

This is a reprint of the original Xlent stucco pump manual. This is from the red Xlent pump in the pictures on the [stucco pump](#) page.

**XLENT EQUIPMENT, LLC**

# **DOMINATOR**

## *OWNERS MANUAL*

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CONGRATULATIONS ON YOUR PURCHASE OF AN XLENT DOMINATOR SPRAY UNIT. CONSIDERABLE RESEARCH AND DEVELOPMENT HAS BEEN INVESTED TO ENSURE THAT THE QUALITY OF ALL XLENT EQUIPMENT'S PRODUCTS ARE THE FINEST AVAILABLE IN THE INDUSTRY.

## **ATTENTION!**

**BEFORE OPERATING YOUR MACHINE, PLEASE  
TAKE THE TIME TO READ ALL OF THE  
“OPERATIONAL PROCEDURES”  
PAYING PARTICULAR ATTENTION TO THE  
RED HIGHLIGHTED AREAS.**

YOUR COMPLETE SATISFACTION IS IMPORTANT TO US. SHOULD YOU HAVE ANY QUESTIONS REGARDING EQUIPMENT OPERATION OR PROCEDURES PLEASE CONTACT US AT

**1-800-444-6614**

# **OPERATIONAL PROCEDURES**

## **BEFORE STARTING DOMINATOR OPERATION**

All oil levels should be checked before operating equipment to insure that no leakage or damage has occurred during shipment.

### **HONDA ENGINE**

Consult your Honda manual for oil type and amount. Engine will not run if oil level is low. Unit should be operated on a level surface.

### **BALDOR ELECTRIC MOTOR**

Electric service must be 230 volts at 33 amps (full load) single phase. Please call if you have any questions.

### **COMPRESSOR**

The compressor has a sight gauge located on the lower front of the compressor housing. The compressor is considered full when the oil is 2/3 of the way up on the sight gauge. If it becomes necessary to add oil to the compressor, only approved compressor oil must be used.

### **CAUTION:**

**KEEP HANDS AND OBJECTS CLEAR OF COMPRESSOR  
FLYWHEEL WHILE MACHINE IS RUNNING.**

### **HYDRAULIC OIL RESERVOIR**

The **Dominator** uses a hydraulic system for operating the peristaltic material pump. While this system only requires one gallon of oil to operate, the reservoir (which is the chassis tubing) is filled with 4 gallons. This allows the system to run cooler, thus increasing the life of the components.

The additional capacity of the reservoir (approximately 2 gallons) is reserved as air space for expansion of oil during operation, and should not be filled with additional oil. The hydraulic oil reservoir is full when it is approximately 2/3's full (2" of oil). The oil level may be checked by removing the 1/4" Socket Plug located

on the chassis behind the hopper, on the compressor side. (The hydraulic oil would normally not require refilling unless oil leakage is present due to a loose fitting or damage to one of the oil lines).

To check the oil level, you will need to remove the air filter and insert a straight piece of material into the filler tube until it bottoms out, and remove. You should be able to see approximately 2 ½" of oil showing.

# INTRODUCTION

The **Dominator** is a peristaltic type pumping system. Unlike most pumps in the industry, the **Dominator** may be run dry without causing damage. Initially, you should become familiar with the pump's operational characteristics and speed control variables.

The following is a volume guideline for your information:

Hose Length (1 ¼" Hose)	Approx. Pump RPM's	Approx. GPM's
50'	5	1.5
	15	5
	30	7
	45	10
	(Maximum speed)	
75'	5	1.2
	15	4
	30	6
	45	8

These volumes are based on a stucco slurry formulation as follows;

- 1) 1 bag (90 lbs) Portland Cement
- 2) ½ bag lime
- 3) 16 to 18 shovels (approx. 200 lbs) sand
- 4) Sufficient water to create a smooth, creamy sprayable solution.

Your actual volumes may vary considerably, depending upon viscosity of material, flowability characteristics, lubricating additives used, hose length, and hose size.

