

ST1 AIR PURGE SPRAY GUN QUICK START GUIDE

EN



READ THE MANUAL Before operating finishing equipment, read and understand all safety, operation, and maintenance information provided in the operation manual.



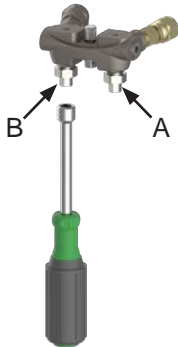
OPERATOR TRAINING All personnel must be trained before operating this equipment.



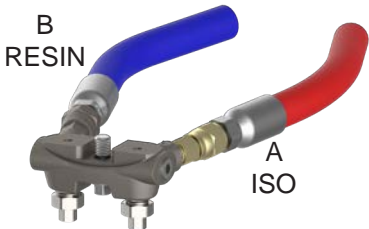
SKIN INJECTION HAZARD Relieve pressure before disconnecting hydraulic/other lines. Tighten all connections before applying pressure.

GETTING STARTED / SET UP

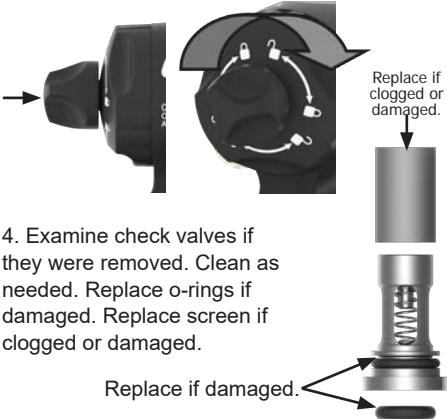
1. Close A-side and B-side shut off valves using 5/16" nut driver and turning counter clockwise.



2. Connect A (ISO) and B (Resin) hoses to manifold.



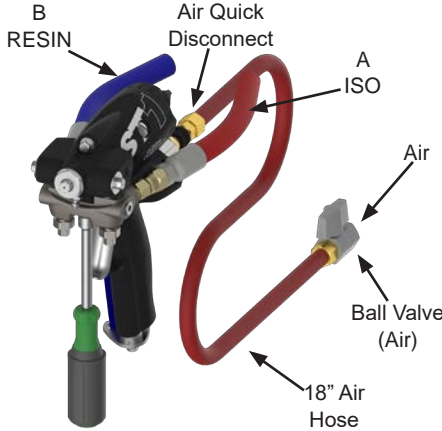
3. Engage safety stop/lock by pressing in and turning clockwise.



4. Examine check valves if they were removed. Clean as needed. Replace o-rings if damaged. Replace screen if clogged or damaged.

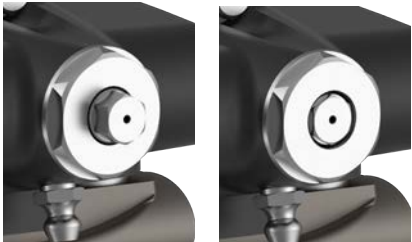
Replace if damaged.

5. Connect manifold (with A and B hoses) to gun. Connect ball valve to 18" air hose and connect main air to ball valve. Use quick disconnect coupler to connect air to gun.



6. Turn on air and open ball valve (air). Air should now flow through the mix tip with gun not triggered.

7. Keep shut-off valves closed. Disengage safety stop/lock and trigger gun. Piston will actuate. Mix tip will come flush with front of gun and air will stop flowing from tip when gun is triggered.



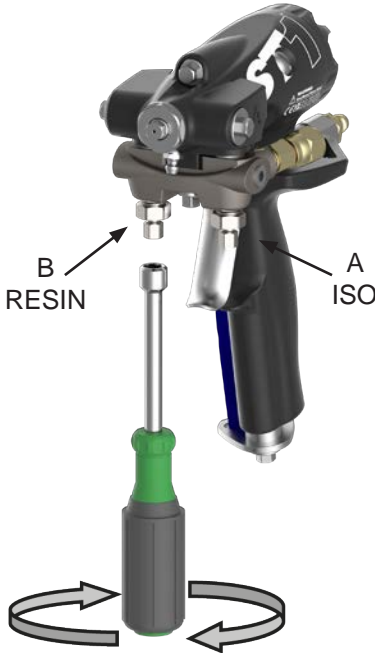
8. Apply thin layer of lubricant over front of gun to prevent overspray build up and to aid in disassembly.

