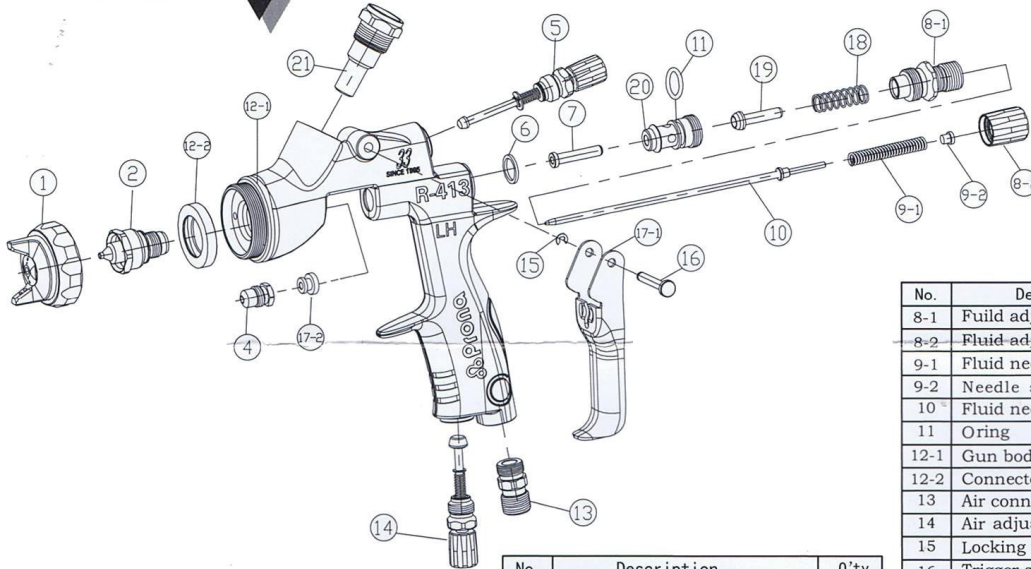


R-413 SPRAY GUN

OPERATING I

PARTS LIST



No.	Description	Q'ty
1	Air cap set	1
2	Fluid nozzle	1
4	Fluid needle packing screw set	1
5	Pattern adjusting set	1
6	Fluid needle guide packing	1
7	Fluid needle guide	1

No.	Description	Q'ty
8-1	Fluid adjusting knob guide set	1
8-2	Fluid adjusting knob	1
9-1	Fluid needle spring	1
9-2	Needle spring gasket	1
10	Fluid needle set	1
11	O-ring	1
12-1	Gun body	1
12-2	Connector washer	1
13	Air connector	1
14	Air adjusting set	1
15	Locking ring	1
16	Trigger stud	1
17-1	Trigger	1
17-2	Trigger guide	1
18	Air valve spring	1
19	Air valve	1
20	Air valve seat set	1
21	Fluid connector	1

Prior to operation read the operating instructions carefully.

OPERATION

The SPRAY GUN has been designed as a HAND HELD, AIR OPERATED TOOL, and in the interests of safety must only be used for the purpose for which it has been designed. The tool should on no account be used for any other purpose & whatever reason, this could result in danger to the operator and those within the immediate area.

The Spray Gun should be connected to a clean air supply using the recommended fitting and hose size as specified in the diagram. Whenever possible there should be an air filter & regulator in the system as diagram. The recommended pressure at the tool should measure 60 psi while running free. Check fitting and hoses regularly for signs of fraying, or accidental damage. Replace any worn items before continuing to operate the Spray Gun.

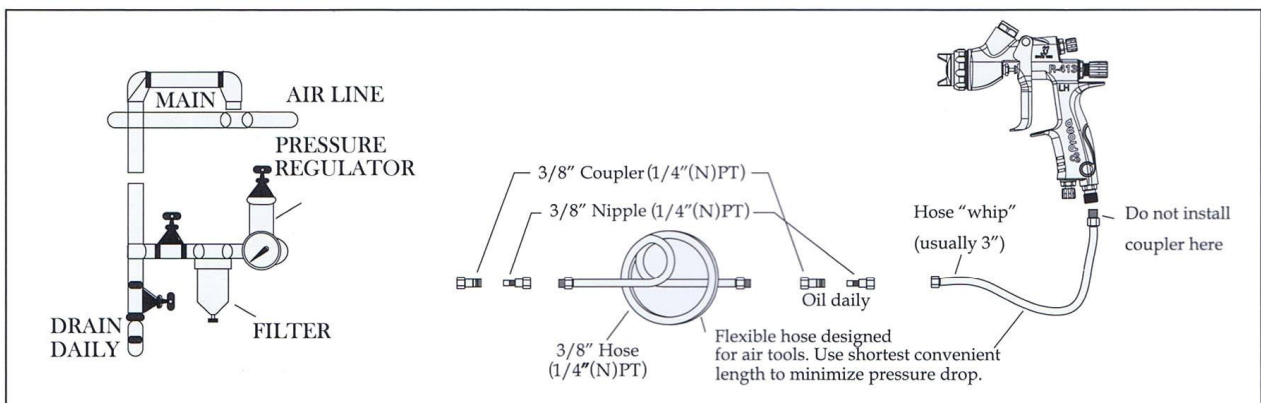
ADJUSTMENT

Always connect the cup and the air hose tightly to the Spray Gun before use. Ensure the material and air supply are disconnected before effecting any work on the Spray Gun.

