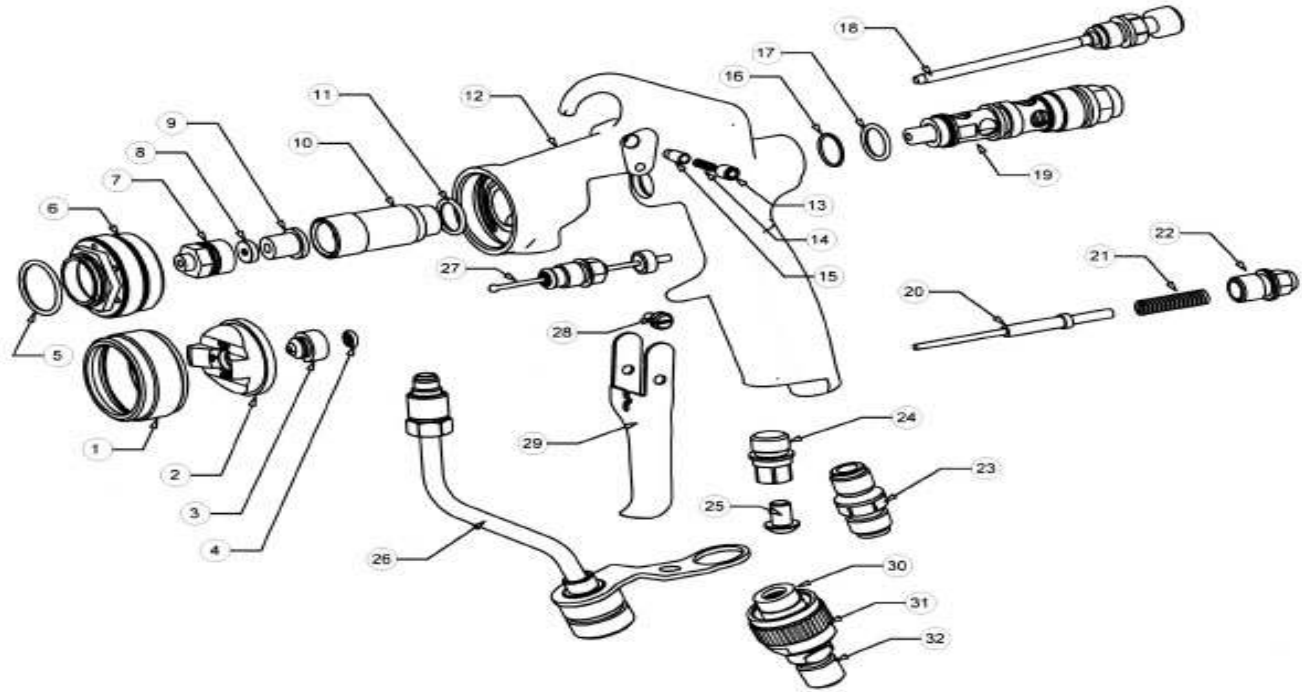
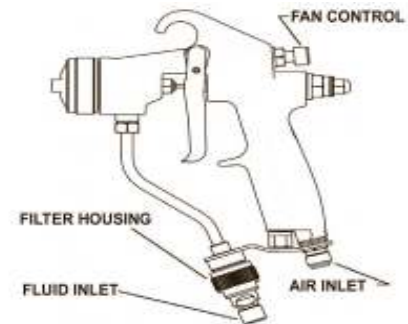


Operation & Maintenance for AAA Spray Gun



OPERATION

1. Connect air supply hose at handle of gun.
2. Connect material supply hose from pump to gun fluid inlet.
3. The trigger safety is activated when trigger is pushed forward
4. Maximum pattern width is determined by tip selection. Turning the fan control knob counter clockwise will narrow the fan. Pattern is maximum when fan control is completely closed.
5. For HVLP compliance, do not exceed 18 psi air pressure at gun handle.



MAINTENANCE

NOTE: Complete gun disassembly is not recommended for normal cleaning and maintenance.

IMPORTANT! Relieve gun fluid pressure to 0 psi before performing any Maintenance.

It is recommended repair kit #137 or 138 be on hand before starting gun repair.

Replacing needle cartridge assembly

1. Remove the trigger by removing both trigger screws 1315 (28)
2. Remove fluid spring cap 340 (22) using a 3/8" wrench.
3. Remove needle return spring 344 (21), and push rod 337 (20).
4. Remove the air valve assembly 1320 (19) using a 9/16" wrench.
5. Using a 3/8" wrench remove the needle seal body. The needle cartridge 330 (27) can be removed through the back of the gun.
6. Inspect o-rings 7014 (17) and 5125 (16) and replace if necessary.

