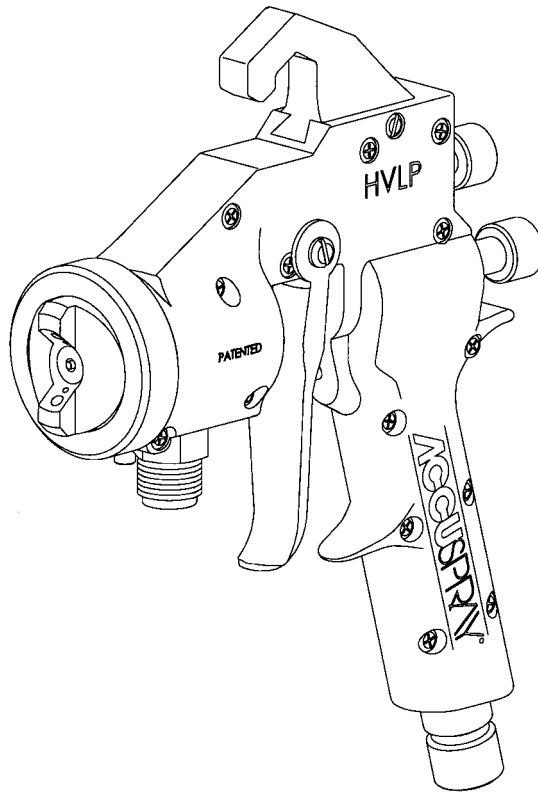




Series 10 & 11 HVLP Spray Gun Owners Manual



This Manual Covers 10 and 11 Series Spraygun Models

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Gun Overview

Accuspray's Series 10/11 Gun was designed from the inside out for HVLP use to deliver performance without compromise. This means achieving compliance with environmental regulations and delivering the fastest production speeds; generating substantial paint savings and producing a first class finish.

This model has a low-pressure inlet so that only low-pressure air (air below 10 psi) enters the gun. This is accomplished with either a low-pressure wall regulator (30-00 and 34-00) or with our mini-regulator and gauge assembly (36-00).

With proper use and maintenance, your Accuspray Gun will deliver long trouble-free life and first class results.

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Contents

Unpacking

Remove the components from the box. Inspect for concealed damage and missing items. If you discover any damage or missing pieces, contact your distributor immediately.

Your Accuspray **10 Series** spray gun package should include:

- 10 Series Spraygun
- Gun Wrench
- Tube of Gun Lube
- Port Plug
- Cleaning Brush
- ½ Pint or 1 Quart Cup (Optional)

Your Accuspray **11 Series** spray gun package should include:

- 11 Series Spraygun
- Gun Wrench
- Tube of Gun Lube
- Port Plug
- Cleaning Brush
- ½ Pint or 1 Quart Cup (Optional)

10 Series Spraygun

The 10 series spraygun is a non-bleed gun for use with either compressed air systems or turbines equipped with a pressure relief mechanism. Air stops flowing through the 10 series gun when the trigger is fully released. The 10 series can be used with compressed air with the use of a 0-10 psi regulator, Part# 36-00.

11 Series Spraygun

The 11 series spraygun is a bleeder gun for use with turbine air systems. The 11 series is a free flow design, which allows air to flow through the gun even after the trigger is released. This design prevents air pressure from causing the turbine to overheat and damage to the system. The 11 series spraygun is used with turbine air systems only.

General Safety

Accuspray's HVLP equipment is for professional use only. Hazards can occur from equipment misuse. Any misuse of the equipment or accessories, such as over pressurizing, modifying parts, using incompatible chemicals and fluids, or using worn or damaged parts can cause serious bodily injury, fire, explosion or property damage. **Please read and follow all General Safety, Safety Precautions and User Instructions.**

Never point a spray gun at anyone or any part of the body. Never place your hand or fingers in front of a spray nozzle.

Never try to stop or deflect leaks with your hand or body.

Never alter or modify any part of this equipment. A malfunction could result.

Check your spray equipment regularly. Repair or replace worn or damaged parts immediately.

Always use Accuspray HVLP replacement parts. Only these parts were designed to work with your equipment.

Safety Precautions

Solvents and coatings can be highly flammable to combustible, especially when sprayed. Adequate exhaust must be provided to keep the air free of accumulations of flammable vapors. Smoking must never be allowed in spray areas. Fire extinguishing equipment must be present in the spray area.

Certain materials may be harmful if inhaled or if there is contact with the skin. Follow the requirements of the Material Safety Data Sheet supplied by the coating material manufacturer. Use a respirator whenever there is a chance of inhaling sprayed material. The mask must be compatible with the material being sprayed and its concentration. Safety equipment must be NIOSH approved.

Certain solvents containing Methylene Chloride and Trichloromethane are not chemically compatible with aluminum or zinc. The solvents reaction can become violent and explosive. If you are in doubt whether a coating or cleaning material is compatible, contact your material supplier.

Improper operation or maintenance may create a hazard. Personnel must be given training. Instructions and safety precautions must be read and understood. Comply with your local, state, and national codes governing ventilation, fire protection, operation, maintenance, and housekeeping.

Set-up

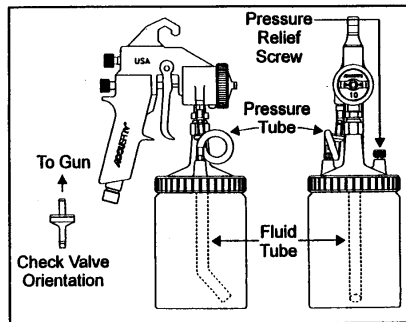
If you have a pressurized 1/2 pint or 1 quart cup, the sections on "Gun/Cup Installation" and "External Check Valve Assembly" below are very important for ensuring your gun operates efficiently.

