

Das WALTHER PILOT-Programm

- Hand-Spritzpistolen
- Automatik-Spritzpistolen
- Niederdruck-Spritzpistolen (System HVLP)
- Zweikomponenten-Spritzpistolen
- Materialdruckbehälter
- Drucklose Behälter
- Rührwerk-Systeme
- Airless-Geräte und Flüssigkeitspumpen
- Materialumlauftsysteme
- Kombinierte Spritz- und Trockenboxen
- Absaugsysteme mit Trockenabscheidung
- Absaugsysteme mit Naßabscheidung
- Pulversprühstände
- Trockner
- Zuluft-Systeme
- Atemschutzsysteme und Zubehör

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Le Programme de WALTHER PILOT

- Pistolets de pulvérisation manuels
- Pistolets de pulvérisation automatiques
- Pistolets de pulvérisation (Système HVLP)
- Installations de marquage
- Pistolets de pulvérisation à deux composants
- Récipients de mélange et de stockage
- Appareils de pulvérisation sans air
- Pompes de transfert
- Murs à aspiration sèche
- Murs à rideau d'eau
- Cabines de poudrage
- Cabines mixtes peinture-séchage
- Installations de soufflage
- Etuves
- Très nombreux accessoires

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The WALTHER PILOT Programme

- Manual Spray Guns
- Automatic Spray Guns
- Low Pressure Spray Guns (System HVLP)
- Two-Component Spray Guns
- Material Pressure Tanks
- Nonpressurized Tanks
- Agitator Systems
- Airless Equipment and Transfer Pumps
- Material Circulation Systems
- Combined Spraying and Drying Booths
- Spray Booths with Filter Mats
- Spray Booths with Water-Wash Function
- Powder Spray Stands
- Dryers
- Ventilation Systems
- Protective Respiratory Systems and Accessory Items

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Il programma WALTHER PILOT:

- Pistole a spruzzo manuali
- Pistole a spruzzo automatiche
- Pistole a spruzzo (sistema HVLP)
- Pistole a spruzzo per due componenti
- Serbatoi per materiale a pressione
- Serbatoi non a pressione
- Impianti di agitazione
- Apparecchiature Airless e pompe per liquidi
- Impianti di circolazione materiale
- Sistemi di aspirazione di vernice polverizzata con separazione a secco e umido
- Apparecchi essiccatrici
- Impianti per aria addizionale (circolazione dell'aria)
- Apparecchi per la protezione respiratoria e accessori

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WALTHER PILOT

Betriebsanleitung / Operating Instructions
Instructions de Service / Istruzioni per l'uso

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Zweikomponenten-Spritzpistole

