

1. Preface

Prior to putting the paint spray gun to be operation, read the operation instruction completely and thoroughly. The stipulations contained therein are to be respected in any case. After that, the operation instructions are to be stored in a safe place, accessible for every user of the equipment. The paint spray gun may only be put into operation by adequately trained operator. Inappropriate use of the paint spray gun, modification of any kind or combination with inappropriate other parts may cause material damage, serious hazard to the user's or other person's or animal's health or even death. Our company shall not take any responsibility for such damages. The applicable safety, workplace and worker health protection regulations of the respective country or area/district in which the paint spray gun is used are to be respected in any case.

IMPORTANT: These guns are not designed for using with highly corrosive or abrasive materials and if used with such materials, as a result the need for cleaning and replacement of parts will be increased. If there is any doubt regarding the suitability of a specific material.

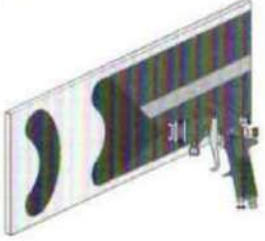
NOTE: This gun is not to be used with halogenated hydrocarbon solvents or cleaning agents such as 1,1,1-Trichloroethane or methylene chloride. These solvents can react with the aluminium components used in this gun and cup. The reaction can become violent and lead to an equipment explosion.

2. Features and technical Data

Model	Technology	Standard nozzle size (mm)	Optimal working pressure (bar/psi)	Max. working pressure (bar/psi)	Pattern width (mm)	Spray distance (mm)	Air consumption (cfm)	Cup capacity (ml)
898-2	LVLP	1.3/1.4/1.8	1.5/21	2.5/36	about 260	200	9-11	600

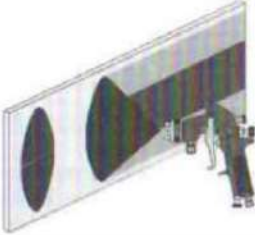
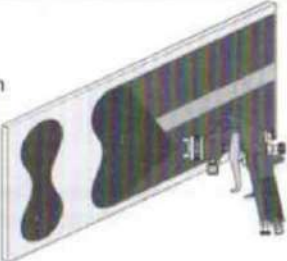
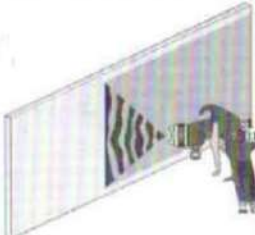
Remarks: the above "working pressure" is the air inlet pressure when the trigger is pulled.

3. Troubleshooting Possible Problems in Operation

CONDITION	CAUSE	CORRECTION
<p>Heavy top or bottom pattern</p> 	<p>Horn holes plugged</p> <p>Obstruction on top or bottom of fluid nozzle</p> <p>Cap and/or nozzle seat dirty</p>	<p>Clean</p> <p>Ream with non-metallic point</p> <p>Clean</p> <p>Clean</p>
<p>Heavy right or left side pattern</p> 	<p>Left or right side horn holes plugged</p> <p>Dirt on left or right side of fluid nozzle</p>	<p>Clean</p> <p>Ream with non-metallic point</p> <p>Clean</p>

Remedies for the top-heavy, bottom-heavy, right-heavy, and left-heavy patterns:

- Determine if the obstruction is on the air cap or the fluid nozzle. Do this by making a test spray pattern. Then, rotate the cap one-half turn and spray another pattern. If the defect is inverted, obstruction is on the air cap. Clean the air cap as previously instructed. Also check for dried paint just inside the cap centre hole opening; remove by washing with solvent.
- If the defect is not inverted, it is on the fluid nozzle. Clean nozzle. If problem persists, renew nozzle.

