The User Guide to

RAPIDFIL™ 406C Series

Designed & built for:

COMPANY

Material: MATERIAL

Serial No: SERIAL
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**RAPIDFIL™**

*LCD computer controlled, 2 component, portable, dispensing equipment*

**RAPIDFIL** C Series is a portable, LCD computer controlled, two component dispensing machine.

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**RAPIDFIL C Standard Features**

- LCD/Computer Controls
- 6 Gallon Vacuum Stainless Steel Tanks
- Diagnostic System
- 2 Component
- Tank Thermostats
- 110 V Power
- Variable Output to 1 gallon/min.
- Electric Agitation
- Vacuum Degas Tanks
- **RAPIDFlex™** Hose Mgt. System
- Disposable Mixers
- Desiccant Dryer System
- Color Coded Insulated Tanks
- Tank Site Gages
- LED Function Indicator Lights
- Automatic purge
- Shot Timing
- Insulated Tanks with Proportional Controls

**RAPIDFIL C Optional Features**

- 12 Gallon Stainless Steel Tanks
- 12’ Heated Hoses
- Foot Pedal Activation
- (HHMP) Hose & Head Mounting Packages
- Pneumatic Snuff Back Head
- Clear Acrylic Tank Covers

*(Shown with standard specifications. See Standard & Option Packages for more details.)*
Initial Startup Preparation

For shipping purposes, your RAPIDFIL™ unit contains RAPIDFLUSH™ (tank flush & preservative) in the hoses and in the pumps. To setup the machine for use, follow the listed procedure for removing the RAPIDFLUSH™ and filling the tanks.

1. **POWER UP THE UNIT:**
   
   a.) Plug in the electric cord located at the rear of the machine.  
   
   b.) PULL the Main Power button to the ON position.
   
   c.) Check the output speed (see variable output section).

   ![Picture](a.) Plug in the machine  
   ![Picture](b.) Pull power button  
   ![Picture](c.) Check speed

2. **DISPENSE THE RAPIDFLUSH™ OUT OF THE MACHINE:**
   
   a.) Press the trigger and dispense out ALL of the RAPIDFLUSH into a disposable container.  
   
   b.) Dispense until the pumps are dry and free from any remaining RAPIDFLUSH .

3. **TURN OFF THE MACHINE AND UNPLUG FROM ELECTRICAL OUTLET.**

4. **REMOVE THE TANK COVERS:** *(MAKE SURE THE UNIT IS OFF AND UNPLUGGED)*
   
   a.) Disconnect Dessicant System hoses.  
   
   b.) Disconnect the electronics cord.  
   
   c.) Pull clamps away from tank and remove cover.

   ![Picture](a.) Disconnect the Desiccant  
   ![Picture](b.) Disconnect electronics cord  
   ![Picture](c.) Remove the tank cover.
5. **FILL THE TANKS:**
   
   a.) Fill the PART A Tank and the PART B Tank with the pre-specified Hapco material.
   
   b.) Add material to both tanks before use (add a minimum of 1/4 tank).
   
   c.) Replace covers and tighten clamps immediately after filling.

**NOTE:** ISO or Epoxy goes in the Part A tank and Polyol or curing agent goes in the Part B tank.

6. **REPLACE THE TANK COVERS:**

   a.) Replace covers and push both clamps toward the tanks.
   
   b.) Reconnect the electronics cords.
   
   c.) Reconnect the Desiccant System Hoses.

7. **POWER UP THE UNIT:**

   a.) Plug in the electric cord located at the rear of the machine.
   
   b.) PULL the Main Power button to the ON position.
   
   c.) Check the output speed (see variable output section).
8. DISPENSE 2 QUARTS OF MATERIAL:

   a.) Extend RAPIDFlex™ arm out as high as it will go. This will allow any trapped air to escape.

   b.) Dispense out approximately 2 quarts of material into a disposable container. (This initial material will contain both RAPIDFLUSH™ and Hapco material.)

   c.) Wipe with A-Tak

9. DISPOSE OF MATERIAL PROPERLY:

   a.) Mix the dispensed RAPIDFLUSH™ and Hapco material by hand in a disposable container and allow to fully cure.

