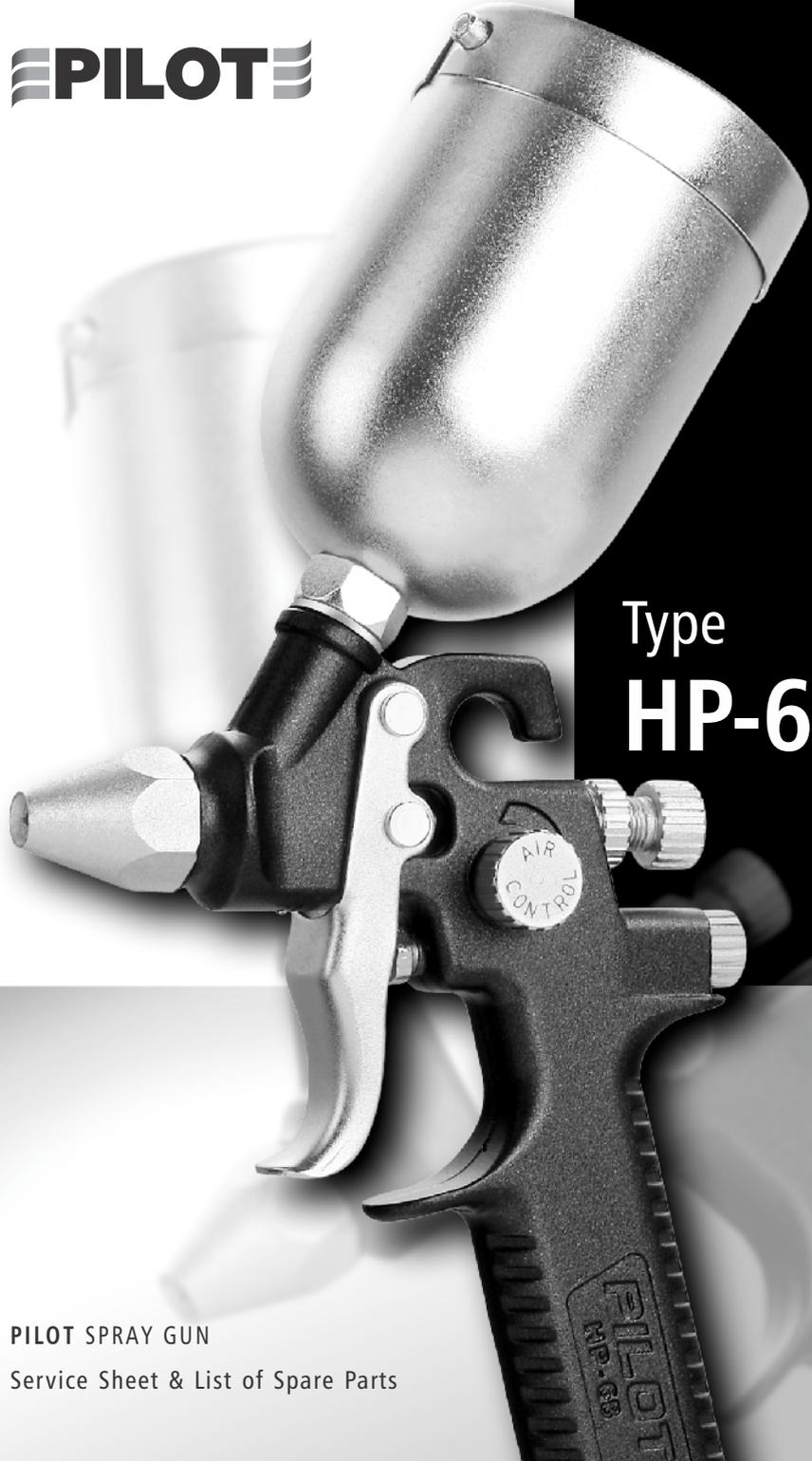




**PILOTE**



Type  
**HP-68**

**CE**  
Conformity to  
European Standards

**PILOTE SPRAY GUN**

Service Sheet & List of Spare Parts

# Dear customer,

Now as you've brought home one of your favourite Pilot spray guns. We'd like to say a special 'thank you'. These precision-engineered tools have been designed to excel, making every spray job the work of a professional.

As you know Pilot has always spelt reliability and safety, earned by 5 decades of experience and overwhelming customer satisfaction. We are certain we have met all safety requirements. Our products bear the identification plate in conformance to the CE ruling.