CONDITION	CAUSE	CORRECTION
Heavy centre pattern 	Spreader adjustment valve set too low. Atomising pressure too low. Material too thick.	Turn out counter clockwise to achieve correct pattern. Increase pressure. Thin to correct consistency.
Split spray pattern 	Air pressure too high. Fluid adjusting knob turned in too far. Spreader adjusting valve set too high.	Reduce at regulator or gun handle. Turn out counter clockwise to achieve correct pattern. Turn in clockwise to achieve correct pattern.
Jerky or fluttering spray 	Loose or damaged fluid nozzle/seat Loose or broken cup fluid nipple Material level too low Container tipped too far Obstruction in fluid passage Loose fluid needle packing nut Damaged fluid needle packing	Tighten or replace Tighten or replace cup Refill Hold more upright Back flush with solvent Tighten Replace
Paint bubbles in cup	Fluid nozzle not tight	Tighten to 9-11 N.m (6-8ft-lbs)
Fluid leaking or dripping from cup lid	Cup lid loose Dirty cup or lid Cracked cup or lid	Push in or replace Clean Replace cup and lid
Thin spray pattern	Inadequate material flow Blocked vent in Cup lid Low air pressure	Loosen the needle adjusting screw by rotating or use larger nozzle size Clean lid and unblock vent Increase air pressure and rebalance gun
Excessive overspray	Fluid nozzle too large Gun too close to work surface Fluid needle loose	Replace smaller fluid nozzle Adjust to correct distance Tighten fluid needle adjusting knob
Dry spray	Air pressure too high Gun too far from work surface Gun motion too fast Fluid flow too low	Reduce air pressure Adjust to correct distance Slow down Loosen the needle adjusting screw by rotating or use larger nozzle size
Fluid leaking from needle packing nut	Needle packing gasket worn	Replace gasket
Fluid leaking or dripping from nozzle	Fluid nozzle or fluid needle worn or damaged Impurities in fluid nozzle Dirt on fluid needle or stuck in needle packing Wrong size fluid needle or fluid nozzle	Replace fluid nozzle and fluid needle Clean Clean Replace fluid nozzle and fluid needle
Fluid dripping or leaking from bottom of cup	Cup loose on gun Dirt cup fluid inlet	Tighten Clean
Paint drip on spray coating surface	Too much material flow Paint material too thin Gun tilted on an angle, or gun motion too slow	Turn fluid adjusting knob clockwise or switch to smaller fluid nozzle and fluid needle size Mix the paint viscosity correctly or apply to light coat Hold gun at right angle to work and adapt to correct spray technique

4.Functional Description

The paint spray gun is designed for spraying paints and lacquers as well as other media (Nozzle size depends on spray viscosity).

Materials that are abrasive, acidic or contain benzene must not be used. The compressed air is supplied through the air inlet coupler which is connected to the gun handle. Pull the trigger to open the air valve only (without pushing the fluid needle), blow off the dirt on spraying surface. Then pull the trigger further to release the fluid needle, spraying the paint out from the nozzle, and atomized by compressed air from the air cap. The cup lid is equipped with leak-proof device that prevents the material from coming out of the vent hole.

5.Cleaning and Maintenance

- a) Clean the fluid passage, air cap, nozzle, fluid needle after paint working finished at first time.
- b) Clean the air cap and fluid nozzle, brush exterior with a stiff bristle brush. If necessary to clean cap holes, use a broom straw or toothpick if possible. If a wire or hard instrument is used, extreme care must be used to prevent scratching or burring of the holes which will cause a distorted spray pattern.
- c) Clean the fluid passages, remove excess material from cup, then flush with gun wash solution. Wipe the gun exterior with a dampened cloth. Never completely immerse in any solvent or cleaning solutions as this is detrimental to the lubricants and life of the spray gun.
- d) When replacing the fluid nozzle or fluid needle, replace both at the same time. Using worn parts can cause fluid leakage. Also, replace the needle packing at this time.
- e) In order to prevent damage to fluid nozzle or fluid needle, be sure to pull tightly the trigger while tightening or loosening the fluid nozzle, or remove fluid adjusting knob to relieve spring pressure against needle collar.