Two-Component-Spray Gun

Pistolet de pulvérisation à deux composants

Pistola a spruzzo per due componenti

PILOT III 2-K



REV. 10/08

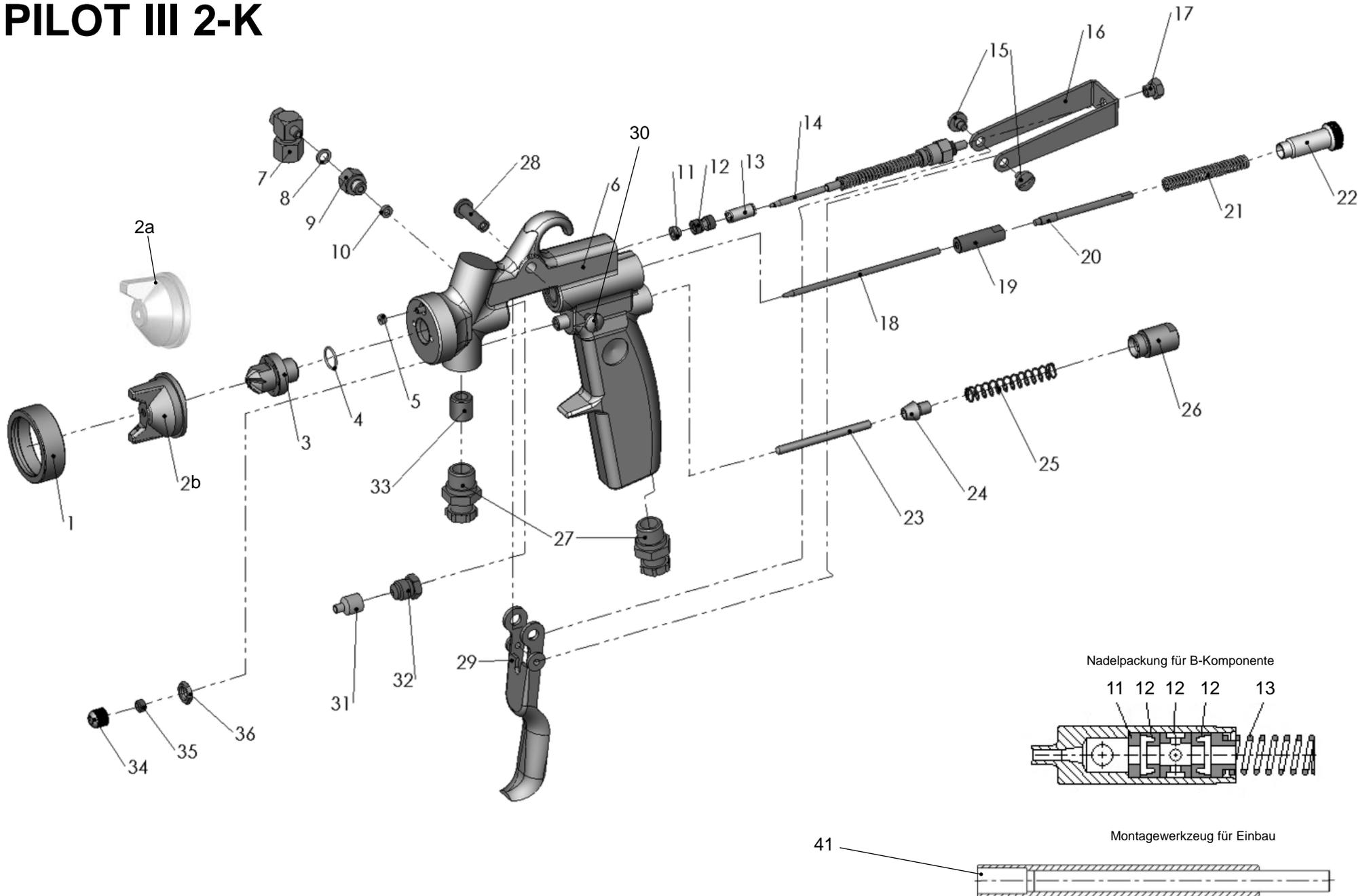


Die Beschichtungs-Experten



Die Beschichtungs-Experten

PILOT III 2-K



Stand: Oktober 2008

EG-Konformitätserklärung

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Wir, der Gerätehersteller, erklären in alleiniger Verantwortung, daß das Produkt in der untenstehenden Beschreibung den einschlägigen grundlegenden Sicherheits- und Gesundheitsanforderungen entspricht. Bei einer nicht mit uns abgestimmten Änderung an dem Gerät oder bei einer unsachgemäßen Verwendung verliert diese Erklärung ihre Gültigkeit.

Hersteller	WALTHER Spritz-und Lackiersysteme GmbH Kärntner Str. 18-30 D-42327 Wuppertal Tel.: 0202 / 787-0 Fax: 0202 / 787-217 www.walther-pilot.de • Email: info@walther-pilot.de			
Typenbezeichnung	Zweikomponenten-Handspritzpistole PILOT III 2-K PILOT III 2-K V 24 531			
Verwendungszweck	Verarbeitung spritzbarer Materialien			
Angewandte Normen und Richtlinien				
EG-Maschinenrichtlinien 98 / 37 EG 94 / 9 EG (ATEX Richtlinien) DIN EN ISO 12100-1 DIN EN ISO 12100-2 EN 1127-1				
Spezifikation im Sinne der Richtlinie 94 / 9 / EG				
Kategorie 2	Gerätebezeichnung		II 2 G c T 6	Tech.File,Ref.: 2410
Besondere Hinweise : Das Produkt ist zum Einbau in ein anderes Gerät bestimmt. Die Inbetriebnahme ist so lange untersagt, bis die Konformität des Endproduktes mit der Richtlinie 98 / 37 / EG festgestellt ist.				

Wuppertal, den 7. Juli 2003

i.V. 

