

# Paasche®

## A-C2F-4-10/-2-8/-0-9 A-C2R-4-6/-2-5

### Automatic Spray Guns

#### OPERATING INSTRUCTIONS & REPLACEMENT PARTS

**DESCRIPTION:** The Automatic Spray Gun is an actuated production spray gun, it includes Stainless Steel Tip and Needle for abrasive material. See Page 2 for spray head options.

**CONNECTIONS:** Spray Gun has the following: Air inlet 1/4" N.P.T (F) and Fluid inlet 3/8" N.P.T. (M).

**PACKING WASHERS:** Packings are available in PTFE for natural lubricity and higher temperatures. See Page 2.

#### OPERATION:

1. Mount Spray Gun in desired position.
2. Blow out all hoses (airlines) before connecting to Spray Gun to remove foreign particles.
3. Connect hose from air supply to air inlet fitting.
4. Connect fluid supply to fluid inlet.
5. Tighten all hose connections securely.
6. Adjust air pressure to desired amount at the Air Regulator.
7. Adjust Fluid volume by turning the Fluid Adjusting Knob to the left or right. **Note: Do not use as shutoff by turning all the way down, it may split the tip.**
8. Adjust to proper fan pattern by turning the Fan Control Screw to left or right.

#### TIP REPLACEMENT:

1. Turn off Air and Fluid Pressure.
2. Release Fluid Needle pressure from seat of Tip by taking off the Cylinder Cap Assembly.
3. Loosen Aircap Nut and remove Multiplehead Assembly. Leave Needle in place.
4. Unscrew Tip and place new Tip in position.
5. To reassemble reverse above procedure.

**MAINTENANCE:** Requirements of the Automatic Spray Gun have been reduced to a minimum. The leather packing washers should be lubricated with light oil or replaced once a month. Old packing washers cause leakage of air and Fluid. PTFE Packings are self-lubricating.

**CLEANING:** After each use flush clean solvent through the fluid passages of the Spray Gun and Wipe off the outside with clean solvent. Never leave the entire Spray Gun immersed in solvent. Dirty Aircaps and Tips should be cleaned by soaking in solvent and blown clean with air.

#### TROUBLE SHOOTING SPRAY PATTERNS:

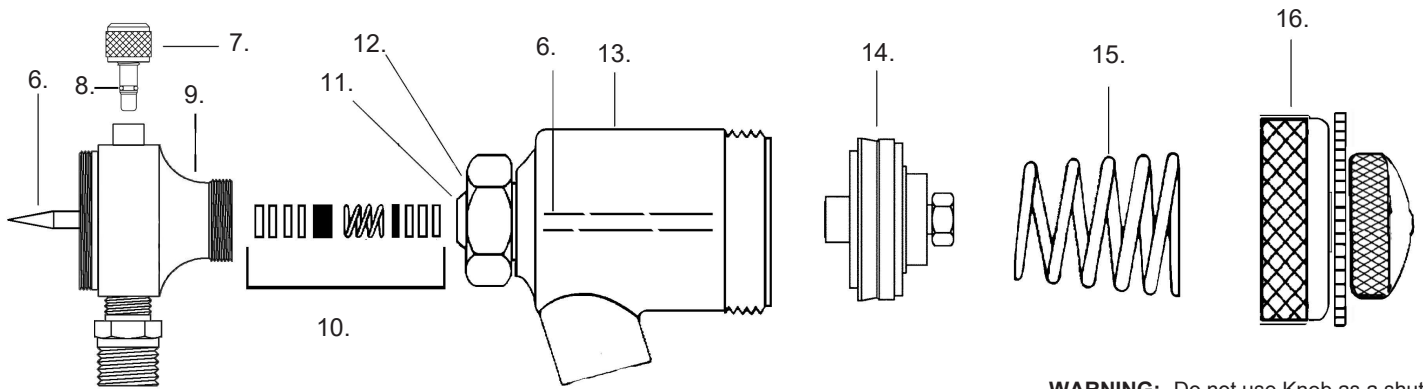
**WARNING:** Spray materials may be harmful if inhaled or allowed to come into contact with the skin or eyes. Consult the product label and Material Safety Data Sheet supplied for the spray material. Follow all safety precautions.  
**CAUTION:** Well Ventilated Area Required to remove fumes, dust or overspray. Secure airhose and fluid hose wrench tight for safety and to prevent leaks.  
**Maximum Air Pressure 100 P.S.I.**  
**Maximum Fluid Pressure 45 P.S.I.**

