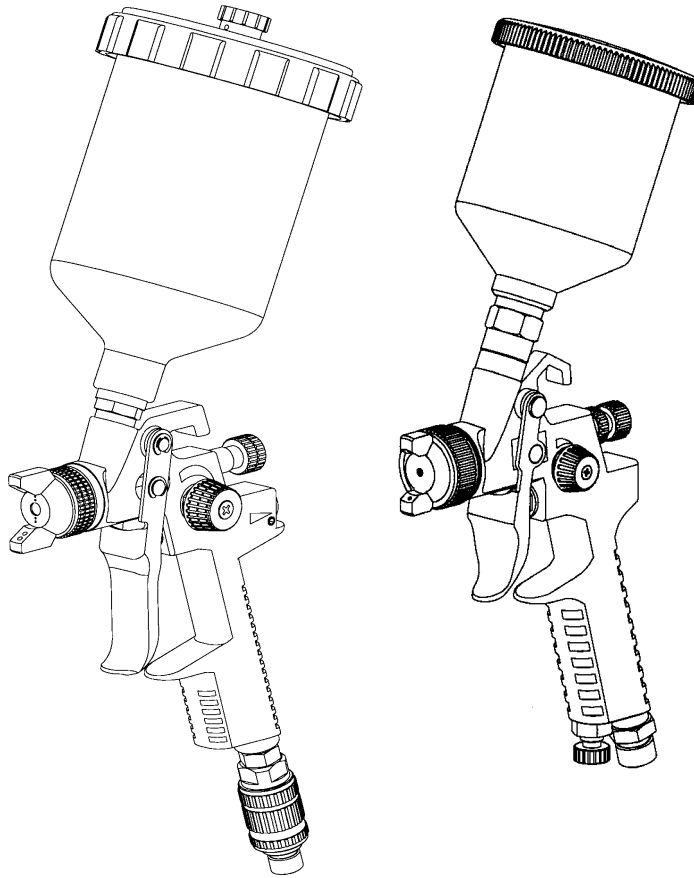




# PerforMax Series HVLP Owners Manual



Literature #SM-05-1005

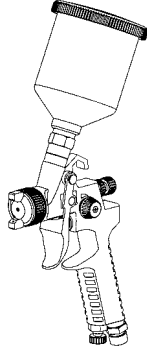
**This manual covers the 05-100 and 05-300 Spraygun models.**

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## PerforMax – Value Packaged Performance

### PerforMax Detail—Detail Spraygun

The PerforMax Detail Spraygun atomizes as well as any detail spraygun on the market, but at a better cost to you. Great for tight spaces, touchup work, and interior jobs. Available spraygun packages.



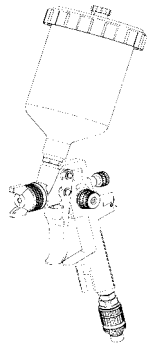
**05-300/0.8 – (0.8mm)**

**05-300/1.0 – (1.0mm)**

**05-300/1.2 – (1.2mm)**

### PerforMax—Primer Spraygun

The PerforMax spraygun is at the top of the value packaged primer sprayguns on the market. Available spraygun packages.



**05-100/1.5 – (1.5mm)**

**05-100/1.8 – (1.8mm)**

**05-100/2.0 – (2.0mm)**

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## Gun Overview

Introducing PerformMax, Accuspray's value series of sprayguns that combine Accuspray's unparalleled HVLP performance with an economical price. PerformMax sprayguns are compliant with environmental regulations without sacrificing speed of application or finish quality.

With proper use and maintenance, your Accuspray PerformMax spraygun will provide long, trouble free life and deliver excellent 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 **PerforMax** spray gun package should include:

- PerforMax Spraygun (05-100 or 05-300)
- Gravity Cup (600ml or 1000ml)
- Gun Wrench
- Tube of Gun Lube
- Cleaning Brush
- Wall Mount Bracket

**05-100 Series:** The PerforMax Primer Spraygun is economy priced for automotive primers and light general-purpose use. Anodized aluminum body and plastic 650ml cup.

**05-300 Series:** The PerforMax Detail Spraygun is economy priced for automotive detail and general-purpose touch-ups. Aluminum body and aluminum 200ml cup.

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## 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.

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## 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.