Name: Torsten Bröker

Stellung im Betrieb: Leiter der Konstruktion und Entwicklung

Diese Erklärung ist keine Zusicherung von Eigenschaften im Sinne der Produkthaftung. Die Sicherheitshinweise der Produktdokumentation sind zu beachten.

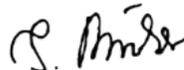
Declaration of CE-Conformity

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We, the manufacturers of the equipment, hereby declare under our sole responsibility that the product(s) described below conform to the essential safety requirements. This declaration will be rendered invalid if any changes are made to the equipment without prior consultation with us.

Manufacturer	WALTHER Spritz-und Lackiersysteme GmbH Kärntner Str. 18-30 D-42327 Wuppertal Tel.: 0202 / 787-0 Fax: 0202 / 787-217 www.walther-pilot.de • Email: info@walther-pilot.de			
Type Designation	Two-Component-Manual Spray Gun PILOT III 2-K PILOT III 2-K V 24 351			
Intended purpose	Processing of sprayable media			
Applied Standards and Directives				
EU-Machinery Directive 98 / 37 CE 94 / 9 EC (ATEX Directives) DIN EN ISO 12100-1 DIN EN ISO 12100-2 EN 1127-1				
Specification according 94 / 9 / CE				
Category 2	Part marking		II 2 G c T 6	Tech.File,Ref.: 2410
Special remarks : The named product is intended for installation in other equipment. Commissioning is prohibited until such time as the end product has been proved to conform to the provision of the Directives 98 / 37 / CE.				

Wuppertal, the 7th of July 2003

i.V. 

Name: Torsten Bröker

Position: Manager, Design and Development

This Declaration does not give assurance of properties in the sense of product liability. The safety instructions provided in the product documentation must be observed at all times.

Déclaration de conformité CE

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En tant que fabricant de cet appareil, nous déclarons en toute responsabilité que le produit décrit ci-dessous est conforme aux exigences de sécurité et de protection de la santé actuellement en vigueur. Toute modification sans autorisation de notre part ou utilisation inadéquate de l'appareil, annulent la validité de cette déclaration.

Fabricant	WALTHER Spritz-und Lackiersysteme GmbH Kärntner Str. 18-30 D-42327 Wuppertal Tel.: 0202 / 787-0 Fax: 0202 / 787-217 www.walther-pilot.de • Email: info@walther-pilot.de			
Dénomination du modèle	Pistolet de pulvérisation manuelle à deux composants PILOT III 2-K PILOT III 2-K V 24 351			
Utilisation	Application de matières pulvérisables			
Normes et directives appliquées				
Directive UE sur les machines 98 / 37 UE 94 / 9 EG (directives ATEX) DIN EN ISO 12100-1 DIN EN ISO 12100-2 EN 1127-1				
Normes et directives appliquées				
Catégorie 2	désignation de l'appareil		II 2 G c T 6	Tech.File,Ref.: 2410
Indications particulières: Le produit est conçu pour être intégré à un autre équipement. La mise en service n'est pas autorisée avant l'établissement de la conformité du produit final avec la directive 98 / 37 / UE.				

Wuppertal, le 7 juillet 2003

i.v. 

Nom: Torsten Bröker

Position dans l'entreprise: chef de l'exécution et du développement

Cette déclaration ne constitue pas un engagement de responsabilité dans le sens de la garantie du produit. Les consignes de sécurité contenues dans les instructions de service devront être respectées.

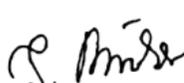
Dichiarazione di conformità CE

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Noi, il produttore dell'apparecchio, dichiariamo sotto la propria responsabilità che il prodotto nella descrizione sottostante è conforme a tutti i requisiti fondamentali di sicurezza e sanitari in materia. In caso di modifiche apparecchio non concordate con noi o nel caso di un uso non appropriato, la presente dichiarazione perde la sua validità.

Produttore	WALTHER Spritz-und Lackiersysteme GmbH Kärntner Str. 18-30 D-42327 Wuppertal Tel.: 0202 / 787-0 Fax: 0202 / 787-217 www.walther-pilot.de • Email: info@walther-pilot.de			
Denominazione del tipo	Pistola a spruzzo manuale per due componenti PILOT III 2-K PILOT III 2-K V 24 351			
Uso previsto	Lavorazione di materiali spruzzabili			
Norme e direttive applicate				
Direttive Macchine CE 98 / 37 CE 94 / 9 CE (direttive ATEX) UNI EN ISO 12100-1 UNI EN ISO 12100-2 UNI EN 1127-1				
Specifica ai sensi della direttiva 94 / 9 / CE				
Categoria 2	Denominazione dell'apparecchio		II 2 G c T 6	Tech.File,Ref.: 2410
Avvertenze particolari: Il prodotto è concepito per essere installato in un altro apparecchio. La messa in funzione è proibita fino a quando non è dimostrata la conformità del prodotto finale alla direttiva 98 / 37 / CE.				

