

# AirPro™ Gravity Feed Airspray Gun

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EN

***Conventional, HVLP, and compliant guns for specialty industrial applications.  
For professional use only.***

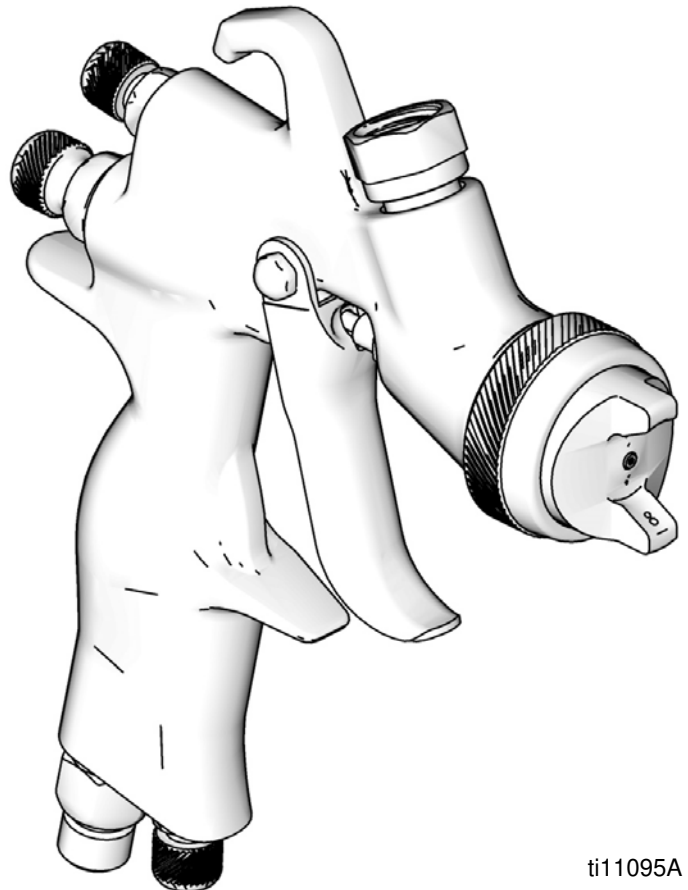
*100 psi (0.7 MPa, 7 bar) Maximum Air Inlet Pressure*



### **Important Safety Instructions**

Read all warnings and instructions in this manual. Save these instructions.

See page 3 for model information.



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## Models

### Gravity Feed without Cup

Orifice Size in. (mm)	Conventional			HVLP			Compliant		
	Model	Series	Max. HVLP/Compliant Air Pressure psi (MPa, bar)	Model	Series	Max. HVLP/Compliant Air Pressure psi (MPa, bar)	Model	Series	Max. HVLP/Compliant Air Pressure psi (MPa, bar)
0.055 (1.4)	289002	A	N/A	289005	A	29 (0.2, 2.0)	289008	A	35 (0.24, 2.4)
0.070 (1.8)	289003	A	N/A	289006	A	29 (0.2, 2.0)	289009	A	35 (0.24, 2.4)

### Gravity Feed with Plastic Cup





Orifice Size in. (mm)	Conventional			HVLP			Compliant		
	Model	Series	Max. HVLP/Compliant Air Pressure psi (MPa, bar)	Model	Series	Max. HVLP/Compliant Air Pressure psi (MPa, bar)	Model	Series	Max. HVLP/Compliant Air Pressure psi (MPa, bar)
0.055 (1.4)	289011	A	N/A	289014	A	29 (0.2, 2.0)	289017	A	35 (0.24, 2.4)
0.070 (1.8)	289012	A	N/A	289015	A	29 (0.2, 2.0)	289018	A	35 (0.24, 2.4)

### Gravity Feed with 3M™ PPS™ Cup

Orifice Size in. (mm)	Conventional			HVLP			Compliant		
	Model	Series	Max. HVLP/Compliant Air Pressure psi (MPa, bar)	Model	Series	Max. HVLP/Compliant Air Pressure psi (MPa, bar)	Model	Series	Max. HVLP/Compliant Air Pressure psi (MPa, bar)
0.055 (1.4)	289020	A	N/A	289023	A	29 (0.2, 2.0)	289026	A	35 (0.24, 2.4)
0.070 (1.8)	289021	A	N/A	289024	A	29 (0.2, 2.0)	289027	A	35 (0.24, 2.4)

# Warnings

The following warnings are for the setup, use, grounding, maintenance, and repair of this equipment. The exclamation point symbol alerts you to a general warning and the hazard symbols refer to procedure-specific risks. Refer back to these warnings. Additional, product-specific warnings may be found throughout the body of this manual where applicable.

