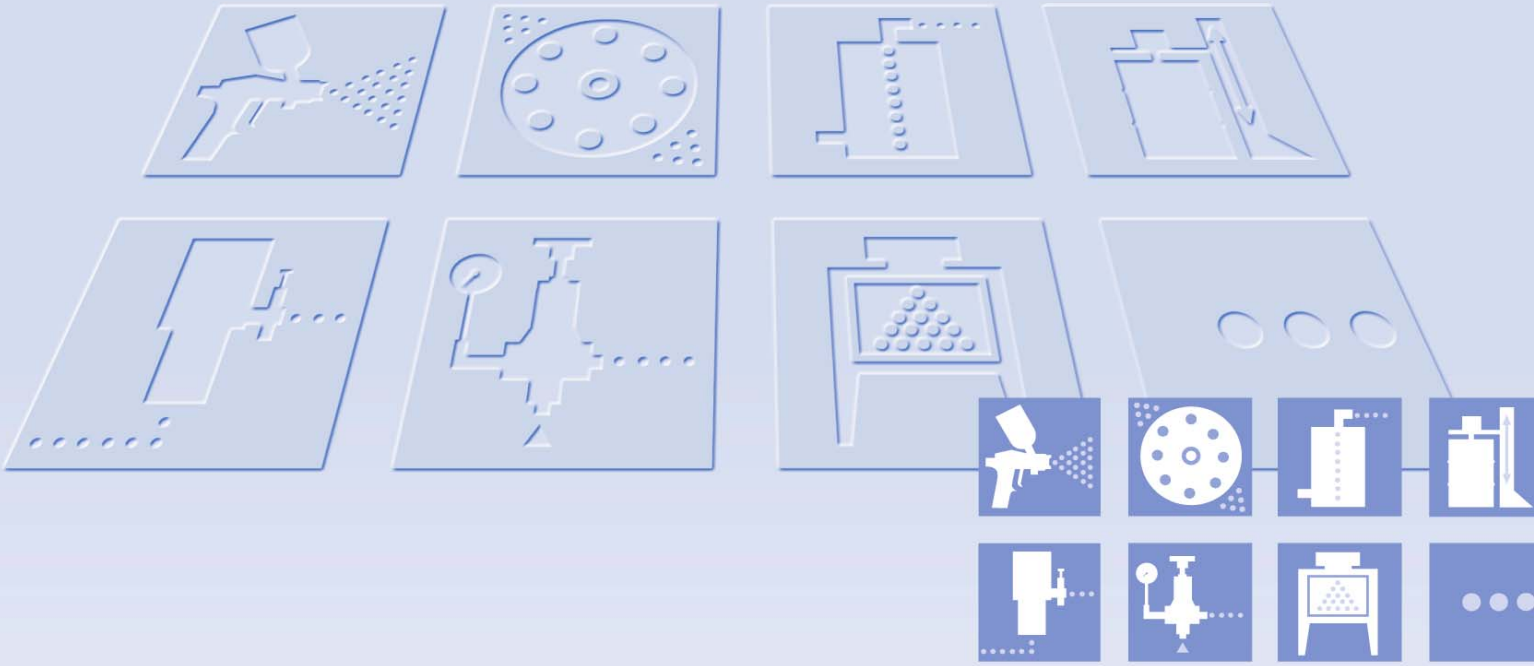


Operating instructions and spare parts list

DOK-044-GB Rev. 2

Spray gun

Type HS-25/2K

Art. No. 2585-090-...

- keep for future use –

CE

Krautzberger

Operating instructions for the 2-component spray gun HS-25/2K

N.B.:

⚠ **NEVER POINT SPRAY GUNS AT PEOPLE**

⚠ **SOLVENTS AND THINNING AGENTS CAN CAUSE BURNS!**

⚠ **THE SPRAY GUN MUST BE DISCONNECTED FROM THE COMPRESSED AIR SUPPLY BEFORE ANY REPARE WORK IS CARRIED OUT!**

⚠ **IN THE WORK AREA, POTENTIAL SOURCES OF IGNITION SUCH AS OPEN FLAMES, NON EXPLOSION-PROTECTED LAMPS, ELECTRIC MOTORS ETC. ARE STRICTLY FORBIDDEN!**