Wuppertal, li 7 luglio 2003

i.v. 

Nome: Torsten Bröker

Posizione nell'azienda: Direttore del reparto Costruzione e Sviluppo

La presente dichiarazione non costituisce una garanzia delle caratteristiche ai sensi della responsabilità da prodotto. Le avvertenze di sicurezza presenti nella documentazione devono essere rispettate.

Listing of Replacement Parts PILOT III 2-K

Item	Article-No.	Description	Item	Article-No.	Description
1	V 01 101 03 003	Air Cap Retaining Nut	19	V 10 353 07 000	Driver Pin
2a	optional for Nozzle Size	Rotary-Jet Air Cap 0,8 / 1,0 mm ø	20	V 10 353 08 000	Counter Screw
Component A with Bore f.		Component B:	21	V 10 306 04 000	Needle Spring
	V 24 531 20 030	0,3 mm ø	22	V 10 306 05 000	Adjusting Screw
	V 24 531 20 040	0,4 mm ø	23	V 10 304 01 000	Valve Stem
	V 24 531 20 050	0,5 mm ø	24	V 10 904 02 000	Valve Cone
2b	optional for Nozzle Size	Wide-Jet Air Cap 0,8 / 1,0 mm ø	25	V 10 304 03 000	Valve Spring
Component A with Bore f.		Component B:	26	V 10 304 04 000	Valve Housing
	V 24 531 40 030	0,3 mm ø	27	V 66 100 06 257	Quick-Release Fitting
	V 24 531 40 040	0,4 mm ø	28	V 10 301 08 000	Trigger Shank Screw
	V 24 531 40 050	0,5 mm ø	29	V 24 531 11 000	Trigger
3	optional	Rotary-Jet Nozzle 0,8 mm ø	30	V 10 301 09 000	Trigger Screw
	V 01 101 37 083		31	V 10 353 06 100	Needle Packing for A-Component
	V 01 101 37 103	1,0 mm ø	32	V 10 353 10 000	Needle Packing Gland
wide selection of nozzles available upon request			33	V 24 531 35 000	Spacer Sleeve
4	V 09 103 33 001	O-Ring	34	V 10 901 06 000	Valve Packing Gland
5	V 09 002 46 000	Seal	35	V 09 101 02 020	Packing
6	V 24 531 01 000	Gun Body	36	V 10 301 10 000	Hexagon Nut
7	V 24 531 16 000	Screw Joint compl.	41	V 24 531 90 000	Tool for Needle Packing B-Component
8	V 66 100 03 565	Seal			
9	V 24 531 14 003	Adapter			
10	V 09 002 28 000	Seal PTFE			
11	V 24 531 17 000	Pressure Disc			
12	V 24 531 34 000	Needle Packing for B-Component			
13	V 24 531 33 000	Spring with Pressure Disc			
14	V 24 531 06 000	Material Needle compl. f. B-Component			
15	V 24 531 13 003	U-Bolt			
16	V 24 531 12 000	Holder for Trigger			
17	V 24 531 10 003	Collar Nut			
18	V 10 353 06 . . 3	Material Needle 0,8 / 1,0 mm ø			

Repair Kit

A WALTHER PILOT repair kit is available for the spray gun PILOT III 2-K which comprises all wearing parts. Wearing parts are also shown (in bold-face) in the Listing of Replacement Parts.

Repair Kit - air side and material side:

Article-No.: V 16 024 00 . . 3

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1 General Information

1.1 Identification of Model Version

Model: Manual Spray Gun PILOT III 2-K

Type: PILOT III 2-K V 24 531

Manufacturer: WALTHER Spritz- und Lackiersysteme GmbH
Kärntner Straße 18-30
D-42327 Wuppertal
Tel: 00 49 202 787-0
Fax: 00 49 202 787-217
www.walther-pilot.de • Email: info@walther-pilot.de

1.2 Normal Use

The manual spray gun PILOT III 2-K is designed exclusively for use with sprayable two-component media. Since all parts that are in contact with the spraying media are made from stainless steel, the high-precision model PILOT III 2-K is particularly suitable for the application of water-soluble two-component adhesives in the upholstery and furniture industry. If other materials are to be used, please contact WALTHER Spritz- und Lackiersysteme GmbH, Wuppertal.