   

   RAPIDFIL™ is now ready for use.
See Quick Startup Procedure to begin.
See Quick Shutdown Procedure to shutdown the machine for later use.
1. **TURN OFF THE MACHINE AND UNPLUG FROM ELECTRICAL OUTLET.**

2. **REMOVE THE TANK COVERS:**
   
   **a.** Disconnect Dessicant System hoses.
   
   **b.** Disconnect the electronics cord.
   
   **c.** Pull clamps away from tank and remove cover.

3. **ADDING MATERIAL:**
   
   **a.** Fill the PART A Tank and the PART B Tank with the pre-specified Hapco material.
   
   **b.** Add material to both tanks before use (add a minimum of 1/4 tank).
   
   **c.** Replace covers and tighten clamps immediately after filling.

   **NOTE:** ISO or Epoxy goes in the Part A tank and Polyol or curing agent goes in the Part B tank.

4. **REPLACE THE TANK COVERS:**
   
   **a.** Replace covers and push both clamps toward the tanks.
   
   **b.** Reconnect the electronics cords.
   
   **c.** Reconnect the Dessicant System Hoses.
Draining the Tanks

Each tank has a ball valve and removable plug for draining purposes. The valves and plugs are located inside the unit, under each tank.

TO DRAIN THE TANKS:
- Remove Drain Plug and insert plastic elbow and hose
- Place a bucket under the drain hose and remove plug from end of hose.
- Turn the drain valve 1/4 turn to begin draining the tank.
- Seal and store drained material according to the Hapco material’s Technical Bulletin.

Tank Shutoff

Each tank has a shut off valve. The tank shutoff valve is located inside the unit, under each tank.

TO SHUT OFF THE TANKS:
- Turn the shut off valve 1/4 turn into a closed position.
Your RAPIDFIL™ comes equipped with a state-of-the-art, custom crafted hose management system called the RAPIDFlex™. The arm articulates in virtually any direction and keeps the hose out of the user’s way. The flexible arm offers a full range of motion and can fill molds within 7 feet of the machine.

**NOTE: Arm works best when it is facing the same direction as the main control panel.**

The dispensing gun can move freely or be in a locked position by tightening the lever above the gun.
TO SETUP THE GUN:

a.) Turn the trigger safety lock to unlock.
b.) With the unit on, hold the gun over a waste container. Depress the trigger to remove the lubricant from inside the ports.
c.) Wipe off excess lubricant using Hapco’s A-Tak.
d.) Put a RS mixer over the detent on the front of the gun. Slide the retainer nut over the mixer and screw on tightly.

The dispensing gun should be properly cleaned after each use. When the machine is not in use, make sure the gun has been cleaned and lubricated (see shutdown procedure).
**Dispensing Startup / Shutdown**

1.) Follow the Gun setup procedure on the previous page.

2.) Check to make sure the ports have been flushed of lubricant.

3.) Depress the trigger and observe the flow.
   
   Check for proper flow from both ports.

4.) Vary the speed as needed to make sure the flow is not inter-

   **STOP! Wipe the output area with Hapco’s A-Tak.**

5.) Attach a RS mixer and screw on the retainer nut.

6.) Depress the trigger while the mixer is over a waste container.

7.) Once the mixer is full, dispense a volume equal to 1 1/2 the mixing tube. You can now begin dispensing.

Dispense material until the mixer is full and an additional 1/2 of the volume of the mixer has flowed out.

**NOTE:** Be aware of the gel time of the material. Material can solidify (gel) in the mixing tube.

**TO SHUTDOWN THE GUN:**

Wipe off the ports and threads with Hapco’s A-Tak.

Wipe nut, threads, and ports with A-TAK until they are free of any material.

Apply a generous amount of lubricant to completely cover over port holes and port threads.

Cover with a retainer nut.
The Desiccant Dryer System is intended to remove moisture from the inside of the tanks. The Desiccant System should be checked frequently.

The Desiccant, when visible through the clear polycarbonate plastic bowl, contains a color indicator. It changes from Blue (dry) to Pink (wet) to indicate the need to replace or regenerate the desiccant.

**To change the cartridge:**

Press the black lever down to unlock and pull the cartridge cover off.

Turn the cartridge and remove carefully.