Gun/Cup Installation

Thread the swivel nut of the cup lid onto the fluid inlet fitting of the spray gun. Tighten with an Accuspray Gun Wrench while applying counterforce with an 11/16" wrench on the fluid inlet fitting of the spray gun.

Before fully tightening, make certain that the fluid tube is pointed forward. Attach the pressure tube from the pressure stem on the gun head to the cup lid.

Note: Spray solvent through the gun before using it for the first time



External Check Valve Assembly

To install the assembly, attach the short pressure tube hose from the check valve assembly to the gun. Loop the tube and attach it to the pressure stem of the cup. The loop plays an important role; it allows you to see any material that may be working its way back up the tube.

A properly working check valve is required for uninterrupted spraying. The advantage of the external check valve is that in its remote location (away from the paint) it is not prone to becoming jammed. The external check valve is a wear part and it will require replacement after it becomes contaminated. The normal life expectancy is from one week to three months, depending on its care.

Maintenance

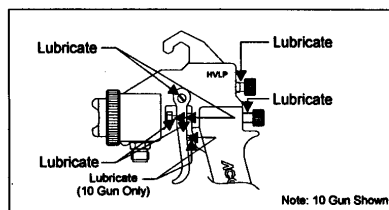
Gun Cleaning

It is very important to clean your gun after every use. Do not clean the gun body with paint strippers containing formic acid or acetic acid. Please refer to the coating manufacturers MSDS for the proper solvents to be used.

Accuspray does not recommend using a gun washer. After cleaning, blow out the gun with air and wipe off the exterior with the appropriate solvent. You can place a small amount of solvent in the cup, pressurize the cup, close your fan air down slightly, and trigger the gun until the stream of solvent runs clear. Do not place the mini-regulator in a gun washer.

Lubrication

After every cleaning of the gun, you must lubricate the working components. Cleaning washes away the lubricants that protect these friction points. Lubricate with Accuspray gun lube part #91-170. The lubrication points are shown below.



Cup Cleaning

It is also very important to clean your cup after every use. Before removing your cup lid from the cup, be sure to relieve the cup pressure through the relief valve. Unscrew the cup lid and remove the remaining material from the cup. Rinse the cup with a suitable solvent.

Cup Warnings

- 1/2 Pint and 1 Quart Pressure Cup Do Not Exceed 10 psi
- 2 Quart Pressure Cup Do Not Exceed 50 psi
- 2.5 Gallon Paint Tank Do Not Exceed 80psi
- Disconnect Atomizing Air Before Opening Cup
- Open Pressure Relief Screw Before Opening Cup

Gasket Replacement

Remember that the cup is a pressure cup. The gasket must be in good condition. The lid must be firmly seated to the cup to prevent air and fluid leakage. Inspect the gasket, lube the gasket channel, and pay attention to the fit with each use. Replace the gasket when necessary.

Overview Series 36

The Series 36 system was designed for maximum operator flexibility in adjusting pressure where coatings are frequently changed and slight variations in atomizing pressures are used.

Series 36 Package Includes:

- 36-00 Mini-regulator and gauge assembly
- Series 10 Gun
- 1/2 Pint or 1 quart pressure cup (optional)

The mini-regulator and gauge assembly provides precision control of low pressure atomizing air. It features a unique automatic shut-off so when the gun is disconnected from the assembly it is not necessary to back down the regulator to stop the airflow.

Series 36 Set-up

The 36-00 mini-regulator and gauge assembly is shipped assembled and attached to your gun. Attach your high-pressure inlet fitting to the inlet of the 36-00 (wrap threads in Teflon tape).

Attach your high-pressure air hose (5/16" I.D. or larger) from your existing high-pressure regulator and filtered air source to the high-pressure inlet fitting now installed on the 36-00.

The 36-00 can also be attached away from the gun, between a whip hose and an atomizing air hose for additional flexibility.

The inlet pressure to the 36-00 should be at least 90 psi in order to have maximum working pressure. Adjust the 36-00 for the desired atomizing pressure 0 to 10 psi with the gun triggered.

Requirements: A high-pressure wall mount regulator. This regulator should be set between 100 and 125 psi.

Caution: Use of wall mount and coalescing filters are highly recommended so that only clean air is delivered to the 36-00 and the gun.

Please refer to Maintenance on page 6 of this manual for gun and cup cleaning, and other maintenance issues.

Overview Series 36-Contiued

Atomizing Pressure

Set the **atomizing pressure** on the mini-regulator **before** spraying. Always set atomizing pressure with the gun trigger pulled so air is flowing out the air cap.

Note: Increasing the air pressure will give finer atomization. Decreasing the air pressure will give less atomization. However, before increasing the atomizing pressure, work with the fan and fluid controls. This will insure maximum paint savings and highest quality finishes.

Fan and Fluid Controls (see also Hand Gun Use on page 9)

Fan and fluid adjustments are used differently than on a high-pressure gun. To start, screw the fan adjusting screw in all the way. Screw the needle adjusting screw until there is very little needle travel. Then back out these knobs, as a starting point, 2 full turns.

Note: When adjusting fan and fluid controls, adjust only 1/2 turn at a time. **Do not open the fan or fluid knobs all the way.**

After all adjustments (air pressure, fan width and fluid flow) have been made, adjustments should only be made in small steps.

Air Pressure Control: Adjust only 1/2 to 1 psi at a time.

Fan and Fluid Controls: Adjust only 1/4 to 1/3 turn at a time.