Replacing gun seat

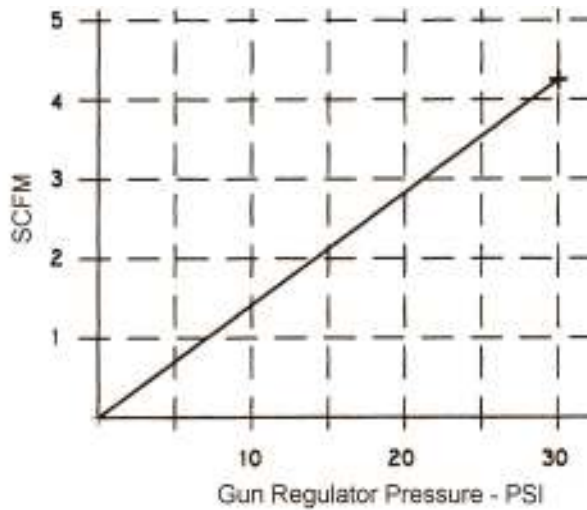
1. Remove air cap and tip. Using a 1/2" socket, remove fluid nozzle body 104 (7)
2. Using an 1/8" rod, push both the seat 105 (8) and seat retainer 110 (9) out of the nozzle body.

Replacing gun filter

1. Using a 3/4" open end wrench, remove filter retainer nut 123 (31) and separate the upper and lower filter housings exposing the filter. It is not necessary to disconnect the fluid hose to change the filter.

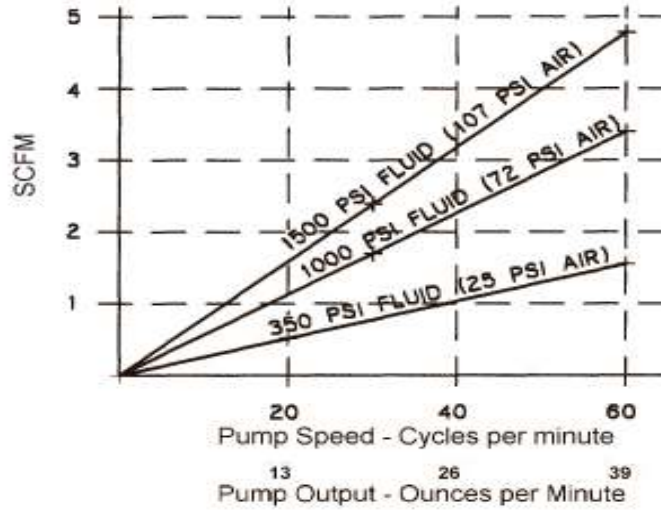
NOTE: The gun is equipped with a 100 mesh filter as standard. 60 mesh filters are also available.

Gun Air Consumption



*Max pressure for HVLP

Pump Air Consumption



Compressed air requirements

Minimum compressor size will vary with the application. Air requirements for the gun and pump must be added together for total air requirements.

Example: Gun regulator setting 25 psi, scfm = 3.5
 Pump fluid pressure is 1000 psi and cycle rate is 30, scfm = 1.75
 Minimum compressor requirement: 3.5 + 1.75 = 5.25 scfm

Fluid tip flow rate chart (fluid oz/min.)

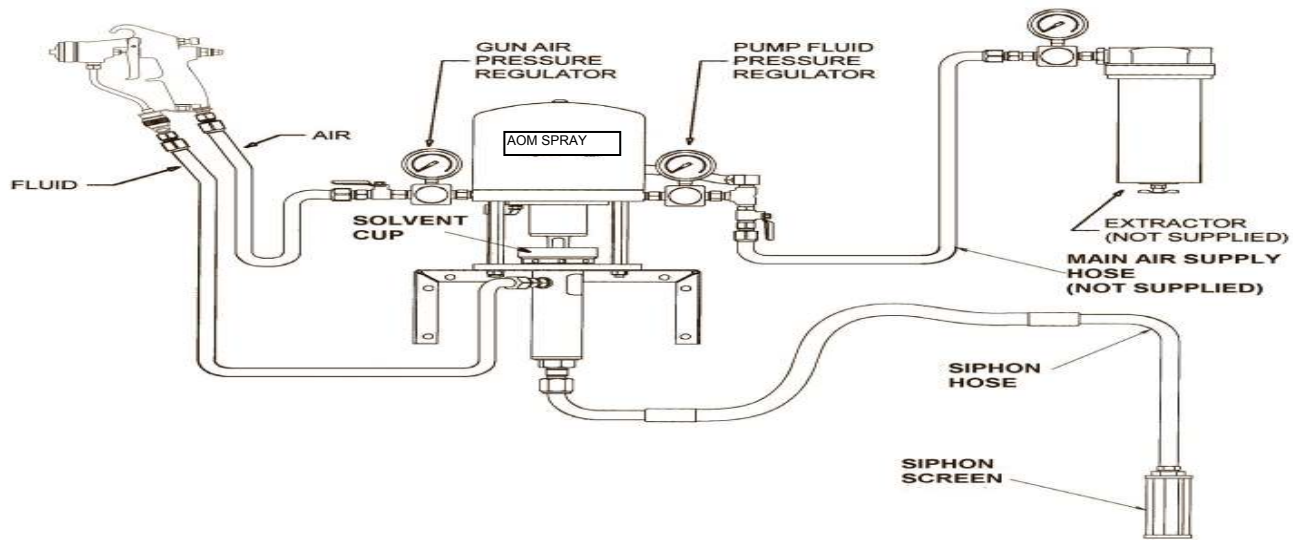
Tip Size	Pressure (psig)							
	350		700		1000		1500	
	light material	heavy material	light material	heavy material	light material	heavy material	light material	heavy material
0.007	3		4		5		6	
0.009	5		8		9		11	
0.011	8		11		13		16	
0.013	10		14		17		21	
0.015	13		18		22		27	
0.017	17	13	24	18	29	22	35	27
0.019	21	16	30	23	36	27	44	33
0.021	27	21	38	29	45	35	56	43