Sprayable material should only be applied to work pieces or similar objects. The temperature of the material to be sprayed should at no time exceed 43° C. The term "normal use" also implies that any and all safety warnings and instructions laid down in these operating instructions have been read, understood and are duly complied with.

This equipment complies with the explosion protection requirements of Directive 94 / 9 / EC (ATEX) for the explosion group, equipment category and temperature class indicated on the type plate. When using the equipment, the requirements specified in these Operating Instructions must be observed at all times.

The technical data indicated on the equipment rating plates and the specifications in the chapter "Technical Data" must be complied with at all times and must not be exceeded. An overloading of the equipment must be ruled out.

The equipment may be used in potentially explosive atmospheres only with the authorisation of the relevant supervisory authority.

The relevant supervisory authority or the operator of the equipment are responsible for determining the explosion hazard (zone classification).

The operator must check and ensure that all technical data and the marking of the equipment in accordance with ATEX are compliant with the necessary requirements.

The operator must provide corresponding safety measures for all applications in which the breakdown of the equipment might lead to danger to persons.

If any irregularities are observed while the equipment is in operation, the equipment must be put out of operation immediately and WALTHER Spritz- und Lackiersysteme must be consulted.

Grounding / Equipotential Bonding

Measures must be taken to ensure that the spray gun is sufficiently grounded (earthed) by means of a conductive air hose (maximum resistance $10^6\Omega$).

1.3 Improper Use

The spray gun must not be used for purposes other than those laid down in the above section *1.2 Normal Use*.

Any other form of use is prohibited.

Improper use includes

- the spraying of material on persons and animals
- the use of liquid nitrogen.

2 Technical Description

The material for component A (adhesive) is fed via link (6 mm \emptyset). Component B (activator) is supplied via the elbow screw joint (Item 7) (4 mm \emptyset).

Material emerges from nozzle (Item 3; Component A) as well as from the horn at air cap (Item 2; Component B). Mixing takes place in the spray jet itself.

The material is supplied via material pressure tanks or pump systems.

Bore for component A: optional 0.8 / 1.0 mm \emptyset (Rotary jet)
Bore for component B: optional 0.3 / 0.4 / 0.5 mm \emptyset

Material pressure for component A: 1.0 - 1.5 bar
Material pressure for component B: 0.3 - 0.8 bar according to mixing ratio.
The exact pressure for both components can be established by comparison.

The TEFLON[®]-coated body prevents sticking of spraying material and thus ensures quick and easy cleaning. All parts in contact with the material are made from stainless steel.

3 General Safety Instructions

All applicable accident prevention rules and regulations as well as other recognised industrial safety and health rules and regulations must be observed at all times.

- Use the spray gun only in well-ventilated rooms. Fire, naked flames and smoking are strictly prohibited within the working area. **WARNING** - during the spraying of flammable materials (e.g. lacquers, adhesives, cleaning agents, etc.), there is an increased risk to health as well as an increased risk of explosion and fire.
- Measures must be taken to ensure that the spray gun is sufficiently grounded (earthed) by means of a conductive air hose (maximum resistance $10^6 \Omega$).
- Before carrying out maintenance or servicing work, always ensure that the air and material feed to the spray gun have been depressurised. Risk of injury!
- When spraying materials, do not place your hands or other parts of the body in front of the pressurised nozzle or the spray gun. Risk of injury!
- Never point the spray gun at persons or animals. Risk of injury!
- Always observe the spraying and safety instructions given by the manufacturers of the spraying material and the cleaning agent. Aggressive and corrosive materials in particular can be harmful to health.
- Exhaust air containing particles (overspray) must be kept away from the working area and personnel. In spite of these measures, always wear the regulation breathing masks and protective overalls when using the gun. Airborne particles represent a serious health hazard!
- Always wear hearing protection when using the gun or when in the vicinity of a gun that is in use. The noise level generated by the spray gun is approx. 86 dB (A).
- After carrying out assembly or maintenance work, always ensure that all nuts, bolts and screw connections have been fully tightened before the gun is used.
- Use only original replacement parts, since WALTHER can only guarantee safe and fault-free operation for original parts.

