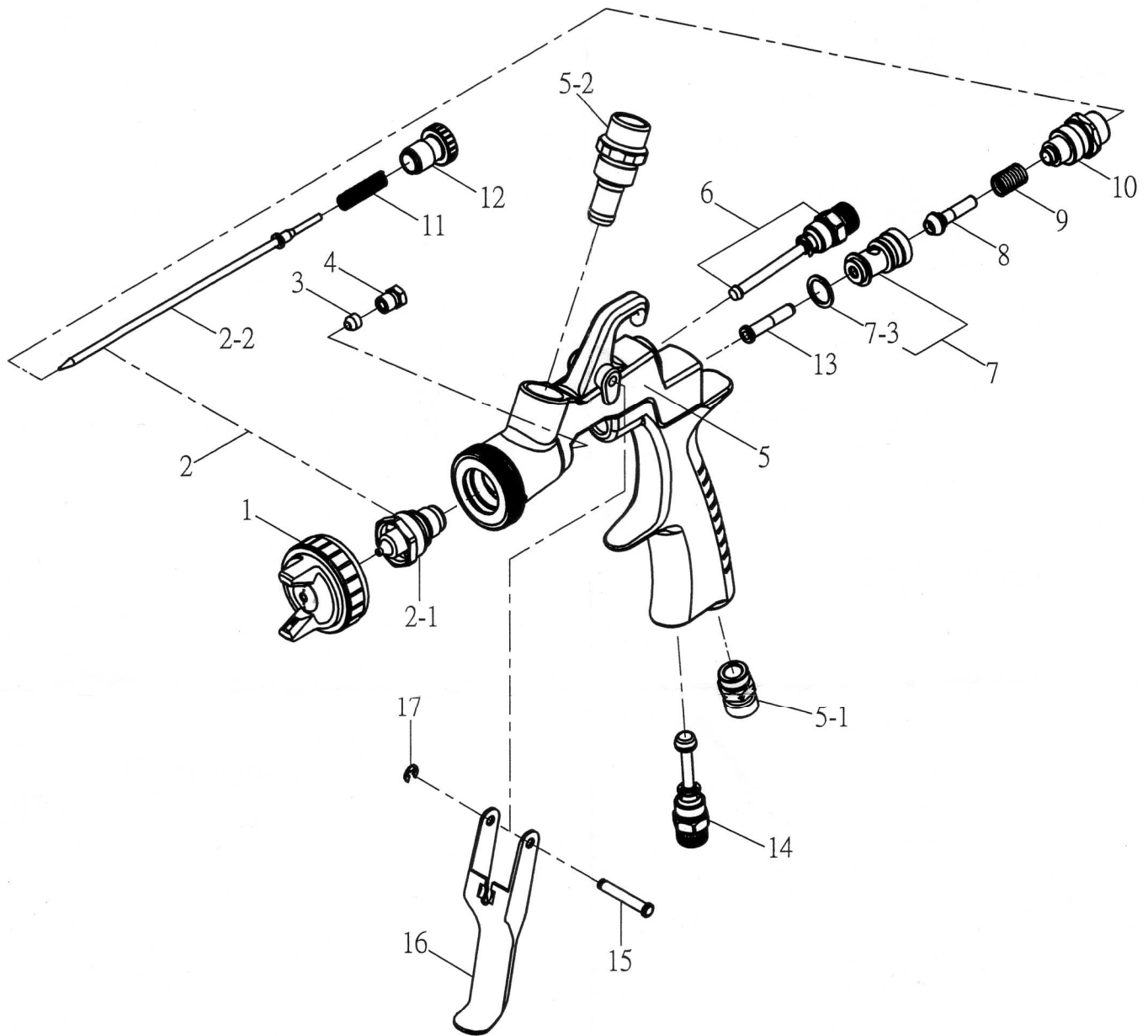




SP400G PARTS BREAKDOWN



PARTS LIST

No.	Description	Q'ty
1	Air cap set	1
2	Fluid nozzle-fluid needle set	1
2-1	Fluid nozzle	1
2-2	Fluid needle set	1
3	Needle packing set	1
4	Needle packing seat	1
5	Body set	1
5-1	Air nipple	1
5-2	Fluid nipple	1
6	Pattern adj. set	1
7	Air valve seat set	1
7-4	O-ring	1

