

The HULK Operating Manual

Brand New HULK Setup

1. Follow the steps listed under “Flexible FAST™ Drum Setup”.
2. Attach air hose between HULK machine and air compressor.
3. Power up air compressor.
4. Install recirculation block and ensure fittings are tight, secure, and absent of fluid or air leaks.



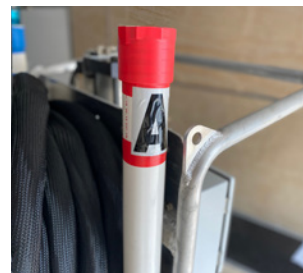
5. Tighten pump packing.
6. Place both ends of recirculation block into an empty trash receptacle.
7. Open manifold shutoff valves.



8. Slowly raise air regulator until machine begins to cycle (low pressure).
9. Let the material flow through the entire hose assembly until there is continuous flow with no air pockets.
10. Lower air regulator to 0 psi.
11. Close both manifold valves.
12. Remove recirculation block.

Flexible FAST Drum Setup

1. Set drums “A” and “B” on the correct sides of the machine. Color-coded labels are placed on each storage tube (located on each side of the machine).



A Side



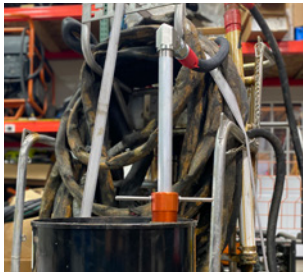
B Side

Note: 15-gallon drums can be placed directly on the HULK's drum rack if desired.

2. Ensure material temperature is correct and, if needed, apply heated blankets to ensure proper temperatures are retained.
3. Carefully open the Flexible FAST drums. **USE WHITE LITHIUM GREASE AT EVERY CONNECTION BEFORE FITTINGS ARE INSTALLED.**
 - a. The large bung connects the drum to the machine.
 - b. The small bung connects to the desiccant dryer.

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4. Insert fluid draw tubes in corresponding "A" and "B" drums.



A Side



B Side

NOTE: Once the A- and B-sides have been designated, DO NOT CROSS-CONTAMINATE WITH OPPOSITE CHEMICAL AT ANY TIME.

5. Remove tape from both ends and install the desiccant driers.



Switching out Flexible FAST Drums

1. Ensure dispensing has completely stopped and the HULK gun is in its "off" position.
2. Place the new set of "A" and "B" drums on the correct sides of the machine.
3. Carefully open the new Part A drum of Flexible FAST.
 - a. Remove the desiccant dryer from the empty drum of Part A and install it into the small bung on the newly opened drum of Part A.
 - b. Remove the pickup tube from the empty drum of Part A and install it into the large bung on the newly opened drum of Part A.

4. Carefully open the new Part B drum of Flexible FAST.

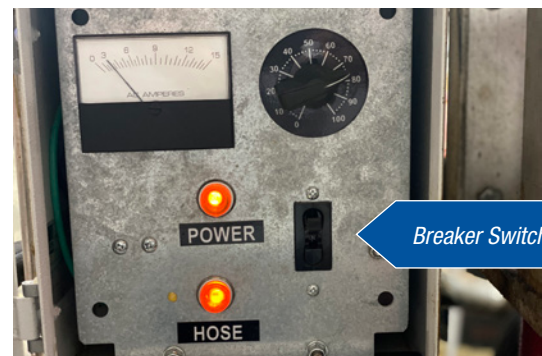
- a. Remove the desiccant dryer from the empty drum of Part B and install it into the small bung on the newly opened drum of Part B.
- b. Remove the pickup tube from the empty drum of Part B and install it into the large bung on the newly opened drum of Part B.

Daily Start-up and Dispensing Procedures

1. Ensure air compressor and generator are set up properly according to manufacturer's instructions.
2. Ensure tape has been removed on desiccant driers and they remain completely open during rig use.



3. If using a heated hose, attach extension cord between the generator and the HULK. If not, skip to Step #6.
4. Power up generator.
5. Turn on breaker and adjust dial to appropriate setting for jobsite conditions.

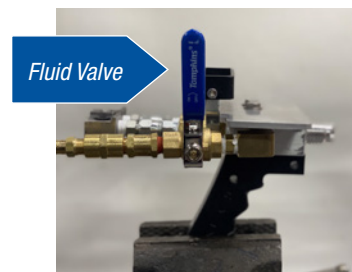


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6. Attach air hose between HULK machine and air compressor.
7. Attach the HULK gun to the hose assembly and ensure fittings are tight, secure, and absent of fluid or air leaks.



8. Power up air compressor.
9. Check gauges for equal pressure on A and B sides.
10. Apply white lithium grease to the threads on a NEW static mixing tip and install the mixing tip onto the gun.
11. Bead application:
 - a. Raise air pressure to appropriate setting. Manufacturer's recommendation is 50 psi.
 - i. Lower settings provide a slower speed of application.
 - ii. Higher settings provide a faster speed of application.
 - b. Open fluid handle completely to begin application of adhesive.



Closed Position



Open Position

- c. Ensure the adhesive is dispensed at a minimum 1/2"–3/4" wet bead and proper spacing is followed.