9. Engage safety stop/lock.



10. Turn on the proportioner. Follow manufacturers guidelines prior to starting the proportioner.

11. Fully open B (Resin) shut-off valve using 5/16" nut driver and turning counter clockwise. Then open A (ISO) shut-off valve.



12. Disengage safety stop/lock.



13. Test spray onto cardboard or plastic. Adjust pressure and temperature to get desired results.

14. When pressure and temperature are set, and the foam is satisfactory, the gun is ready to spray.

CAUTION

Air supply is required for gun actuation. Do not connect gun air supply until fluid pressure is relieved.

GROUNDING

Check local electricity code and proportioner manual for grounding instructions.

Ground spray gun through connection to a IntelliSpray™ approved grounded fluid supply hose.

PRESSURE RELIEF AND SHUT DOWN

WARNING

Relieve pressure before cleaning or servicing gun

1. Engage safety stop/lock.



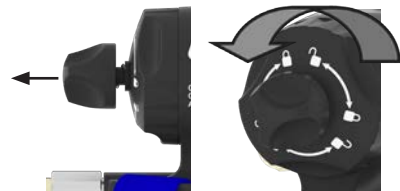
CAUTION

Air supply is required for gun actuation. Do not disconnect gun air supply until fluid pressure is relieved.

2. Close shut-off valves A and B using a 5/16" nut driver and turning clockwise. Leave air valve open.



3. Disengage safety stop/lock



4. Trigger onto cardboard or into waste container to relieve pressure.

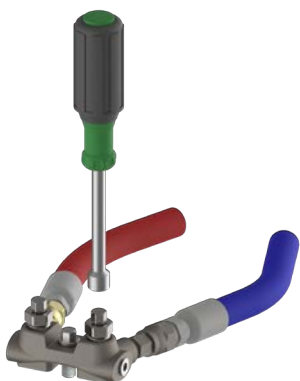
5. Engage safety stop/lock.



WARNING

Fluid in the hose and proportioner is still under pressure. Follow the pressure relief procedure in the proportioner manual.

To relieve pressure in the hose after the gun is removed, place fluid manifold over a container facing away from you. Carefully open the shut off valves. Be aware that fluid will spray sideways from the fluid ports when under pressure. Open Slowly.



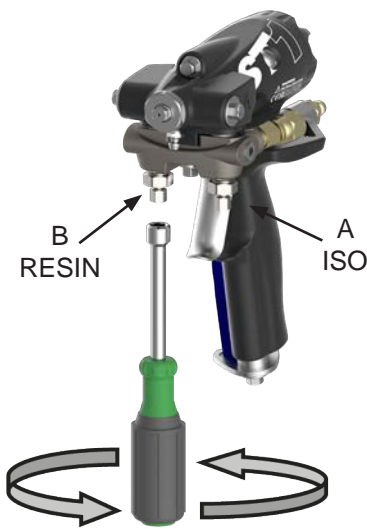
LOSS OF AIR PRESSURE

WARNING

In the event of the loss of air pressure, gun will continue to spray. To shut off gun, engage the safety stop/lock and/or close both shut off valves.



Push in knob and turn clockwise to lock and stop fluid flow.