To obtain the required spraying pattern, volume of fluid and degree of atomisation, use the Pattern Adjusting Set, Air Adjusting Set and the Fluid Adjusting Screw.

This spray gun has been developed to operate with low air pressure comparing with the conventional spray guns. The recommended atomising air pressure is 2.0-3.0 bar (29-43 psi). Excessive atomising air pressure can increase overspray, reduce transfer efficiency.

The recommended spray distance is 20-25cm (7.9-9.8 in). Good finishing will not be obtained if the spray distance is too far. The recommended material viscosity is 15 - 23 seconds / Ford#4.





PRONA AIR TOOL MANUFACTURING LIMITED

INSTRUCTIONS

ISO9001:2008 CE

SERVICING

- Clean air cap, fluid nozzle and fluid needle with brush after each operation.
- Flush the gun material passage with appropriate solvent.
- Do not submerge complete spray gun in solvents.
- Fluid needle packing screw should not be tightened completely, or the fluid needle set will be sluggish.
- Turning the fluid adjusting knob too far to the left will weaken the fluid needle spring, this will make the fluid nozzle to leak.
- The material should be filtered through 60-90 mesh filter before use.
- Before install or dismantle nozzle, fluid knob must be dismantled and press the trigger to make sure that nozzle and needle disconnect, otherwise needle and nozzle wear and tear each other and cause bad seal.

PERSONAL PROTECTIVE EQUIPMENT

The use of breathing mask is recommended at all times when spraying. The noise level may exceed 85 dB (A) when the spray gun is being used, a sound absorber protection is also recommended. Always wear goggles and gloves when spraying or cleaning. No vibrations are transmitted to the operator when using the spray gun.

SAFETY

- Never allow untrained or unauthorized persons to operate this spray gun.
- Never exceed the recommended air pressure.
- Never use matches, smoke or operate a spray gun in the vicinity of a naked flame.
- Never aim spray gun at people.
- Never spray food or chemicals through spray gun.
- Do not carry or pull the gun by the hose, this could cause failure of the hose/gun connection result in danger to the operator or other workers.
- Use only original spare parts.
- Do not use the following solvents. 1,1,1-Trichloroethane and Methylene Chloride. These solvents can chemically react with aluminium used in spray guns and fluid cups possibly causing an explosion. Do not use these solvents for equipment cleaning or flushing. Spray gun should never be stored in acid laden cleaners.
- If in doubt consult material supplier.

Model	Type of Feed	Fluid Nozzle Orifice	Air Cap	Air Pressure	Air Consumption	Fluid Output	Spray Width ± 20	Weight
		\varnothing mm(in)		kg/cm ² (Mpa)				
R-413-G12	Gravity	1.2(0.047)	LV 2	2.0-3.0 (0.2-0.29)	320	160	230-250(9.06-9.84)	517 (1.14)
R-413-G13		1.3(0.051)				180	240-260(9.45-10.24)	
R-413-G14		1.4(0.055)				215	250-275(9.84-10.82)	
R-413-G15		1.5(0.059)				270	260-280(10.24-11.02)	
R-413-G16		1.6(0.063)				275	300-340(11.81-13.39)	
R-413-G18		1.8(0.071)				330	330-355(12.99-13.98)	
R-413-G20		2.0(0.079)				390	320-365(12.6-14.37)	
R-413-G25		2.5(0.098)	W2	2.5-3.0 (0.24-0.29)	360	510	320(12.60)	

R-413 Spray Distance :250mm(9.84). Fluid Viscosity:20 \pm 1 seconds/RV-2. Fluid Intake:M16X1.5P. Air Intake:1/4PF/NPF.

TROUBLE-SHOOTING

TROUBLE	CAUSE	SOLUTION
 Fluttering	a. Insufficient material in cup. b. Dry or worn fluid needle packing set or loose fluid needle packing screw. c. Loose or damaged fluid nozzle	a. Refill material. b. Lubricate or replace fluid needle packing set or tighten fluid needle packing screw. c. Tighten or replace fluid nozzle.
 Crescent	a. Material store-up on air cap.	a. Clean air cap with proper objects. b. Clogged air holes must not be cleaned with metal objects.
 Heavy top or bottom	a. Material store-up on air cap. b. Dirty or damaged fluid nozzle.	a. Clean or replace air cap. b. Clean or replace fluid nozzle.
 Split	a. Material too thin or not enough. b. Atomizing air pressure too high.	a. Increase material viscosity. b. Reduce air pressure.
 Heavy center	a. Material too thick or too much. b. Atomizing air pressure too low.	a. Reduce material viscosity. b. Increase air pressure.
Material drips from fluid nozzle	a. Obstructions between fluid nozzle and fluid needle. b. Worn fluid nozzle or needle.	a. Clean fluid needle and fluid nozzle in thinner. b. Replace parts.
Material leaks from needle packing screw	a. Loose fluid needle packing screw. b. Dry or worn fluid needle packing.	a. Tighten fluid needle packing screw, check fluid needle for free movement. b. Lubricate or replace needle packing.