12. Splatter Application: The equipment settings listed below must be followed for approved splatter application.
 - a. Equipment Setting: 60 PSI
 - b. HULK Gun Air Pressure: 80 PSI
 - c. HULK Gun Air Handle: Crack open 1/8

*Air Pressure may need adjusted when material temperature exceeds 80°F

 - d. HULK Gun Fluid Handle: 100% open



13. While dispensing, check to make sure the A and B pressures are within 300 psi of one another. Adjust air pressure accordingly.
 - a. **NEVER** allow a pressure difference greater than 400 psi between the A and the B sides.
14. When you have reached a stopping point, ensure gun is pointed in a safe direction and close any open fluid or air valves on the gun.
15. Once valves are closed, discard the used static mixing tip and replace with a new one.

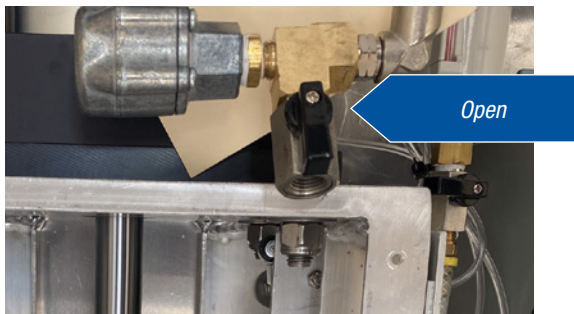
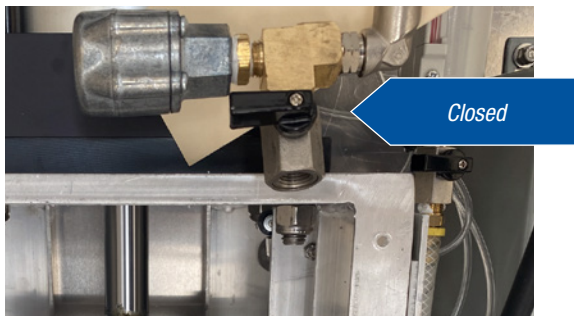
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Short-Term Shutdown Checklist (Overnight/Lunch Break)

1. Turn off hose heat.



2. Turn off generator.
3. Back air pressure off to 20 lbs.
4. In a safe direction, dispense excess material until both A and B gauges reach approximately 200 psi.
5. Open shutdown valve by a quarter turn.



6. Raise air pressure until blow-off is complete.



7. Turn air regulator off 100%.
8. Close shutdown valve completely.
9. Close both manifold valves on the HULK gun.
10. Disconnect air from spray gun.
11. Remove and discard the used static mixing tip.
12. Disconnect HULK gun from hose assembly.
13. With the fluid handle in the "open" position, clean HULK gun threads and clear fluid passages with non-chlorinated brake cleaner.
14. Shutdown is now complete.

Long-Term Shutdown Checklist (2 weeks or longer)

The following steps are to be completed at the end of each job or when the HULK will not be used for 14 days or longer.

1. 10 gallons of the proper pump lube from 4C's Spray Equipment must be used for flushing the machine.
2. Pour 2.5 gallons of pump lube into a clean 5-gallon bucket for the A-side, and repeat this step with the remaining pump lube for the B-side.

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3. Remove the A-side pickup tube from the Flexible FAST drum and wipe the outside of the tube with a clean cloth before inserting into the 2.5-gallon bucket of pump lube. Ensure the tube is in a vertical position. Repeat this step with the B-side pickup tube



4. Raise the air pressure to 20 pounds.
5. Using an empty trash receptacle, open both liquid manifold valves on the HULK gun and begin dispensing until clear liquid comes out of both the A-Side and B-side on the HULK gun.
6. Ensure buckets of pump lube do not run empty during flushing.
7. After about 50 strokes or when clear liquid is present, lower the air pressure to 0.
8. When both sides are clear, you may put the HULK machine into the park position (pumps are in the down position).



9. Close both manifold valves.
10. Once manifold valves are closed, you must put 1 quart of CLEAN pump lube into the A-side storage tube. Repeat this step for the B-side storage tube.
11. Put the A-side pickup tube from the bucket of pump lube into the A-side storage tube. Put the B-side pickup tube from the bucket of pump lube into the B-side storage tube.



12. Install all bung lids on both Flexible FAST drums, making sure to use white lithium grease on the threads.
13. Disconnect HULK gun from hose assembly.
14. With the fluid handle in the "open" position, clean HULK gun threads and clear fluid passages with non-chlorinated brake cleaner.
15. Shutdown is now complete.

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Prevention Tips

1. Use white lithium grease for all fittings, and threads for static mixing tips. This helps prevent material buildup and seals all possible passages for air and moisture.
2. Letter-label or color-code fittings, desiccant driers, and containers. This helps ensure that fittings and accessories stay on their designated A- or B-side.
3. Ensure all openings have been plugged unless being vented properly.

*Replace desiccant driers when needed.

Blue = Good to use

Pink = Needs replaced

4. When in doubt, flush it out. Flushing your machine regularly will significantly increase the operating life of your HULK and reduce downtime on the jobsite.

Troubleshooting

1. Proper storage of material is essential. Ensure the material temperature of Flexible FAST is kept at 70°F (21°C) at all times.
2. Ensure both ends of the desiccant driers are completely open.
3. Ensure the Y-screen on the A-side is clear and free of debris or crystals. Replace if needed.
4. Ensure gun and hose fittings are completely secure and tightened with no air leaks.
5. Ensure hoses are free of all kinks and twists.
6. Ensure a new static mixing tip is being used after stopping for 30 seconds or longer.