Replace with a new desiccant and replace cover. Check all connections before starting.

After replacing the desiccant, the used desiccant can be disposed of or reclaimed. To reclaim, pour out the used, pink desiccant onto a flat pan. Place in an oven at 350°F (176°C) for three hours or until the desiccant color has changed back to blue.
The vacuum tanks combine production grade vacuum (up to 28”), heat (if necessary), and agitation for quick and efficient degassing of materials.

Vacuum degas is highly assisted by using agitation during the process.

**WARNING:**

- Degas material BEFORE operating the dispensing machine.
- Do not exceed a vacuum of 28” of mercury, as this will cause outside air to enter the machine through the ball valves.
TO OPERATE VACUUM DEGAS TANKS:

a.) Fasten tank covers. To fasten, press down on the red tank handles, so they are locked.
b.) Attach vacuum hose.
c.) Check vacuum gage *(do not exceed a vacuum of 28” of mercury)*
d.) Turn on vacuum. At the top of the tank, turn the black valve switch to the vacuum ON position *(arrow points to vacuum connection).*
e.) Turn on agitation (and heat if required).
f.) When degassing is complete, turn black valve switch to the vacuum OFF position *(arrow points away from vacuum connection, towards agitation motor).*

When degas is complete, be sure to turn the valve to the OFF position. NEVER degas during operation of machine. Always degas before operation.
Setting Date & Time

The RAPIDFIL’s scheduling works from the current date and time found in the HT&AG menu. This may need to be changed depending on the time zone or daylight savings time. To set and reset the real-time clock, use the following procedure.

1) From the main menu press the HT&AG button.
2) ARROW down once and the cursor will be on the line with the current date/time.
3) In order to change anything on that line, you must first press any number from 0-9, preferably one that corresponds to the next number on the line, as the date will most likely stay the same.

1) Once the line is “activated”, the cursor can be moved left or right to modify the date and time.
2) When finished, press ENTER.

1. Press the HT&AG button.  
2. ARROW down to date/  
3) Press any number 0-9.
4) ARROW across and change time.  
5) Press ENTER.
Your RAPIDFIL™ is equipped with tank agitation. The agitation controls for Part A and for Part B are separate.

As a safety feature, the tank mixers automatically turn ON when the tank heaters are turned ON.

TO RUN AGITATION:

1. Press the SETUP menu button.
2. The cursor will be flashing on the MIXER A OFF.
3. Press the ENTER key to turn MIXER A ON. The cursor is now on the mixer’s speed.
4. Enter a speed from 10-100 RPM using the number pad and push ENTER.
5. The cursor is now on MIXER B OFF. Repeat steps 3 and 4 for MIXER B.
Your RAPIDFIL™ is equipped with user controlled, insulated tank heaters.

The heat control for Part A and for Part B are separate.

A is the control for the Part A tank.

B is the control for the Part B tank.

C* is the control for the heated hose.

As a safety feature, the tank mixers automatically turn ON when the tank heaters are turned ON.

TANK HEATER MENU:

<table>
<thead>
<tr>
<th></th>
<th></th>
<th>SET</th>
<th>ACTUAL</th>
</tr>
</thead>
<tbody>
<tr>
<td>A</td>
<td>Part A tank</td>
<td>displays the tank temperature set by the user.</td>
<td></td>
</tr>
<tr>
<td>B</td>
<td>Part B tank</td>
<td></td>
<td>displays the actual tank temperature.</td>
</tr>
<tr>
<td>C*</td>
<td>Heated Hose</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

* Heated Hoses are an optional feature they do not come standard.

TANK HEATER OPERATION:

1. Press the SETUP menu button and then the TEMP button.
2. A (Part A Tank) appears on the screen. The cursor defaults under the SET position.
   To change/set the temperature, type the new Fahrenheit degree temperature and press ENTER.
3. The cursor is now on tank heater OFF/ON position.
   Press ENTER key to turn the tank heater on.
4. B (Part B Tank) is now on the screen. Follow the same procedure above. When finished.