 <b>WARNING</b>	
	<p><b>FIRE AND EXPLOSION HAZARD</b></p> <p>Flammable fumes, such as solvent and paint fumes, in work area can ignite or explode. To help prevent fire and explosion:</p> <ul style="list-style-type: none"> <li>• Use equipment only in well ventilated area.</li> <li>• Eliminate all ignition sources; such as pilot lights, cigarettes, portable electric lamps, and plastic drop cloths (potential static arc).</li> <li>• Keep work area free of debris, including solvent, rags and gasoline.</li> <li>• Do not plug or unplug power cords or turn lights on or off when flammable fumes are present.</li> <li>• Ground all equipment in the work area. See <b>Grounding</b> instructions.</li> <li>• If there is static sparking or you feel a shock, <b>stop operation immediately</b>. Do not use equipment until you identify and correct the problem.</li> <li>• Keep a working fire extinguisher in the work area.</li> </ul>
	<p><b>PRESSURIZED EQUIPMENT HAZARD</b></p> <p>Fluid from the gun/dispense valve, leaks, or ruptured components can splash in the eyes or on skin and cause serious injury.</p> <ul style="list-style-type: none"> <li>• Follow <b>Pressure Relief Procedure</b> in this manual, when you stop spraying and before cleaning, checking, or servicing equipment.</li> <li>• Tighten all fluid connections before operating the equipment.</li> <li>• Check hoses, tubes, and couplings daily. Replace worn or damaged parts immediately.</li> </ul>
	<p><b>EQUIPMENT MISUSE HAZARD</b></p> <p>Misuse can cause death or serious injury.</p> <ul style="list-style-type: none"> <li>• Do not exceed the maximum working pressure or temperature rating of the lowest rated system component. See <b>Technical Data</b> in all equipment manuals.</li> <li>• Use fluids and solvents that are compatible with equipment wetted parts. See <b>Technical Data</b> in all equipment manuals. Read fluid and solvent manufacturer's warnings.</li> <li>• Check equipment daily. Repair or replace worn or damaged parts immediately.</li> <li>• Do not alter or modify equipment.</li> <li>• Use equipment only for its intended purpose. Call your Graco distributor for information.</li> <li>• Route hoses and cables away from traffic areas, sharp edges, moving parts, and hot surfaces.</li> <li>• Do not kink or overbend hoses or use hoses to pull equipment.</li> <li>• Keep children and animals away from work area.</li> <li>• Comply with all applicable safety regulations.</li> </ul>

 **WARNING****PERSONAL PROTECTIVE EQUIPMENT**

You must wear appropriate protective equipment when operating, servicing, or when in the operating area of the equipment to help protect you from serious injury, including eye injury, inhalation of toxic fumes, burns, and hearing loss. This equipment includes but is not limited to:

- Protective eyewear
- Clothing and respirator as recommended by the fluid and solvent manufacturer
- Gloves
- Hearing protection

## Gun Selection

### Conventional Guns

Excellent atomization and high production rates typically with some reduction in transfer efficiency.

### HVLP Guns

An HVLP gun is a high transfer efficiency gun which limits the air pressure at the air cap to 10 psi (0.07 MPa, 0.7 bar) maximum. In some areas, an HVLP gun is required for compliance with environmental standards.

### Compliant Guns

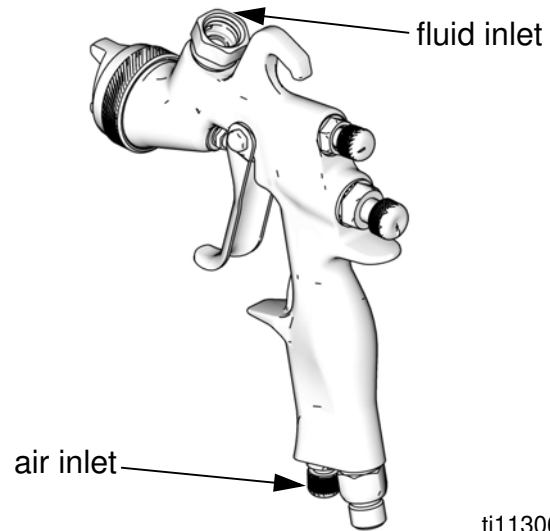
A compliant gun is a high transfer efficiency gun which has been tested to have a transfer efficiency greater than or equal to HVLP guns. The Graco compliant guns have no restrictions on air cap pressures, but the gun inlet pressure must remain under 35 psi (0.24 MPa, 2.4 bar) to remain in compliance.

## Setup



- Check that your shop air provides adequate air flow. See **Technical Data**, page 19, for minimum cfm requirements.
  - Recommended 5/16 in. (7.9 mm) ID hose, optional 3/8 in. (10 mm) ID air hose.
  - Set shop air pressure regulator (not supplied) according to paint manufacturer's recommendation. See maximum compliant air pressure on air cap.
  - Make sure no air restrictions, such as low-volume cheater-valves, obstruct the air flow. If an air adjusting valve is desired, use a Graco adjustable air valve (234784).
1. Shut off the air supply.
  2. Install a shutoff valve (not supplied) downstream of the air regulator to shut off gun air.
  3. Install an inline air filter (not supplied) to clean and dry the gun air supply.
  4. Connect a clean, dry, filtered air supply to the air inlet fitting. See FIG. 1.