6.Important notice:

Spray gun may be cleaned with solvent or cleaning agents manually or in a conventional gun-washing machine.

The following actions damage the gun which lead to entirely annul any warranty claims:

- Immersing the gun in solvent or cleaning agents, or for a period longer than required during the cleaning process.
- Storing the gun inside the gun-washing machine.
- Cleaning the gun by using ultrasound cleaning systems.
- Exerting violent, inappropriate treatment.

7.Operation

7.1 Clean air and correct inlet pressure

Make sure to feed spray guns with clean and dry air that filtered carefully. The diameter of air hose should be ≥ 8 mm to ensure plentiful air flow. It is better to fix an air regulator at the air inlet to get an exact and optional inlet pressure value required for this series spray gun. About the optimal working pressure, please refer to "TECHNICAL DATA FORM".

7.2 Air adjustment

For maximum air flow, fully open air regulator (arrow 1).

Pressure can be adjusted directly on the spray gun.

The spray gun internal pressure can be set by using the variable adjustable air regulator.

Connect the spray gun to the air supply, pull the trigger and adjust the requested spray gun internal pressure.

7.3 Material flow control

In accordance with material viscosity and required flow rate (arrow 2).

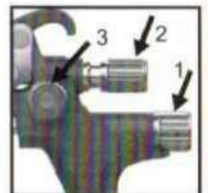
Under normal circumstance, the material flow control is fully open.

7.4 Round/flat spray control

Spray pattern is adjustable (arrow 3)

Turn to the left - flat spray

Turn to the right - round spray



7.5 Correct spray and spray distance

Correct spray:

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

Spray distance:

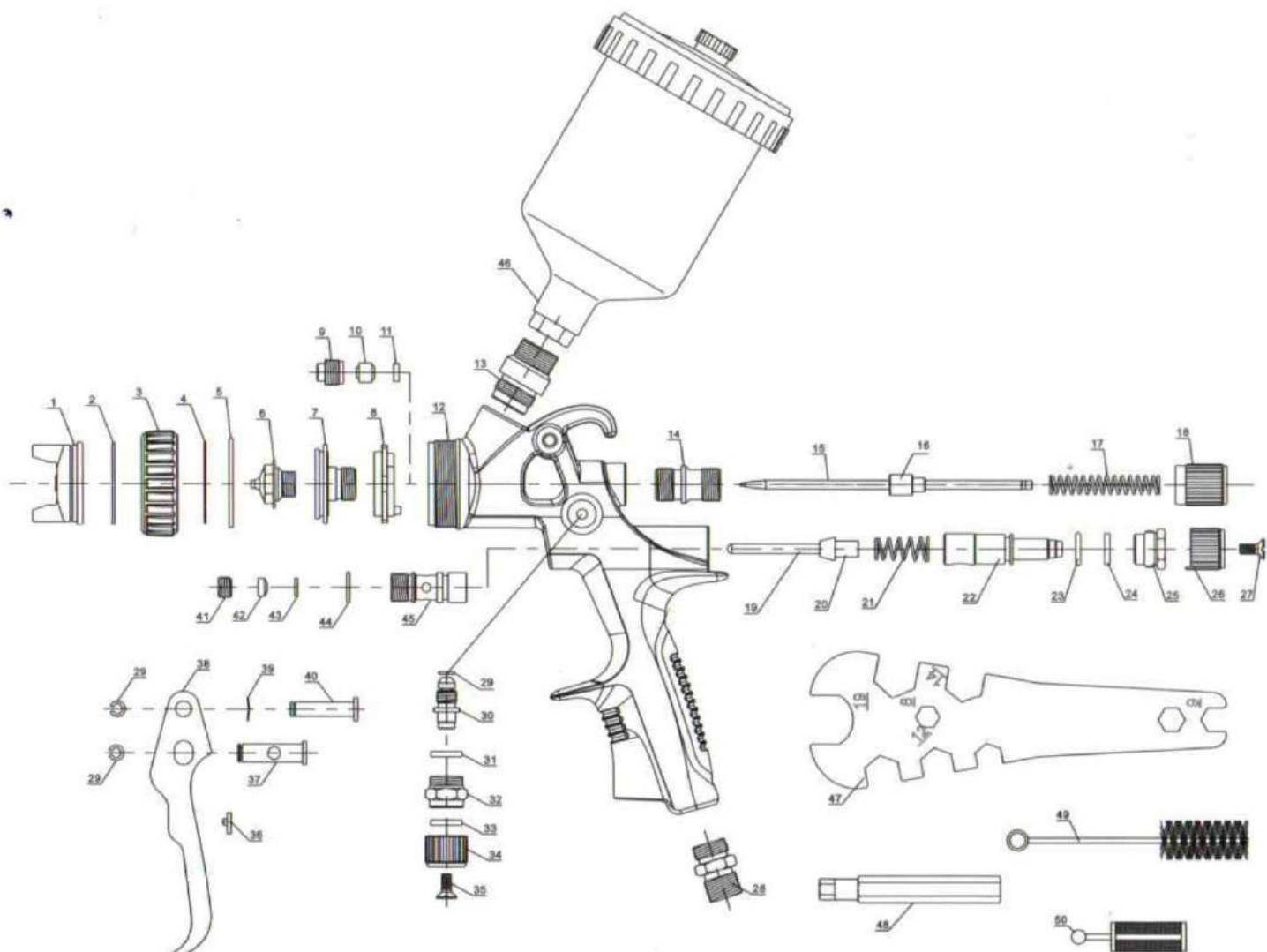
In order to avoid overspray and surface problems, we recommend a spray distance between air cap and object should be maintained.

