

AUTOMATIC GUNS Models 651513-XX-B



**READ THIS MANUAL CAREFULLY BEFORE INSTALLING,
OPERATING OR SERVICING THIS EQUIPMENT.**

It is the responsibility of the employer to place this information in the hands of the operator. Keep for future reference.

SPECIFICATIONS

Material Inlet	1/4 - 18 N.P.S.M.
Air Inlet.....	1/8 - 27 N.P.T.F. - 1
Diameter	2" (50.8 mm)
Length (without nozzle).....	6-11/32" (161.1 mm)
Weight	17 oz. (482 grams)
Mounting Hole Diameter.....	33/64" (13.1 mm)
Maximum Operating Fluid Pressure....	5000 p.s.i. (345 bar)
Minimum Air Pressure Required	
@ 2000 p.s.i. (138 bar) Fluid Pressure.	50 p.s.i. (3.4 bar)

DESCRIPTION

The following model guns permit spraying or extruding of material continuously or intermittently by using spring return. See chart below for characteristics of each model.

These unit are identical except spray guns include a spray guard which retains the TC-XXXX airless spray tip. They include a stainless steel head, aluminum air cylinder, a 1/4 - 18 N.P.S.M. material inlet, a 1/8 - 27 N.P.T.F. - 1 air inlet and a needle shroud (17) for prolonged life. The compact design of either gun allows mounting in a closely confined area.

Model	Material	Includes	Tips
651513-11-B	Heavy Materials		66541-XX
651513-12-B	Light Fluids	66504 Cap	TC-XXXX

OPERATION

Turn air to "ON" position at supply source. Air must be regulated at 60 p.s.i. (4 bar) to maintain proper performance.

STROKE ADJUSTMENT

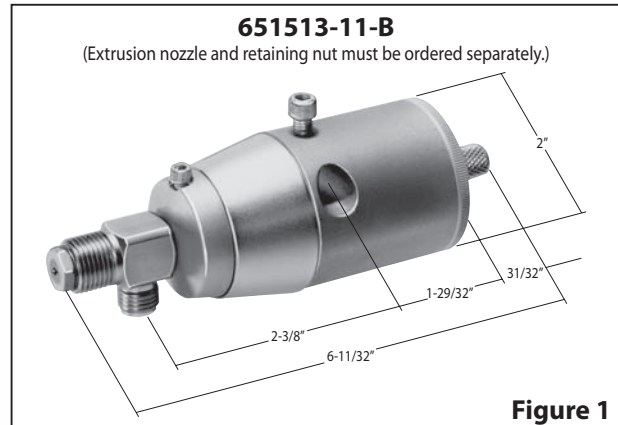
For maximum fluid flow and tip and needle life;

1. Turn knurled adjusting screw (23) counterclockwise until contact is lost between it and (15) nut.
2. Turn adjusting screw clockwise until contact is again made with the (15) nut.
3. Back out adjusting screw approximately 1/4 turn.
4. Lock (23) adjusting screw in place by tightening (24) nut.

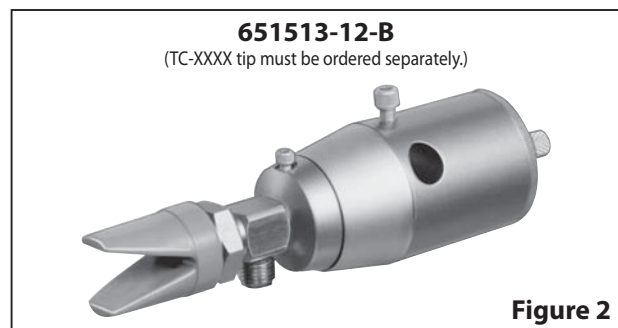
MAINTENANCE

To maintain reliable performance, the gun should be flushed out with a compatible solvent immediately following each spray or extrusion period. This will decrease the chance of material build-up within the gun which will cause poor functioning.