* Use the orange arrow keys to scroll up and down the menu and review the settings.
Scheduled Tank Temperature Control

Your RAPIDFIL™ has individual user controlled heat temperature settings for Part A and Part B tanks with four (4) programmable auto on/off schedule periods per day. Temperature is displayed in degrees Fahrenheit. Time is displayed in military time. Tank agitation automatically turns on when tank heaters are turned on.

HEAT/AGITATION MENU
(Example)

TIME HEAT&AGT AUTO
WE 09/03/08 15:45:07
SELECT DAY/TIME:

SELECT DAY/TIME:

DAY OF WEEK TIME

From-To

1: Mo-Tu 08:45-09:45

2. Mo-Fr 07:00-17:00

Time is in military time.

THE MACHINE MUST BE ON FOR THE HEAT TO RUN ON SCHEDULE

SCHEDULED TANK HEATER OPERATION:

1. Select HT&AG from Main Menu.

2. Press ENTER to change the setting to AUTO and to turn the heat timer ON or;
   Press ENTER to change the setting to MANUAL to shut the heat timer OFF.

3. ARROW down to: SELECT DAY/TIME:>
   Press ENTER to setup heat schedules.

4. Select a start day (From) for when the heat will turn on. Press ENTER.

5. Select an ending day (To) for when the heat will turn off. Press ENTER.

6. Select the time for the heat to turn on, and then select the time for the heat to turn off.
   Example: To have the heater turn on at 7:00 am and shut off at 5:00 pm, Monday through Friday, the setting will read:
   Mo-Fri 07:00 -17:00

7. To have the heat turn on for just one day, leave the second position (To) blank.
   Example:  Mo-07:00 -17:00
   Repeat the above steps to program 4 cycles, if needed.

8. Press the HOME button to go back to the previous screen.

9. ARROW down to change/set the temperature for each heater.(Tank A, Tank B, and the Hose)

10. Type the new Fahrenheit degree temperature and press ENTER.

11. The cursor is now on tank heater OFF/ON position. Press ENTER to turn the tank heat ON or OFF.

* To change current date/time please see page 25
Heated Tank Operation Modes

There are two methods for heating the tanks, Proportional Heating and Straight Heating. Each tank can be heated individually by using either the proportional method or the straight heating method.

Your rapidfil™ is pre-programmed to heat in the proportional heat mode called TUNE NORM. When you first turn on the tank heater(s) the TUNE NORM mode is on.

Proportional Heating - TUNE NORM

The temperature gradually climbs and the heater slows down as the temperature approaches the setpoint. This has the effect of slowing down the heater so that it will not overshoot the setpoint, but will approach the setpoint and maintain a stable temperature.

Depending on the material being used, this method usually takes between 15-25 minutes to reach maximum temperature and temperature accuracy is ± 3°.

Proportional heating yields a more accurate reading, and maintains the set-point temperature. Proportional Heating is slower than Straight Heating. A good starting point is 75°F.

Straight Heating - TUNE NORM OFF

Heat goes directly to the tanks and stops when the set-point temperature is reached. When the material temperature goes below the set-point, straight heat is on, and when the temperature is above the setpoint, straight heat is off.

This is a start/stop method of heating. Straight heating generally takes between 10-15 minutes to reach maximum temperature. Temperature accuracy for straight heat is ± 5°. Straight Heating is the fastest method.
Your RAPIDFIL™ is pre-programmed to heat in the proportional heat mode called TUNE NORM. When you first turn on the tank heater(s) the TUNE NORM mode is

![Proportional Heating](image)

TUNE NORM = Proportional Heating (± 3°F)
TUNE NORM OFF = Straight Heating (± 5°F)

Temperature is displayed in °F. For °C see enclosed conversion chart (last page).

**To change the heating mode:** *(Tank heaters must be turned off.)*

1. Press the **SETUP** button.
2. Press the **TEMP** button.
3. **ARROW** down to TUNE NORM and press **ENTER** to change the heating mode.

1. Press **SETUP**.
2. Press **TEMP**.
3. Scroll to TUNE NORM & press **ENTER** to change the heat mode.
The output speed controls the output speed / volume of material, and is located in the SETUP menu under: SPEED. The temperature of the material and the nozzle size have a direct relationship to the output speed /volume. Perform shot testing before use.