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## Set-up

**Gun/Cup Installation 05-100 (650ml Plastic)** Screw the cup onto fluid passage fitting, and tighten at the cup hex nut with your gravity cup gun wrench. With material in the cup, tighten the lid securely. MAKE SURE ALL FOUR THREADS ARE ENGAGED. Align the cup lid with the threads. Then, rotate the lid until snug. With the gun in a horizontal position, swish the material inside the cup around. Look for seepage where the lid meets the cup. If any seepage appears, check that the lid is fully engaged to cup.

### **Warning:**

The composite gravity cup will swell when overexposed to solvents. To prevent this, do not use a gun washer. Instead, place a small amount of solvent in the cup, swirl solvent around, and wipe dry. This will also minimize staining. If a gun washer is used, promptly remove the cup and lid and wipe dry. Do not soak in solvent. Limit the time in the gun washer to 5 minutes.

If the cup or lid is swollen and the lid has not been fully engaged to the cup, the cup may leak. To "un-swell" the cup, allow it to air dry. Depending on the severity of the overexposure, the drying time can take up to a week. Use a replacement cup while the cup is drying.

### **Gun/Cup Installation 05-300 (200mL Aluminum)**

**Caution:** Do not use solvents containing Methylene Chloride and Trichloromethane with this cup. They are not chemically compatible with aluminum.

**Before Spraying:** Wipe the cup interior with a soft cloth that has been dampened with an appropriate solvent. Wipe the lid completely, including the area around the sealing barbs.

**Attaching the Cup:** Hold and spin the cup closer to the bottom (fitting end) of the cup. Grasping the cup at the top and applying pressure may cause the cup to go out of round, affecting the lid seal. Tighten the cup at the fitting with your gravity gun wrench.

**Cleaning:** The cup may be cleaned in a gun washer or wiped clean. Do **not** clean the lid in a gun washer. Wipe clean only. Note: The lid is a wear part. The sealing threads and gasket, in time, will wear. Order Part #97-261 when necessary.

### ***When Spraying***

It is very important to keep the breather hole, located on both cup lids, free of obstructions. Air must be able to flow in.

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## Set-Up Continued

### Optional Filter Installation

Place the filter for the gravity cup into the fluid passage of the gravity gun. Push the filter down until it is fully seated. Follow the gun/cup installed on the previous page.

### Attaching Your High-Pressure Air Hose

When attaching your high pressure air hose (5/16" or larger) to the gun, use your gravity gun wrench, or a 9/16" open end wrench to apply counter force to the air inlet fitting while tightening (or removing) your high pressure air hose with a 5/8" open end wrench. This will prevent damage to the air inlet tube inside the gun.

### High-Pressure Air

The high-pressure air into the gun is decompressed inside the gun on average, at approximately a 4.3 to 1 reduction ratio. The high-pressure regulator setting depends on the atomizing set and air cap selected, and the desired result. See **Guidelines for Setting Inlet Pressure** on page 8.

### Air Regulation

The 05-100 Primer Gun and the 05-300 Detail Gun packages both include air regulators. The 05-100 Primer Gun has an external detachable regulator while the 05-300 Detail Gun has an internal regulator. The regulator adjustment knob on the 05-300 Detail Gun is located at the base of the gun handle directly next to the air inlet. Counter-Clockwise adjusting will increase airflow while adjusting clockwise will decrease airflow on either Gun.

### First Time Use

Spray solvent through the gun before using it for the first time. This will remove any contaminants that may have entered the fluid passage.

## Hand Gun Use

### Gun Adjustments

The fan size is regulated by the fan adjustment knob located on the side of the gun. With the gun pointed at your target, turn the knob toward you until it stops. This is the fully closed position. Turning the knob away from you increases the fan air.

