

Instruction Manual

Automatic Spray Gun

for ENAMEL APPLICATION



SB-E-2-scorpion

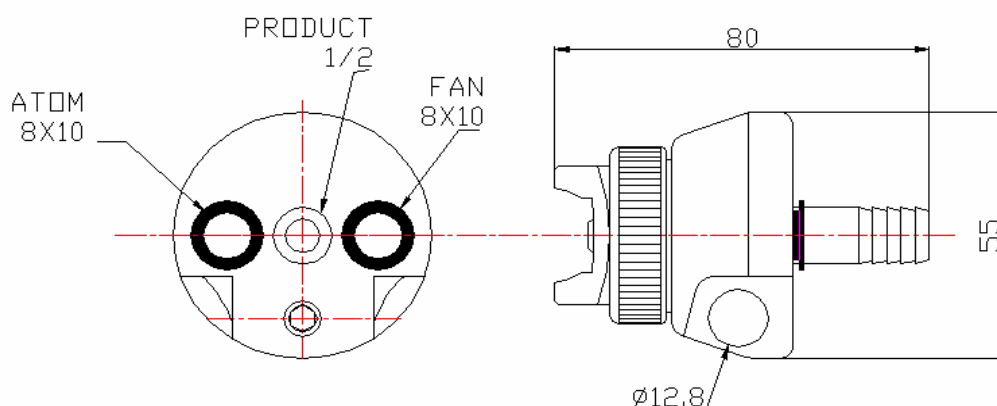


WARNING: All spray guns project particles at high velocity and must never be aimed at any part of the body.

DESCRIPTION

The "SCORPION" spray gun is used to spray abrasive material full open flow. This spray gun head is a light weight and compact design, especially adapted for tile machine application and for rotary machines. This gun is sold with hardened stainless steel tips specially treated (800Hv through) to resist material abrasion. The air cap fluid can be easily disassembled by ¼ turn for quick cleaning of the fluid tip and the air cap.

IMPORTANT : This spray gun can not be used with materials containing solvents or flammable materials.



REFERENCE :

SCO-E22-14 Spray head with 1.4 mm tip, air cap N°E22.

SCO-E22-16 Spray head with 1.6 mm tip, air cap N°E22

SCO-E22-18 Spray head with 1.8 mm tip, air cap N°E22

SPECIFICATION

Dimensions : 80 mm * dia. 55 mm

Maximum air pressure : 9 bar

Air pressure recommended in use : 2 bar

Maximum fluid pressure : 9 bar

Weight of the gun : 225 g

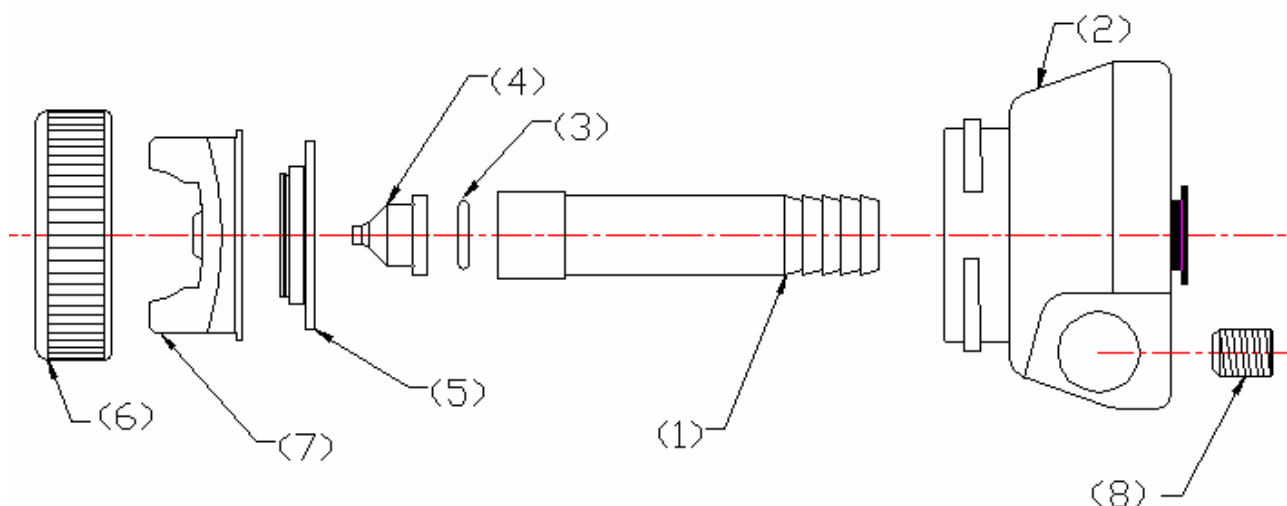
ITW.Finishing Products and Systems
Ringwood Road, Bournemouth BH11 9LH England
Tel-(01202) 571111 Fax (01202) 581940