5. Connect the fluid supply to the fluid inlet fitting.



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FIG. 1

## Ground the Gun

Check your local electrical code for detailed grounding instructions.

Ground the gun through connection to a Graco-approved conductive air supply hose.

## Flush Before Using Equipment

The equipment was tested with lightweight oil, which is left in the fluid passages to protect parts. To avoid contaminating your fluid with oil, flush the equipment with a compatible solvent before using the equipment. See **Flush**, page 9.

## Adjust Spray Pattern

1. Rotate the air cap to achieve desired spray pattern. See FIG. 2.

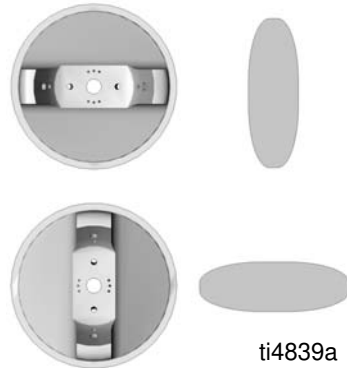


FIG. 2

2. To achieve full fan pattern, open the air control valve by turning the knob fully counterclockwise. See FIG. 3.
3. To create a round pattern, turn the pattern air off by turning the air control valve fully clockwise. See FIG. 3.
4. Trigger gun and adjust gun air pressure. Refer to **Technical Data**, page 19, for inlet air pressure.
5. To establish the correct fluid flow, turn the fluid control valve counterclockwise until no restriction of the trigger movement is felt, then turn out another half turn.

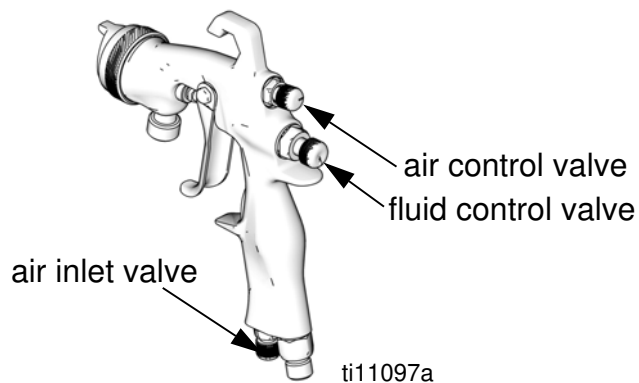


FIG. 3

6. To reduce fluid flow, turn the fluid control valve clockwise.
  - If the fluid control valve is turned clockwise all the way, the gun will emit only air.
  - If you cannot achieve the correct fluid flow with the fluid control valve, a different sized nozzle may be necessary. For smaller fluid flow, use the next size smaller nozzle. For a larger fluid flow, use the next size larger nozzle.
7. Spray a test pattern. Evaluate the spray pattern size and atomization.
8. To achieve a narrow spray pattern, turn air control valve clockwise.
9. To improve atomization, reduce the fluid flow rate. Increasing the air pressure can improve atomization but may result in poor Transfer Efficiency (TE) or non-compliant operation.

## Operation



### Pressure Relief Procedure

1. Turn off the gun air supply.
2. Trigger the gun to relieve pressure.

### Apply Fluid

#### CAUTION

Excessive atomizing air pressure can increase over-spray, reduce transfer efficiency, and result in a poor quality finish. Regulatory agencies in certain states prohibit the operation of a spray gun above 10 psi (69 kPa, 0.7 bar) atomizing air cap pressure.

1. Fill the cup with material. Do not fill past the full markings on cup.
2. Turn on the shop air to the gun. Set atomizing pressure with the gun fully triggered.
3. Adjust the pattern size and shape. See page 7.
4. To achieve the best results when applying fluid:
  - Keep the gun perpendicular and 6 to 8 inches (150 to 200 mm) from the object being sprayed.
  - Use smooth, parallel strokes across the surface to be sprayed with 50% overlap.

 See **Troubleshooting**, page 11, if you experience an irregular pattern.

When using the HVLP spray gun, instead of a conventional airspray gun, you may need to use a slightly slower hand movement and make fewer passes with the gun to coat a part. This is due to the reduced spray velocity produced by lower HVLP air pressures, along with a larger fluid particle size because there is less air to blow off solvents than is produced by conventional airspray. Take care to avoid runs or sags as you spray.

### Volatile Organic Compounds (VOC) Regulation

In certain states, spraying solvents that release VOCs into the atmosphere when cleaning a spray gun is prohibited. To comply with these air quality laws, you must use a cleaning method that prevents the escape of VOC vapors into the atmosphere. See **Compliant Cleaning Methods**, page 10.