TO INCREASE / DECREASE OUTPUT

1. Press the SETUP button and then press SPEED on the following screen.(Shown above)
2. The cursor defaults to the SET position. To change/set the output speed, type in the new speed (higher for faster dispensing, lower for slower dispensing) and press ENTER.
3. Press HOME to go back to the main menu screen.

Note: Maximum reading is 120 Hertz (Hz). Minimum reading is 0 Hertz (Hz). Normal operation is from 0 -80 Hz. 28
**RAPIDFIL™** has an Automatic Shot Timer that allows the user to select automatic timed shot dispensing. In the **ON** mode, the size of the shot is measured in seconds. Pressing and releasing the trigger will dispense the preset amount. When in the **OFF** mode, the user controls the dispensing length of time by pressing and holding down the trigger or foot pedal.

**TO OPERATE THE AUTOMATIC SHOT TIMER:**

1. Press the **SHOT** menu button.
2. Press the **ENTER** key to turn the shot timer **ON**.
3. The cursor is now on **SHOT TIME**.
   Type in the timed shot desired (in seconds) and press **ENTER**.

The units for the shot timer are in seconds.
Entering 1.0 will dispense material for 1 second after the trigger is pulled.

1. Press **SHOT**.
2. Press **ENTER**.
3. **ARROW** down to **SHOT**
4. Type in **SHOT TIME**. (seconds)
RAPIDFIL™ has an Auto Purge feature. Auto Purge prevents the material from curing in the nozzle by dispensing a preset amount of material at set intervals. The feature is typically used in a production environment where continuous, manual dispensing is not necessary. Auto Purge, when ON, automatically dispenses a preset amount of material at user defined intervals based on the material’s gel time.

WHEN AUTO PURGE IS ON, THE MACHINE WILL AUTOMATICALLY DISPENSE MATERIAL WITHOUT OPERATING TRIGGER.

TO OPERATE THE AUTOMATIC PURGE FEATURE:

1. Press the SETUP menu button.
2. ARROW down to the AUTO PURGE line.
3. Press the ENTER key to turn the auto purge ON.
4. The cursor is now on GEL TIME.
   Type in the gel time of the material (in minutes) and press ENTER. The time interval between shots should be set several minutes ahead of the actual gel time.
   i.e. Typing in 10 will dispense material every 10 minutes.
5. The cursor is now on PURGE TIME. Type in the time (in seconds) for the purge interval and press ENTER.
   Purge time for the average static mixer is approx. 2-3 seconds.
**RAPID** allows the user to program up to 4 pre-set recipes that include: Heat, agitation, speed, shot time, and purge time settings. These recipes can easily be modified, saved as a number or name, and loaded as needed.

The shot time recipes can be accessed, modified, and saved from the **SHOT** menu button on the main screen.

**TO CREATE NEW RECIPE**

1. In the **SHOT** menu, enter appropriate data into the fields. (See example below)
2. Press the **SAVE** button.
3. Enter desired name. (Same method as sending a text message on a cell phone)
4. Press **OK**.

**SHOT RECIPE MENU**
(Example)

- TIME SHOT ON
- RECIPE: Part1
- SHOT TIME 2.5 SEC
- AUTO PURGE ON
- PURGE TIME 15 SEC
- SET SPEED 40.00
- TANKA 100F ON
- TANK B 100F OFF
- HOSE C 68F OFF

1. Enter data into fields.
2. Press **SAVE**.
3. Enter name using number pad. (Same as texting)
4. Press **ENTER**
Shot Recipes (Cont.)

TO LOAD EXISTING RECIPE

1. Press the **SHOT** menu button.
2. Press the **LOAD** button.
3. **ARROW** down to desired recipe using the orange arrows and press **SELECT**.

**1. Press SHOT.**  
**2. Press LOAD.**  
**3. ARROW to desired recipe and press SELECT.**

TO MODIFY EXISTING RECIPE

1. Press the **SHOT** menu button.
2. Press the **LOAD** button.
3. **ARROW** to desired recipe using the orange arrows and press **SELECT**.
4. Change data and press **SAVE**.