If you feel the gun is spraying too much material, try closing down the fluid adjustments a little at a time to achieve the desired finish. Do this before increasing air pressure. *Increasing the air pressure increases the airflow.*

Suggested Starting Points for Automotive Finishes

	Atomizing Air Pressure	Fluid Adjustment (turns from fully closed)	Fan Adjustment (turns from fully closed)
Base Coat	4 psi	1-1/2 turns	3/4 turns
Single Stage	5-1/2 psi	2-1/2 turns	1 turn
Clear Coat	6-1/2 psi	2-1/2 turns	1 turn

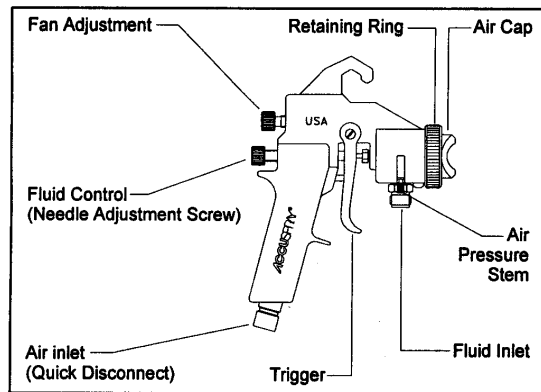
*Another air pressure rule of thumb is to use 10% of the high-pressure setting recommended by your paint manufacturer. For example, if 55 psi is recommended for Single Stage, start your Accuspray adjustment at 5.5 psi.

*When using a remote 2 quart cup or paint tank, set fluid flow to 0-20psi. Fluid atomizes best within this range. Some special applications may require over 20psi. Using fluid pressures over 20psi may create "heavy center" effects in the spray patterns. Changing the fluid nozzle to the next larger size, then reducing the fluid pressure will reduce "heavy center" effects in the spray patterns. Please refer to Needle Tips/Nozzles and Air Caps beginning on page 15 of this manual for further information.

Hand Gun Use

The fan size is regulated by the fan adjustment located at the top, rear of the gun. As a starting point, gently turn the knob clockwise until you feel no further adjustment. Next, turn the knob counter-clockwise one full rotation. The fan adjustment will allow you to spray from a small round to a full wet pattern. The pattern can also be changed from vertical to horizontal by rotating the air cap $\frac{1}{4}$ turn.

The fluid flow can be adjusted by the needle adjustment screw. The needle adjustment screw is located directly below the fan adjustment knob. As a starting point, gently turn the knob clockwise until you have very little needle travel. (Pull trigger to verify). Do not over-tighten. After the needle travel has stopped, further tightening will only serve to compress the spring and will not aid in adjustment. Next turn the knob counterclockwise two full turns. These adjustment procedures will serve only as a starting point. Fine tuning of these adjustments will be based on your material and technique.



Note: The small round pattern can be achieved by closing down the fan adjustment, triggering the gun lightly, and maintaining a distance from your target of 2 to 4 inches.

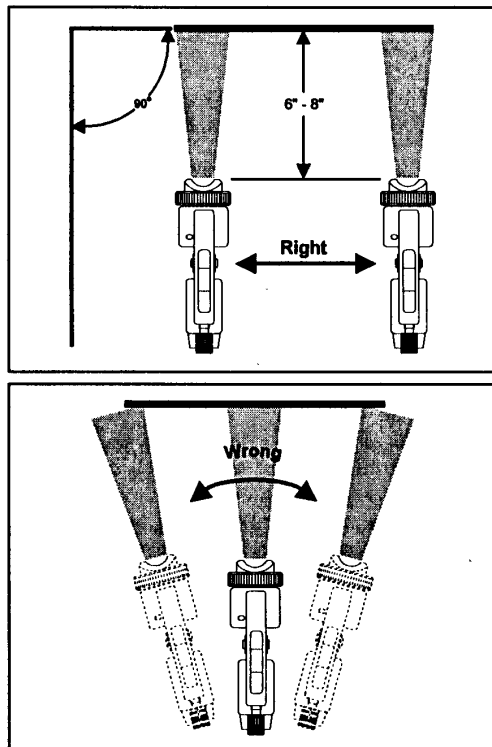
Hand Gun Use-Continued

Spray Technique

Proper spray technique is very important to achieve a good finish. Always spray at a distance of 6 to 8 inches from your target. Keep the gun parallel to your target throughout the entire pass. More detailed spraying can be done with the gun as close as 2 inches from the target. Make sure that your wrist remains firm during each pass.

Trigger the gun only after your pass begins, and release the trigger before stopping your motion. Do not angle your gun upward or downward while spraying. Angled spraying will develop an uneven paint buildup. Overlap your passes approximately 50% for an even finish.

Always be certain to thin your material with the proper solvent, and to follow the recommendations of the materials manufacturer.



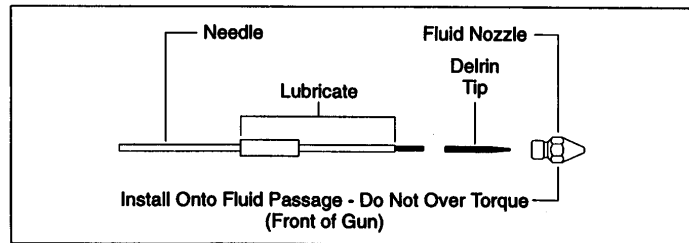
Hand Gun Use-Continued

Why change needle tips/nozzles and air caps?

The atomizing set in your gun was selected for its performance with many frequently used coatings. At the same time, different sizes of needle tips/nozzles or air caps can improve the results with coatings of different viscosities. To extend the versatility of your Accuspray gun, please see general guidelines for needle tips/nozzles and air caps.

To Change Needle Tips and Nozzles:

- 1) Remove the retaining ring and air cap.
- 2) Squeeze the trigger and keep the needle retracted for the next procedure.
- 3) Remove the fluid nozzle from front of the gun with the gun wrench.
- 4) Release the gun trigger.
- 5) Unscrew the Delrin needle tip and replace.
- 6) Squeeze trigger again and hold.
- 7) Replace the fluid nozzle. Tighten the nozzle . No not over-tighten.
- 8) Check the needle packing to ensure a proper seal.
- 9) Replace the air cap and retaining ring.