⚠ **THE RELEVANT REGULATIONS ON WORK SAFETY MUST BE OBSERVED AT ALL TIMES!**

⚠ **ALWAYS ADHERE TO THE RELEVANT ACCIDENT PREVENTION REGULATIONS!**

Design

The 2-component spray gun consists of a main and an auxiliary nozzle system and is designed for the application of 2-component materials. The A component is applied via the main nozzle system and the B component via the auxiliary nozzle system. Atomisation of the A component in the main nozzle system is effected in accordance with HVLP specifications.

The material is transported to the gun through hoses; material feed can therefore be effected either from a pressure feed container or with the aid of a pump.

Startup

Unpack the spay gun and clean away any packaging remains.

When the spray gun has been connected up to the compressed air supply, activate the trigger several times to blow air through the gun in order to remove any foreign particles from the air ducts.

Then connect the gun up to the material feed system; the gun is now ready for use.

Material feed regulation

a) Main (A component) nozzle system

Screw the adjusting screw of the end piece (item 13-1) into the gun until the material needle (item 9) no longer moves when the trigger (item 24) is activated. The adjusting screw is then loosened to set the needle distance required for the desired material discharge. The larger the needle travel, the greater the material feed.

b) auxiliary (B component) nozzle system

The activator feed can be varied using two nozzle system sizes as well as on the basis of material pressure.

Air regulation

The spray gun is equipped with a built-in regulator (item 6) for fine regulation of the air throughput directly on the gun.

Jet regulation

The main nozzle system of the spray gun is fitted as standard with a flat jet nozzle (item 3). The built-in jet regulator (item 14) enables the user to vary the output from a full flat jet to a fine circular jet to suit the workpiece to be processed.

Working pressure

Upstream installation of a pressure reducer (ensure sufficient air throughput) guarantees uniform working pressure. The required pressure head depends on the viscosity of the material to be processed and must be set accordingly.

Work interruption

Before stopping for breaks, the spray gun must be rinsed through/cleaned using a suitable solvent. This prevents caking of material remains and ensures constant availability.

Nozzle set change

Material nozzles and needles – as well as gaskets – are wearing parts which need to be replaced periodically.

a) Main (A component) nozzle system

To remove the nozzle set , first unscrew the closer section (item 13/13-1) and pull out the entire valve axis (item 8) together with needle (item 9) and valve spring (item 12) towards the back.

Then loosen the sealing screw (item 11) of the valve axis and remove the material needle together with the needle spring (item 10). Before fitting a new material needle, you should check whether its setting dimension. (needle tip to needle nuts) matches the data on the spare parts drawing. If necessary, adjust the setting dimension and fix the needle nuts in place using a locknut.

To change the air and material nozzle, first loosen the nut (item 1) by hand and remove the gasket (item 2) and the air nozzle (item 3). The material nozzle (item 4) can then be screwed off. The threads off the new parts should be lightly greased. It is important to ensure that the material nozzle is tightly screwed in place.

b) Auxiliary (B component) nozzle system

To remove the material needle (item 39), first loosen and remove the needle carrier (item 49) and the nut (item 50). Then unscrew the screw (item 40) and pull out the needle. Then loosen the nut (item 38), remove the air cap (item 37) and unscrew and replace the material nozzle (item 36). Before fitting a new material needle, push the spring (item 41) and the screw (item 40) onto the threaded end of the needle; then screw on the needle carrier (item 49) and the nut (item 50). When the setting dimension is correct (see spare parts drawing), fix in place using a locknut. Then insert the parts in the housing (item 35) and screw in the screw (item 40). The threaded parts should be lightly greased.

Cleaning and maintenance

When cleaning the spray gun and in particular the air cap, never use sharp-edged or pointed tools (wire, twist drill or similar). Special flat/round brushes with plastic bristles are available for this purpose. Never immerse the whole gun in solvent! This would destroy the gaskets.

Proceed as described in the section “work interruption” and rinse the gun through using a suitable solvent. Ex-

ternal cleaning can be effected using a brush an solvent.