Note: Values are approximate and will vary depending on actual material viscosity.

Fluid tip selection chart

Part No.	Orifice Size	Fan Width*
207	0.007	4"
309	0.009	6"
409	0.09	8"
211	0.011	4"
311	0.011	6"
411	0.011	8"
511	0.011	10"
611	0.011	12"
213	0.013	4"
313	0.013	6"
413	0.013	8"
513	0.013	10"
613	0.013	12"
315	0.015	6"
415	0.015	8"
515	0.015	10"
615	0.015	12"
715	0.015	14"
815	0.015	16"
417	0.017	8"
517	0.017	10"
717	0.017	14"
619	0.019	12"
719	0.019	14"
621	.021"	12"

*Fan width is based on 10" gun to target distance. Material viscosity will influence width.



SETUP

1. **Back the pump pressure regulator completely off (counterclockwise) and close the ball valve.**
Attach the main air supply hose to ball valve on the pump fluid pressure regulator.
2. Attach one end of fluid hose to pump outlet and the other end to gun fluid inlet.
3. Attach the end of the air hose to the ball valve at gun pressure regulator. Ball valve should be closed and regulator backed off. Attach the 1/4" end of the hose to the air inlet on gun
4. Attach siphon hose to the pump inlet and insert siphon hose strainer into material to be sprayed.

BE SURE ALL CONNECTIONS ARE TIGHT

OPERATION

1. Remove air cap and fluid tip from spray gun.
2. Turn pump fluid pressure ball valve on and **slowly increase pressure on regulator** until pump begins to stroke.
3. Direct spray gun discharge into material container. Trigger the spray gun and hold open until fluid is flowing from gun. Release the spray gun trigger and pump will stop. Pump is now primed.
4. Replace the fluid tip and air cap on spray gun.
5. With the spray gun triggered, increase pressure on pump until a fan pattern appears at the spray tip.
6. Open the ball valve at the gun pressure regulator. Increase the atomizing air pressure to the gun until the spray pattern is even and no longer has tails.

NOTE: For HVLP compliance, maximum pressure setting on gun regulator is 18 psi .

Pump pressure may be increased to eliminate tails in pattern.

7. It is recommended that a solvent compatible with the material being sprayed be used in the pump solvent cup. This will increase pump seal life and minimize down time.