Note: To prevent damage to the needle tip, be sure to follow steps 2 and 6 above when removing or replacing the fluid nozzle.

Note: If removing a full stainless steel needle please do the following.

Remove retaining ring, air cap, and fluid nozzle/ Loosen packing nut. Remove needle adjustment screw and needle adjustment spring. Gently pull out the stainless steel needle from the back of the gun. Please refer to literature #SI-MK-0295 Series 10/11 Maintenance Kit Service Instructions for detailed adjustment and component replacement instructions.

Needle Tips/Nozzles and Air Caps

General Guidelines

- Light viscosity coatings will usually require a smaller nozzle.
- To adjust speed of application, the nozzle size can be changed

Smaller Nozzles----Slower

Larger Nozzles----Faster

- To adjust the degree of fine finish, the air cap size can be changed

Smaller Air Caps----Finer Finishes

Prokits:

These atomizing sets combine popular tip/nozzle and air cap sizes.

Prokit-10:

Includes: .036(0.9mm) Delrin tip and Nozzle; #8 Delrin Air Cap

Lighter viscosity materials such as acrylic lacquers, waterborne laquers, shellacs, stains, wood sealers. Also most automotive finishes.

Prokit-11:

Includes: .043(1.1mm) Delrin Tip and Nozzle; #9 Delrin Air Cap

Medium viscosity materials, such as waterborne clears, epoxies, polyurethanes, acrylic urethanes, and enamels. Also most automotive finishes.

Prokit-12:

Includes: .051(1.3mm) Delrin Tip and Nozzle; #10 Delrin Air Cap

Heavier viscosity architectural and maintenance materials, such as full-bodied stains, waterborne and acrylic enamels, latexes, and adhesives.

Prokit-30:

Includes: .036, .043, .061(1.3mm) Delrin Tip and Nozzle; #8 & #9 Delrin Air Caps

Various coatings with low medium and heavier viscosities.

Prokits can also be ordered with an aluminum air cap. To order, add an "A" to the Prokit part number.

Needle Tips/Nozzles and Air Caps

Recommendations and ordering information for architectural, maintenance, and production applications:

91-143-xxxDT.....Delrin tip and nozzle set.

Replace the xxx to specify size:

- .021(.5mm) or .028(.7mm) for very light viscosity coatings; low fluid flow
- .036(.9mm) for light /medium viscosity coatings; low fluid flow
- .043(1.1mm) for medium viscosity coatings; medium fluid flow
- .051(1.3mm) for heavier viscosity coatings; medium fluid flow
- .061(1.5mm) -.110(3.0mm) also available for the heaviest materials; high fluid flow

Recommendations and ordering information for automotive applications:

91-143-xxxDT.....Delrin tip and nozzle set.

Replace the xxx to specify size:

- .021(.5mm) or .028(.7mm) for spot repairs; exceptional material control; slow speed.
- .036(.9mm) for spot, panel and completes; excellent for bases; medium speed.
- .043(1.1mm) for panels and completes; excellent for single stage colors and clears; fast speed.
- .051(1.3mm) for high viscosity materials; great for primers; very fast speed.

91-009-yy.....Delrin Air Cap

A delrin air cap provides a smooth non-stick surface for easy cleaning and quality finishes. The smaller the air cap, the finer the finish.

Replace the yy to specify size: 8,9,10,11,11.5,12,13

91-071-yy.....Aluminum Air Cap

Aluminum air caps are machined at slightly higher tolerances and are usually used in automotive refinishing where a very fine finish is needed. The smaller the number air cap, the finer the finish. Replace the yy to specify size.

#5 air cap. No orange peel. For a mirror like finish with high solids and clears.

#6 air cap. No orange peel. For completes on single-stage solid colors, candies and clears.

#7 air cap. Almost no orange peel. For panels and completes on single-stage solids, candies and clears.

#8 air cap Little orange peel. For spot, panel and completes on single stage finishes, candies and clears.

#9 air cap. Some orange peel. Will duplicate most O.E.M. finishes. For spot, panel, and completes on single stage finishes, basecoats and clears.

#10 air cap. Will leave some orange peel. For primers, sealers, and some undercoatings.

Maintenance Kits and Accessories

Complete Gun and Cup Care Kit #91-270

Maintenance Kit #91-028
Cup Gasket #94-034(8)
Cup Lid Diaphragm #94-021(6)
Gun Handle Screw Kit #91-106
Check Valve Assembly #94-049(6)
Spring Clip for Diaphragm 94-064(3)
Gun Wrench #91-145
Gun Lube #91-170
Brush #SH-480

10 Series Maintenance Kit #91-028
11 series Maintenance Kit #91-029
10 Series O-Ring Kit #91-049
11 Series O-Ring Kit #91-249
Mini-Regulator #36-00
Replacement Gun Handle Kit #91-152
½ Pint Cup Assembly #41-11
Standard 1 Quart Cup #41-22
Premium 1 Quart Cup #41-42
11 to 10 Spraygun Conversion Kit #91-140
Complete Brush Cleaning Kit #91-470

Gun Conversions for Fluid Handling Options

Attached Cup to Pressure Feed

When using your gun with a 2 quart cup or paint tank, rather than with an attached ½ pint or 1 quart cup. Install the pressure stem cap (#91-109) by pushing it over the air pressure stem (#LFG-465) to prevent loss of atomizing pressure.