Parts list

- 01 air cap
- 02 steel ring
- 03 air cap ring
- 04 air cap washer
- 05 air cap ring gasket
- 06 nozzle
- 07 nozzle holder
- 08 atmolysis ring
- 09 needle screw
- 10 needle gasket
- 11 valve needle gasket
- 12 gun body
- 13 fluid inlet coupler
- 14 needle adj. holder
- 15 fluid needle
- 16 needle holder
- 17 needle spring

- 18 needle adj. Knob
- 19 valve needle
- 20 valve plastic
- 21 valve spring
- 22 valve switch
- 23 O-ring
- 24 valve seal gasket
- 25 valve holder
- 26 air adj. knob
- 27 cross screw
- 28 air inlet coupler
- 29 split washer
- 30 pattern valve rod
- 31 pattern holder gasket
- 32 pattern parts holder
- 33 pattern seal gasket
- 34 pattern adj. Knob

- 35 cross screw
- 36 trigger pad
- 37 trigger pin with hole
- 38 trigger
- 39 saddle gasket
- 40 trigger pin
- 41 valve seal screw
- 42 valve seal gasket
- 43 O-ring
- 44 O-ring
- 45 valve sleeve
- 46 gravity cup
- 47 wrench
- 48 Auxiliary wrench
- 49 steel brush
- 50 plastic filter



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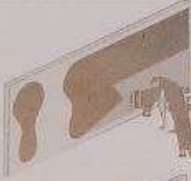
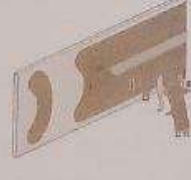
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2. If the defect is not inverted, it is on the fluid nozzle. Clean nozzle. If problem persists, renew nozzle.

Optimal pressure: 1.5bar/21psi

Maximum pressure: 2.5bar/36psi

Air consumption: 9~11cfm

Pattern width: about 260mm

Spray distance: 200mm

Cup capacity: 600 ml

Nozzle size :

○ 1.3mm ● 1.4mm ○ 1.8mm