For further information on the safe use of the spray gun and the spraying materials, please contact WALTHER Spritz- und Lackiersysteme GmbH, D-42327 Wuppertal, Germany.

4 Connection of Input Lines



Note

Please refer to the exploded view supplied with this manual when performing the installation steps described on the following pages.

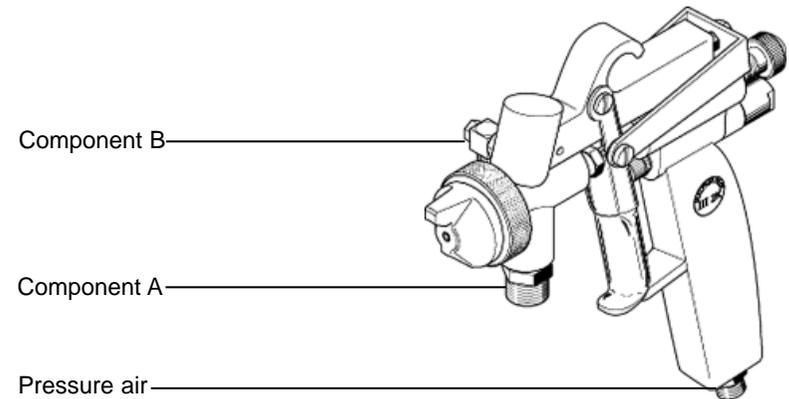


Warning

The air pressure of the gun must not exceed 6 bar; otherwise safe operation of the gun cannot be guaranteed.

1. Connect the air hoses (cleaned compressed air) to the material pressure tanks and the air inlet of the spray gun.

2. Fill the material pressure tanks for component A and component B with the respective material and close the lid.
3. Fasten the material inlet hose to its respective material pressure tank or the material pressure regulator, if a pump system is used, and to the material inlets of the spray gun.
4. Switch on the pressurised air and adjust the air pressure reduction valve to the required atomizing air pressure. Adjust the air pressure reduction valves on the material pressure tanks to the required pressure. If the material is fed via a pump system the pressure is adjusted via an adjusting key on the material pressure control.
5. Open the material tap at the material outlet of the relevant pressure tank.
6. To bleed any air left in the material hose actuate the trigger until a uniform jet emerges from the nozzle. The spray gun is now ready for operation.



5 Operation

5.1 Safety Instructions

Please pay special attention to the following safety instructions when using the spray gun!

- Be sure to wear the required respiratory protection masks and protective overalls whenever you are operating the spray gun. Airborne particles represent a health hazard.
- Be sure to wear suitable ear protection. The spray gun produces sound levels of approx. 86 dB (A).
- No open fires, naked lights or smoking in the working area. The spraying of readily inflammable media is accompanied by an increased risk of fire and explosion.

5.2 Requirements at the Start and Finish of Operation

The following requirements must be met before the spray gun is operated:

- The atomizing air pressure must be available at the gun.
- The material pressure must be available at the gun.

**Caution**

The material pressure should not exceed 6 bar. The air pressure should not exceed 6 bar. Otherwise the operational reliability of the spray gun will be impaired.

**Warning**

It is important to remember to relieve the spray gun of all pressures when work is terminated. Lines left under pressure may burst and the released material may injure any persons in the vicinity.

5.3 Spray Pattern Test

Spray pattern tests should be performed whenever:

- the spray gun is taken into operation for the first time
- the spraying medium has been changed
- the spray gun was taken apart for maintenance or repair works.

The spray pattern is best tested using a workpiece sample, a sheet of metal, cardboard or paper.

**Warning**

Keep your hands or other parts of the body away from the spray gun nozzle under pressure - risk of injury.

**Warning**

Make sure that no other people are in the spraying zone when the spray gun is started - risk of injury.

1. Start the gun to produce a spray pattern sample (see 5.2 *Requirements at the Start and Finish of Operation*).
2. Inspect the sample and, if necessary, adjust the settings of the gun (see 5.4 *Spray Pattern Adjustment*).

