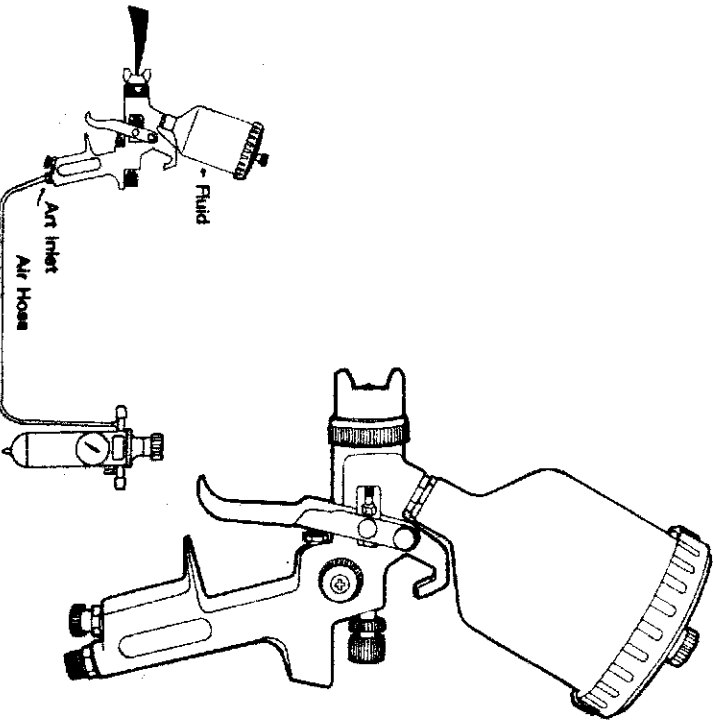


INSTRUCTIONS S-106

Your new Spray Gun is exceptionally rugged in construction, and is built to stand up under hard, continuous use. However, like any other fine precision instrument, its most efficient operation depends on a knowledge of its construction, operation, and maintenance. Properly handled and cared for, it will produce beautiful, uniform finishing results long after other spray guns have worn out.



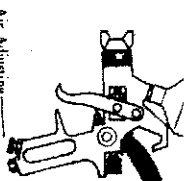
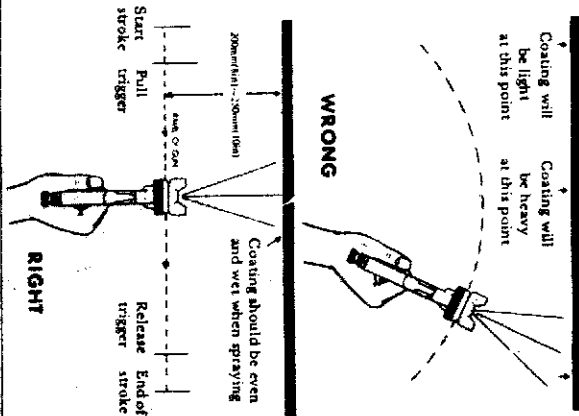
Air pressure for atomization is regulated at extractor. Amount of fluid is adjusted by fluid control screw on gun, viscosity of paint, and air pressure.

WARNING: DO NOT POINT SPRAY GUN TOWARDS THE FACE AND BODY.

GUN HANDLING

The first requirement for a good resultant finish is the proper handling of the gun. The gun should be held perpendicular to the surface being covered, and moved parallel with it. The stroke should be started before the trigger is pulled and the trigger should be released before the stroke is ended. This gives accurate control of the gun and material. The distance between gun and surface should be 6 to 12 inches depending on material and atomizing pressure. The material deposited should always be even and wet. Lap each stroke over the preceding stroke to obtain a uniform finish.

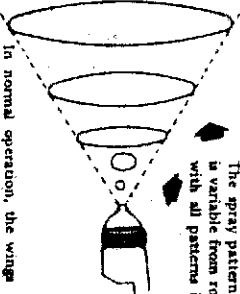
NOTE: To reduce overspray and obtain maximum efficiency, always spray with the lowest possible atomizing air pressure.



The spray pattern of the gun is variable from round to flat with all patterns in between.

Spray width adjusting. Turn right for round, left for fan. Fluid control screw. Turn right to decrease flow, left to increase.

As width of spray is increased, more material must be allowed to pass through the gun to obtain the same coverage on the increased area.



In normal operation, the wings on the nozzle are horizontal as illustrated here. This provides a vertical fan shaped pattern which gives maximum even, uniform, material coverage as the gun is moved back and forth parallel to the surface being finished.