When higher volumes are desired you may need to thin the product or add additional lubricating products to assist the flow. Experimentation in this area will help you achieve the desired results.

As you know, there are many different types of products on the market. Some of them were not designed to be pumped at all. Most manufacturers have several product choices. Do your homework before using the **Dominator**. This will help you avoid unnecessary problems. **It is the responsibility of the customer to use the proper material for pumping.**

# MATERIAL LOADING

- 1) Pour premixed material into hopper. Material must be mixed to the proper consistency for spraying. Check with your product manufacturer or call us if you have any questions.
- 2) Be sure all hoses are connected properly. It is generally a good idea to establish the flow of product through the hose before attaching the gun. This is particularly important with sand based or other heavy aggregated products.

## BEFORE PUMPING

### **CAUTION: CEMENT BASED MATERIALS**

Cement Based materials require special procedures to be followed in order to successfully pump these products. They may include, but are not limited to the following:

1. “False” set must be “broken” before dumping into hopper.
2. Sand must be free of rocks, shells, and other contamination.
3. Mix must be thoroughly agitated to a smooth, creamy formula.
4. **USE OF HOSE LUBRICANTS DURING START-UPS MAY BE NECESSARY.**
5. **Sand/Cement formulas usually require a lubricant**, such as lime, to help create flowability (Does not necessarily apply to pre-packaged products or EIFS Materials).
6. For most materials, the recommended start up procedure is as follows:
  - A) Wet the inside of the material hose with water before attaching it to the pump.
  - B) Then remove any standing water from the hose by elevating the hose from one end to the other so as to allow excess water to run out. Some heavy aggregated materials may tend to pack during the initial start up flow through the hose. (The addition of a hose lubricant, such as Flo-Eze, or lime slurry poured into the hose will prevent this problem).

If you need further information or would like to discuss a particular product or formula, please call customer service at 1-800-444-6614.

## PUMP SPEED ADJUSTMENT

The **Dominator** uses a unique air cylinder type speed control, which can be adjusted to provide a wide range of speed variables for material flow.

Locate the speed control by lifting the rear engine cover. The speed control is located behind the engine between the engine and hopper. Screw in (clockwise) the speed control handle knob to slow down the pump. To run pump faster, open speed control knob (counter-clockwise.)

**TO SLOW DOWN PUMP – SCREW IN  
TO SPEED UP PUMP – SCREW OUT**

**WARNING:**

**DO NOT RUN THE DOMINATOR ABOVE 45 RPM'S.**

PLEASE NOTE: SPEEDS ABOVE 45 RPM'S DO NOT INCREASE MATERIAL FLOW BUT MAY CAUSE PREMATURE FAILURE OF PUMP ASSEMBLY.

**SPRAY NOZZLE OPERATION**

Become familiar with the nozzle operation before pumping material.

1. The on/off operation of the pump is controlled by the slider-valve located on the gun.
2. The air hose must be connected to the gun in order for the on/off valve to work.
3. Shut off air flow at the gun head (located at top of gun).
4. Move the slide valve to the on position to turn on the pump. (Turn to the off position to turn pump off).

**Please note again:** In order for the pump to turn on, you should turn off the atomization air at the gun head so that air can be diverted to the speed control cylinder.

**SPRAYING SUGGESTIONS**

## **SPRAYER MUST BE LEVEL DURING OPERATION!**

The spray pattern will vary depending upon gun tip size, air stem adjustment, material flow rate, and air volume. We recommend using the largest tip size that still achieves the desired spray pattern as this helps reduce tip clogging and increase material flow rates. A small amount of experimentation will be rewarded by increased productivity and quality.

Establishing flow of product through the hoses before attaching gun is highly recommended. This expels build up material and reduces the chances of clogging at the tip during start up. With some materials, however, such as drywall products, this procedure is usually not necessary. The quick release fittings used with the hose and gun assemblies must be cleaned in order to seal properly. Forcing these fittings together may result in broken fittings.

