SPRAY GUN

This manual contains IMPORTANT WARNINGS and INSTRUCTIONS Read and understand the instruction manual before use and retain for reference.

INSTRUCTION MANUAL

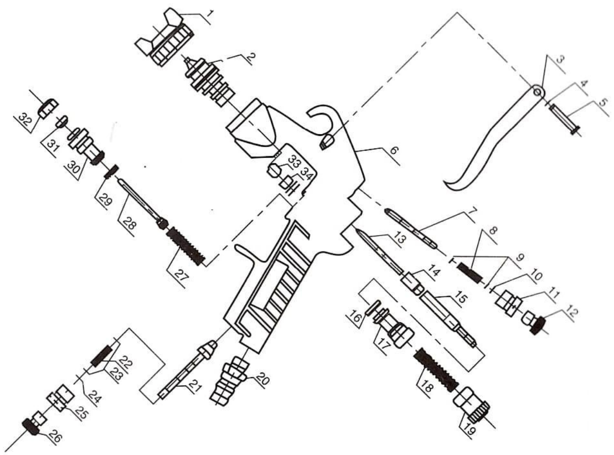
Main Specifications	Maximum Working Pressure Nosie level (LAeqT) Temperature range	6.8 bar (98 PSI) 74.8 dB(A) 5-40

Model	Type of feed	Nozzle oriffice ømm (in)	※Atomizing air pressure bar(PSI)	Fluid ourput cc/min	Air consumption L/min(cfm	Pattern width mm(in)	Weight g(lbs)
F-75	Suction	1.2(0.047)	3.5-5.0 (50-80)	125	80(2.85)	135(5.34)	0.59(1.31)
		1.5(0.059)		180	165(5.8)	170(6.7)	
		1.8(0.071)		195	230(8.2)	200(7.9)	
S-710		1.0(0.039)		95	72(2.7)	100(2.9)	0.65(1.45)
		1.3(0.051)		135	85(3.0)	135(5.3)	
		1.5(0.059)		180	165(5.8)	170(6.7)	
		1.8(0.071)		195	230(8.2)	200(7.9)	
S-770		1.5(0.059)	4.0-8.0 (60-115)	255	180(6.3)	200(7.9)	0.8(1.78)
		2.0(0.078)		345	250(8.9)	225(8.9)	
		2.5(0.098)		430	325(11.5)	250(9.9)	
		3.0(0.118)		520	390(13.6)	270(10.6)	
		3.5(0.138)		610	450(16.1)	280(11.1)	
F-75	Gravity	1.2(0.047)	3.5-5.0 (50-80)	155	85(3.0)	155(6.1)	0.53(1.18)
		1.5(0.059)		210	165(5.8)	185(7.3)	
		1.8(0.071)		220	230(8.2)	230(9.0)	
S-710		1.0(0.039)		110	75(2.7)	120(4.7)	0.55(1.22)
		1.3(0.051)		155	85(3.0)	155(6.1)	
		1.5(0.059)		210	165(5.8)	185(7.3)	
		1.8(0.071)		220	230(8.2)	220(8.7)	
S-770		1.5(0.059)	4.0-8.0 (60-115)	285	180(6.3)	210(8.2)	0.68(1.51)
		2.0(0.078)		390	250(8.9)	255(10.0)	
		2.5(0.098)		485	325(11.5)	275(10.9)	
		3.0(0.118)		560	390(13.6)	285(11.2)	
		3.5(0.138)		640	450(15.9)	290(11.4)	