 Clean air line filters as directed by the manufacturer.



# Daily Gun Maintenance



## General Tasks

Follow the **Pressure Relief Procedure**, page 8.

- Frequently lubricate the gun moving parts with a drop of non-silicone oil.
- Do not disassemble the spray gun if you are having a spray pattern problem. See **Troubleshooting**, page 11, for information on how to correct the problem.
- Clean the fluid and air line filters daily.
- Check for fluid leakage. Tighten fittings or replace equipment as needed.

### CAUTION

Solvent left in gun air passages could result in a poor quality paint finish. Do not use any cleaning method that may allow solvent into the gun air passages.

- Do not point gun up while cleaning it.
- Do not wipe gun with a cloth soaked in solvent; wring out the excess.
- Do not immerse the gun in solvent.

## Flush

Flush before using the equipment, before changing colors, and when you are done spraying. Use solvent that is compatible with gun wetted parts and with the fluid that will be sprayed.



See **Compliant Cleaning Methods**, page 10, to comply with air quality laws if applicable.

1. Follow **Pressure Relief Procedure**, page 8.

2. Dispose of any paint in the cup.
3. Fill the cup with a small amount of solvent.
4. Spray into a grounded metal waste container until the equipment is clean.
5. Follow **Pressure Relief Procedure**, page 8.

## Clean Gun and Cup

### CAUTION

- Do not submerge gun in solvent. Solvent dissolves lubricant, dries out packings, and clogs air passages.
- Do not use metal tools to clean air cap holes as this may scratch them and distort the spray pattern.
- Use a compatible solvent.

1. Flush, page 9.
2. Dampen a soft cloth with solvent and wring out the excess. Point the gun down and wipe off the outside of the gun and cup.
3. Make sure cup lid vent hole is clear.
4. Blow dry gun inside and out. Lubricate.




See **Compliant Cleaning Methods**, page 10, to comply with air quality laws if applicable.

## Clean Nozzle and Air Cap

1. Remove air cap (13), trigger gun, remove nozzle (11), and soak both in a compatible cleaning solution.

CAUTION
Trigger the gun whenever you tighten or remove the nozzle. This keeps the needle tip away from the nozzle seating surface and prevents the tip from being damaged.

2. Clean air cap, nozzle, and front of the gun with a soft-bristle brush dipped into compatible solvent. Do not use a wire brush or metal tools.
3. Use a soft implement, such as a toothpick, to clean out air cap holes.
4. Trigger the gun while you install the fluid nozzle with the gun tool. Tighten the nozzle securely to 155-165 in-lb (17.5-18.6 N•m) to obtain a good seal.
5. Install the retaining ring (14) and air cap (13).

 When reassembling, make sure the air cap matches the color etched onto the side of the nozzle (gold, brown, grey, blue, etc.).





6. After cleaning the gun, lubricate the following parts with lubricant 111265 daily:
  - fluid control valve threads
  - trigger pivot pin
  - fluid needle shaft

## Compliant Cleaning Methods

1. Place spray gun in a gun washer that completely encloses the gun and components during cleaning, rinsing, and draining.
2. Spray solvent through the spray gun into a closed gun cleaning station.

## Troubleshooting



Problem	Cause	Solution
Spray Pattern  <b>Right</b>	Normal pattern.	No action necessary.
Spray Pattern  <b>Wrong</b> Heavy top or bottom	Dirty or damaged air cap or fluid nozzle.	Rotate air cap 180°. <i>If pattern follows air cap, problem is in air cap (13). Clean and inspect. If pattern is not corrected, replace air cap.</i> <i>If pattern does not follow the air cap, the problem is with the fluid nozzle. Clean and inspect the nozzle. If the pattern is not corrected, replace nozzle.</i>
Spray Pattern  <b>Wrong</b> Split pattern	Pressure too high for viscosity of material being sprayed.	Reduce air pressure and increase material viscosity. Correct pattern by narrowing fan size with fluid control valve (8).
Spray Pattern  <b>Wrong</b>	Dirty or distorted air horn holes.	Clean and inspect air cap. If pattern is not corrected, replace air cap.
Gun spitting	Air getting into paint stream.	Check if cup is empty and fill. Tighten fluid nozzle (11). Check and tighten needle packing nut (17). Check fluid nozzle (11) for damage. Replace fluid inlet gasket (3)
	Damaged fluid nozzle seal (19).	Replace seal (19).
Will not spray	Cup is empty.	Fill cup.
	Fluid control valve (8) turned too far clockwise.	Adjust valve (8) counterclockwise.

