

TECHNICAL DATA

Semco® Model 250-B Gun

Description

The Semco® model 250-B handleless sealant gun is the standard of the aerospace and electronics industries. It is designed for quiet pneumatic application of sealants, adhesives, potting compounds, and other materials packaged in Semco® disposable cartridges or Semkit® packages for multi-component materials.

The Semco® model 250-B gun is available with retainers to fit standard 32 cc, 59 cc, 156 cc, 214 cc, and 310 cc (1, 2.5, 6, 8, and 12 ounce) disposable cartridges. Air hoses to operate the gun must be ordered separately.

The gun is constructed of durable metal and engineered plastic parts designed to withstand the rigors of the production work place. The nickel plated retainers are affixed to the valve assembly via a quick connect, secure bayonet lock fixture permitting easy replacement of cartridges

Accessories

Hose assemblies to fit the metal multi-axis swivel air fitting are available in 1.5 meter (5-foot) increments with Aro, Hansen, or Schrader air fittings attached. Also available are hose assemblies equipped with a female ¼" universal fitting for air supplies that do not use Aro, Hansen or Schrader air fittings.

PPG Industries produces Semco® brand precision molded cartridges, plungers, nozzles, Sem-Luer™ adapters and Sem-Needles™. When these disposable plastic products are used in conjunction with the Semco® model 250-B gun, the exact amount of material can be dispensed at the precise location required.

Operation

Attach the air hose assembly to a regulated compressed air source. Some applications may require the user to replace the quick release hose connector with a fitting compatible with local air supply hardware. Unscrew the back knob and disengage the retainer from the valve assembly. Place the cartridge into the retainer and replace the loaded retainer onto the valve assembly. Tighten the back knob until snug.

When the lever is depressed, air pressure pushes against the plunger in the cartridge. This allows for positive, even dispensing of the material. The material continues to flow until the lever is released, thereby permitting a drop, shot, or bead to be accurately applied. The amount of material dispensed is determined by the viscosity of material, air line pressure, nozzle or needle orifice size, and length of time the lever is depressed. When all the material has been dispensed from the cartridge, loosen the retainer by unscrewing the back knob. Remove the disposable cartridge and nozzle. Dispose of leftover material in accordance with local regulations and instructions on the material safety data sheet.

Features

- New bracket which lowers lever bar profile for easier access.
- Removable guard to protect against accidental discharge.
- Shorter swivel fitting ensures more accessibility.
- TPR coated knob for easier handling.
- Reduces applied material cost.
- Provides accurate material control.
- Lightweight.
- 0-6.9 bar (0-100 psi) operating range.
- Available in 32 cc, 59 cc, 156 cc, 214 cc, and 310 cc (1, 2.5, 6, 8, and 12 oz.) sizes.
- Bayonet lock on retainer permits quick cartridge change.
- Durable, shock resistant parts.
- Touch control on lever regulates flow.
- Positive control for smooth, even dispensing.
- Ergonomic design.
- Quiet operation.

Semco® Model 250-B Gun

Item	Part no.	Description
1	231611	Retainer, 32 cc (1 oz)
2	220256	Retainer, 59 cc (2.5 oz)
3	220928	Retainer, 156 cc (6 oz)
4	220926	Retainer, 214 cc (8 oz)
5	220923	Retainer, 310 cc (12 oz)
6	240050 includes	Valve body assembly
7	(items 7, 8, 9, 10,	Valve core, 6.2 bar (90 psi)
8	10, 11, 13, 15, 16,	O-Ring
9	17, 22 and 34)	Plunger
10		Washer, hard fiber
11		Hairpin clip
12		C-Clip
13		Muffler
14		O-Ring
15		Valve body
16		Bushing
17		Lever**
18	240015 includes	Swivel assembly
19	(items 10, 14, 19,	Swivel
20	20, 21 and 23)	Swivel nut
21		Swivel bolt, ext. hex head
22		Clevis pin
23		Swivel bolt
24	240036	Bracket assembly
25	240012	TPR coated knob assembly
26		Bracket, lever **
27		Dowel pin **
28		Screw
29		Washer
30	see table	Hose assembly
31		Cover **
32	240018	Service wrench
	240020 includes	Repair kit
	items 7-14 & 34	
33		Guard
34		Spring **

**** These parts are not interchangeable with parts from the 250-A Gun**

Universal hose assembly with a female 1/4" universal fitting for air supplies that do not use Aro, Hansen or Schrader air fittings.

231876	5' hose with 1/4" universal fitting
232649	10' hose with 1/4" universal fitting

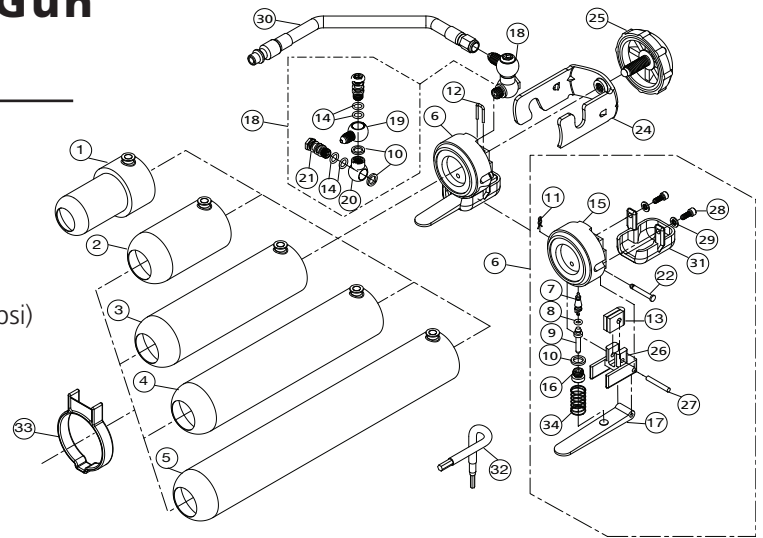


Complies with Machinery Directive 93/68EEC and Safety Standard EN60292

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Printed in the U.S.A



Complete sealant gun (less hose)

Model no.	Assembly no.	Size
	No handle	
250B-1	250010B	32 cc (1 oz)
250B-2.5	250250B	59 cc (2.5 oz)
250B-6	250060B	156 cc (6 oz)
250B-8	250080B	214 cc (8 oz)
250B-12	250120B	310 cc (12 oz)

All hose assemblies must be ordered separately. Fitted hoses are available with Hansen, Aro, or Schrader connectors.

For customer assembly and repair of hoses, the following components are available:

Components available

Description	Part no.
Hansen connector assembly	229186
Aro connector assembly	229187
Schrader connector assembly	229188
B-Nut assembly (gun end)	229189
Bulk gun hose (sold by the foot)	220895

Hose Assemblies

Hansen	Schrader	Aro	Length
280000	280006	280012	1.5 m (5 ft)
280001	280007	280013	2.9 m (10 ft)
280002	280008	280014	4.4 m (15 ft)
280003	280009	280015	5.9 m (20 ft)
280004	280010	280016	7.3 m (25 ft)
280005	280011	280017	8.9 m (30 ft)

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Issue Date: 02/11
Supersedes: 02/01
Lit: 1603