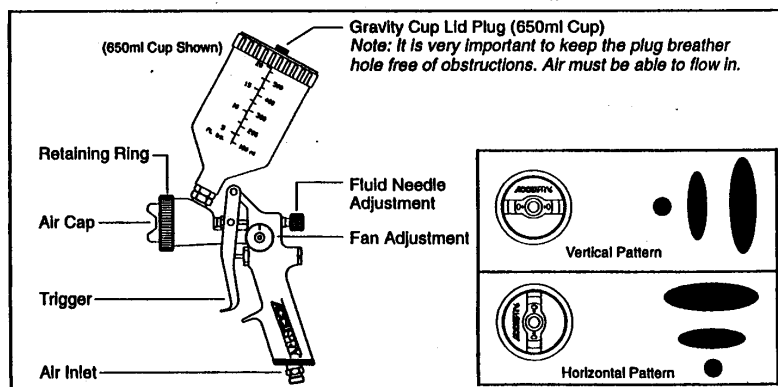
The fluid flow is controlled by the needle adjustment screw located at the rear of the gun. Turning the knob clockwise will close down the fluid flow, minimizing needle travel (trigger pull). Turning the knob counterclockwise will increase the fluid flow, maximizing needle travel (trigger pull).

With the first thread of the needle adjustment screw showing from the gun body (approximately 4 counterclockwise turns from closed) you will have full needle travel.

Please note that, when closing down the needle adjustment screw, when the needle travel has stopped, further tightening will damage the needle tip and will not aid in adjustment.

As a starting point, open the fan adjustment knob between 1/4 and 1/2 turn. Set the needle adjustment screw so that the first thread is showing from the gun body. This will give you approximately an 8 inch wide pattern, at 8 inches from your target (depending on air cap & pressure setting). Fine-tuning of these adjustments will be based on your material and technique.

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



**Note: Spraygun shown may differ slightly for actual PerforMax Spraygun**

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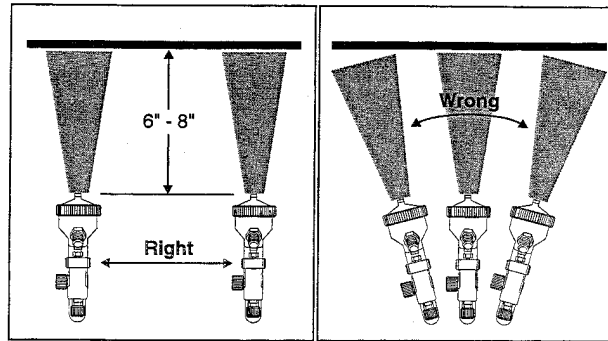
## Hand Gun Use - Continued

### Spray Technique

Proper spray technique is very important to achieve a good finish. Always spray at a distance of 6 to 8 inches away from your target. Spray 4 to 6 inches from your target with the 05-300 PerforMax Detail spraygun. Keep the gun parallel to your target throughout the entire pass. More detailed spraying can be done with the gun as close as 1 inch from the target. Make sure 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 the 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 material's manufacturer.



**Note: Cup Not Shown for Clarity**

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## Hand Gun Use - Continued

**Guidelines for Setting Inlet Pressure** Your 07 series spraygun requires lower than expected inlet pressures to produce excellent atomization and desired speed of application. The chart below shows recommended starting points for setting inlet pressures at the gun.

<b>Typical Application</b>	<b>Inlet Pressure Setting (at Gun)</b>
Low Solids	22-24psi
Medium Solids Bases	25-27psi
Medium Solids Clears	30-35psi
Single Stages	28-32psi
Primers	30-32psi

### **Available Atomizing Sets**

Note: A larger fluid nozzle will deliver a faster rate of application.

#### **05-100**

97-134/1.5	1.5mm Needle/Nozzle/Air Cap Kit
97-134/1.8(Standard)	1.8mm Needle/Nozzle/Air Cap Kit
97-134/2.0	2.0mm Needle/Nozzle/Air Cap Kit

#### **05-300**

97-210/0.8	1.5mm Needle/Nozzle/Air Cap Kit
97-210/1.0(Standard)	1.8mm Needle/Nozzle/Air Cap Kit
97-210/1.2	2.0mm Needle/Nozzle/Air Cap Kit

## Daily Maintenance

### Gun Cleaning

Your Accuspray PerforMax spraygun is made from aluminum, and it contains aluminum components. Certain solvents containing Methylene Chloride and Trichloromethane are not chemically compatible with aluminum. If you are in doubt whether a chemical coating is compatible, contact your material supplier.

It is very important to clean your gravity gun and cup after every use. Adding a small amount of solvent to a clean cup and triggering the gun can clean the fluid passage. Do this with the air cap removed so you can recapture the spent solvent for proper disposal.