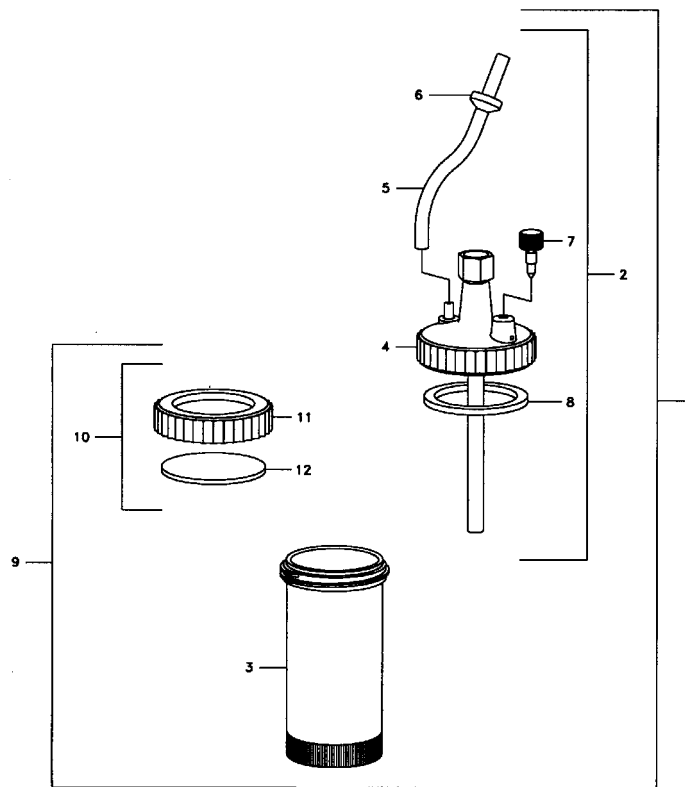
For permanent use of your gun with 2 quart cup or paint tank, remove the pressure stem (#LFG-465) and replace it with a port plug (#UH-694).

**You will be able to convert back to a cup set-up by removing the plug and re-installing the pressure stem.*

Pressure Feed to Attached Cup

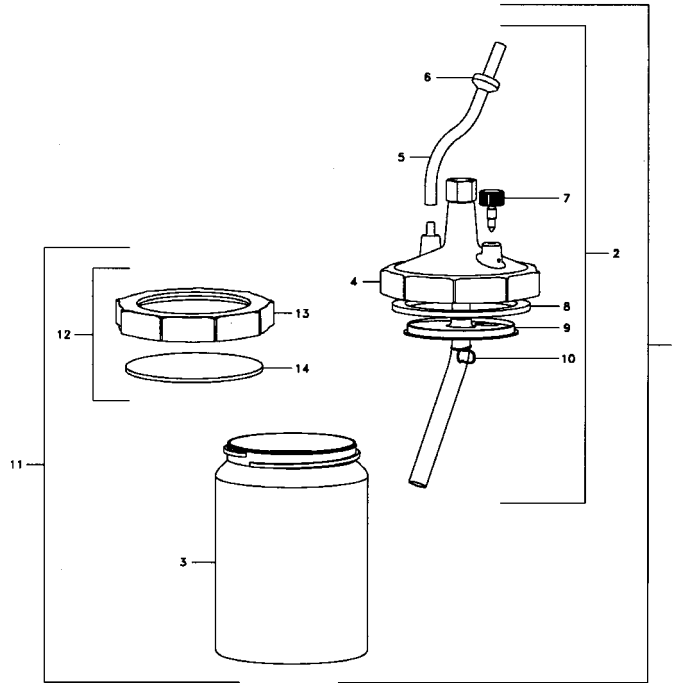
When the gun is purchased as a pressure feed gun and you want to convert it to a pressure gun, the pressure stem (#LFG-465) must replace the plug (#UH-694). After the pressure stem is installed in the gun, the easiest way to change to pressure feed is through installing the air stem cap (#91-109). To install, simply push over the stem.

Parts Identification ½ Pint Cup Assembly (41-11)



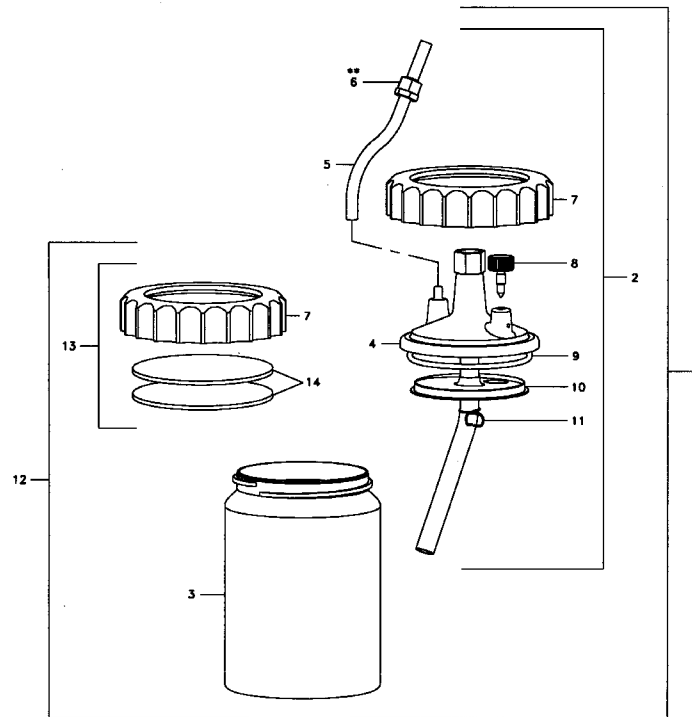
Item	P/N	Description
1	41-11	½ Pint Cup Assembly
2	94-101	½ Pint Cup Lid Assembly w/ Ck. Valve
3	94-082	½ Pint Cup (Cup Only)
4	94-087	Cup Lid Sub-Assembly
5	94-049/3	Check Valve Assembly (Pack of 3)
6	91-129/4	Check Valve (Pack of 4)
7	94-035A	Pressure Relief Screw
8	94-084/4	Gasket (Pack of 4)
9	94-232	Storage Cap/Cup Assembly
10	94-231	Storage Cap Assembly
11	94-226	Storage Cap
12	94-227/4	Storage Cap Gasket

