fluid Cartridge Outlet Grease Tool

Solvent Flush Canister Kit

2006016, 1 qt (0.95 l) Solvent Cup

Complete with 2000660 Flushing Manifold to flush gun with solvent. Portable for remote flushing. Refer to the Solvent Flush Kit manual. See **Related Manuals**.

ClearShot Liquid

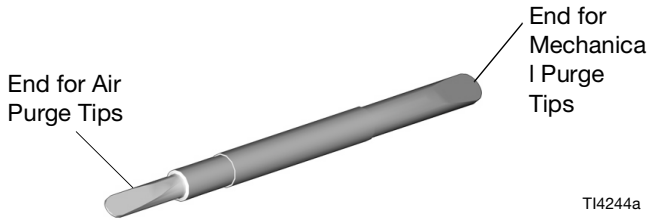
See MSD060

Kit	Description
256385	Package of 25 cartridges
256386	Package of 50 cartridges
256387	Package of 100 cartridges
17X756	Bulk CS fluid, 4 pack, 16 oz. bottles (can fill 100 CS tubes)
17X757	Bulk CS fluid, 12 pack, 16 oz. bottles (can fill 300 CS tubes)

Tip Clean-out Tool

15D234

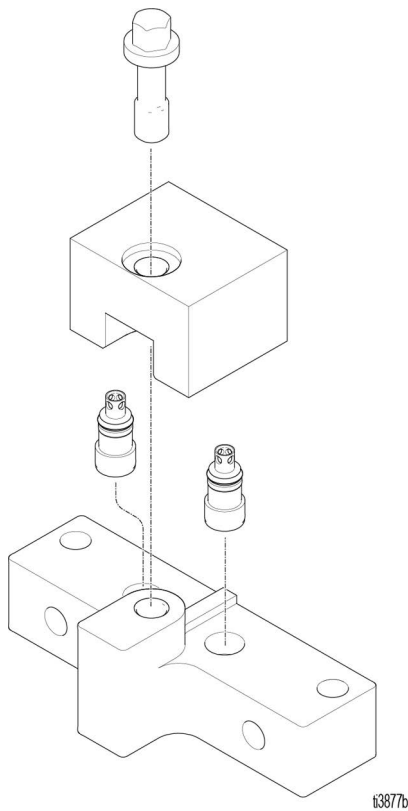
Designed to fit CeramTip™ internal dome and flat tip slits.



Circulation Manifold

2002324

Attach to gun fluid manifold to enable preheating of hose. Refer to Circulation Manifold Kit Instruction Manual. See **Related Manuals**, page 3.



Fusion AP Manifold Adapter Block

2002360

Allows Fusion FX gun to fit onto existing Fusion AP/PC manifold.

Fusion AP Manifold Adapter Block with Hose Bundle

2002347

Allows Fusion FX gun to fit onto existing Fusion AP/PC manifold. Includes both adapter block and 6 ft. hose bundle.