After cleaning, the moving parts of the gun which are accessible from the outside should be lightly oiled.

these parts are:

- the trigger axis (item 23)
- the material needle (item 9) in front of the sealing nut (item 22)
- the valve axis (item 8) in front of the sealing screw (item 19)
- the carrier (item 20) on the presser mushroom
- the material needle (item 39) in front of the screw (item 40)
- the needle carrier (item 49)

Incorrect functioning

Incorrect functioning can be caused by, among other things, the following:

The material nozzle has been insufficiently tightened. This can cause air to enter the material duct and lead to jolting operation of the gun.

The use of impure compressed air . Condensate and floating particles can get into the spray gun and lead to defective spray coats. This problem can be avoided by using a a pressure reducer filter.

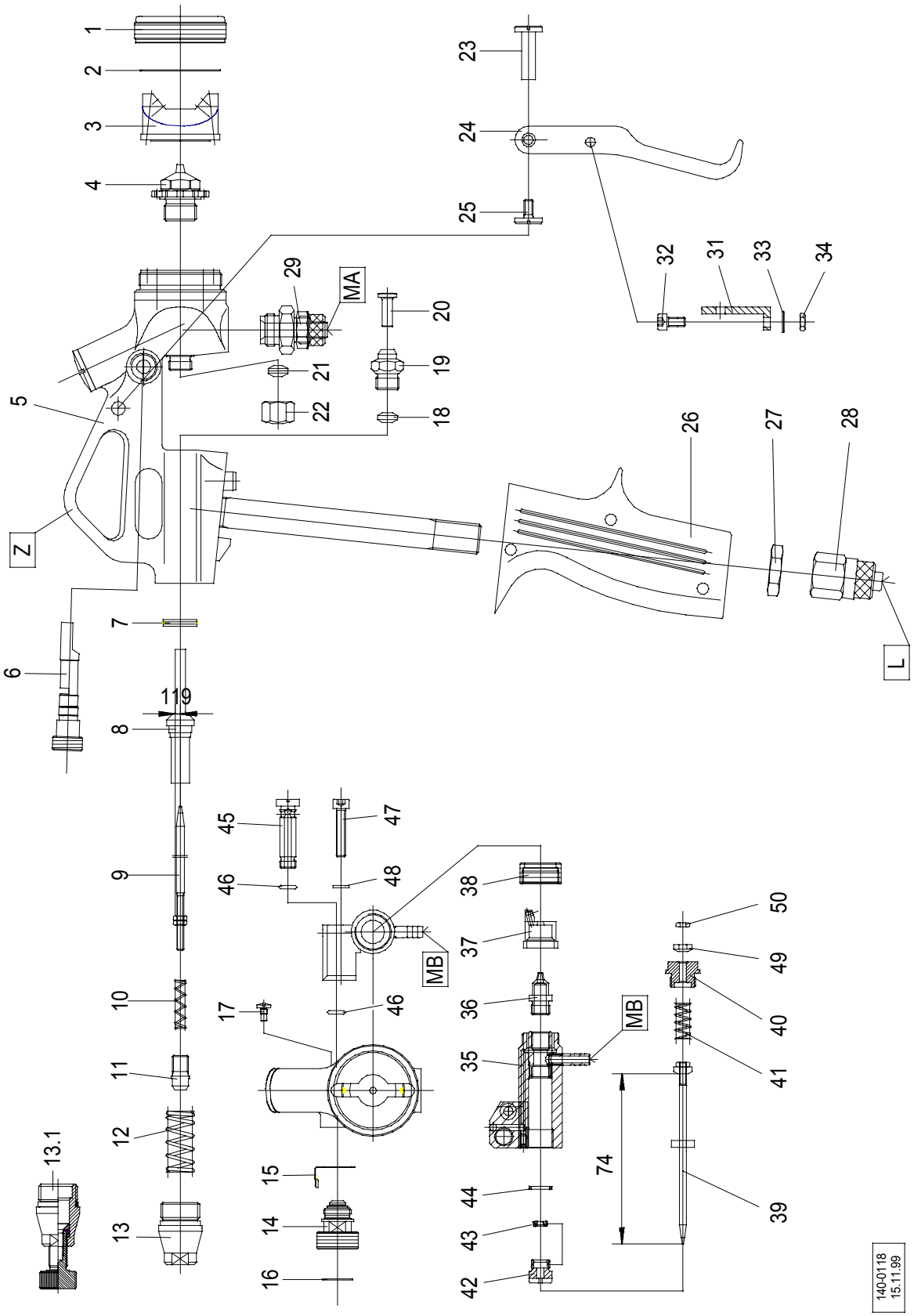
Soiled air gap between air and material nozzle or blocked borings in the humps of the air cap. This leads to an uneven material jet. These parts should therefore always be kept clean.