AUTOMATIC EXTRUSION GUNS



AUTOMATIC AIRLESS SPRAY GUNS



OPERATING AND SAFETY PRECAUTIONS

⚠ WARNING HIGH PRESSURE DEVICE. Improper usage of equipment could result in serious injury. The possibility of injection into the flesh is a potential hazard. Never allow any part of the human body to come in front of or in direct contact with the material outlet.

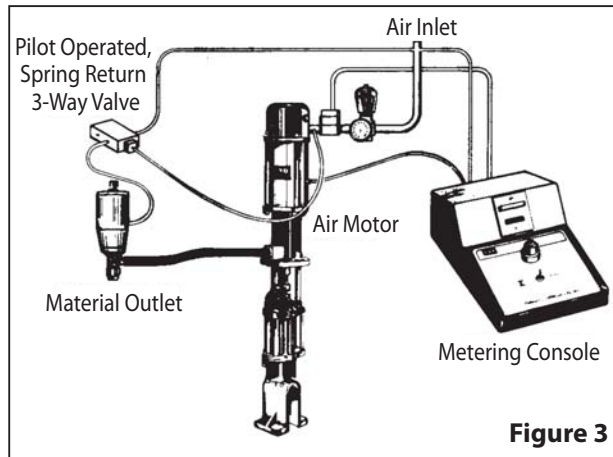
⚠ WARNING AN INJECTION INJURY CAN BE SERIOUS. If injection should occur, contact a qualified physician for immediate treatment of such injuries.

⚠ WARNING DO NOT EXCEED MAXIMUM WORKING PRESSURE OF 5000 P.S.I. (345 BAR).

⚠ WARNING ALWAYS DISCONNECT THE MATERIAL LINE AND THE AIR INLET BEFORE SERVICING THIS UNIT TO REDUCE THE CHANCE OF ACCIDENTAL DISCHARGE.

INSTALLATION

The automatic gun may be mounted on a 1/2" rod and held in place by (21) set screw.
Connect 1/4 - 18 N.P.S.M. material line to fluid inlet as shown.
Connect 3-way valve and air line to 1/8 - 27 N.P.T.F. air inlet on side of gun body (see figure 3, below).



DISASSEMBLY

1. Remove (17) cover.
2. Loosen (24) nut and remove (23) adjusting screw.
3. Remove (13) cap.
4. Remove (14) "O" ring.
5. Remove (22) spring.
6. Hold (15) nut and loosen (18) collet nut. CAUTION: Do not scratch (19) piston rod or burr (18) collet nut.
7. Loosen (4) cap screw.
8. Unthread (7) gun body and adapter assembly from (1) body.
9. Push (18) collet nut, with (16) piston, out of (1) body.
10. Unthread (18) collet nut from (19) piston rod.
11. Remove (2) "O" ring from (16) piston.
12. Remove (15) nut from (19) piston rod, using wrench flats on piston rod.
13. Remove (20) "O" ring.
14. Remove (9) guard and tip (models 651513-12-B only).
15. Remove (12) washer.
16. Remove (11) screw, (25) screw, (27) ball seat and (26) gasket.
17. Remove the (8) ball and stem assembly.
18. Remove (10) washer.
19. Unthread (3) retaining screw and remove from (7) gun body and adapter assembly.
20. Remove the two (5) flat packings and two (6) packings.