To facilitate easy understanding of the working procedures please refer to the detailed instruction manual. Along with the manual you will also find a certificate with the declaration of conformity to various amendments.

## Description

Type HP - 68 spray guns are easier to use than most spray guns. These lightweight gravity feed spray guns are suitable for production work on articles of medium or large sizes. They are ideal for spray-painting motorcar bodies, refrigerators, machinery, etc. Perfect balance, comfortable handle and trigger action makes them easy and non-tiring to operate. A knob on the left can easily control round to fan spray of pattern.

These gravity feed spray guns are supplied with a 0.15 lit. gravity cup.

**Important:** These guns are not designed to be used with highly corrosive or highly abrasive coating materials. Violation may increase the need for thorough cleaning and /or the necessity for replacement of parts. If there is any doubt regarding the suitability of a specific material you may seek advise and /or submit a sample for test.

## Safety Warnings

### Fire and Explosion

- Solvents and coating materials can be highly flammable or combustible, especially when sprayed.
- Workstations must be provided with adequate ventilation / exhaust to prevent the build up of flammable vapors.
- Smoking and naked flames must not be allowed in the spraying or mixing areas.
- Fire extinguishing equipment must be provided in the spraying and mixing areas.
- Users must comply with all local and national codes of practice and insurance company requirements governing ventilation, fire precautions, operation, maintenance and housekeeping of work stations.

**Halogenated hydrocarbon solvents** for example 1,1,1 Trichloroethane and Methylene Chloride can chemically react with aluminum and galvanized or zinc coated parts and cause an explosion hazard. Read the label and data sheet of the material you intend to spray.

**Do not use solvents or coating materials containing halogenated hydrocarbons with this equipment.**

**Static Electricity** is generated by fluid moving through pipes and hoses. A static spark, Capable of igniting certain solvents and coating materials could be produced by high fluid flow rates. To prevent the risk of fire or explosion, earth continuity to the spray equipment and object being sprayed should be maintained.

## Personal Protective Equipment

Toxic Vapours when sprayed, certain material may be poisonous, create irritation or otherwise be harmful to health. Always read carefully all labels and safety / performance data for the material being sprayed and follow any recommendation.

### **If in doubt, consult the material supplier.**

- The use of respiratory protective equipment is recommended at all times when spraying. The type of respiratory protective equipment used must be compatible with the material being sprayed and the level of concentration.
- Always wear eye protection when spraying or cleaning the equipment.
- Gloves must be worn for spraying or cleaning the equipment when certain coating materials and solvents are used.

### **Training**

Personnel should be given adequate training in the safe use and maintenance of this equipment. Training courses on all aspects of the equipment are available. For details contact your local representative. The instructions and safety precautions contained in this literature and the literature supplied with the coating material should be read and understood before the equipment is used.

### **Misuse**

- All spray guns project particles at high velocity and must never be aimed at any part of the body.
- Never exceed the recommended safe working pressures for any of the equipment used.  
The fitting of non-recommended or non-original accessories or spare parts may create hazardous conditions.
- Before dismantling the equipment for cleaning or maintenance, all pressures, air and material, must be isolated and released.

The disposal of non-metallic materials must be carried out in an approved manner. Burning may generate toxic fumes. The removal of waste solvents and coating materials should be carried out by an authorized local waste disposal service.

The materials used in the construction of this equipment are (bearing in mind the warning on Halogenated Hydrocarbons) solvent resistant enabling the equipment to be cleaned using gun washing machines. However, this equipment must not be left inside the gun washing machine for prolonged periods of time after the automatic cleaning cycle has been completed. The solvents used in the gun washing machine should be regularly checked to ensure that the equipment is not flushed through with contaminated material. Follow the recommendations of the machine manufacturer.

### **Noise Levels**

The continuous A-weighted sound pressure level of this spray gun may exceed 85 dB (A) depending on the air cap/nozzle set-up being used. Sound levels are measured using an impulse sound level meter and analyzer, when the gun is being used in a normal spraying application. Details of actual noise levels produced by the various air cap/nozzle set-ups are available on request.

### **Installation**

**Important:** To ensure that this equipment reaches you in first class condition, protective coatings, rust inhibitors, etc. have been used. Flush all equipment through with a suitable solvent before use to remove these agents from the material passages.