SIPHON SPRAYING







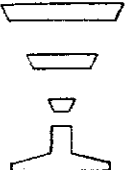
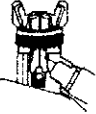
Set atomization pressure at approximately 50 psi for lacquer and 60 psi for enamel. Test spray. If the spray is too fine, reduce the air pressure or open fluid control screw. If the spray is too coarse, close the fluid control screw. Adjust the pattern width and repeat adjustment of spray if necessary.

PRESSURE SPRAYING

After selecting correct size fluid orifice, set fluid pressure for desired flow. Open atomization air and test spray. If spray is too fine reduce air pressure. If spray is too coarse, raise air pressure. Adjust pattern width and repeat adjustment of spray. Keeping fluid control screw in open position will reduce fluid needs waste.

NOTE: To reduce overspray and obtain maximum efficiency, always spray with the lowest possible atomization air pressure.

FAULTY PATTERNS and how to correct them

PATTERN	CAUSE	CORRECTION
	<p>Dried material in side-port "A," restricts passage of air. Greater flow of air from cleaner side-port "B" forces fan pattern in direction of clogged side.</p> 	<p>Dissolve material in side-port with thinner, then blow gun clean. Do not poke into openings with metal instruments.</p>
	<p>Dried material around the outside of the fluid nozzle tip at position "C" restricts the passage of atomizing air at one point through the center opening of air nozzle and results in pattern shown. This pattern can also be caused by loose air nozzle.</p> 	<p>Remove air nozzle and wipe off fluid tip, using rag wet with thinner. Tighten air nozzle.</p>
	<p>A split spray or one that is heavy on each end of a fan pattern and weak in the middle is usually caused by (1) too high an atomization air pressure, or (2) by attempting to get too wide a spray with thin material.</p>	<p>Reducing air pressure will correct cause (1). To correct cause (2), open material control to full position by turning to left. At the same time, turn spray width adjustment to right. This will reduce width of spray fan will correct split spray pattern.</p>
	<p>Low atomization air pressure. Too thick material. Too much material.</p>	<p>Raise air pressure. Regulate material viscosity. Reduce fluid flow by turning screw (B) on suction feed guns. Reduce fluid pressure on pressure feed guns.</p>
 <p>FLUTTERING or SPITTING SPRAY</p>	<p>(1) Dried out packing around material needle valve permits air to get into fluid passage-way. This results in spitting. (2) Dirt between fluid nozzle seat and body or loosely installed fluid nozzle will make gun spit. (3) A loose or defective swivel nut on siphon cup or material hose can cause spitting.</p>	<p>To correct cause (1) back up knurled nut (E), place two drops of machine oil on packing, replace nut and tighten with fingers only. In aggravated cases, replace packing. To correct cause (2), remove fluid nozzle (F), clean back of nozzle and nozzle seat in gun body using rag wet with thinner, replace nozzle and draw up tightly against body. To correct cause (3), tighten or replace swivel nut.</p> 

General Maintenance

SPRAY GUN

1. Immerse only the front end of the gun until solvent just covers the fluid connection.
 2. Use a bristle brush and solvent to wash off accumulated paint.
 3. Do not submerge the entire spray gun in solvent because:
 - a. the lubricant in the leather packings will dissolve and the packings will dry out.
 - b. the lubricant at wear surfaces will dissolve causing harder operation and faster wear.
 - c. residue from dirty solvent may clog the narrow air passages in the gun.
 4. Wipe down the outside of the gun with solvent dampened rag.
 5. Lubricate gun daily. Use a light machine oil on:
 - a. fluid needle packing.
 - b. air valve packing.
 - c. side port control packing.
 - d. trigger pivot point.
- Coat the fluid control spring with vaseline.
6. Caution: Never use lubricant containing silicone. This material may cause finish defects.

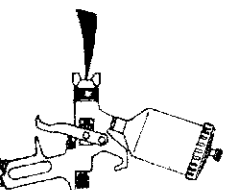
✳ POINTERS ON CLEANING

AIR NOZZLE, FLUID NOZZLE, NEEDLE ASSEMBLY

1. All nozzles and needles are precision made. They should be handled with care.
2. Except as described in 5, do not make any alterations in the gun. To do so could cause finishing difficulties.
3. To clean nozzles, soak them in solvent to dissolve any dried material, then blow them clean with air.
4. Do not probe any of the holes in the nozzles with metal instruments. If probing is necessary, use only a tool that is softer than brass.
5. Adjust the fluid needle valve so that when gun is triggered, air flow occurs before fluid flow.