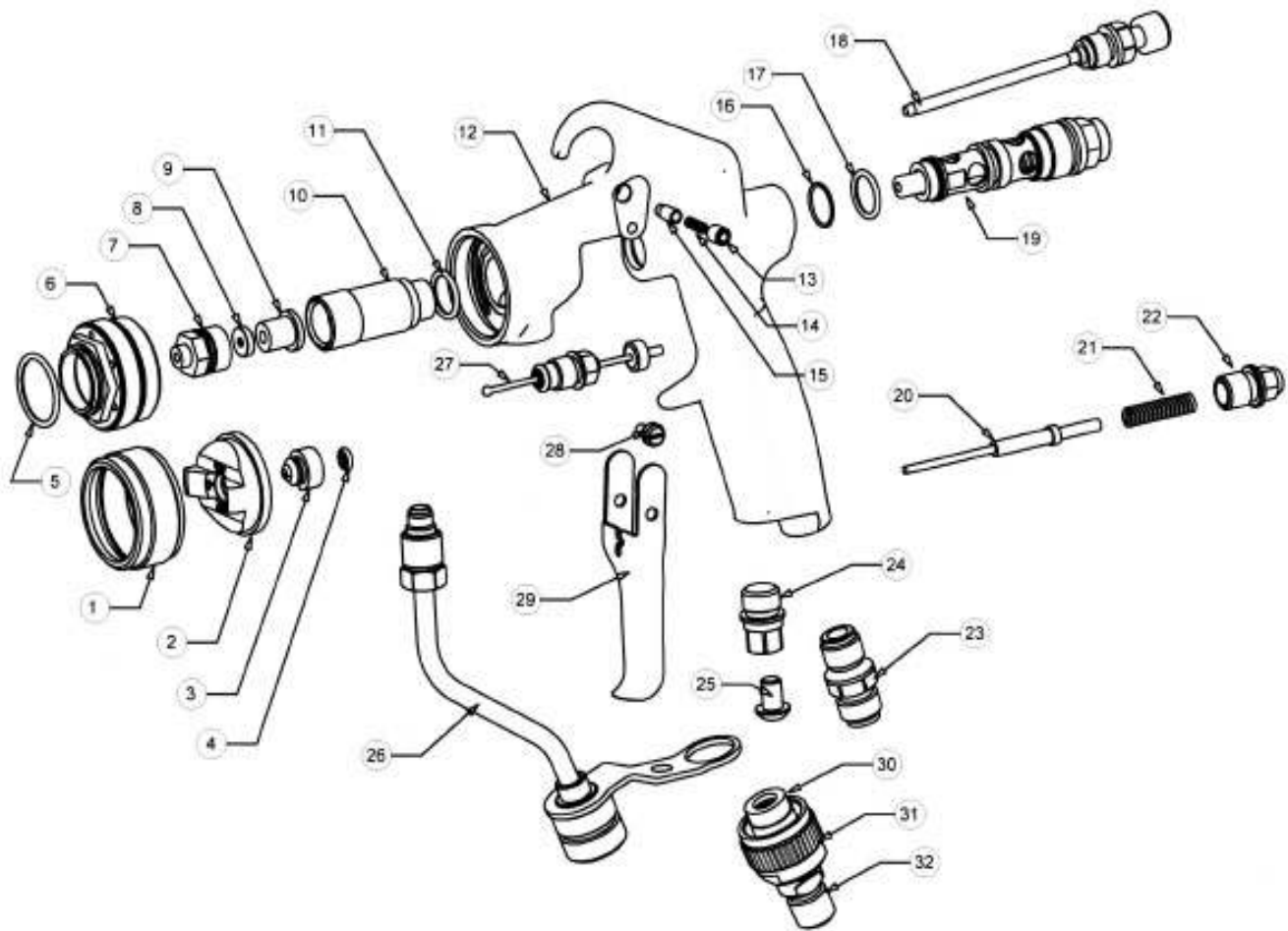
SHUT DOWN

FOR SHORT TERM SHUT DOWN:

1. Close the pump pressure ball valve and relieve pressure by triggering the spray gun.

FOR LONGER TERM SHUT DOWN:

1. Remove air cap and fluid tip from spray gun and close ball valve on gun pressure regulator.
2. Remove siphon hose from material.
3. Back pump pressure regulator off completely.
4. With the spray gun triggered and directed into the material container, slowly increase pressure on pump until pump strokes slowly. Continue until all material is returned to container.
5. Immerse siphon hose in a clean compatible solvent. Circulate solvent thru system until completely clean.
6. Purge solvent from system by removing siphon hose from solvent and continuing to operate pump until system is empty. Stop pump with pump rod in down position.



ITEM #	PART#	DESCRIPTION	ITEM #	PART#	DESCRIPTION
1	1001	AIR CAP RING	19	1320**	AIR VALVE ASSEMBLY
2	101	AIR CAP	20	337	PUSH ROD
3	511	FLUID TIP (see fluid tip chart for other sizes)	21	344	SPRING
4	8007*	O-RING (standard)	22	340	SPRING CAP
4	100	TIP STRAINER (optional)	23	104	AIR INLET FITTING
5	8019*	O-RING	24	319	HANDLE PLUG
6	103	AIR CAP ADAPTER	25	186	SCREW
7	104	NOZZLE BODY	26	315	FLUID TUBE ASSEMBLY
8	105*	SEAT	27	330**	NEEDLE SEAL ASSEMBLY
9	110	SEAT RETAINER	28	1315	TRIGGER PIVOT SCREW
10	302	NOZZLE CARRIER	29	350	TRIGGER
11	8014*	O-RING	30	125	FILTER (100 mesh standard)
12	301	GUN BODY	30	124	FILTER (60 mesh optional)
13	275	SET SCREW	31	123	FILTER RETAINING NUT
14	310	SPRING	32	122	FILTER HOUSING, LOWER
15	313	PIN, TRIGGER SAFETY			
16	5125*	O-RING	**	137	GUN REPAIR KIT (soft seals only)
17	7014*	O-RING	*	138	COMPLETE GUN REPAIR KIT
18	308	FAN CONTROL			(complete gun repair includes 1320 and 330)