



AIR CAP AND FLUID NOZZLE CHART

MODEL NO.	AIR CAPS	Press / Siphon	*MAX GUN INLET PRESS. FOR HVLP	SCFM @ MAX GUN INLET	AIR CAP RING	AVAILABLE FLUID NOZZLES TIPS	NEEDLES / marking on needle
AM CPR	23-2101	pressure	29	11	23-0102 (Included)	33-0208 0.8mm (.022")	40-AM308 (308)
						33-0210 1.0mm (.040")	40-AM310 (310)
						33-0212 1.2mm (.046")	40-AM312 (312)
						33-0213 1.3mm (.052")	40-AM313 (313)
						33-0214 1.4mm (.055")	40-AM314 (314)
	23-1302	pressure	45*	13.5	23-0101 (Included)	33-0215 1.5mm (.059")	40-AM315 (315)
						33-0217 1.7mm (.070")	40-AM317 (317)
						33-0219 1.9mm (.075")	40-AM319 (319)
						33-0222 2.2mm (.086")	40-AM322 (322)

*Note: Air cap test gages are available to confirm HVLP compliance.

Operation and Maintenance Instructions for *AM* CPR Spray Guns

Needle seal replacement

Needle (16) replacement:

1. Remove fluid control knob (24) and locknut (23)
2. Remove spring seat (22) and needle return spring (21).
3. Needle can be pulled out of the back of the gun.

Needle seal (8) replacement:

1. Remove fluid needle (16) as described above.
2. Remove rear cap (20), needle stop sleeve (19) and piston spring (18).
3. Remove piston (14).
4. Remove air spool (11) using an 3/4" socket wrench.
5. Needle seal assembly (8) can be removed from the air spool using a 3/8" wrench. Note: replacement needle seal includes o-ring. Inspect the air spool o-rings (items 6, 9, 10) for damage and replace if necessary.

NOTE: Gun head disassembly is not recommended for normal cleaning and maintenance.

Disassembly and reassembly:

Before beginning complete gun disassembly, it is recommended repair kit 10-146 be on hand.

Follow the needle seal replacement procedure before gun head disassembly and reassembly procedures.

Gun head disassembly:

1. Remove air cap (1) and fluid orifice (2).
2. Remove 2 o-rings (27). Using a 3/16" hex wrench remove the fluid inlets (26). Nozzle carrier (4) can be pushed out from the back of the gun body. Note: If the gun is not a recirculating gun, one of the fluid inlets will be blanked. It is essential to return blanked inlet to the same position on reassembly.