*Daily Gun Maintenance*

<b>Problem</b>	<b>Cause</b>	<b>Solution</b>
Excessive air blowing back	Loose fluid nozzle (11).	Tighten fluid nozzle (11).
	Damaged fluid nozzle seal (19).	Replace seal (19).
Excessive air leak behind trigger.	Worn u-cups/air valve.	Repair gun (Kit 289408). Be sure to use all included parts.
	Worn trigger.	Replace trigger (part 289140). If leak persists repair gun (Kit 289408).

# Repair

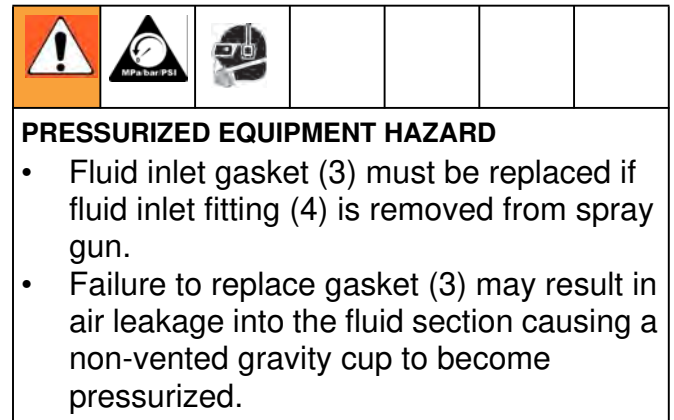


See **Parts**, page 15, for callout references.

## Disassembly

1. Unscrew retaining ring (14) to remove air cap (13b). Check o-rings (13a and 13c) and replace if necessary.
2. Trigger gun while unscrewing nozzle (11) to prevent needle damage.
3. Check o-ring (19) and replace if necessary.
4. Remove fluid control valve (8), spring (26), needle (9), and nut (7). Inspect. Replace tip (9c), needle (9), and u-cup seal (20) as necessary. If replacing needle tip, use low strength thread adhesive on needle tip threads.
5. Remove spring (28) and push the air valve assembly (6) out the back of the gun. Inspect. Replace air valve assembly (6) and u-cup seal (20) as necessary. Use tool (33) to install u-cup seal.
6. Remove trigger nut (22), trigger pin (21), wave washer (18), and trigger (10).
7. Unscrew needle packing nut (17) and remove u-cup packing (16) and spreader (15).
8. Remove air control valve assembly (5). Inspect and replace as necessary.
9. Remove air inlet valve assembly (27). Inspect and replace as necessary.