**IF THE TIP BECOMES CLOGGED, TURN OFF THE PUMP IMMEDIATELY.** Sometimes the particle may dislodge if the gun end is tapped on a hard surface. If the tip must be removed for cleaning, **BE SURE PUMP IS IN THE OFF POSITION.**

Viscosity, or consistency, of the material varies a great deal between manufacturers, and also depends on age and types of products. Each material must be thinned to a consistency that is somewhat thinner than a “trowelable” product. **Generally if you scoop up a handful of material and squeeze it in your fist, all of the material should be squeezed out. If a lump of material remains in your hand, the mixture is too thick or requires additional lubricating additives.** Some experimenting with this aspect of the spray procedure will be well worth the time and effort. Of course, compliance with the manufacturer recommendations in this area is a necessity.

### **HERE ARE SOME ADDITIONAL SUGGESTIONS OR DETAILS TO HELP YOU SUCCEED IN PUMPING YOUR CEMENT BASED MATERIALS:**

After the mix has been thoroughly blended, turn off the mixer for 5 to 10 minutes to allow mix to false set. You may find that the material is thicker after 5 to 10 minutes of setting than when it was originally mixed. By allowing the “false” set to occur, and then breaking it up by re-mixing the material (you may need to add a small amount of water to reduce the viscosity somewhat) you will extend the open time on the next set to approximately 45 minutes to 1 hour. This allows for a more uniform pumping formula.



Hose lubricants such as Flo-Eze will help material flow through the hose on the initial start up. You may also use a small amount of lime, mixed to a slurry with water.

The richer the formula is in cement, the better it will “flow.” Formulas with a low cement content may work okay with a hand application, but may not pump well. However, the addition of a “slip,” such as lime, in the mix will substantially improve flowability. See page 5 for a suggested slurry formulation.

Start out with slower pump speeds and shorter hose lengths. After you get material pumping then gradually increase the pump speed and hose lengths, as required.

During startup, get the product flow established through the hose first, and then put the gun on. This allows the “stiffer” startup flow to be expelled from the hose. This stiffer material will sometimes get caught up in the nozzle restrictions, and may cause a “pack.”

Use the largest tip possible to allow for expulsion of sand /cement contaminants, and also to reduce back pressure in hose.

**IF THE FLOW OF MATERIAL STOPS, TURN THE PUMP OFF IMMEDIATELY!** This usually indicates a problem, such as packing or blockage in hose, or hopper is out of material. **NOTE: YOU CANNOT BREAK A MATERIAL “PACK” BY TURNING PUMP ON AND TRYING TO FORCE MATERIAL OUT!!!** This procedure only increases the possibility of pump damage. Locate the source of the problem, remove the pack, and then proceed. If the material continues to pack, the mix needs to be adjusted, such as adding more lubrication or thinning.

Because of the setting nature of cement based products, it is recommended to occasionally check the bottom of the hopper to make sure that the material has not solidified in the pump housing, restricting the flow into the pump.

## **SUGGESTED START-UP PROCEDURES**

1. Refer to this manual initially for:

- A. Introduction
- B. Material Loading
- C. Pump Speed Adjustment
- D. Spraying Suggestions

2. Use one 25' hose
3. Start at a slow speed with the air turned off at the nozzle. (It is easier to determine the proper flow of material with the air off)
4. Adjust air stream forwards (toward tip) until it starts to interfere with the material flow. Then move air stem back until material flow is not affected. (This is usually about ¼ inch back from opening)
5. Open air on/off valve. Air adjustment valve should be closed. Gradually open air adjustment valve until desired atomization is achieved.
6. Experiment with the different tip sizes to fine tune the spray pattern
7. Add additional hose lengths as needed

## **CLEAN-UP**

The degree of clean up will vary with the type of material being pumped.