No.	Description	Q'ty
8	Air valve	1
9	Air valve spring	1
10	Fluid adj. guide	1
11	Fluid needle spring	1
12	Fluid adj. knob	1
13	Air valve shaft	1
14	Air adj. set	1
15	Trigger stud	1
16	Trigger	1
17	E stopper	1
		1
		1



HOW TO OPERATE

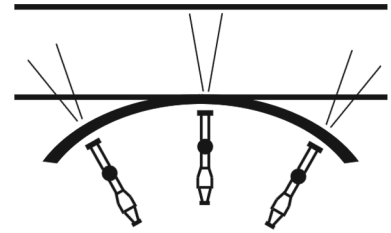
Suggested air pressure is 2.0 to 3.5 bar (29 to 50 psi).

Recommended paint viscosity differs according to paint property and painting conditions. 15 to 23 sec. / Ford #4 is recommendable.

Keep fluid output as low as possible to the extent that the job will not be hindered. It will lead to a better finish with finer atomization.

Set the spray distance from the gun to the work piece within the range of 150-200mm (5.9-7.9 in).

The gun should be 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. Arcing the gun causes uneven painting.



MAINTENANCE AFTER PAINTING







⚠ WARNING

- Turn off air coating material to the gun and release pressure by triggering the gun before disassembling, cleaning or servicing.
 - Pay attention when disassembling spray gun and handling sharp parts.
 - Do not disassemble if unsure of the procedures.
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 pattern 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 thoroughly before disassembly. Use a spanner or box wrench to remove the fluid nozzle.
 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 tighten gradually by spanner. Adjust packing set while pulling trigger and watching movement of fluid needle set since too much tightening will slow down movement of fluid needle and result in leakage from tip of nozzle. If tightened too much, turn counterclockwise to a suitable position.
 6. Turn pattern adjustment knob counterclockwise to fully open, and then tighten pattern adjustment guide into gun body.

⚠ CAUTION

- Use only original Atomex spare parts for repairs.
- Never immerse the whole gun into liquid such as thinner.
- Damaging holes of air cap, fluid nozzle and fluid nozzle may lead to degraded performance and/or malfunction.

TROUBLESHOOTING

Spray Pattern	Problems	Fix
Fluttering 	<ol style="list-style-type: none"> 1. Air enters between fluid nozzle and tapered seal of gun body. 2. Air is suctioned from fluid needle packing. 	<ol style="list-style-type: none"> 1. Remove fluid nozzle to clean seat. If it is damaged, replace nozzle. 2. Tighten fluid needle packing.
Crescent 	<ol style="list-style-type: none"> 1. Paint buildup on air cap partially clogs horn holes. Air pressure from both horns differs. 	<ol style="list-style-type: none"> 1. Without using metal objects, remove obstructions from horn holes.
Inclined 	<ol style="list-style-type: none"> 1. Paint buildup on air cap partially clogs horn hole or air cap center hole. 2. Loose fluid nozzle. 	<ol style="list-style-type: none"> 1. Remove obstructions. Replace part if required. 2. Remove fluid nozzle and clean seated section.
Split 	<ol style="list-style-type: none"> 1. Paint viscosity too low. 2. Fluid output too high. 	<ol style="list-style-type: none"> 1. Add paint to increase viscosity. 2. Adjust fluid adjustment knob or patten adjustment knob.
Heavy Centre 	<ol style="list-style-type: none"> 1. Paint viscosity too high. 2. Fluid output too low. 	<ol style="list-style-type: none"> 1. Reduce viscosity. 2. Increase fluid output.
Spit 	<ol style="list-style-type: none"> 1. Fluid nozzle and fluid needle set are not sealed properly. 2. The first-stage travel of trigger (air discharge only) decreases. 3. Paint buildup inside air cap set. 	<ol style="list-style-type: none"> 1. Clean or replace fluid nozzle and fluid needle set. 2. Replace fluid nozzle and fluid needle set. 3. Clean air cap set.