

**PILOT SPRAY GUN**  
Service Sheet & List of Spare Parts



Type  
**64**

**CE**  
Conformity to  
European Standards

## Dear customer,

Now as you've brought home one of your favorite 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 stands for quality, reliability and safety, earned by 6 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.**

## Description

Type - 64 spray guns are easier to use than most spray guns. These lightweight gravity feed spray guns are suitable for production work on articles of small or medium 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.

These gravity feed spray guns are supplied with a 0.34 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 advice and /or submit a sample for test.

## 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.

## 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 compressor installed should be close as possible to the gun and should provide filtered and regulated air. Recommended air supply hose size up to 10meters 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 manufacturer's 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 2.1 - 2.8 kgs/sq.cm. (30 to 40p.s.i.).
- It requires air about (4 - 6 c.f.m.) 113 - 170 liter per minute depending on the liquid to be sprayed.
- Close the needle adjusting screw by turning clockwise.
- Turn on the air at the source of supply and spray test area by turning the needle adjusting screw counter-clockwise until a full coat is obtained.
- If the finish is too sandy and dry, reduce the viscosity of the coating material supply by turning the needle 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 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

### 1) Needle Valve (8)

- Remove needle adjusting screw (11), needle spring (10) needle spring box (9) and needle valve (8). Replace any worn or damaged parts ensuring that the needle valve seats correctly in the nozzle then adjust packing with needle packing nut (7) so that the movement of the needle is not restricted.


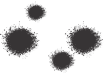



### 2) Packing Bush (6)

- Remove needle valve (8) as 1 above.
- Remove trigger (21) and link (17) by unscrewing (19, 20) and nut (18).
- Remove needle packing nut (7) and packing bush (6). Replace any worn or damaged parts and re-assemble, reversing steps 1 to 2. Adjust packing so that the movement of the needle is not restricted.

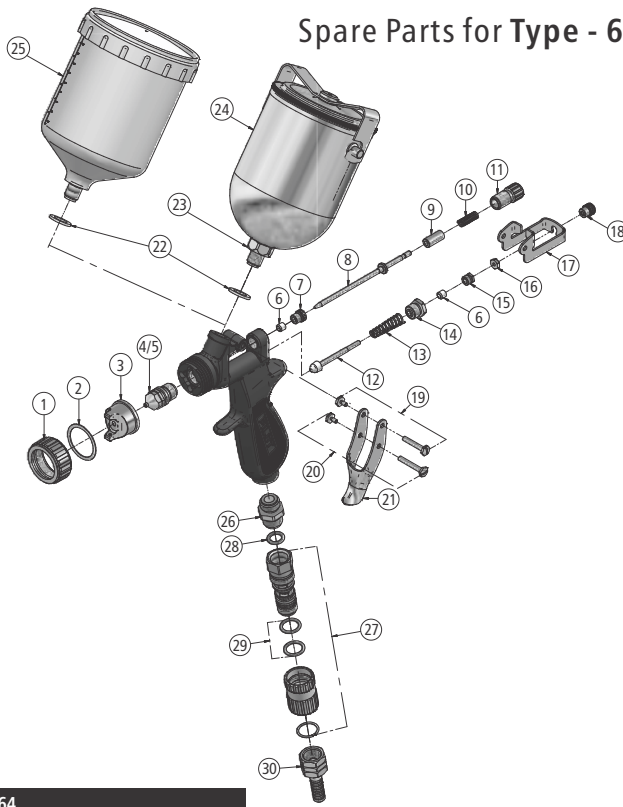
### 3) Air Valve Pin (12) Packing Bush (6)

- Remove needle valve (8) as 1 above.
- Remove air valve locking nut (18), pull trigger (21) and swing link (17) away, unscrew air valve packing box (14) and remove air valve spring (13), air valve pin (12), washer (15 & 16) and packing bush (6). Replace any worn or damaged parts and re-assemble reversing step 3.

## Service Checks - Troubleshooting

Fault	Cause	Remedy
<b>Not spraying</b> 	1. No pressure at the gun 2. Needle Adjusting Screw not properly adjusted.	1. Check air supply 2. Adjust
<b>Uneven spray</b> 	1. Material build up on air cap/nozzle 2. Coating material flow or viscosity incorrect	1. Clean air cap / nozzle 2. Adjust needle adjustment screw, or Reduce viscosity
<b>Intermittent spray</b> 	1. Insufficient material in cup 2. Gun material passage blocked 3. Loose or damaged nozzle 4. Needle sealing damage.	1. Fill cup 2. Clean 3. Tighten or replace 4. Replace
<b>Fluid leakage from packing nut</b> 	1. Needle packing damage	1. Replace packing.
<b>Dripping from the nozzle</b> 	1. Damaged nozzle or needle 2. Foreign substances between nozzle and needle prevent sealing	1. Replace 2. Clean needle and nozzle in thinner or Replace.

# Spare Parts for Type - 64 Spray Gun



## Type 64 Spray Gun

### List of Spare Parts Type 64

Sr. No.	Description	Code No.
	<b>Spray Gun Type - 64 With</b>	
	<b>S.S. Top Feed Cup 0.34 Litre</b>	<b>64000S</b>
	<b>Spray Gun Type - 64 With</b>	
	<b>Plastic Top Feed Cup 0.34 Litre</b>	<b>64000N</b>
1	Air Cap Locking Nut	64001
2	Air Cap Washer	64002
3	Air Cap	64003
4	M.S Nozzle	64004
5	S.S Nozzle	64005
6	Packing Bush	64007
7	Needle Packing Nut	64008
8	Needle Valve	64009
9	Needle Spring Box	64010
10	Needle Spring	64011
11	Needle Adjusting Screw	64012
12	Air Valve Pin	64013
13	Air Valve Spring	64014
14	Air Valve Packing Box	64015
15	Air Valve Packing Box Washer	64016
16	Air Valve Washer	64017

Sr. No.	Description	Code No.
17	Link	64018
18	Air Valve Locking Nut	64019
19	Fulcrum Screw	64020
20	Trigger & Link Screw	64021
21	Trigger	64022
22	Nylon Cup Washer	64023A
23	Cup Bottom Part	64023B
24	S.S Top Feed Cup 0.34 Litre	64023
25	Plastic Top Feed Cup 0.34 Litre	64024
26	Air Intake Connector	64025
27	Air Control Valve	64026
28	Air Intake O Ring	64026A
29	Air Control Body O Ring Small	64026D
30	Hose Coupling	64027
31	M.S. Repair Kit	64080M
32	S.S. Repair Kit	64080S

# Accessories

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

@ Please Mention Nozzle Size While Ordering Spare Parts.

Manufactured by :

**Manik Machinery Manufacturers Pvt. Ltd.**

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