Parts Identification 1 Quart Pressure Cup (41-22)



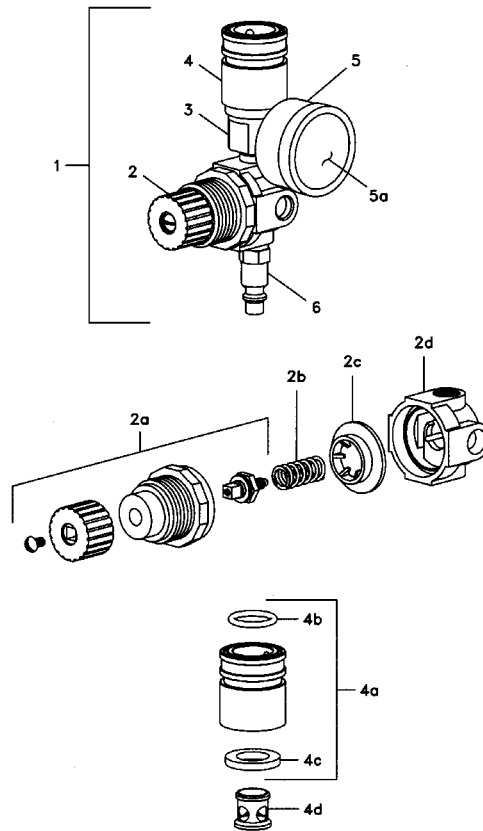
Item	P/N	Description
1	41-22	1 Quart Cup Assembly
2	94-057	1 Quart Cup Lid Assembly w/ Check Valve
3	94-056	1 Quart Cup (Cup Only)
4	94-061	Cup Lid Sub-Assembly
5	94-049/3	Check Valve Assembly (Pack of 3)
6	91-129/4	Check Valve (Pack of 4)
7	94-035A	Pressure Relief Screw
8	94-034/4	Gasket (Pack of 4)
9	94-021/3	Diaphragm (Pack of 3)
10	94-064/3	Spring Clip (Pack of 3)
11	94-234	Storage Cup/Cap Assembly
12	94-233	Storage Cap Assembly
13	94-228	Storage Cap
14	94-230/4	Storage Cap Gasket

Parts Identification 1 Quart Premium Cup (41-42)



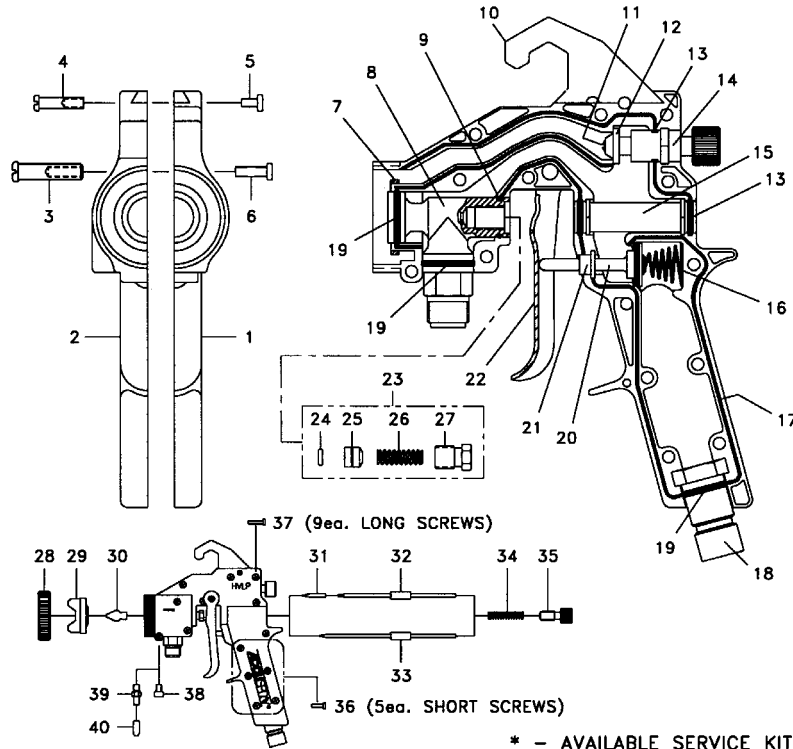
Item	P/N	Description
1	41-42	Premium 1 Quart Cup Assembly
2	94-596	1 Quart Cup Lid Assembly w/ Check Valve
3	94-594	1 Quart Cup (Cup Only)
4	94-593	Cup Lid Sub-Assembly
5	94-601	Check Valve Assembly (Pack of 3)
6	91-225	Serviceable Check Valve
7	94-597	Retaining Ring
8	94-035A	Pressure Relief Screw
9	UH-13773	O-Ring Seal (Pack of 3)
10	94-021/3	Diaphragm (Pack of 3)
11	94-064/3	Spring Clip (Pack of 3)
12	94-634	Storage Cup/Cap Assembly
13	94-433	Storage Cap Assembly
14	94-230/4	Storage Cap Gasket
**	91-228/10	Check Valve Diaphragm (Pack of 10)

Parts Identification Mini-Regulator/Gauge (36-00)



Item	P/N	Description
1	36-00	Air Regulator Assembly
2	93-025V	0-10 PSI Regulator
2a	93-026	Bonnet Assembly
2b	93-027	10lb. Adjustment Spring
2c	93-028	Diaphragm
2d	93-081	Air Regulator Base
3	93-029	Adaptor Body
4	80-983	Quick Disconnect Assembly
4a	80-985	Quick Disconnect Body
4b	UH-840	O-Ring Seal
4c	80-981	Washer Seal
4d	80-982	Shut-Off Valve
5	93-035	0-10 PSI Air Gauge
5a	93-036	Replacement Gauge Lens
6	80-936	Male Quick Disconnect