Spare parts list

Item	Art.No.	Designation
01	2583-040-0075	Nut
* 02	2583-010-0401	gasket
** 03	2583-060-....	Air cap, HVLP, (main nozzle system)
** 04	2583-050-....	Material nozzle, HVLP, (main nozzle system)
05	2585-080-0605	Main element
06	2500-080-0231	Air regulator
* 07	2500-010-0015	Gasket
08	2500-040-0644	Valve axis
** 09	2500-070-....	Material needle
10	2500-020-0002	Spring
11	2500-040-0651	Screw
12	2500-020-0001	Spring
13	2585-080-1758	End piece
13.1	2585-080-0306	needle stroke adjuster
14	2585-080-0485	Jet regulator
15	2585-020-0024	Spring
16	2585-040-0212	Dial disc
17	2500-040-0672	Screw
* 18	2500-010-0014	Gasket
19	2500-040-0107	Screw
20	2500-040-0652	Carrier
21	2500-010-0007	gasket, PTFE-graphite
22	2500-040-0658	Nut
23	2500-040-0538	Trigger axis
24	2585-040-2496	Trigger
25	2500-030-1373	Screw
26	2500-080-0315	Grip
27	2500-040-0654	Nut
28	2585-030-3131	Screw connector
29	2585-040-2588	Screw connector
31	2585-040-2392	Angle bracket
32	2585-030-0209	Screw
33	2585-030-2856	Washer
34	2585-030-2897	Nut
35	2585-080-0949	Housing
** 36	2585-050-....	Material nozzle
** 37	2585-060-....	Air nozzle
38	2585-040-2009	Nut
** 39	2585-070-....	Material needle
40	2585-040-2007	Screw
41	2585-020-0044	Spring
42	2585-040-2370	Screw
* 43	2585-010-0035	Gasket
* 44	2585-010-0034	Gasket
45	2585-040-2029	Screw
* 46	2585-010-0715	Gasket (2pcs.)
47	2585-030-0527	Screw
48	2585-030-1897	Washer
49	2585-070-0727	Needle carrier
50	2585-030-2913	Nut
-	2585-010-0658	Gasket set
-	7026-120-0353	Tool set

* contained in the gasket

** available nozzle sizes: (main system/ auxiliary nozzle system): 0,8/0,3 mm; 1,2/0,5 mm; 1,2/0,8 mm; 1,5/0,5 mm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Declaration of conformity

under the terms of the EC Directive 89/392 EEC and the amendment directives 91/368/EEC, 93/44/EEC and 93/68/EEC

Krautzberger GmbH, Stockbornstrasse 13, D-65343 Eltville

Design of unit:	**Spray gun**
Type designation:	**HS-25/2K**
Make:	**Krautzberger GmbH**
Serial no.:	**2585-000**

The spray gun type HS-25/2K was developed, designed and produced in compliance with the EC Directive 89/392/EEC.

The following harmonised standards were applied:

- EN 292, Safety of Machines, Plant and Equipment
- EN 1953, Spraying Equipment for Coating Substances, Safety Requirements (German version prEN 1953: 1995)

The following documents are fully available:

- Overall diagram of the spray gun type HS-25
- Detailed and complete diagrams for the checking of compliance of the spray gun type
- HS-25 with the basic safety and health safety requirements
- A list of the basic requirements from EC Directives, standards and specifications applied during the development, design and production of the spray gun type HS-25
- A description of the solutions to prevent hazards arising from use of the spray gun type HS-25
- A copy of the operating instructions

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head of design