1 Atomizing air pressure means air pressure at gun inlet when trigger is puiled and air flows.

PARTS LIST

Na	Description
1	Air cap set
2	Fluid nozzle
3	Trigger
4	E stopper
5	Trigger stud
6	Gun body
7	Fluid Adj. Knob
8	Fluid Needle Spring
9	Gasket
10	O-ring
11	Pattern Adj. Knob
12	Pattern Adj.
13	Fluid Adj. Needle
14	Joint
15	Fluid Adj. Knob
16	Gasket
17	Fluid needle guide
18	Fluid Needle Spring
19	Fluid Adj. Knob
20	Air joint
21	Air Inlet Valve
22	Air Valve Spring
23	Gasket
24	O-ring
25	Air Adj. Knob
26	Air Adj. Screw
27	Air valve spring
28	Air valve
29	Air valve packing
30	Air valve seat
31	Air valve packing
32	Air valve packing seat
33	Fluid Needle packing set
34	Needle packing nut



SAFETY WARNINGS

FIRE OR EXPLOSION HAZARD

1.Fluid and solvents can be highly flammable or combustible.
Use in well-ventilated spray booth.
Avoid any ignition sources such as smoking, open flames,electrical hazard,etc.
2.NEVER use HALOGENATED HYDROCARBON SOLVENTS (1.1.1 TRICHLORINE,ETHYL CHLORIDE,etc).
Which can chemically react with aluminium and zinc parts and cause an explosion.
Be sure that all fluids and solvents used are chemically compatible with aluminium and zinc parts.
3.To reduce the risk of static sparking,grounding continuity to the spray equipment and object being sprayedmust be maintained.

MISUSE HAZARD

1.NEVER point gun in the direction of human body.
2.NEVER exceed the maximum safe working pressure of the equipment
3.ALWAYS release air and fluid pressures before cleaning, disassembling or servicing.
For emergency stop and prevention of unintended operation, a ball valve installation near the gun to stop air supply is recommended.

HAZARD CREATEDWHILE COATING MATERIALS APE ATOMIZED AND SPRAYED

1 Toxic vapours produced by spraying certain materials can create intoxication and serious damage to health.
Use the gun in well-ventilated areas.
Always wear protective eyewear,gloves, respirator,etc, to prevent the toxic vapour hazzard, solvents and paint from coming into contact with your eyes or skin.
2.Noise level mentioned in main specifications was measured at 1.0 m behind the tip of the gun, 1.6m height from floor.
Wear earplugs if required.

OTHER HAZARDS

1.NEVER modify this product for any applications.
2.NEVER enter working areas of robots,reciprocators,conveyors,etc, unless machines are switched off.
3.NEVER spray foods or chemicals through the spray gun.

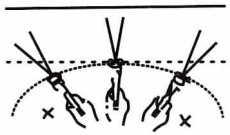
INSTALLATION

IMPORTANT	This gun should be operated by adequately trained operators only. Ensure that the gun has not been damaged during transportation. Clean dry air should be supplied to the gun.

1.Connect an air hose to air nipple tightly.
2.Connect a fluid hose or a container to fluid nipple tightly.
3.Flush the gun fluid passage with acompatible solvent.
4.Pour paint into container, test spray and abjiust fluid output as well as pattem width.

HOW TO OPERATE

Suggested air pressure is 3.0 to 3.5bar(43 to 50 psi)
Recommended paint viscosity differs according to paint property and painting conditions. 15to 23 sec./Ford#4 is recommendable.



Keep fluid output as small as possible to the extent that the job wil not be hindered.It will lead to better finishing with fine atomization.

Set the spray distance from the gun to the workpiece as near as possible within the range of 150-200mm(6-8inches).

The gun should be held so that it is perpendicular to the surface of the workpiece at all times.Then, the gun should move in a straight and horizontal line. Arcing the gun causes uneven painting.

MAINTENANCE AFTER PAINTING

⚠ WARNING

TURN OFF AIR AND COATING MATERIALS TO THE GUN AND RELEASE PRESSURE BY TRIGGERING THE GUN BEFORE DISASSEMBLING, CLEANING OR SERVICING.
PAY ATTENTION WHEN DISASSEMBLING SPRAY GUN SINCE YOU MUST TOUCH SHARP PARTS.
DO NOT DISASSEMBLE WITHOUT RECEIVING ENOUGH KNOWLEDGE AND EDUCATION.