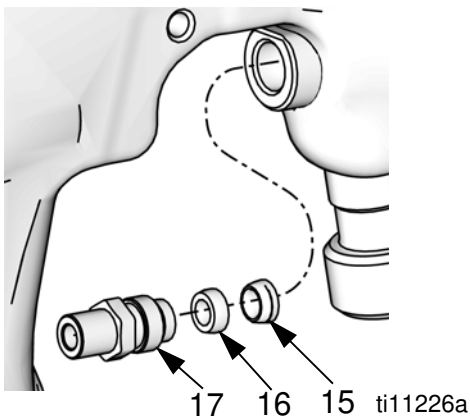
## Fluid Inlet Fitting Replacement



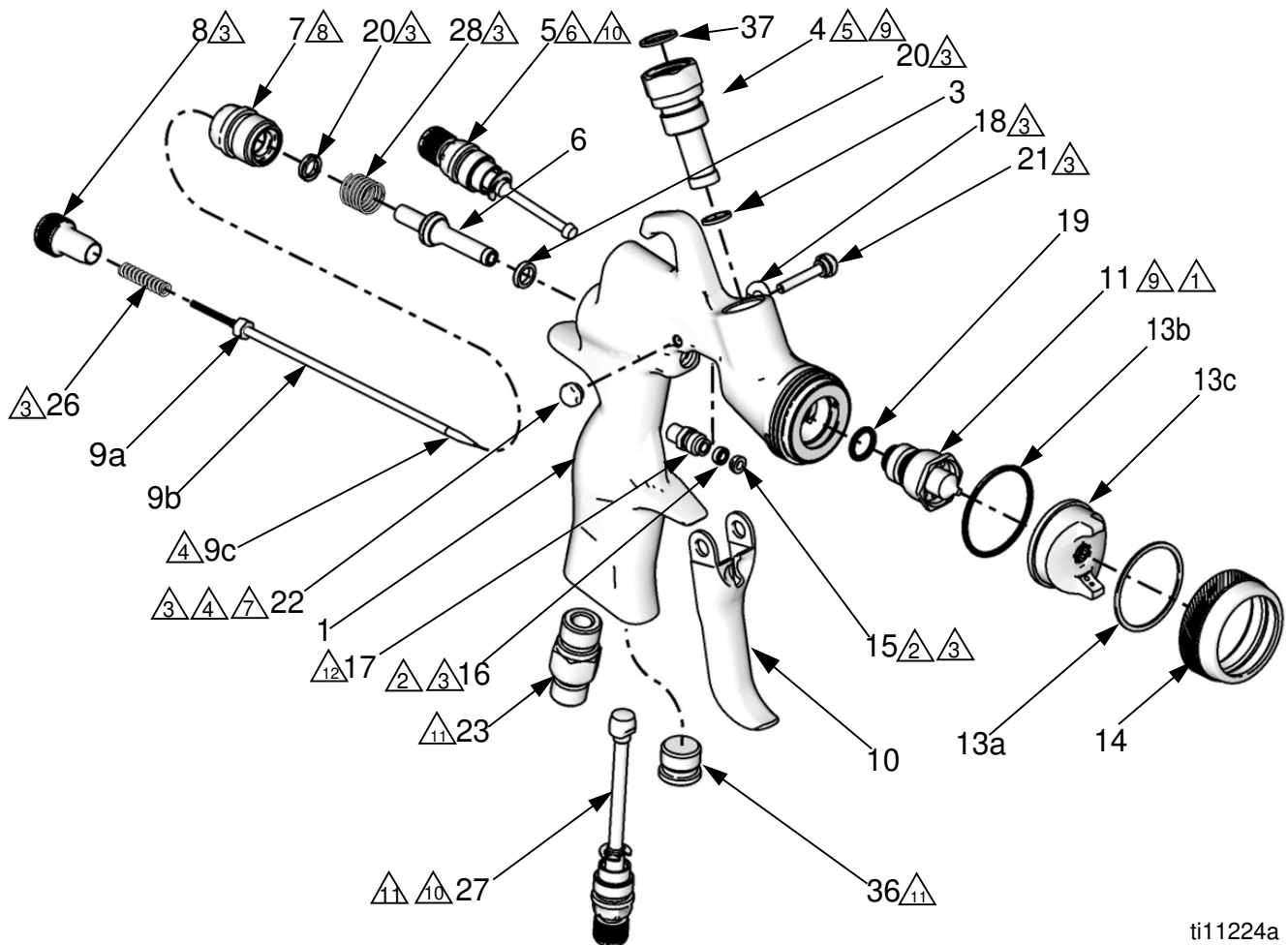
1. Remove fluid inlet fitting (4).
2. Remove fluid inlet gasket (3) from gun body and discard.
3. Apply thread sealant to replacement fluid inlet fitting (4) threads.
4. Snap the fluid inlet gasket (3) securely onto the fluid inlet fitting (4).
5. Screw in fluid inlet fitting (4) and torque to 155-165 in.-lb (17.5-18.6 N•m).
6. Replace washer (28) as required.

## Reassembly

1. Install air control valve assembly (5) with valve turned fully counterclockwise to outermost position. Torque to 85-90 in-lb (9.6-10.2 N•m).
2. Install air inlet valve assembly (27) with valve turned fully counterclockwise to outermost position. Torque to 205-215 in-lb (23.2-24.3 N•m).
3. Lubricate u-cup spreader (15) and u-cup packing (16). Install spreader (15) with tapered end facing rear of gun. Install u-cup packing (16) with open end facing front of gun. Install packing nut (17). Torque to 3 in-lb (0.3 N•m).
4. Install wave washer (18) with cupped side toward the gun body. Lubricate and apply thread retainer to trigger pin (10). Install trigger (10), trigger pin (21), and trigger nut (22). Torque to 15-20 in-lb (1.7-2.2 N•m).
5. Install air valve assembly (6), spring (28), and nut (7). Torque to 175-185 in-lb (19.8-20.9 N•m).
6. Install needle (9) and spring (26). Lightly lubricate and install fluid control valve (8).
7. Trigger gun while replacing nozzle (11). Torque to 155-165 in-lb (17.5-18.6 N•m).
8. Install air cap assembly (13) and retaining ring (14).



## Parts



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- △1 Pull trigger before installing nozzle (11).
- △2 Insert spreader (15) with tapered end facing rear of gun. Insert u-cup (16) with open end facing front of gun.
- △3 Apply lubricant.
- △4 Apply low strength thread retainer.
- △5 Apply thread sealant.
- △6 Torque to 85-90 in-lb (9.6-10.2 N•m).
- △7 Torque to 15-20 in-lb (1.7-2.2 N•m).
- △8 Torque to 175-185 in-lb (19.8-20.9 N•m).
- △9 Torque to 155-165 in-lb (17.5-18.6 N•m).
- △10 Install with valve assembly turned fully counterclockwise to outermost position.
- △11 Torque to 205-215 in-lb (23.2-24.3 N•m).
- △12 Torque to 3 in-lb (0.3 N•m).