**1. Press SHOT.**  
**2. Press LOAD.**  
**3. ARROW to desired recipe and press SELECT.**  
**4. Change data and press SAVE.**
Check Valve Maintenance

The check valves need to be changed as a preventative maintenance procedure established by the customer.*

Reasons for changing check valves:

1. Inconsistent ratio dispensing from the machine (see ratio check).
2. Poor flow of material.
3. Extended periods of lack of use.
4. Normal maintenance, every 6 weeks.

*Note: Machine usage and materials will directly affect the time in between each replacement. Change every six weeks to four months.

(Hapco recommends changing of the check valves, not cleaning them).
Check Valve Maintenance

Problems:

Cured material

Clogged port holes
Cleaning threads and port holes:

Remove cured material from threads by using a wire brush.

Remove material from port holes by using a number 27 drill bit in a pin vice (tool included).

*Note: Be sure not to mark or scratch openings.*
Check Valve Maintenance

Changing the check valves:

Remove hose

Remove Check Valve
Check Valve Maintenance

Changing the check valves:

Remove 2nd hose

Remove check valve (and adapter if applicable)

Wipe ports clean
Check Valve Maintenance

Attaching new check valves:

New check valves

Attach adapter  Attach check valve  Tighten valve
Attaching new check valves:

Attach hose

Tighten

Attach 2nd check valve

Tighten
Check Valve Maintenance

Attaching new check valves:

Attach 2nd hose

Tighten
**Steps for measuring the ratio:**

1. Remove retainer nut from gun and wipe output holes with A-Tak.
2. Set output speed to 15.
3. Turn shot time on, and set time to 5 seconds.
4. Partially remove the tops of disposable cups and tare on scale.
5. Label each cup with appropriate label (A or B).
6. Place one cup under output hole, and the other cup under the other output hole.
7. Dispense material.
8. Repeat 3 times.
9. Divide the B weight by the A weight and that is the mixing ratio.
   
   Record the results.
Your **RAPIDFIL** Equipment has been set up for use with **MATERIAL**.
The **RAPIDFIL** ratio can be varied to accommodate most Hapco materials.
Contact Hapco directly for information on any changes to the original configuration.

To change the pulleys or belt use the following procedure:

- **Remove side panel.**
- **Loosen tension nut on idler pulley.**
- **Remove belt.**

- **Remove the three bolts from hub.**
- **Install bolts into the three opposite holes.**
- **Tighten bolts and bushing will come off.**

Change the pulleys and/or belt per Hapco’s instructions:
- Reinstall the cog gear/pulley and bushing.
- Tighten the three bolts.
- Put on belts and tighten until there is no play in the belt.
- **Tighten belt. Tighten idler. Replace door panel.**
WARNING:

RAPIDFIL is designed to be used with Hapco materials only. Hapco does not warranty RAPIDFIL when non-Hapco materials are used in the machine. The warranty is null and void when non-Hapco materials are used in a RAPIDFIL machine.

1. REMOVE THE TANK COVERS: (MAKE SURE THE UNIT IS OFF AND UNPLUGGED)
   a.) Disconnect Dessicant System hoses
   b.) Disconnect the electronics cord.
   c.) Undo the clamps by pulling them away from the tank.

   ![Disconnect the Desiccant](image1)
   ![Disconnect electronics cord](image2)
   ![Remove the tank cover](image3)

2. DRAIN THE TANKS:
   a.) Place a bucket under the drain spout.
   b.) Turn the drain valve 1/4 turn to begin draining the tank.
   c.) Take a spatula and scrape the sides and bottom of each tank as they are draining out.

   ![Drain valve](image4)
   ![Drain hose](image5)

3. WASH THE TANKS:
   a.) Wash the insides of both tanks using Hapco’s A-TAK and disposable paper towels. Dispose of properly
   b.) Turn the drain valve 1/4 turn to shut it off.
4. **FLUSH THE TANKS:**
   a.) Pour 1 gallon of RAPIDFLUSH into each tank (1 gallon in Part A, 1 gallon in Part B).

5. **POWER UP THE UNIT:**
   a.) Plug in the electric cord located at the rear of the machine.
   b.) **Pull** the Main Power button on the Main Control Panel.
   c.) Check output speed (see variable output section).

6. **DISPENSE / PUMP RAPIDFLUSH:**
   a.) Press the trigger and pump RAPIDFLUSH™ into a disposable container or back into their original containers.
   b.) Pump until the pumps are dry and free from any remaining RAPIDFLUSH™.