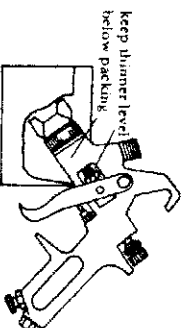
WHEN USED WITH SIPHON CUP

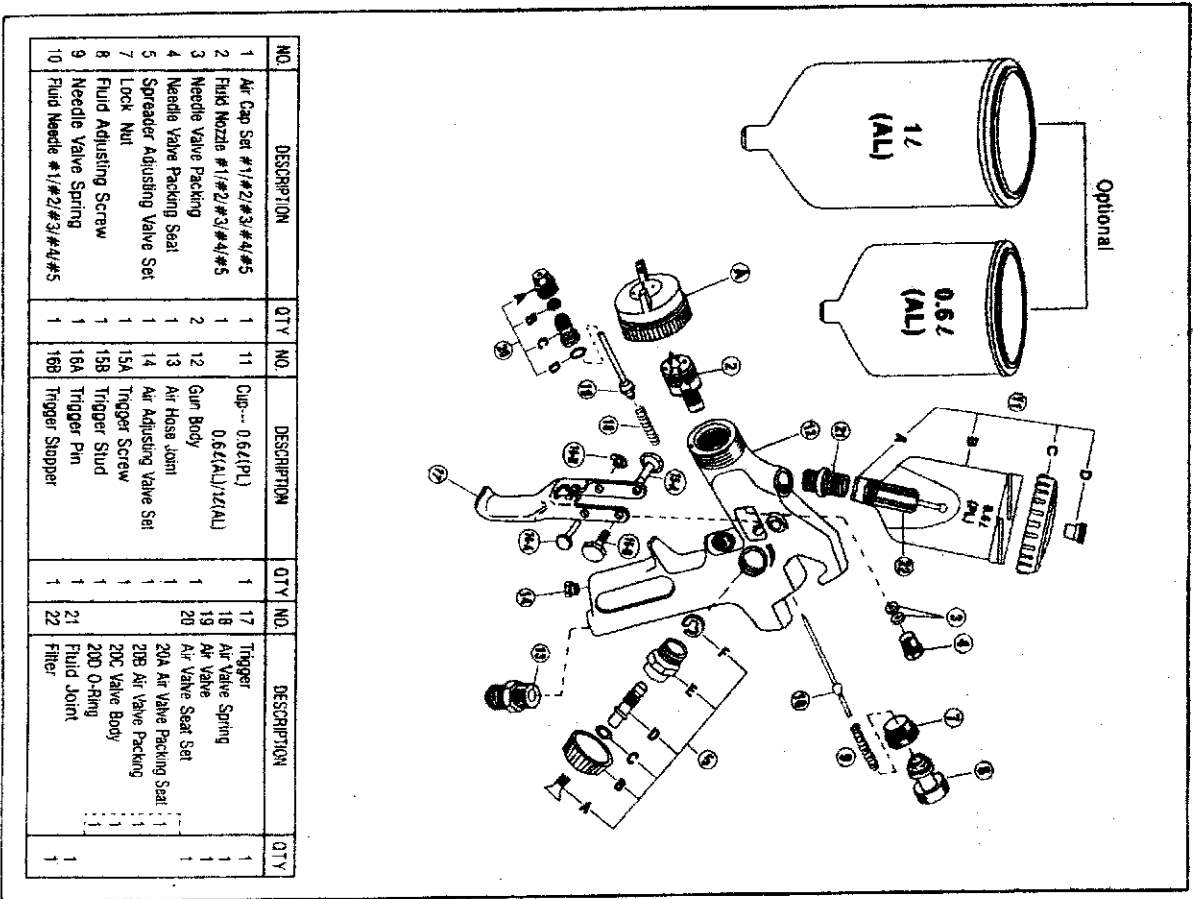
A comparable thinner or solvent should be siphoned through gun by inserting tube in open container of that liquid. Trigger gun repeatedly to flush passage-way thoroughly and to clean tip of needle.