ASSEMBLY

1. Replace the (10) washer.
2. Put the (8) ball and stem assembly into the (7) gun body and adapter assembly.
3. Assemble (26) gasket and (27) ball seat into (11) screw, securing with (25) screw.
4. Thread (11) screw into (7) gun body and adapter assembly and tighten into body. NOTE: The (9) guard is used on the spray type models only. When assembling an extrusion type gun, insert an extrusion tip assembly instead.
5. Put the (12) washer inside (9) guard (see note) and thread into (7) gun body and adapter assembly and tighten.
6. Put a small amount of grease in hole and on outside diameter of (5 and 6) packings.
7. Put one of the new (6) packings onto the wire of the (8) ball and stem assembly (see figure 4, page 3, for correct installation).
8. Put the two (5) flat packings onto the wire of (8) ball and stem assembly.
9. Put the remaining new (6) packing onto the wire of (8) ball and stem assembly (see figure 4, page 3 for correct installation).
10. Slide the (3) retaining screw over the wire of the (8) ball and stem assembly. Push the packings into the cavity of the (7) gun body and adapter assembly.
11. Thread (3) retaining screw into (7) gun body and adapter assembly.
12. Push (8) ball and stem assembly into (11) screw until ball seats against (27) ball seat. Then tighten (3) retaining screw. Caution: Do not bend (8) ball and stem assembly.
13. Thread (7) gun body and adapter assembly into (1) body, until it is in position shown in figure 4, page 3.
14. Tighten (4) cap screw.
15. Put (2) "O" ring onto the (16) piston.
16. Put (20) "O" ring onto the (19) piston rod.
17. Put (19) piston rod through (16) piston. Thread (15) nut onto (19) piston rod and tighten, using flats provided.
18. Thread (18) collet nut into (19) piston rod loosely.
19. Lubricate (2 and 20) "O" rings and push (16) piston into (1) body. Do not force into (1) body. CAUTION: Make sure the (8) ball and stem assembly wire enters the (18) collet nut.
20. Push the (16) piston until it bottoms in the (1) body.
21. Push the (16) piston back out off the bottom of (1) body, approximately 1/32". NOTE: Make sure (8) ball and stem assembly is still seated against (27) ball seat.
22. Tighten (18) collet nut by holding (15) nut. Do not move piston from position given in step (21).
23. Replace (22) spring, securing with (13) cap.
24. Replace (23) adjusting screw and (24) nut.

PARTS LIST / 651513-XX-B

Item	Description (size)	(Qty)	Part No.
1	Body	(1)	91639
2	"O" Ring (1/8" x 1-3/8" o.d.)	(1)	Y325-216
3	Retaining Screw	(1)	91473
4	Cap Screw (#8 - 32 x 1/2")	(1)	Y154-42-C
5	Flat Packing	(2)	91472
6	Packing	(2)	91471
7	Spray Gun Body and Adapter Assembly	(1)	66178
8	Ball and Stem Assembly	(1)	66597-3
9	Cap and Guard Assembly (651513-12-B only) (includes items 28, 29 and 30)	(1)	66504
10	Washer	(1)	91180
11	Screw	(1)	92426
12	Washer	(1)	91181
13	Cap	(1)	91787
14	"O" Ring (1/16" x 1-1/2" o.d.)	(1)	Y325-28

Item	Description (size)	(Qty)	Part No.
15	Nut (#10 - 32)	(1)	Y22-110-C
16	Piston	(1)	91633
17	Cover	(1)	91636
18	Collet Nut	(1)	91474
19	Piston Rod	(1)	91628
20	"O" Ring (1/16" x 3/8" o.d.)	(1)	Y325-10
21	Set Screw (1/4" - 28 x 5/16")	(1)	Y23-43
22	Spring	(1)	91832
23	Adjusting Screw	(1)	91788
24	Nut	(1)	91789
25	Screw	(1)	92427
26	Gasket	(1)	92425
27	Ball Seat	(1)	92424
28	Retaining Nut	(1)	75807-1
29	Nozzle Guard	(1)	91999
30	Feed Ring Wire	(1)	91338