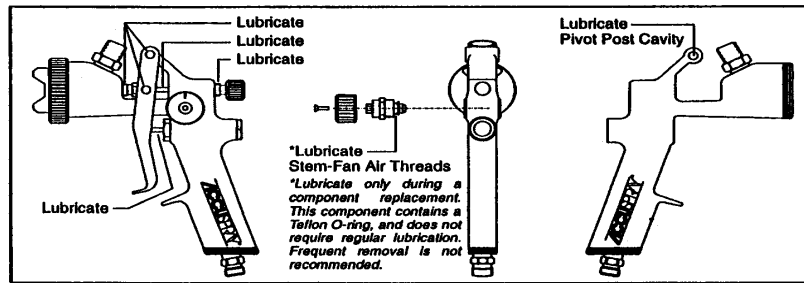
The air cap should be cleaned by soaking or by using a soft brush. Never use a hard tool that may damage the air cap holes. Clean the air cap holes with a wooden tooth pick or pipe cleaner. The smallest amount of damage to the air cap holes can affect the spray pattern.

Your gun and cup may be cleaned in a gun washer by removing the cup and filter, and inverting the gun. Limit the time in a gun washer to a maximum of 5 minutes. Some solvent may enter through the air inlet fitting. This will not damage the gun, and the excess solvent may be blown out with air.

### Cup Cleaning

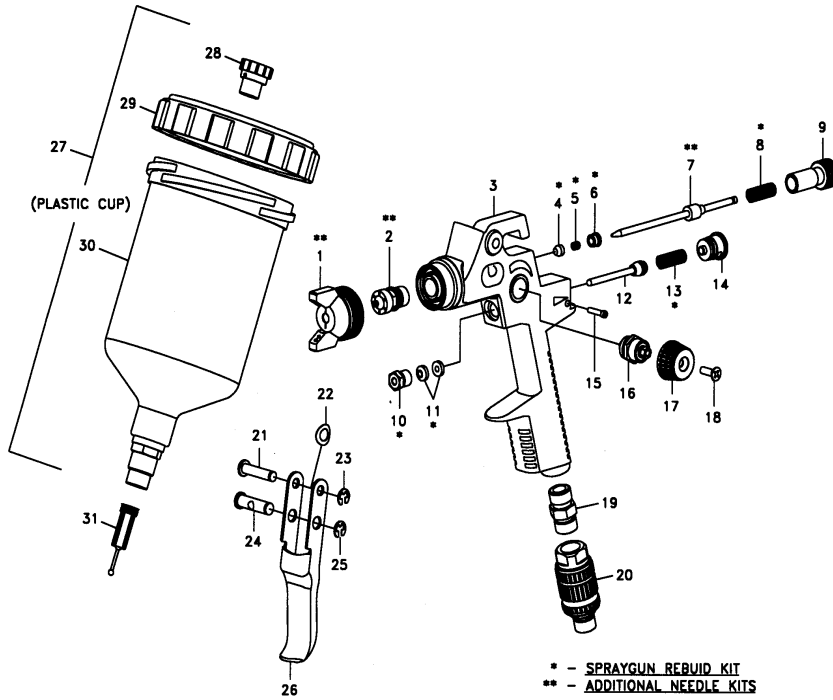
It is also very important to clean your cup after every use. Before removing your cup lid from the cup, be sure to relieving the cup pressure through the relief valve. Unscrew the cup lid and remove the remaining material from the cup. Rinse the cup with a suitable solvent.

**Lubrication** After every cleaning of the gun, you must lubricate the moving components. Cleaning washes away the lubricants that protect the friction points.