WHEN USED WITH PRESSURE TANK

Shut off air supply to tank and release pressure on tank. Open vent and loosen air nozzle. Hold a piece of cloth over the air nozzle and squeeze trigger. Air will back up through fluid nozzle, and force fluid out of hose into tank. Next, put enough thinner into tank to wash hose and gun thoroughly. Spray thinner through the gun until it is clean. Attach fluid hose to air line and blow it out thoroughly to remove all traces of materials and to dry it.



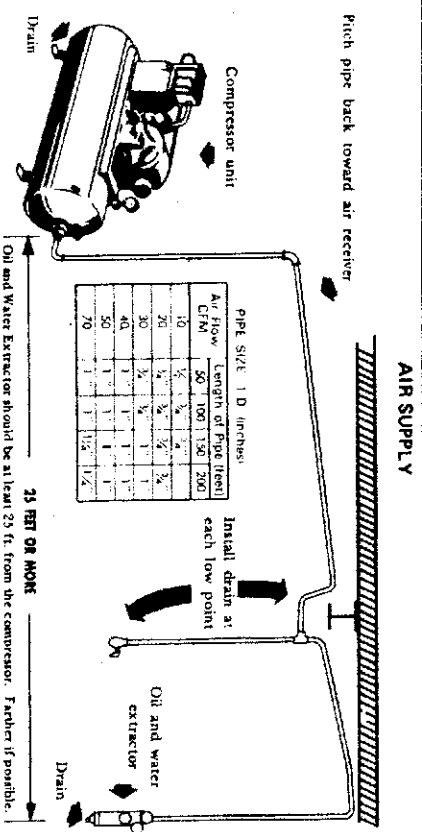


NO.	DESCRIPTION	QTY.	NO.	DESCRIPTION	QTY.	NO.	DESCRIPTION	QTY.
1	Air Cap Set #1/#2/#3/#4/#5	1	11	Cup-- 0.62(PU)	1	17	Trigger	1
2	Fluid Nozzle #1/#2/#3/#4/#5	1	12	Gun Body 0.62(AL)/12(AL)	1	18	Air Valve Spring	1
3	Needle Valve Packing	1	13	Air Hose Joint	1	19	Air Valve	1
4	Needle Valve Packing Seal	1	14	Trigger Screw	1	20	Air Valve Seal Set	1
5	Spreader Adjusting Valve Set	1	15A	Trigger Stud	1	20A	Air Valve Packing Seal	1
7	Lock Nut	1	15B	Trigger Pin	1	20B	Air Valve Packing	1
8	Fluid Adjusting Screw	1	16A	Trigger Stopper	1	20C	Valve Body	1
9	Needle Valve Spring	1	16B	Trigger Stopper	1	20D	O-Ring	1
10	Fluid Needle #1/#2/#3/#4/#5	1	16B	Trigger Stopper	1	21	Fluid Joint	1
						22	Filter	1

Model No.	Type	Fluid Tip (ID.) mm	Required Pressure kg/cm ²	Air Consumption (at Required Pressure)	Fluid Output c.c./min	Max. Spray Pattern mm	Max. Compressor I/W	Cup Capacity #	Approx. Weight Gun-Cup g
S-106-1G	Gravity feed	1.4	3.5-5	l/min 185	255	250	0.75-1.5	0.6 1	760
S-106-2G	Gravity feed	1.7	3.5-5	220	325	280	0.75-1.5	0.6 1	760
S-106-3G	Gravity feed	2.0	3.5-5	250	360	275	0.75-1.5	0.6 1	760
S-106-4G	Gravity feed	2.5	3.5-5	330	430	285	0.75-1.5	0.6 1	760
S-106-5G	Gravity feed	2.8	3.5-5	400	480	350	1.5	0.6 1	760

Δ ALL ABOVE RECORDS FOR REFERENCE ONLY.

Exchange of nozzle set (C)
 ▲ When changing to another nozzle size, make sure that the complete nozzle set is exchanged. A set comprises of air cap, paint nozzle and paint needle.



The oil and water extractor should not be mounted on or near the air compressor.
 The temperature of air is greatly increased during compression. As the air cools down to room temperature, in the air line, on its way to the spray gun, the moisture contained in it condenses. Thus, for maximum effectiveness, the oil and water extractor should be mounted at some point in the air supply system where the temperature of the compressed air in the line is likely to be lowest.
 Air lines must be properly drained. Pitch all air lines back towards the compressor so that condensed moisture will flow back into the air receiver where it can be drained off. Each low point in an air line acts as a water trap. Such points should be fitted with an easily accessible drain. See diagram above.