ITW Surfaces et Finitions
163 –171 Avenue des auréats BP1453
26014 Valence cedex France
Téléphone 04-75-75-27-00
Téléfax : 04-75-75-27-99
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SCORPION



PARTS LIST

Item	Part Number	Description	Qty
1	SPA-34	Fluid connector	1
2	SPA-403	Gun body anodised with air connectors	1
3	S-28218-K5	Gasket	1
4	SPA-255-14 SPA-255-16 SPA-255-18	Tip hard hardened 1.4 mm with gasket item 3 Tip hard hardened 1.6 mm with gasket item 3 Tip hard hardened 1.8 mm with gasket item 3	1
5	SPA-35	Brass baffle	1
6	SPA-36	Retaining ring 1/4 turn	1
7	SPA-100-E22	Air cap	1
8	SSF-2048-K5	Grub screw	1

PREVENTIVE MAINTENANCE

Cleaning :

Unscrew the retaining ring remove the air cap the tip and the baffle, clean it with water.

If the air cap holes are obstructed by material build up, clean the surface with a soft cloth, a brush or toothpick to remove the obstruction. Never use a steel wire or hard instrument which will damage the air cap and result in a distorted spray pattern.

Tip hard hardened 1.4 mm with gasket item 3

COMBINATION AIR CAP / TIP (recommended)

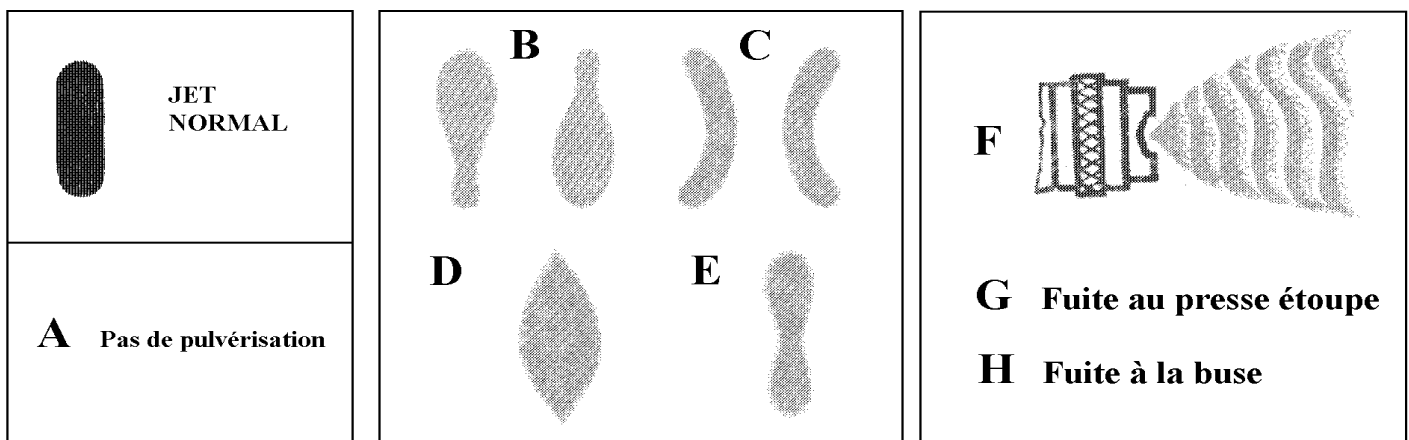
Air cap	Tip	Air flow	Fluid flow	Fluid Viscosity	Pattern size
N°	Dim.	L/min (bar)	cc/min	Range ford N°4	(mm)
E22	1.4 mm	350 l/min (2bar)	50 to 300	15-50	350 max
	1.6 mm				
	1.8 mm				

INSTALLATION

In order to ensure that this equipment reaches you in first class condition, protective coating rust inhibitors, etc., have been used. Flush all equipment through with a suitable solvent before use to remove these agents from materials passages.

