PILOT

Type P-70

PILOT SPRAY GUN

Service Sheet & List of Spare Parts

CE

Conformity to
European Standards

Description

Type - P-70 spray guns are easier to use than most spray guns. These lightweight suction 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 back can easily control round to fan spray of pattern.

These suction feed spray guns are supplied with a 1 lit. suction 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 contract 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 (25). 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 suction 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 suction 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 2.5 -5.0 kgs/sq.cm. (14 to 72 p.s.i.).

  It requires air about (7 - 10 c.f.m.) 200 - 283 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.

If 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 and 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

Needle Valve (20)

1. Remove needle adjusting screw (22), spring (21) and Needle Valve (20). Replace any worn or damaged parts ensuring that the fluid needle seats correctly in the fluid tip then adjust packing with needle packing nut (8) so that the movement of the needle is not restricted.

Needle Packing Bush (7)

Remove fluid needle as 1 above.

2. Remove trigger (23) by unscrewing Washer & Screw (23/24)

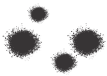
3. Remove Needle packing nut (8) and packing Bush (7). Replace any worn or damaged parts and re-assemble, reversing steps 1 to 3. Adjust packing Bush so that the movement of the needle is not restricted.

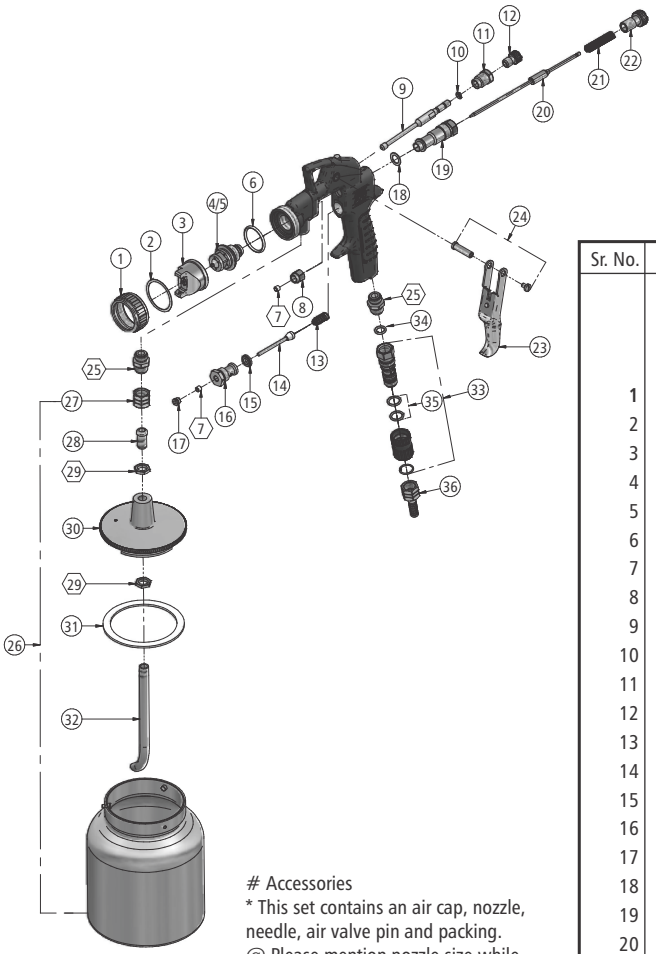
Air Valve (14) Packing Bush (7)

Remove fluid needle as 1 above.

4.Remove air valve body (16), pull trigger (23) unscrew air valve packing box washer (17) and remove spring (13), air valve pin (14), and packing (7). Replace any worn or damaged parts and re-assemble reversing steps 1 and 4.

Service Checks - Troubleshooting

Fault	Cause	Remedy
Not spraying 	1. No pressure at the gun 2. Needle Adjusting Screw not properly adjusted.	1. Check air supply 2. Adjust
Uneven spray 	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
Intermittent spray 	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
Fluid leakage from packing nut 	1. Needle packing damage	1. Replace packing.
Dripping from the nozzle 	1. Damaged nozzle or needle 2. Foreign substances between fluid tip and needle prevent sealing	1. Replace 2. Clean needle and nozzle in thinner or Replace.



Accessories
* This set contains an air cap, nozzle, needle, air valve pin and packing.
@ Please mention nozzle size while ordering spare parts.

Spare Parts for
Type - P-70 Spray Gun

Sr. No.	Description	Part No.
	Spray Gun Type P - 70 with Bottom Feed Cup 1 Litre	**70000**
	Spray Gun Type P - 70 without Cup	**70000WC**
1	Air Cap Locking Nut	70001
2	Air Cap Washer	70002
3	Air Cap	70003
4	M.S. Nozzle	70004
5	S.S. Nozzle	70005
6	Nozzle Gasket	70006
7	Packing Bush Set	70008
8	Needle Packing Nut	70009
9	Spreader Control Spindle Shaft	70012
10	Spreader Control Spindle O Ring	70013
11	Spreader Control Knob Guide	70014
12	Control Knob	70015
13	Air Valve Spring	70016
14	Air Valve Pin	70017
15	Air Valve Body Packing Bush	70018
16	Air Valve Body	70019
17	Air Valve Packing Box Washer	70020
18	Needle Cylinder Packing Washer	70021
19	Needle Cylinder	70022
20	Needle Valve	70023
21	Needle Spring	70024
22	Needle Adjustment Screw	70025
23	Trigger Assembly	70026
24	Trigger Screw	70028
25	Air Intake Connector	70029
26	Suction Feed Cup 1 Litre	70030
27	Coupling Nut	70030A
28	Connection Nipple	70030B
29	Connection Nut	70030C
30	Cup Lid	70030D
31	Packing Washer	70030E
32	Fluid Tube	70030F
33	Air Control Valve	70031
34	Air Intake O Ring	70031A
35	Air Control Body O Ring Small	59031D
36	Hose Coupling	70032
37	M.S. Repair Kit	70080M
38	S.S. Repair Kit	70080S

Manufactured by :

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