Attach the air supply line to the air intake connector (26). An air transformer installed as close as possible to the gun will provide filtered and regulated air.

## **Recommended Air Hose Sizes:**

### **Attached air hose connector from a filtered regulated air supply.**

Recommended air supply hose size up to 10 meters long (1/4") bore.

Attach the gravity feed cup to the material inlet and ensure that the sealing washer is compressed.

## **Operation**

Mix, prepare and strain the coating material to be sprayed according to the paint manufacturers instructions. Use a lint free mesh to strain the material.

- Fill the gravity feed cup with the material. Do not overfill. Ensure that the vent hole in the cup lid is clear.
- Adjust the atomizing air pressure to 1-2.5 kgs/sq.cm. (14 to 36 p.s.i.).  
It requires air about (2 - 4 c.f.m.) 55 - 115 liter per minute depending on the liquid to be sprayed.
- Close the fluid needle adjusting screw by turning clockwise.
- Turn on the air at the source of supply and spray test area by turning the fluid needle adjusting screw counter-clockwise until a full coat is obtained.

In the finish is too sandy and dry, reduce the viscosity of the coating material supply by turning the adjusting screw counter-clockwise.

Increasing or decreasing the atomizing air pressure can also correct both the above. The most efficient atomizing air pressure is the lowest possible air pressure that will give the desired effect.

The gun should be held perpendicular to the spray surface at all times. Do not arc the gun as this produces an uneven coat of paint. The recommended spraying distance is between 230mm (9").

## **Preventive Maintenance**

### **Cleaning**

Turn off air supply and release pressure.

Empty surplus coating material from cup and clean.

Remove air cap and clean by immersing in solvent, brush or wipe clean. If any holes in the air cap are blocked use a toothpick or broom straw to remove the obstruction. Never use a steel wire or hard implement which will damage the air cap and result in a distorted pattern.

### **Lubrication**

Lubricate all moving parts daily with a few drops of light oil and occasionally place a light coating of Vaseline on the needle spring. The packing may need to be oiled occasionally to keep them pliable.

### **Replacement of Parts**

Fluid Needle (6)

1) Remove needle adjusting screw (9), spring (7) and needle (6). Replace any worn or damaged parts ensuring that the fluid needle seats correctly in the fluid tip then adjust packing with needle packing nut (3) so that the movement of the needle is not restricted.

#### **Needle Packing (4)**

Remove fluid needle as 1 above.

2) Remove air cap (1) Nozzle (2)

3) Remove needle packing nut (3) and packing (4) replace any worn or damaged parts and re-assemble.

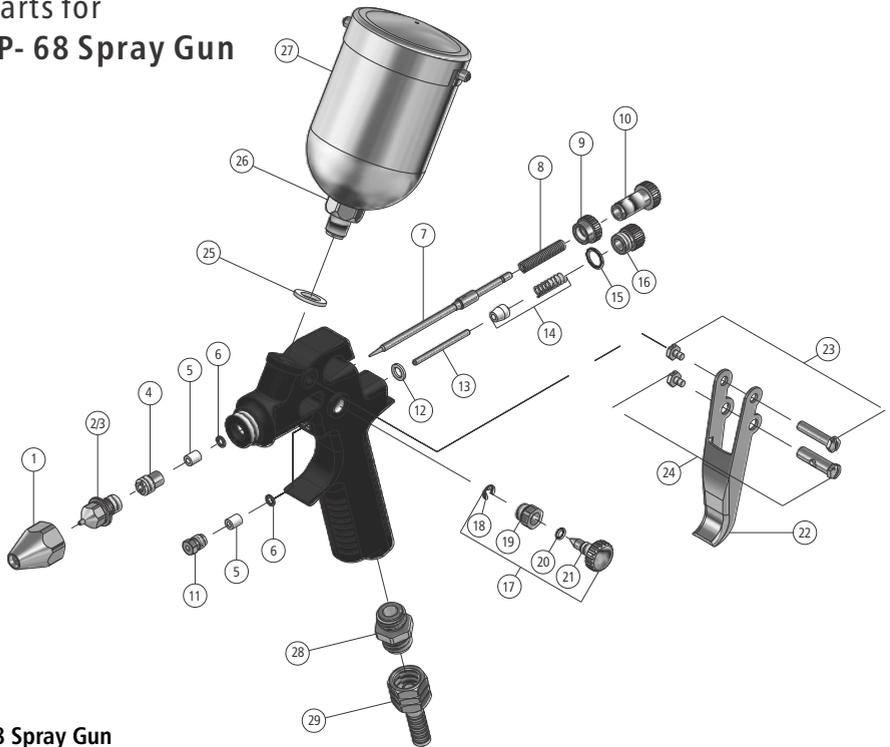
Reversing steps (1) to (3) adjust packing so that the movement of the needle is not restricted.