- (A) A **ROUGH OR STIPPLED FINISH** is caused by low or restricted flow of air pressure or too heavy materials being applied with gun too close to surface.
- (B) A **WET OR SAGGING FINISH** is due to low air pressure or restricted flow of air, material being too thin, or applied too close to the surface.
- (C) A **SPUTTERING SPRAY** is caused by air leaking into fluid line or can be caused by a loose fluid tip, a broken or split tip, lumpy material, a clogged vent hole in cover of material cup, or air leak at fluid pipe attached to inside of tank cover, or a clogged paint strainer. Sputtering may also be caused by worn packing washers, or worn or scored needle.  
**TO CORRECT:** Tighten tip securely or replace. Strain material and clean strainer. Tighten fluid pipe in tank or replace packings and needle in Spray Gun.
- (D) AN **ARCHED FAN SPRAY PATTERN** is caused by dried material accumulated in one fan port of the multiplehead, distorting the pattern.  
**TO CORRECT:** Dissolve material inside fan port with suitable solvent applied with a small brush.  
**NOTE: Never use wire or sharp instruments to clean Fan Ports as permanent damage to the fan ports will result in destroying uniformity of the Fan Pattern.**
- (E) **UNBALANCED FAN SPRAY PATTERN**, heavy on one side, may be caused by material collecting around outside of the fluid tip and aircap, or by a loose aircap.  
**TO CORRECT:** Remove aircap and clean fluid tip and aircap with solvent then dry with air. Always be sure fan aircap and aircap body are tightened securely.
- (F) A **HEAVY CENTER** in a fan pattern is caused by insufficient air pressure at the fan port. Rough or shady edges are also caused by low air pressure.  
**TO CORRECT:** Increase air line pressure.
- (G) A **SPLIT FAN SPRAY PATTERN**, heavy on each end and light in the center, is caused by excessive air pressure.  
**TO CORRECT:** Reduce air pressure.

SPRAY PATTERNS:



Paasche Airbrush Company  
9511 58th Place  
Kenosha, WI 53144  
Phone: (800) 621-1907  
Website: paascheairbrush.com  
E-Mail: info@paascheairbrush.com



**WARNING:** Do not use Knob as a shut-off by turning all the way down - it will split the tip.

- |     |               |  |     |                |                       |
|-----|---------------|--|-----|----------------|-----------------------|
| 6.  | <b>A-U-4L</b> | Stainless Steel Needle                 | 12. | <b>U-3632</b>  | Small "O" Ring        |
| 7.  | <b>U-3651</b> | Fan Control Screw<br>(Includes O-Ring) | 13. | <b>U-1907B</b> | Shell                 |
| 8.  | <b>3A-4</b>   | O-Ring (1) (6 Pack)                    | 14. | <b>U-3656</b>  | PTFE Piston           |
| 9.  | <b>C-31</b>   | Fluid Body                             | 15. | <b>U-2966</b>  | Piston Spring         |
| 10. | <b>U-3502</b> | Packing Set                            | 16. | <b>U-2686A</b> | Cylinder Cap Assembly |
| 11. | <b>U-3633</b> | Large "O" Ring                         |     |                |                       |

**ROUND PATTERN**

- **Application:** Standard Spray
- **Sizes:** 2-5(.73) & 4-6(.93)
- **Fluid Viscosity:** Light to Medium (3 to 6 C.F.M. @ 40 P.S.I.)

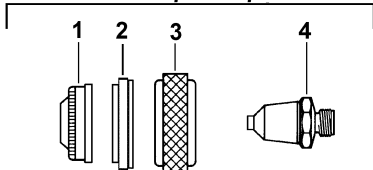
- |    |               |  |
|----|---------------|--|
| 1. | <b>56RA-</b>  | Aircap Body (Select Size above)        |
| 2. | <b>U-3707</b> | Sleeve PTFE                            |
| 3. | <b>U-1649</b> | Aircap Nut                             |
| 4. | <b>U-</b>     | Stainless Body Tip (Select Size above) |
| 5. | <b>A-U-4L</b> | Stainless Needle                       |

**FAN PATTERN**

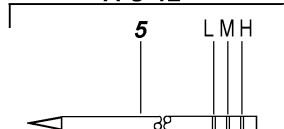
- **Application:** Standard Spray
- **Sizes:** 0-9(.55), or 4-10(.93)
- **Fluid Viscosity:** Light to Medium (4 to 12 C.F.M. @40 or 50 P.S.I.)