7. **FILL THE TANKS WITH ALTERNATE HAPCO MATERIAL:**
   a.) Fill the PART A Tank and the PART B Tank with the pre-specified Hapco material.
   b.) Add material to both tanks before use (add a minimum of 1/4 tank).
   c.) Replace covers and tighten to seal immediately after filling.
8. REPLACE THE TANK COVERS:
   
   a.) Replace covers and push both clamps toward the tanks.
   
   b.) Reconnect the electronics cords.
   
   c.) Reconnect the Desiccant System Hoses.

9. DISPENSE 2 QUARTS OF MATERIAL:
   
   a.) Dispense out approximately 2 quarts of material into a disposable container.
       (This initial material will contain both RAPIDFLUSH™ and Hapco material.)
   
   b.) Wipe with A-Tak

9. DISPOSE OF MATERIAL PROPERLY:
   
   a.) Mix the dispensed RAPIDFLUSH™ and Hapco material by hand in a disposable container and allow to fully cure.

   RAPIDFIL is now ready for use.

   See Quick Startup Procedure to begin.

   See Quick Shutdown Procedure to shutdown the machine for later use.
Recommended heated tank temperature setting is:
(unless otherwise specified)

<p>| | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td>To be determined by customer</td>
</tr>
<tr>
<td>Part B</td>
<td></td>
</tr>
</tbody>
</table>

Mix Ratio

<p>| | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>By Volume</td>
<td>A:B</td>
</tr>
<tr>
<td>By Weight</td>
<td>A:B</td>
</tr>
</tbody>
</table>

* Gel Time  
* Mixer size  

* Gel time will be decreased when heat is added.  
* Contact Hapco for additional mixer sizes.

NOTE: Hapco’s Part A (white tank) is the ISO or epoxy side.  
Hapco’s Part B (blue tank) is the polyol or amine side.

**RAPIDFIL Meter/Mix Dispensing Unit for**

**MATERIAL**

Model 306C

Serial # 0000000

**Standard Features Included:**

- LCD/Computer Controls
- 12 Gallon Stainless Steel Tanks
- Diagnostic System
- 2 Component
- Tank Thermostats
- 110 V, 20 amp Power
- Variable Output to 1gallon/min.
- Electric Agitation
- Fast Heat Tanks with Proportional Controls
- Disposable Mixers
- Desiccant Dryer System
- Color Coded Insulated Tanks
- Tank Site Gages
- LED Function Indicator Lights
- Automatic purge
- Shot Timing

**Optional Features Included:**

- Clear cover vacuum tanks
- Floor mounted hose management system
- Heated hose package
- Remote LCD Diagnostic control box
- Foot pedal dispensing control
Quick Start-up Procedure

1. Plug in the unit and turn on the main power.
2. Turn on tank heaters and set temperature if needed.
3. Remove any lubricant from output side of gun and wipe with A-tak.
4. Unlock trigger safety.
5. With mixing gun aimed over waste container, depress the trigger and make sure the flow is not interrupted (no blockage).
6. Increase the speed and check the flow again.
7. Wipe the material off of the output end of the gun and wipe with A-Tak.
8. Attach an RS mixer and secure with a retainer nut.
9. With the nozzle aimed into a waste container, depress the trigger and dispense a volume equal to 1/2 the volume of a mixing tube.

*Now you can begin dispensing.*

**NOTE:** Be aware of the material’s gel time to avoid curing material in the nozzle.

**Important - Keep the RAPIDFIL clean!**
Quick Shutdown Procedure

1. Switch the trigger lock into the lock position.
2. Shut off the power by pressing down the main power button.
3. Unscrew the RS mixer retainer nut.
4. Remove the used mixer and dispose of properly (see MSDS sheet).
5. Wipe and remove material from the output side of the gun.
6. Wipe and clean the output side of the gun with A-Tak until all residue is removed.
7. Apply lubricant to ports, threads, and retainer nut (see procedure).
8. Check material volume, fill if necessary.
9. Check desiccant cartridge and change if necessary.

Important—Keep the *RAPIDFIL™* clean!
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