5.4 Spray Pattern Adjustment

The spray pattern of the Pilot III 2-K can be adjusted as follows:

Adjusting the Material Flow Rate

The material flow rate can be adjusted by turning the adjusting screw (Item 22). The material flow is increased by turning it to the left (screwing out), decreased by turning it to the right (screwing in).

Adjusting the Material Pressure

The material pressure can only be adjusted at the pump or the pressure tank. Please follow the instructions and safety instructions issued by the manufacturer.

5.5 Retooling the Spray Gun / Repairs

Air cap, material nozzle and needle packing, all chosen for a particular spraying material, together form a unit - the nozzle insert assembly. Always change the complete insert assembly to maintain the desired spray finish quality.

**Warning**

Air and material inputs must be shut off prior to retooling - risk of injury.

**Note**

Please refer to the exploded view at the beginning of this manual to perform the steps detailed below.

Replacement of Material Nozzle and Air Cap

1. Unscrew the air cap retaining nut (Item 1).
 2. Remove the air cap (Item 2a / 2b).
 3. Remove the material nozzle (Item 3) from the gun body, using wrench (width over flats 12)
 4. Remove the seal (Item 5) from the material nozzle.
- Reassembly of the new nozzle insert and the remaining parts is performed in reverse order.

Replacement of Material Needle (Component A)

1. Unscrew the adjusting screw (Item 22).
 2. Remove the spring (Item 21).
 3. Remove the material needle (Item 18) from the gun body.
- Reassembly is performed in reverse order. The distance between the tip of the material needle for the initial air inlet and the driving sleeve should be 76.5 mm.

Replacement of Material Needle (Component B)

1. Unscrew the two U-bolts (Item 15) with a screwdriver.
 2. Unscrew the collar nuts (Item 17) (width over flats 9).
 3. Remove the holder for the trigger (Item 16).
 4. Unscrew the material needle (Item 14).
 5. Remove the spring (Item 13) together with thrust washer.
- Reassembly is performed in reverse order.

Replacement of Defective Needle Packings (Component A)

1. Remove the material needle as described in "Replacement of Material Needle (Component A)".
 2. Unscrew the needle packing gland (Item 32) from the gun body (width over flats 11).
 3. Remove the needle packing (Item 31) from the gun body.
- Reassembly of replacement parts is performed in reverse order.

Replacement of Defective Needle Packings (Component B)

1. Remove the material needle as described in "Replacement of Material Needle (Component B)".
 2. Remove the needle seal packing (Items 12) from the gun body. Use a strong wire with one end bent to form a small hook.
- Installation is performed in reverse order. You may use installation tool V 24 531 90 000 (Pos. 41).



Caution

Because of the highly aggressive nature of the activator a leak in the needle seal packing of component B will damage and destroy the gun body. Therefore the packing (Item 12) should be replaced at least every 500 operating hours or earlier. If the gun is not used for a longer period, it should be depressurised. An assembly tool kit is available on request.



Note

The needle seal packings for component A and B which have been removed from the gun body should not be re-used, since the sealing properties may be impaired



Note

Prior to assembly all moveable and sliding parts should be lubricated with a non-acidic, non-resinogenic grease.

Repair Kits:

A WALTHER PILOT repair kit is available for the spray gun PILOT III 2-K which comprises all wearing parts. Wearing parts are also shown (in boldface) in the Listing of Replacement Parts.

Repair Kit - air side and material side: No. V 16 024 00 . . 3

6 Cleaning

6.1 Safety Warnings

- Prior to any service work all air and material inputs should be shut off - risk of injury.
- Open fires, naked lights and smoking are prohibited in the working area. There is an increased risk of fire and explosion, when spraying readily flammable media, such as cleaning solutions.
- Follow the safety instructions issued by the manufacturer of the cleaning media. Aggressive and caustic cleaning agents in particular represent health hazards.

6.2 General Cleaning Procedure

The spray gun should be frequently cleaned and lubricated to ensure reliable operation and long life.



Caution

Never immerse the spray gun in solvents or other cleaning fluids as this will impair the functional reliability and efficiency of the gun.



Caution

Do not use any hard or sharp-pointed objects when cleaning the spray gun, as the precision-made parts can easily be damaged and are likely to affect your spraying results. The TEFLON®-coating may be damaged as well, reducing the non-stick effect.