Parts

Ref.	Part No.	Description	Qty.	Ref.	Part No.	Description	Qty.
1*	---	BODY, gun	1	27	289142	VALVE, assembly, air inlet	1
3*†	---	GASKET, fluid inlet	1	28*	---	SPRING, compression	1
4*	289792	FITTING, fluid inlet, includes gasket (item 3)	1	29	289794	TOOL, gun	1
5	289796	VALVE, air control assembly	1	33*★	---	TOOL, installation, seal	1
6*★	289039	VALVE, air, assembly	1	36	289452	NUT, air plug, not assembled	1
7*	289052	NUT, air valve, u-cup assembly	1	37❖★	---	WASHER, uhmw	1
8	289097	VALVE, fluid control	1	38	289770	CUP, gravity, 650 cc	1
9	See p. 18	NEEDLE, assembly	1	38a	289195	FILTER, cup (not shown)	
9a	---	NUT, needle	1			★ Included in Gun Repair Kit 289790.	
9b	---	NEEDLE	1			❖ Included in Trigger Repair Kit 289143 (contains 5 of each part).	
9c	See p. 18	TIP, needle	1			+ Included in Needle Packing Repair Kit 289455 (contains 5 of each part).	
10	289140	TRIGGER	1			* Included in Air Valve Repair Kit 289408.	
11	See p. 18	NOZZLE, fluid	1			◆ Included in Air Cap Seal Kit 289791 (contains 5 of each part).	
13	See p. 18	AIR CAP, assembly (includes 13a-13c)	1			✓ Included in Retaining Ring Kit 289079.	
13a★◆✓	---	WASHER	1			❖ Included in Cup Gasket Repair Kit 289213 (pack of 10).	
13b★◆✓	---	O-RING	1			* Included in Gun Body Kit 289022.	
13c	See p. 18	AIR CAP	1			† Included in Fluid Inlet Gasket Kit 24A560, package of 5 (purchase separately).	
14✓	---	RING, retaining	1				
15★+	---	SPREADER, u-cup	1				
16★+	---	PACKING, u-cup	1				
17	289793	NUT	1				
18❖	---	WASHER, wave	1				
19★	111457	O-RING	1				
20*	---	PACKING, u-cup	1				
21❖	---	PIN, pivot	1				
22❖	---	NUT, pivot pin	1				
23	289451	FITTING, air inlet	1				
26*	---	SPRING, compression	1				

--- Not sold separately.



## Accessories

### Cups

#### Part No. Description

289797	Cup, aluminum, 23 oz (650 cc)
289802	Cup, aluminum, 34 oz (1 liter)
289770	Cup, plastic, 23 oz (650 cc)
192407	Cup Holder

### Repair Kits

#### Part No. Description

289455	Needle Packing Repair Kit
289790	Gun Repair Kit
289791	Air Cap Seal Kit
289143	Trigger Repair Kit
289408	Air Valve Repair Kit
289213	Cup Gasket Kit, 10 pack
289079	Retaining Ring Kit
289022	Gun Handle Replacement Kit
24A560	Fluid Inlet Gasket Kit, 5 pack
24C310	Nozzle O-Ring Kit, 5-pack
195065	Steel Air Inlet Fitting

### Air Valves

#### Part No. Description

234784	Air Control Valve with Gauge
235119	Gun Air Regulator Assembly
239655	Swivel Air Valve

### Cleaning Kit

#### Part No. Description

105749	Cleaning Brush
111265	Gun Lubricant
15C161	Ultimate Gun Cleaning Kit

### 3M™ PPS™ Cups and Accessories

#### Part No. Description

234941	Cup and Collar, 6 oz, 8-pack
234771	Cup and Collar 25 oz, 8-pack
234937	Cup and Collar 32oz, 4-pack
234940	Lid and Liner, 6 oz, 50-pack
234772	Lid and Liner, 25 oz, 50-pack
234938	Lid and Liner, 32 oz, 25-pack
234942	Ratio Film, insert, 6 oz, 50-pack
15F531	Ratio Film, insert, 25 oz, 100-pack
234939	Ratio Film, insert, 32 oz, 100-pack
289486	Gravity Cup Assembly, 25 oz, includes cup, collar, lid, liner, and adapter
289795	Gravity Feed Adapter
15E470	Lid Dispenser
15E469	Liner Dispenser
15E467	Gun Tray

### Test Gauge

#### Part No. Description

289803	HVLP Verification
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### Hoses

#### Part No. Description

239636	15 ft Air Hose Assembly (5/16 in.)
239637	25 ft Air Hose Assembly (5/16 in.)