#### **Air Piston Head Complete (13) and Teflon Seal (12)**

4) Remove plug (14), replace any worn or damaged parts and re-assemble.

Remove fluid needle as (1) above, remove trigger (21) by unscrewing (19, 20) and remove trigger pin (10) and Teflon packing for trigger pin (12) replace any worn or damaged parts and re-assemble.

# Spare Parts for Type HP- 68 Spray Gun



## Type HP-68 Spray Gun

### List of Spare Parts HP 68

Sr. No.	Description	Code No.
	Spray Gun Type HP - 68 Gun With S.S Cup 0.14 Litre	HP 68000S
1	Air Cap	HP 68001
2	M.S. Nozzle	HP 68002
3	S.S. Nozzle	HP 68003
4	Needle Packing Nut	HP 68004
5	Packing Bush Set	HP 68005
6	Needle Packing Nut Washer	HP 68006
7	Needle Valve	HP 68008
8	Needle Spring	HP 68009
9	Needle Locking Nut	HP 68010
10	Needle Adjusting Screw	HP 68011
11	Air Valve Nut	HP 68012
12	Air Valve Pin Washer	HP 68013
13	Air Valve Pin Shaft	HP 68014
14	Air Piston Head Complete	HP 68015
15	Plug "O" Ring	HP 68016
16	Plug	HP 68017
17	Spreader Control Assembly	HP 68018

Sr. No.	Description	Code No.
18	E Clip	HP 68018A
19	Spreader Control Housing	HP 68018B
20	Spreader Control "o" Ring	HP 68018C
21	Spreader Control Valve	HP 68018D
22	Trigger	HP 68019
23	Fulcrum Screw	HP 68020
24	Trigger Screw	HP 68021
25	Nylon Cup Washer	HP 68022A
26	Cup Bottom Part	HP 68022B
27	S.S Top Feed Cup 0.14 Litre	HP 68022
28	Air Intake Connector	HP 68023
29	Hose Coupling	HP 68024
30	M.S Repair Kit	HP68080M
31	S.S Repair Kit	HP68080S

# Accessories

\* This Set Contains An Air Cap, Nozzle, Needle, Air Valve Pin & Packing.

@ Please Mention Nozzle Size While Ordering Spare Parts.

# Service Checks

## Troubleshooting

Fault	Cause	Remedy
<b>Not spraying</b>	<ol style="list-style-type: none"><li>1. No pressure at the gun</li><li>2. Needle adjustment Screw not properly adjusted.</li></ol>	<ol style="list-style-type: none"><li>1. Check air supply</li><li>2. Adjust</li></ol>
<b>Uneven spray</b> 	<ol style="list-style-type: none"><li>1. Material build up on air cap/nozzle</li><li>2. Coating material flow or viscosity incorrect</li></ol>	<ol style="list-style-type: none"><li>1. Clean air cap / nozzle</li><li>2. Adjust needle adjustment screw, or Reduce viscosity</li></ol>
<b>Intermittent spray</b> 	<ol style="list-style-type: none"><li>1. Insufficient material in cup</li><li>2. Gun material passage blocked</li><li>3. Loose or damaged nozzle</li><li>4. Needle sealing damage.</li></ol>	<ol style="list-style-type: none"><li>1. Fill cup</li><li>2. Clean</li><li>3. Tighten or replace</li><li>4. Replace</li></ol>
<b>Fluid leakage from packing nut</b>	<ol style="list-style-type: none"><li>1. Needle packing damage</li></ol>	<ol style="list-style-type: none"><li>1. Replace packing.</li></ol>
<b>Dripping from the nozzle</b>	<ol style="list-style-type: none"><li>1. Damaged nozzle or needle</li><li>2. Foreign substances between fluid tip and needle prevent sealing</li></ol>	<ol style="list-style-type: none"><li>1. Replace</li><li>2. Clean needle and nozzle in thinner or Replace.</li></ol>

Manufactured by :

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