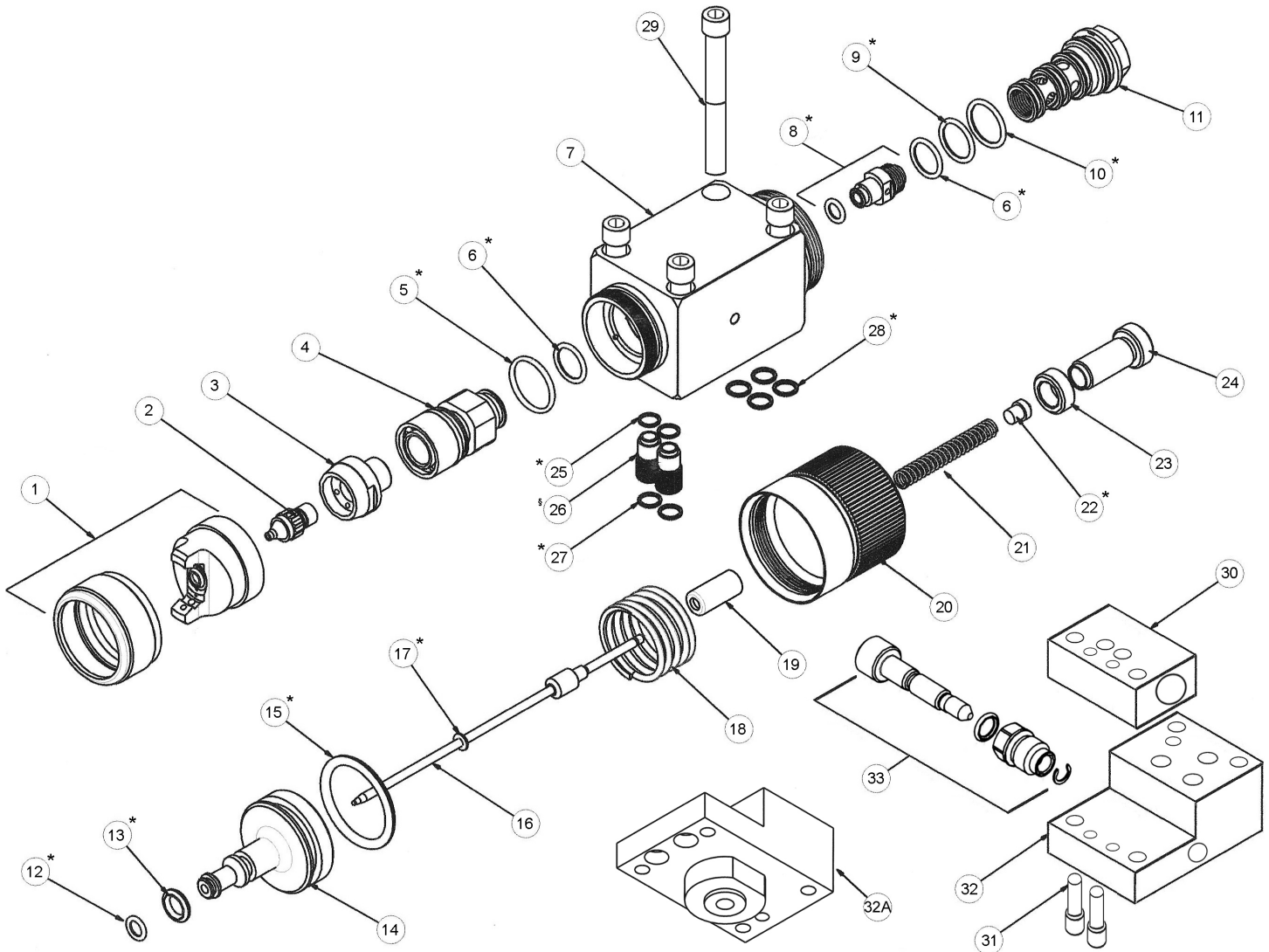
Gun head reassembly:

1. Install new o-rings (5) and (6) on nozzle carrier (4) and insert into gun body. Rotate nozzle body until fluid inlets align with the threaded fluid inlets in the gun body (7).
2. Install new fluid inlet seals (25) on the fluid inlets (26). Screw fluid inlets into gun body. Fluid inlets will thread in easily below gun body surface if nozzle body is properly aligned. Tighten each inlet down evenly to approx. 75 in -lbs torque. Both fluid inlets should be 1/16" below gun body surface.

Gun back end reassembly:

Note: Lubricate all new viton o-rings during installation.

1. Install new o-rings (6), (9), (10) and a new needle seal (8) onto air spool (11).
2. Install air spool (11) into gun body (7) and tighten to approx. 100 in-lbs torque.
3. Install new o-rings (12) and (15) on piston (14). Push piston into back of air spool.
4. Install new o-ring (17) on needle assembly (16). Push needle assembly through piston as far forward as possible.
5. Install piston spring (18), needle stop sleeve (19) and rear cap (20).
6. Install needle return spring (21), spring seat (22) and fluid control knob assembly (23 & 24).