- |    |               |  |
|----|---------------|--|
| 1. | <b>56FA</b>   | Aircap Body (Select Size above)        |
| 2. | <b>U-3663</b> | Sleeve PTFE                            |
| 3. | <b>U-1649</b> | Aircap Nut                             |
| 4. | <b>U-</b>     | Stainless Body Tip (Select Size above) |
| 5. | <b>A-U-4L</b> | Stainless Needle                       |

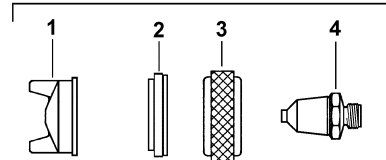
**Round Aircap Components**



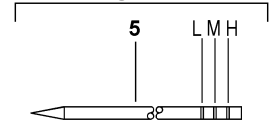
**A-U-4L**



**Fan Aircap Components**



**A-U-4L**

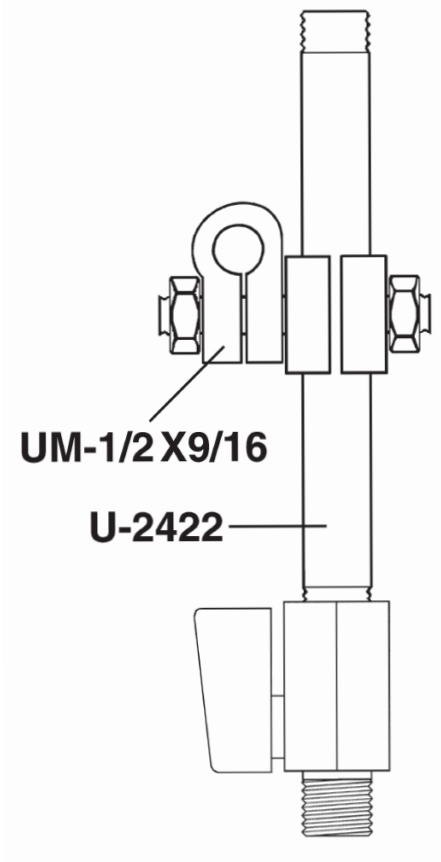


# OPTIONAL ACCESSORIES



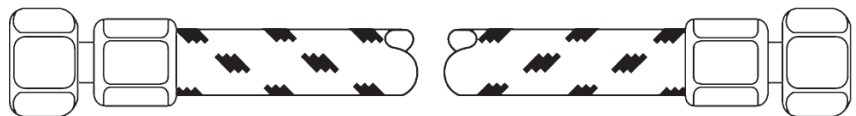
HA-1/4-10

FLUID HOSE



UM-20

MOUNTING ASSEMBLY



HL-3/16-10

AIR HOSE



## SAFETY WARNINGS

### FIRE AND EXPLOSION



Solvents and coating materials can be highly flammable or combustible when sprayed. **ALWAYS** refer to the coating material supplier's instructions and MSDS sheets before using this equipment.



Users must comply with all local and national codes of practice and insurance company requirements governing ventilation, fire precautions, operation and house-keeping of working areas.

**This equipment, as supplied, is NOT suitable for use with Halogenated Hydrocarbons.**



Static Electricity can be generated by fluid and/or air passing through hoses, by the spraying process and by cleaning non-conductive parts with cloths. To prevent ignition sources from static discharge earth continuity must be maintained to the spraygun and other metallic equipment used. It is essential to use conductive air and/or fluid hoses.



### PERSONAL PROTECTIVE EQUIPMENT



**Toxic vapors** – When sprayed, certain materials may be poisonous, create irritation or be otherwise harmful to health. Always read all labels, safety data sheets and follow any recommendations for the material before spraying. **If in doubt, contact your material supplier.**



The use of respiratory protective equipment is recommended at all times. The type of equipment must be compatible with the material being sprayed.



Always wear eye protection when spraying or cleaning the spray gun



Gloves must be worn when spraying or cleaning the equipment.



### TRAINING

Personnel should be given adequate training in the safe use of spraying equipment.

### MISUSE

Never aim a spray gun at any part of the body.

Never exceed the max. recommended safe working pressure for the equipment.

Before cleaning or maintenance, all pressure must be isolated and relieved from the equipment.

The product's metal parts can be cleaned using a gun-washing machine. However, this equipment should not be left inside gun-washing machines for prolonged periods of time. Certain seals and o-rings may not be solvent compatible.

### NOISE LEVELS



The A-weighted sound level of spray guns may exceed 85 dB (A) depending on the set-up being used. Details of actual noise levels are available on request. It is recommended that ear protection is worn all times when spraying.

### OPERATING

Spray Equipment using high pressures may be subject to recoil forces. Under certain circumstances such forces could result in repetitive strain injury to the operator.