1. Install the gun head on the support of your machine (diameter of support recommended 12 mm). Tighten the gun in place using the screw item 8. Ensure that the gun is securely fixed on the machine.
2. Connect the fan and atomising air supply hoses (Type "Nylon" 10x8 recommended). Regulated and filtered air supply.
3. Connect the fluid hose ½" bore on the barbed fluid connection.

FAULT FINDING



CAUSE		CORRECTION	
A	No pressure at the spray gun	A	Check the air and fluid hoses
B-C	Material builds up on air cap or fluid tip	B-C	Clean cap or tip, do not use metallic tools.
D	Material too thick or too much	D	Thin or reduce material supply pressure
E	Not enough material	E	Increase fluid supply pressure
F	1. Insufficient material or fluid passage obstruction. 2. Material passage obstructed. 3. Damage or loose fluid tip.	F	1. Fill or clean obstruction. 2. Replace fluid tip seal. 3. Replace or tighten the retaining ring.

SAFETY WARNINGS

FIRE AND EXPLOSION

Solvents and coating materials can be highly flammable or combustible especially when sprayed.

- * Work stations must be provided with adequate ventilation and exhaust to prevent the build-up of flammable vapours.
- * Smoking and naked flames must not be allowed in the spraying or mixing areas.
- * Fire extinguishing equipment must be provided in the spraying and mixing areas.

Users must comply with all local and national codes of practice and insurance company requirements governing ventilation, Fire precautions, operation, maintenance and housekeeping of work stations..

HALOGENATED HYDROCARBON SOLVENTS - for example 1,1,1-Trichloroethane and Methylene Chloride can chemically react with aluminium and galvanised or zinc coated parts and cause an explosion hazard. Read the label and data sheet for the material you intend to spray.

This equipment, as supplied, is suitable for use with Halogenated Hydrocarbons and the user must ensure that all other equipment in the system is also suitable for use with these materials. **DO NOT USE SPRAY MATERIAL CONTAINING THESE SOLVENTS EXCEPT WITH EQUIPMENT SPECIFICALLY DESIGNATED BY THE MANUFACTURER AS BEING SUITABLE FOR SUCH USE..**

STATIC ELECTRICITY - is generated by fluid moving through pipes and hoses. A static spark, capable of igniting certain solvents and coating materials, could be produced by high fluid flow rates. To prevent the risk of fire or explosion, earth continuity to the spray equipment and object being sprayed should be maintained.

PERSONAL PROTECTIVE EQUIPMENT

TOXIC VAPOURS - when sprayed certain materials may be poisonous or otherwise be harmful to health. Always read carefully all label and safety performance data for the material being sprayed and follow any recommendations. **IF IN DOUBT, CONSULT THE MATERIAL SUPPLIER.**

- * The use of respiratory protective equipment is recommended at all times when spraying.

The type of respiratory protective equipment used must be compatible with the material being sprayed and the level of concentration.

- * Always wear eye protection when spraying or cleaning the equipment

Gloves must be worn for spraying or cleaning the equipment when certain coating materials and solvents are used.

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.

WARNING

- * 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 authorised 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 recommendation of the machine manufacturer.

NOISE LEVELS

The continuous A-weighted sound pressure level of this spray gun may exceed 85dB(A) depending on the air cap /fluid tip set up being used. Sound levels are measured at the position of the operators ear using an impulse sound level meter and analyser, when the gun is being used in a normal spraying application. Details of actual noise levels produced by the various air cap/fluid tip set ups are available on request.