### Tips

#### Part No. Description

24E484	.030 SST Needle Tips (Pack of 5)
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# Repair Kits

## Without Gravity Cup

Model	Spray Type	Nozzle Size in. (mm)	Air Cap Kit (13a-13c)	Nozzle Kit (11, 19)	Needle Assembly Kit (9a-9c)	Needle/ Nozzle Kit (9a-9c, 11, 19)	Needle Tip Kit (9c, 5-pack)
289002	Conventional	0.055 (1.4)	289773	289780	289799	289493	288185
289003	Conventional	0.070 (1.8)	289773	289767	289786	289494	289001
289005	HVLP	0.055 (1.4)	289771	289776	289786	289495	289001
289006	HVLP	0.070 (1.8)	289771	289801	289786	289496	289001
289008	Compliant	0.055 (1.4)	289772	289779	289799	289497	288185
289009	Compliant	0.070 (1.8)	289772	289559	289799	289498	288185

## With Gravity Cup

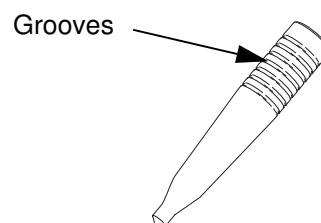
Model	Spray Type	Nozzle Size in. (mm)	Air Cap Kit (13a-13c)	Nozzle Kit (11, 19)	Needle Assembly Kit (9a-9c)	Needle/ Nozzle Kits (9a-9c, 11, 19)	Needle Tip Kit (9c, 5-pack))
289011	Conventional	0.055 (1.4)	289773	289780	289799	289493	288185
289012	Conventional	0.070 (1.8)	289773	289767	289786	289494	289001
289014	HVLP	0.055 (1.4)	289771	289776	289786	289495	289001
289015	HVLP	0.070 (1.8)	289771	289801	289786	289496	289001
289017	Compliant	0.055 (1.4)	289772	289779	289799	289497	288185
289018	Compliant	0.070 (1.8)	289772	289559	289799	289498	288185

## With 3M PPS Cup

Model	Spray Type	Nozzle Size in. (mm)	Air Cap Kit (13a-13c)	Nozzle Kit (11, 19)	Needle Assembly Kit (9a-9c)	Needle/ Nozzle Kits (9a-9c, 11, 19)	Needle Tip Kit (9c, 5-pack))
289020	Conventional	0.055 (1.4)	289773	289780	289799	289493	288185
289021	Conventional	0.070 (1.8)	289773	289767	289786	289494	289001
289023	HVLP	0.055 (1.4)	289771	289776	289786	289495	289001
289024	HVLP	0.070 (1.8)	289771	289801	289786	289496	289001
289026	Compliant	0.055 (1.4)	289772	289779	289799	289497	288185
289027	Compliant	0.070 (1.8)	289772	289559	289799	289498	288185

## Needle Tips

Grooves	Needle Tip Kit (5-pack)
4	288185
7	289001



ti14043a

## Technical Data

<b>Maximum Air Inlet Pressure</b> .....	100 psi (0.7 MPa, 7 bar)
<b>Maximum HVLP/Compliant Inbound Air Pressure:</b>	
HVLP gravity feed .....	29 psi (0.2 MPa, 2.0 bar)*
Compliant gravity feed .....	35 psi (0.24 MPa, 2.4 bar)*
<b>Air Consumption:</b>	
Conventional Gun .....	13.3 CFM at 43 psi (0.3 MPa, 3.0 bar)
HVLP Gun .....	14.4 CFM at 29 psi (0.2 MPa, 2.0 bar)
Compliant Gun .....	11.2 CFM at 35 psi (0.24 MPa, 2.4 bar)
<b>Fluid and Air Operating Temperature Range</b>	32°F to 109°F (0°C to 43°C)
<b>Spray Gun:</b>	
Air Inlet .....	1/4 npsm (R1/4-19)
Weight with cup .....	1.3 lbs (0.6 kg)
<b>Sound Data:</b>	
Conventional	
Sound pressure at 43 psi (0.3 MPa, 3.0 bar) .....	79.52 dB(A)**
Sound power at 43 psi (0.3 MPa, 3.0 bar) .....	88.05 dB(A)**
HVLP	
Sound pressure at 29 psi (0.2 MPa, 2.0 bar) .....	83.9 dB(A)**
Sound power at 29 psi (0.2 MPa, 2.0 bar) .....	90.8 dB(A)**
Compliant	
Sound pressure at 35 psi (0.24 MPa, 2.4 bar) .....	81.8 dB(A)**
Sound power at 35 psi (0.24 MPa, 2.4 bar) .....	88.7 dB(A)**
<b>Gravity Cup Size</b> .....	23 oz (0.68 liter) cup
<b>Wetted Parts</b> .....	303 stainless steel, 17-4 PH stainless steel, PEEK, acetal, UHMWPE

\* Produces 10 psi (0.07 MPa, 0.7 bar) spraying pressure at air cap.

\*\* All readings were taken with the fan valve fully open (fan full size) at the assumed operator position. Sound power was tested per ISO 9614-2.

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**Phone:** 612-623-6921 **or Toll Free:** 1-800-328-0211, **Fax:** 612-378-3505

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