1.Pour remaining paint into another container and then clean paint passages and air cap,Spray a small amount of thinner to clean paint passages. Incomplete cleaning will cause adverse pattem shape and particles. Clean fully and promptly two-component paint after use.

2.Clean other sections with attached brush soaked with thinner and waste cloth

3.Clean paint passages fully before disassembly.

4.Remove fluid nozzle after removing fluid needle set or while keeping fluid needle pulled, in order to protect seat section

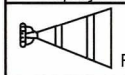
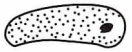
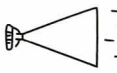
5.While keeping fluid needle set inserted, tighten fluid needle packing set by hand. Then tigtengradually by spanner Adjust packing set while pulling trigger and watching movement of fluidneedle set since too much tightening will slow down movement of fluid needle and result in leakage from tip of nozzle.
If tightened too much,tum counterclockwise to the sufficient position without stuck needle and fluid leakage.

6.Tum Spread adj, knob counterclockwise to fully open. And then tighten Spread adj. guide into gun body.

⚠ CAUTION

- NEVER USE COMMERCIAL OR OTHER PARTS INSTEAD OF A ORIGINAL SPARE PARTS.
- NEVER IMMERSE THE WHOLE GUN INTO LIQUID SUCH AS THINNER.
- NEVER DAMAGE HOLES OF AIR CAP, FLUID NOZZLE FLUID NEEDLE.

TROUBLESHOOTING

Spray Pattern	Problems	Remedies
 Fluttering	1.Air enters between fluid nozzle and tapered seat of gun body. 2.Air is suctioned from fluid needle packing.	1. Remove fluid nozzle to clean seat. if it is damaged, replace nozzle. 2.Tighten fluid needle packing.
 Crescent	1.Paint buildup on air cap partially clogs horn holes. Air pressure from both horns differs.	1.Remove obstructions from born holes. But do not use metal objects to clean horn holes.
 Inclined	1.Paint buildup on air cap partially clogs horn hole or air cap center hole or causes causes damage. 2.Loose fluid nozzle.	1.Remove obstructions. Replace if damaged. 2.Remove fluid nozzle and clean seated section.
 Split	1.Paint viscosity too low. 2.fluid output too high.	1.Add paint to increase viscosity. 2.Adjust fluid adj. Knob or spread adj,knob.
 Heavy Center	1.Paint viscosity too high. 2.fluid output too low.	1.Reduce viscosity. 2.Increase fluid output.
 Split	1.Fluid nozzle and fluid needle set are not seated properly. 2.The first-stage travel or trigger (when only air discharges)decreases 3.Paint buildup inside air cap set.	1.Clean or replace fluid nozzle and fluid needle set. 2.Replace fluid nozzle and fluid needle set. 3.Clean air cap set.

R 1:retighten R 2:adjust R 3:clean R 4:replace parts

Problem	Where it occurred	Parts to be checked	Cause	Romody			
				R1	R2	R3	R4
Air leaks (from tip of air cap)	Air valve set	Air valve	• Dirt or damage on seat			O	O
		Air valve seat set	• Dirt or damage on seat			O	O
			• Wear on air valve spring				O
		Air valve packing	• Damage or deteriorated				O
Paint leaks	Fluid nozzle	Fluid nozzle-fluid needle set	• Dirt, damage, wear on seat			O	O
			• Loose fluid needle adj. Knob		O		
			• Wear on needle spring				
		Fluid nozzle-gun body	• Insufficient tightening	O			
			• Dirt or damage on seat			O	O
		Fluid needle-packing set	• Needle does not return due to packing set too tight		O		O
			• Needle does not return due to paint buildup. on fluid needle		O	O	
	Fluid needle	Needle packing set-needle set	• Wear	O			O
		Packing nut	• Insufficient tightening	O			
Paint does not flow	Tip of gun	Fluid adj Knob	• Insufficient opening		O		
		Tip hole of nozzle	• Clogged			O	
		Paint filter	• Clogged			O	O