ITEM NUMBER	QTY	PART NUMBER	DESCRIPTION	ITEM NUMBER	QTY	PART NUMBER	DESCRIPTION
1	1	See Air Cap Chart	Air Cap Assembly	19	1	60-715	Needle Stop Sleeve
2	1	See Air Cap Chart	Fluid Nozzle Tip	20	1	60-704	Rear Cap
3	1	33-1201	Fluid Nozzle Body	21	1	60-204	Needle Return Spring
4	1	60-702	Fluid Nozzle Carrier	22	1	60-205	Spring Seat*
5	1	98-7018	O-Ring*	23	1	60-612	Locknut
6	2	98-7014	O-Ring*	24	1	60-608	Fluid Control Knob
7	1	60-701	Gun Body	25	2	66-254	Fluid Seal*
8	1	60-710	Needle Seal Assembly*	26	2	66-253	Fluid Insert §
9	1	98-7015	O-Ring*			66-253-B	Fluid Insert Blank §
10	1	98-7016	O-Ring*	27	2	98-8010	O-Ring*
11	1	66-255	Air Control Spool	28	4	98-7011	O-Ring*
12	1	98-8010	O-Ring*	29	4	98-0290	Mounting Screw
13	1	98-7109	O-Ring*	30	1	66-267	Fluid Manifold Block
14	1	66-257	Piston	31	2	98-0249	Allen Screw
15	1	98-7217	O-Ring*	32	1	66-266	Air Manifold Block (Standard)
16	1	See Air Cap Chart	Fluid Needle	32A	1	66-268	Air Manifold Block (Cefla®)
17	1	98-7006	O-Ring*	33	1	66-258	Fan Control Assembly
18	1	66-246	Piston Spring				

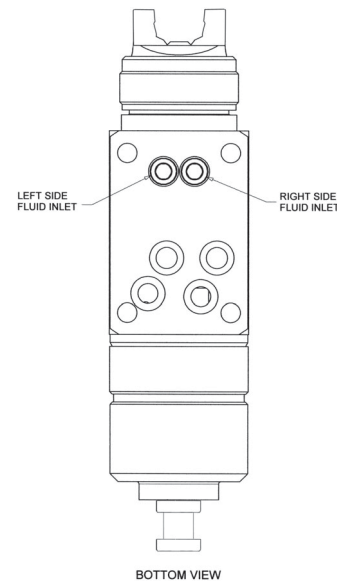
*Indicates items included in repair kit P/N 10-146

§ See page 4 for explanation on possible gun assembly variations

The AM CPR guns can be configured for fluid circulation through the head or non-recirculation with fluid inlet from either side of manifold.

For fluid circulation through the head, both left and right fluid inlet ports have p/n 66-253 installed. Inlet fluid can be introduced from either side of manifold.

For non-recirculating guns, either the left or right inlet port must be blocked by p/n 66-253-B. Inlet fluid to the manifold will depend on which gun port is blocked. If the left gun port is blocked, the fluid inlet to manifold would be on right and vice versa.



HAZARD WARNINGS

General Safety

The AM CPR gun is intended to be used by professional personnel only. Everyone using this equipment should read and understand all safety warnings.

Do not exceed the maximum working pressure of this equipment.

Do not modify this equipment.

Always relieve fluid pressure to 0 psi before performing maintenance.

Make sure all fluid connections are tight before operating this equipment.

Toxic Fume and Fluid Hazard

Inhalation of toxic fumes and skin exposure to some chemicals can be a serious health hazard.

Read all manufacturers information for the material being sprayed, including material safety data sheets (MSDS sheets) and warnings.

Be sure recommended protective clothing and eye protection are used.

Wear a respirator or particle mask appropriate for material being sprayed.

Store all materials and solvents in accordance with manufacturers recommendations and local, and state safety codes.

Possible Fire or Explosion Hazard

Static sparks can cause fire or explosion.

DO NOT operate this equipment near pilot lights, open flames or anyone smoking.

Keep spray area clear and free of combustible debris.