Only use cleaning solutions recommended by the manufacturer of the spraying material. These solutions should not contain any of the following constituents:

- halogenated hydrocarbons (e.g. 1,1,1-trichloroethane, methylene chloride etc.).
- acids and acidic cleaning solutions.
- regenerated solvents (so-called cleaning dilutions).
- paint removers.

These constituents cause chemical reactions with electroplated components resulting in corrosion damage. WALTHER Spritz- und Lackiersysteme is not liable for any damages resulting from improper treatment of the gun.

The spray gun should be cleaned

- prior to every change of the spraying medium
- at least once a week
- as often as necessary because of the spraying medium used and the resulting level of soiling.

The above cleaning measure are designed to maintain the functional efficiency of the gun.

Following these recommendations will ensure safe spray gun operation and performance.

1. Dismantle the gun as described in section 5.5 *Retooling the Spray Gun*.
2. Clean the air cap and nozzle with a brush dipped in the recommended cleaning solution.
3. Clean the gun body and all remaining parts with a soft cloth and the recommended cleaning solution.
4. Apply a thin layer of grease to the following parts:
 - material needle.
 - needle spring.
 - all sliding parts and bearings.
 - The moveable inner parts should be greased at least once a week.
 - The springs should at all times be coated with a thin layer of grease.

Use non-acidic, non-resinogenic grease and a brush. The spray gun is then re-assembled in reverse order.

6.3 Routine Cleaning

It is not always necessary to dismantle the spray gun for cleaning purposes when paint colour is changed at regular intervals or at the end of a work period (depending, of course, on the material used). The TEFLON®-coated gun body may be cleaned with a cloth.

For routine cleaning purposes please observe the following steps:

1. Fill the clean material pressure tanks with a cleaning solution compatible with the material used.
 2. Start the spray gun (see 5.2 Requirements at the Start and Finish of Operation).
 3. Do not stop the gun until only clear cleaning solution emerges from the nozzle.
- The complete spraying system should stay depressurised until the gun is used again.

7 Troubleshooting



Warning

Prior to any servicing and repair work the spray gun should be in unpressurised state, i.e. all control air and atomizing air pressure as well as all material inputs must be shut off - risk of injury.

Fault	Cause	Remedy
Gun is dripping (Component A)	Material needle or nozzle soiled	Clean needle or nozzle see
	Material needle or nozzle damaged	Replace; see 5.5 Retooling the Spray Gun
	Needle spring (Item 21) defective	Remove material needle and replace spring
	Size mismatch between material control needle and nozzle	Make sure same diameters are used
	Adjusting screw (Item 22)	Slightly screw in adjusting screw (turn clockwise) towards the back
Gun is dripping (Component B)	Needle spring (Item 13) defective	Replace
	Material needle (Item 14) damaged	Replace
	O-ring (Needle point) defective	Replace
Pulsating or unsteady spray jet	Level in material tank too low Material control nozzle is loose or damaged	Top up material level (see Manufacturer's Operating Instructions).
	Material nozzle is loose or damaged	Tighten, possibly replace seal (Item 5)
Gun keeps blowing in off-position	Valve spring (Item 25) or valve cone (Item 24) damaged	Replace

8 Disposal of Cleaning and Servicing Substances

The disposal of substances used for cleaning and servicing should be in accordance with local, national and international laws and directives.



Warning

Particular attention should be paid to the spray and cleaning media manufacturers' instructions. Improper disposal represents a serious threat to the health of humans and animals.

9 Technical Data

Net Weight: 600 g

Air Cap: Rotary Jet Air Cap
Wide Jet Air Cap

Nozzle Bore Component A: 0.8 / 1.0 mm ø
Nozzle Bore Component B: 0.3 / 0.4 / 0.5 mm ø

Pressure Ranges:
Max. Input Air Pressure 6 bar
Max. Material Pressure 6 bar

Max. Operating Temperature of Spray Gun: 43 °C

Noise Level
(measured at a distance of ca. 1 m from spray gun) 86 dB (A)

Air consumption:

Atomising air pressure	Rotary Jet Air Cap	Wide Jet Air Cap
1 bar	180 l/min	180 l/min
2 bar	230 l/min	245 l/min
3 bar	260 l/min	300 l/min
4 bar	300 l/min	340 l/min
5 bar	330 l/min	380 l/min
6 bar	350 l/min	400 l/min

Right to effect technical changes reserved.