**Note:** Spraygun shown may differ slightly for actual PerforMax Spraygun

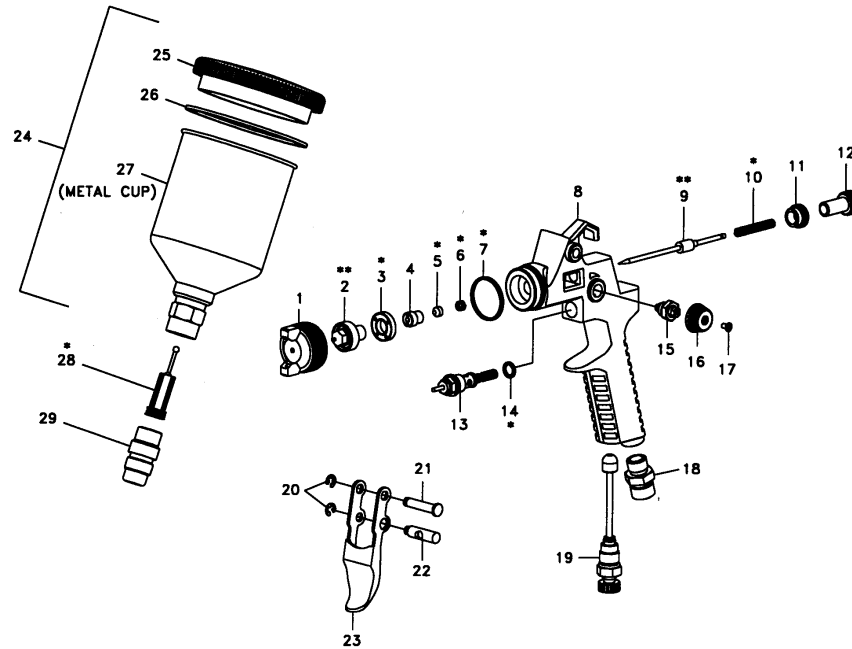
## 05-100 PerforMax Series Parts Identification



ITEM	PART No.	DESCRIPTION
1	**	AIR CAP
2	**	FLUID NOZZLE (1.8mm)
3	97-162	SPRAYGUN HANDLE
4	*	NEEDLE PACKING
5	*	COMPRESSION SPRING
6	*	PACKING NUT
7	**	NEEDLE (1.8mm)
8	*	COMPRESSION SPRING
9	97-116	ADJUSTMENT SCREW
10	*	SEAL NUT
11	*	VALVE STEM SEAL
12	97-170	VALVE STEM ASSEMBLY
13	*	COMPRESSION SPRING
14	97-172	VALVE CAP ASSEMBLY
15	97-173	VALVE CAP LOCKING PIN
16	97-174	FAN AIR ASSEMBLY
17	97-115	FAN AIR KNOB
18	97-175	SCREW
19	97-176	AIR INLET FITTING

ITEM	PART No.	DESCRIPTION
20	97-177	AIR REGULATOR
21	97-178	TRIGGER PIVOT PIN
22	97-187	SPRING WASHER
23	97-179	E-CLIP
24	97-180	TRIGGER PIN
25	97-181	E-CLIP
26	97-114	TRIGGER
27	97-117	GRAVITY CUP AND LID ASSEMBLY
28	97-182	VENT CAP
29	97-183	GRAVITY CUP LID
30	97-188	GRAVITY CUP
31	97-016/5	GRAVITY CUP FILTER
-	97-184	GUN WRENCH
-	97-185	ALLEN WRENCH
-	97-186	CLEANING BRUSH
*	97-118	SPRAYGUN REBUILD KIT
**	97-134/1.5mm	1.5mm NEEDLE KIT
**	97-134/1.8mm	1.8mm NEEDLE KIT
**	97-134/2.0mm	2.0mm NEEDLE KIT

## 05-300 PerforMax Series Parts Identification



\* - SPRAYGUN REBUILD KIT  
 \*\* - ADDITIONAL NEEDLE KITS

ITEM	PART No.	DESCRIPTION
1	97-240	AIR CAP
2	**	FLUID NOZZLE (1.0mm)
3	*	FLUID NOZZLE GASKET
4	97-212	PACKING NUT
5	*	NEEDLE PACKING
6	*	COMPRESSION SPRING
7	*	AIR CAP SEAL
8	97-216	SPRAYGUN HANDLE
9	**	NEEDLE (1.0mm)
10	*	COMPRESSION SPRING
11	97-218	LOCK NUT
12	97-219	ADJUSTMENT SCREW
13	97-220	VALVE STEM ASSEMBLY
14	*	VALVE STEM SEAL
15	97-222	FAN AIR ASSEMBLY
16	97-223	FAN AIR KNOB
17	97-224	SCREW
18	97-225	AIR INLET FITTING