Cementitious materials must be thoroughly removed from all surfaces, gun parts, pump housing, etc. Due to the thick viscosity of most aggregated products being pumped with the **DOMINATOR**, it is recommended that you break down each hose section before cleaning. Use of the cleanout system, which uses a sponge being pushed through the hose with air pressure provided by the use of the cleanout “tool” is also recommended. The sponge provides a better “wipe” of the hose interior and reduces unnecessary waste created when the product is diluted by water.

Recommended Clean-Up procedures are as follows:

1. Pump all material out of hopper.
2. Disconnect all hose assemblies from the pump and gun.
3. Rinse the fitting at the female end of the hose and insert the small round sponge supplied.
4. Attach air tool to the hose. Make sure air valve on tool is in the off position and attach other end of tool to air hose.
5. While an assistant holds the opposite hose end in a bucket, open air valve in **SHORT BURSTS** to force sponge through hose. The sponge will move through the hose **VERY RAPIDLY** and air should be regulated carefully to avoid sponge bursting explosively from hose end. This procedure will clean 95% of material from hose. **NOTE:** Keep an eye out for the sponge so you may retrieve it for future use.
6. Remove air tool and again insert round sponge into hose. Push water hose pistol grip nozzle into hose end holding the two together tightly. Turn on the water and sponge will travel through hose, cleaning as it goes. Repeat until the water flows clear.
7. Flush hopper and **Dominator** pump assembly with water until clear.
8. Clean gun by flushing with water repeatedly. Flushing should be done from both ends of the gun. Open air valve and flush water backward through air stem until clear water flows from the air connection fitting at the bottom end of the gun. Spray lubricant on moving parts.

## **MAINTENANCE**

(Refer to Honda Engine Manual for Engine Maintenance)

**DURING TRANSPORTATION OF UNIT, BE SURE TO TURN THE FUEL SHUT OFF SWITCH TO THE OFF POSITION.** This will avoid complications with gas pumping into the crankcase. (If gasoline is pumped into the crankcase then the spark plug has to be removed and the oil has to be changed before you can run the engine again.)

If you have an electric start motor model, be sure to keep the extra key in a safe place (on your car keys, perhaps). This key is **NOT** standard. You must purchase a HONDA key in order to start your engine. NOTE: Electric start models will **NOT** start unless key is turned to the ON position.

Compressor oil level should be checked each time the Dominator is used, just like the engine oil.

**PLEASE NOTE THIS IMPORTANT INFORMATION REGARDING YOUR HYDRAULIC OIL FILTER!**

Hydraulic filter requires changing after first 50 hours and every 200 hours thereafter. **Failure to change filter will result in pump failure and will void the warranty.** To insure you receive the correct filter, order your filter from Xlent Equipment by calling toll free 1-800-444-6614 or you contact your Xlent Dealer.

## **TWO YEAR LIMITED WARRANTY**

XLENT EQUIPMENT, LLC warrants its products against defects in materials and workmanship under normal use and service for a period of two years from the date of purchase. We may, at our discretion and for the original purchaser only, replace and/or repair said parts having determined that these parts were not subjected to abnormal abuse and/or are not parts that are expected to wear out during the course of normal usage. This warranty does not cover labor for installation of the replaced parts nor their transportation to and from the factory. XLENT EQUIPMENT, LLC does not warranty engines, motors, compressors or batteries, as these parts are covered by their respective original manufacturers' warranties. This warranty is for replacement of defective parts only and does not cover any other damages such as lost time, employee expenses, loss of materials, loss of profits, deadline penalties and/or related damages. XLENT EQUIPMENT, LLC reserves the right to make changes or improvements upon its products without imposing on itself the obligation to install the same changes or improvements upon products previously manufactured.

### **Notes from Nolan:**

**This was one of the best 1.5” squeeze pumps I have owned. It has much more torque than the other 1.5” pumps like the Quikspray Pump and other small Stucco Pumps.**

**If you have other manuals to share please email them to me at [nolan@mortarsprayer.com](mailto:nolan@mortarsprayer.com). I will add them to the [Stucco Pump](#) page.**