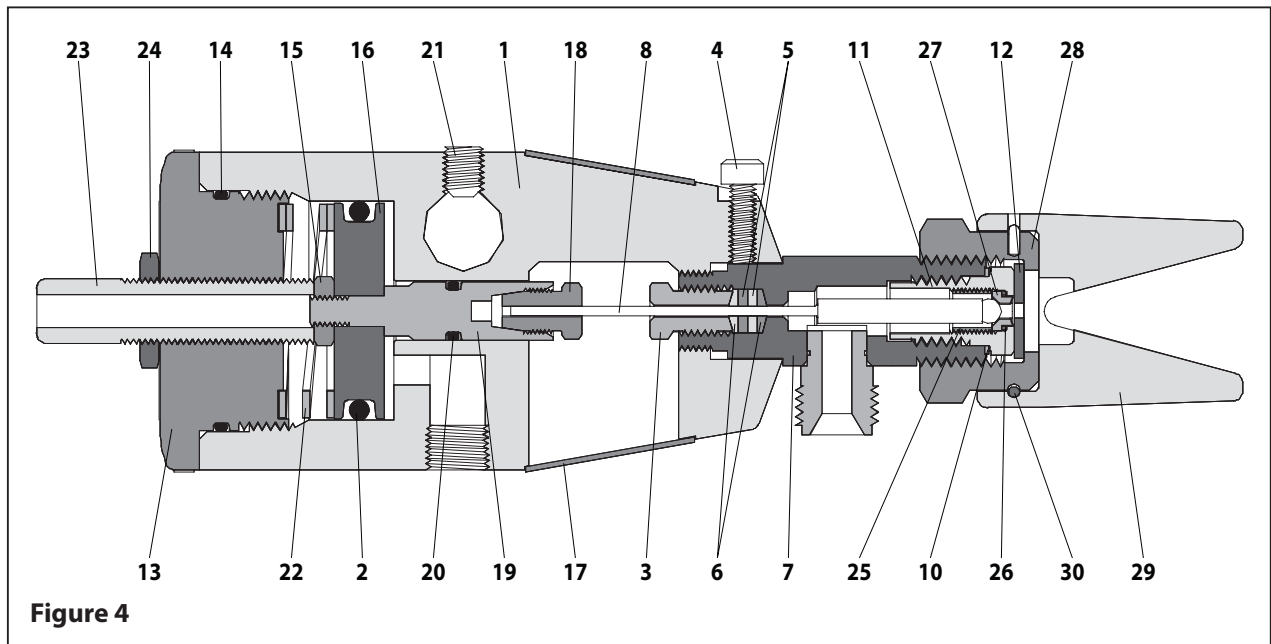


Figure 4

EXTRUSION TIPS AVAILABLE

Extrusion nozzle and retaining nut assembly (not included and must be ordered separately). Used on models 651613-11-B.

Tip Number	Orifice Diameter	Tip Number	Orifice Diameter
66541-03	0.031"	66541-15	0.156"
66541-04	0.046"	66541-17	0.172"
66541-06	0.063"	66541-18	0.187"
66541-09	0.093"	66541-25	0.250"
66541-12	0.125"	66541-37	0.375"

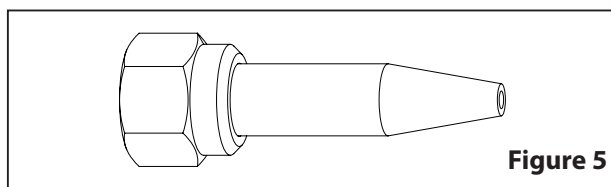


Figure 5

SPRAY TIPS AVAILABLE

Spray tip (must be ordered separately by customer). See tip chart for desired size. Used on models 651513-12-B.

Tip Number	Orifice	Pattern Width
TC-1850	0.018"	10"
TC-2140	0.021"	8.5"
TC-2150	0.021"	11.5"
TC-2640	0.026"	9"
TC-2650	0.026"	12"

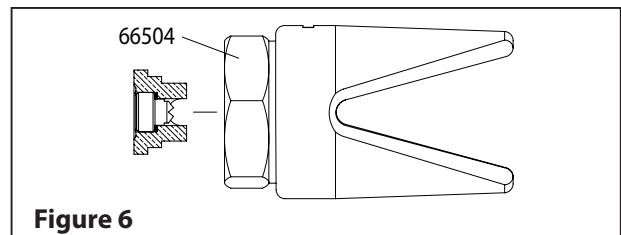


Figure 6