10 Series Hand Gun Parts Identification

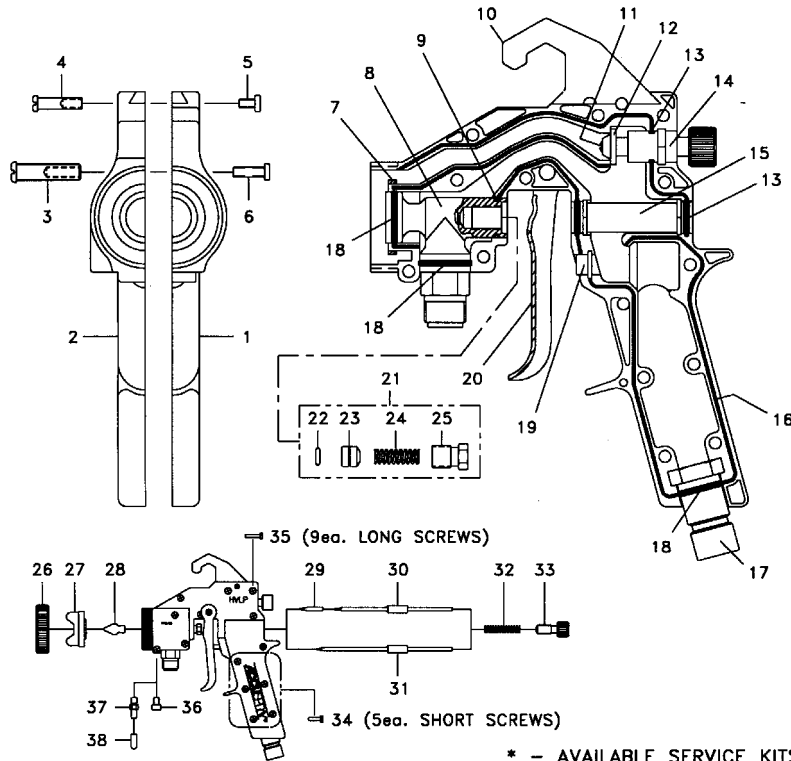


* - AVAILABLE SERVICE KITS

ITEM	PART No.	DESCRIPTION
1	91-123-A	LEFT-HALF SPRAYGUN HANDLE
2	91-122	RIGHT-HALF SPRAYGUN HANDLE
3	91-014	TRIGGER PIVOT POST
4	91-141	HOOK POST
5	UH-869/4	HOOK POST SCREW
6	UH-769/4	TRIGGER PIVOT POST SCREW
7	91-276	CLOSURE RING
8	91-064	FLUID PASSAGE ASSEMBLY
9	UH-790/10	O-RING (PACK OF 10)
10	91-124	SPRAYGUN HOOK
11	UH-765/4	FAN VALVE ASSEMBLY SCREW
12	91-015	VALVE SEAL
13	UH-647/10	O-RING (PACK OF 10)
14	91-072	FAN VALVE ASSEMBLY
15	91-041	THREADED SLEEVE ASSEMBLY
16	91-019/5	TELESCOPIC SPRING
17	UH-753/2	SEAL
18	91-020	AIR INLET ASSEMBLY
19	UH-789/10	O-RING (PACK OF 10)
20	91-142	POPPET VALVE ASSEMBLY
21	91-021	FLANGED BUSHING
22	HP-405	TRIGGER

ITEM	PART No.	DESCRIPTION
23	91-200	SELF-ADJUSTING PACKING KIT
24	UH-1405/10	O-RING (PACK OF 10)
25	91-202/2	NEEDLE GUIDE (PACK OF 2)
26	91-199/3	COMPRESSION SPRING (PACK OF 3)
27	91-201	PACKING NUT
28	91-271	RETAINING RING
29	91-009-xxx	AIR CAP (DELTRIN)
29	91-071-xxx	AIR CAP (ALUMINUM)
30	91-008-xxx	FLUID NOZZLE
31	91-107-xxx/4	NEEDLE TIP (PACK OF 4)
32	91-078	NEEDLE SHAFT
33	91-006-xxx	FULL S.S. NEEDLE
34	LG-27/5	SPRING (PACK OF 5)
35	91-068	NEEDLE ADJUSTMENT SCREW
36	UH-800/10	1/2" (SHORT) SCREW (PACK OF 10)
37	UH-801/10	5/8" (LONG) SCREW (PACK OF 10)
38	UH-694/4	AIR PRESSURE PORT PLUG
39	LFG-465	AIR PRESSURE STEM
40	91-109/10	AIR PRESSURE STEM CAP
*	91-028	SPRAYGUN REBUILD KIT
*	91-049	O-RING REPLACEMENT KIT
*	91-152-A	HANDLE REPLACEMENT KIT

11 Series Hand Gun Parts Identification



* - AVAILABLE SERVICE KITS

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8	91-064	FLUID PASSAGE ASSEMBLY
9	UH-790/10	O-RING (PACK OF 10)
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11	UH-765/4	FAN VALVE ASSEMBLY SCREW
12	91-015	VALVE SEAL
13	UH-647/10	O-RING (PACK OF 10)
14	91-072	FAN VALVE ASSEMBLY
15	91-041	THREADED SLEEVE ASSEMBLY
16	UH-753/2	SEAL
17	91-020	AIR INLET ASSEMBLY
18	UH-789/10	O-RING (PACK OF 10)
19	91-027	PLUG
20	HP-405	TRIGGER
21	91-200	SELF-ADJUSTING PACKING KIT