ITEM	PART No.	DESCRIPTION
19	97-226	AIR REGULATOR ASSEMBLY
20	97-227	E-CLIP
21	97-228	TRIGGER PIVOT PIN
22	97-229	TRIGGER PIN
23	97-230	TRIGGER
24	97-231	0.2L GRAVITY CUP ASSEMBLY
25	97-232	GRAVITY CUP LID
26	97-233/2	GRAVITY CUP LID GASKET
27	97-234	0.2L GRAVITY CUP
28	97-016/5	GRAVITY CUP FILTER
29	97-235	FLUID INLET FITTING
-	97-184	GUN WRENCH
-	97-185	ALLEN WRENCH
-	97-186	CLEANING BRUSH
*	97-236	SPRAYGUN REBUILD KIT
**	97-210/0.8mm	0.8mm NEEDLE/NOZZLE KIT
**	97-210/1.0mm	1.0mm NEEDLE/NOZZLE KIT
**	97-210/1.2mm	2.0mm NEEDLE/NOZZLE KIT

## Troubleshooting

<b>Problem</b>	<b>Cause</b>	<b>Remedy</b>
<b>Bad Spray Pattern</b>	Air Cap Clogged	Soak in Thinner
	Nozzle Clogged	Appropriate Solvent
	Bent Fluid Needle	Replace Fluid Needle
<b>Blistering</b>	Moisture on Surface	Clean Surface
	Wrong Solvent	Check Solvent
	Coats Not Compatible	Check Compatability
	Insufficient Dry Time	Longer Dry Time
<b>Fish Eyes</b>	Surface Too Cold	Warm Surface
	Air Contamination	Add Air Filtration
<b>Heavy Middle Pattern</b>	Silicone Contamination	Clean Surface W/ Solvent
	Too Much Pot Pressure	Reduce Fluid Pressure
<b>Intermittent, Pulsating Spray</b>	Not Enough Atomizing Pressure	Increase Atomizing Pressure
	Worn or Loose Packing	Tighten or Replace
<b>Insufficient Fluid Flow, Pressure Feed</b>	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
<b>Coarse or Lumpy Surface</b>	Low Fluid Pressure	Increase Fluid Pressure
	Dirt or Dust on Surface	Tack Wipe Before Spray
<b>Mottled Looking Surface</b>	Material is Contaminated	Change or Strain
	Coating Too Thin	Use Less Thinner
<b>No Paint Flow</b>	Coats Too Wet	Reduce Fluid Flow
	Improper Spray Technique	Hold Gun Parallel to Work
	Clogged Fluid Nozzle	Clean Fluid Nozzle
<b>Orange Peel</b>	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
<b>Overspray is Excessive</b>	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
<b>Pin-holing, Solvent Pops</b>	Viscosity Too Heavy	Reduce with Solvent
	Trapped Solvent	Apply Lighter Coats
	Improper Solvent	Check Coating Mfg.
<b>Paint Leak</b>	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
<b>Tilted Gun</b>	Needle Not Closing	Packing Too Tight. Broken or Missing Needle Spring. Dried Paint on Needle.
		Do Not Tilt While Spraying

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## Troubleshooting-Continued

<b>Problem</b>	<b>Cause</b>	<b>Remedy</b>
<b>Runs and Sags</b>	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

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.

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To order additional copies of this manual, call Accuspray  
Customer Service at 1-800-618-6860  
Fax your request to (440) 498-9815.  
Visit us online at [www.accuspray.net](http://www.accuspray.net).  
Request Literature Number: SM-05-1005

#### LIMITED WARRANTY

Accuspray, (Accuspray Application Technologies, Inc.), warrants all equipment manufactured by and bearing its name to be free from defects in material and workmanship on the date of sale by an authorized Accuspray distributor to the original purchaser for use. As purchaser's sole remedy for breach of this warranty, Accuspray will, for a period of twelve months from the date of sale, repair or replace any part of the equipment proven defective.

This warranty does not cover, and Accuspray shall not be liable for any malfunction, damage, or wear caused by faulty installation, misapplication, abrasion, corrosion, inadequate or improper maintenance, negligence, accident, tampering, or substitution of non-Accuspray component parts. This warranty is conditioned upon the prepaid return of the equipment claimed to be defective for examination to verify the claimed defect.

A complete description of this warranty can be obtained by calling or writing Accuspray.

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