ITEM	PART No.	DESCRIPTION
22	UH-1405/10	O-RING (PACK OF 10)
23	91-202/2	NEEDLE GUIDE (PACK OF 2)
24	91-199/3	COMPRESSION SPRING (PACK OF 3)
25	91-201	PACKING NUT
26	91-271	RETAINING RING
27	91-009-xxx	AIR CAP (DELTRIN)
27	91-071-xxx	AIR CAP (ALUMINUM)
28	91-008-xxx	FLUID NOZZLE
29	91-107-xxx/4	NEEDLE TIP (PACK OF 4)
30	91-078	NEEDLE SHAFT
31	91-006-xxx	FULL S.S. NEEDLE
32	LG-27/5	SPRING (PACK OF 5)
33	91-068	NEEDLE ADJUSTMENT SCREW
34	UH-800/10	1/2" (SHORT) SCREW (PACK OF 10)
35	UH-801/10	5/8" (LONG) SCREW (PACK OF 10)
36	UH-694/4	AIR PRESSURE PORT PLUG
37	LFG-465	AIR PRESSURE STEM
38	91-109/10	AIR PRESSURE STEM CAP
*	91-029	SPRAYGUN REBUILD KIT
*	91-049	O-RING REPLACEMENT KIT
*	91-152-A	HANDLE REPLACEMENT KIT

Troubleshooting

Problem	Cause	Remedy
Bad Spray Pattern	Air Cap Clogged	Soak in Thinner
	Nozzle Clogged	Appropriate Solvent
	Bent Fluid Needle	Replace Fluid Needle
Blistering	Moisture on Surface	Clean Surface
	Wrong Solvent	Check Solvent
	Coats Not Compatible	Check Compatability
	Insufficient Dry Time	Longer Dry Time
Fish Eyes	Surface Too Cold	Warm Surface
	Air Contamination	Add Air Filtration
Heavy Middle Pattern	Silicone Contamination	Clean Surface W/ Solvent
	Too Much Pot Pressure	Reduce Fluid Pressure
Intermittent, Pulsating Spray	Not Enough Atomizing Pressure	Increase Atomizing Pressure
	Worn or Loose Packing	Tighten or Replace
Insufficient Fluid Flow, Pressure Feed	Low Fluid in Cup or Pot	Add Fluid
	Restriction in Fluid Line	Use 3/8" Fluid Hose
	Blocked Hose	Flush or Replace Hose
	Fluid Nozzle Too Small	Use Larger Needle/Nozzle
Coarse or Lumpy Surface	Low Fluid Pressure	Increase Fluid Pressure
	Dirt or Dust on Surface	Tack Wipe Before Spray
Mottled Looking Surface	Material is Contaminated	Change or Strain
	Coating Too Thin	Use Less Thinner
No Paint Flow	Coats Too Wet	Reduce Fluid Flow
	Improper Spray Technique	Hold Gun Parallel to Work
	Clogged Fluid Nozzle	Clean Fluid Nozzle
Orange Peel	Loss of Air Pressure	Check Hose, Cup Gasket
	Loss of Fluid Pressure	Out of Paint
	Clogged Air Passage	Clean With Solvent
	Restriction in Mat'l Hose	Flush With Solvent
	Clogged Check Valve	Replace Check Valve
Overspray is Excessive	Paint Drying Too Fast	Use Proper Solvent
	Gun Too Far From Target	6 - 8 Inches is Ideal
	Too Much Atomizing Air for Coating Being Sprayed	Reduce Atomizing Air
Pin-holing, Solvent Pops	Viscosity Too Heavy	Reduce with Solvent
	Trapped Solvent	Apply Lighter Coats
	Improper Solvent	Check Coating Mfg.
Paint Leak	System Contaminated	Clean all Parts
	Wrong Needle Size	Replace
	Damaged/Worn Needle	Replace
	Loose Fluid Nozzle	Tighten or Replace
	Worn/loose Packing Nut	Tighten or Replace
	Needle Not Closing	Packing Too Tight. Broken or Missing Needle Spring. Dried Paint on Needle.
Tilted Gun	Do Not Tilt While Spraying	

Troubleshooting-Continued

Problem	Cause	Remedy
Runs and Sags	Material Too Thin	Add Product
	Moving Gun Too Slow	Speed up, Smaller Nozzle
	Surface Too Cold	Warm Up Surface
	Too Much Product	Reduce Fluid flow
	Gun Too Close To Target	6 - 8 Inches is Ideal

Troubleshooting for the 36-00 Mini-Regulator

Problem	Cause	Remedy
Air Pressure Too High	Regulator sticking caused by dirt on valve body or seat or piston seat or improperly lubricated parts	Clean, replace and lubricate parts Install good air filter before main regulator and maintain it
Not Enough Pressure	Dirty filter	Replace filter element
	Air hose too small from high pressure wall mount regulator to gun mount HVLP regulator	Install larger air hose (5/16") to eliminate the restriction. 85-125 psi should be kept at the regulator inlet for full efficiency
	Insufficient line pressure	Increase pressure delivered to gun or shorten hose length
Regulator Doesn't Hold Pressure	Dirt from contaminated air is making diaphragm stick or solvents have attacked the seals	Use only clean filtered air to the mini-regulator. Do not place mini-regulator in a gun washer

Some Reminders:

If correcting a problem involves changing the fluid nozzle:

- Be sure to squeeze the trigger to retract the needle. This will prevent damaging the needle tip.

If it necessary to remove cup lid from the cup:

- Be sure to relive cup pressure through the relief valve.

When using a cup gun and spraying a horizontal surface, the fluid may work itself into the tube. In order to reverse this flow, follow these instructions:

- Hold the gun upright
- Open the pressure relief valve screw (94-035A)
- Pull the trigger back just enough for air. This will push paint back into cup.
- When the tube is clear of fluid, re-close the pressure relief screw.
- If the tube has been coated, replace it before your next use.

Notes

To order additional copies of this manual, call Accuspray Customer Service at 1-800-618-6860 or fax your request to (440) 498-9815. You may also request the manual on the web at www.accuspray.net. Request Literature Number: SM-10-0695

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