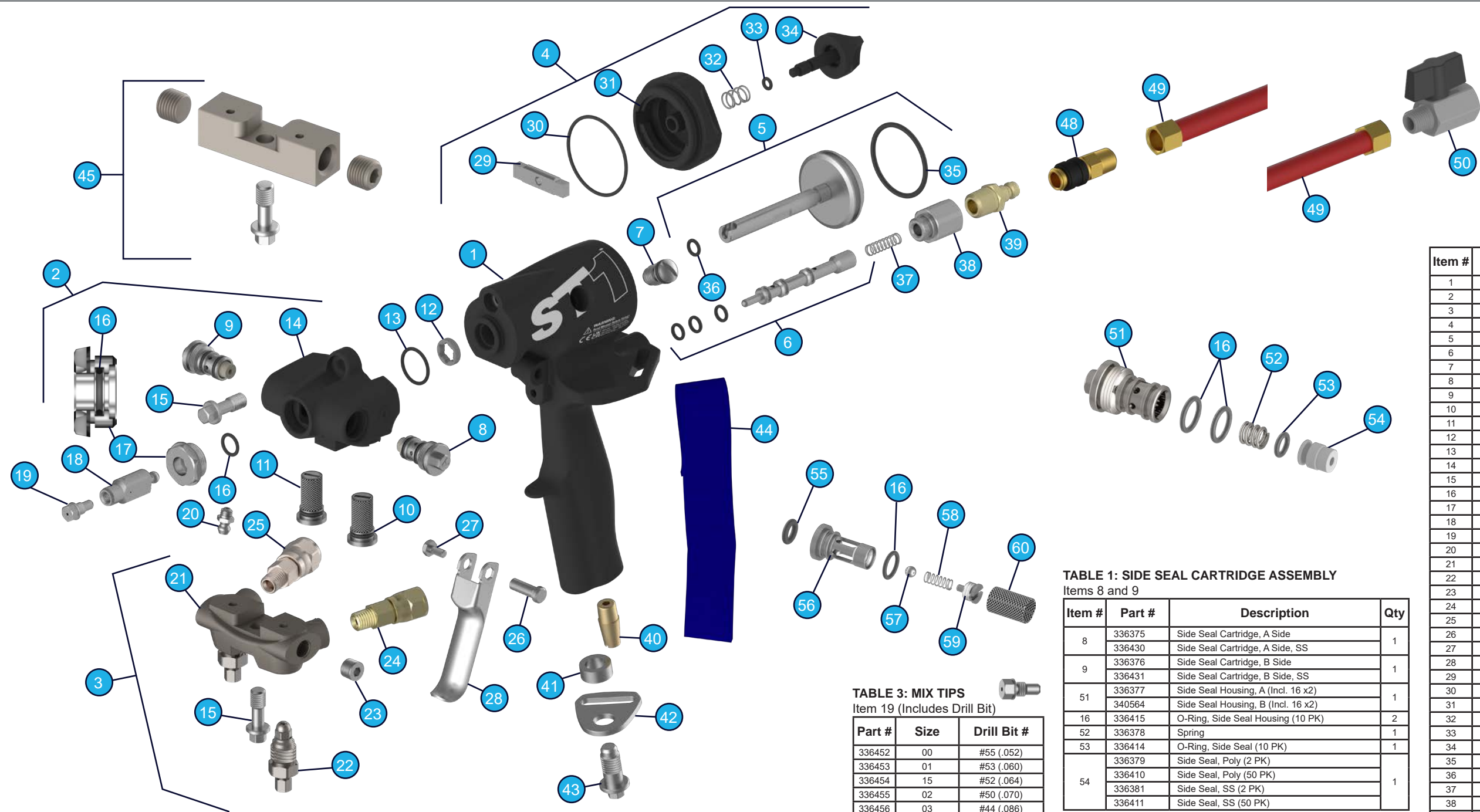
Close shut off valves A and B with a 5/16" nut driver by turning counter clockwise.

AIR PRESSURE KEEPS GUN IN TRIGGERED POSITION

WARNING

A DAMAGED O-RING IN THE AIR VALVE CAN CAUSE THE GUN TO KEEP SPRAYING. SHUT OFF AIR IMMEDIATELY

Then engage the safety stop. Push knob in and turn clockwise. Shut off manual valves.



HARDENED MIX TIPS
Item 19 (Includes Drill Bit)

Part #	Size	Size Equivalent
336802	01	(.060)
336803	15	(.064)
336804	02	(.070)
336805	03	(.086)
336806	04	(.093)

EXTENSION TIPS
(Includes Drill Bit)

Part #	Size	Added Length
336458	01 XS (.060)	1/2"
336459	01 XL (.060)	1"
336460	15 XS (.064)	1/2"
336461	15 XL (.064)	1"
336462	02 XS (.070)	1/2"
336463	02 XL (.070)	1"

STANDARD MIX CHAMBER/TIP COMBOS
Item 18 and 19 (Includes Drill Bits)

Part #	Mix Chamber	Mix Tip	Size Equivalent
336440	A	00	2929
336441	B	01	4242
336442	C	15	4747
336443	D	02	5252
336444	E	03	6060
336445	F	04	7070

TABLE 2: MIX CHAMBERS
Item 18 (Includes Drill Bit)

Part #	Size	Drill Bit #
336446	A	#68 (.031)
336447	B	#58 (.042)
336448	C	#56 (.047)
336449	D	#55 (.052)
336450	E	#53 (.060)
336451	F	#50 (.070)

TABLE 3: MIX TIPS
Item 19 (Includes Drill Bit)

Part #	Size	Drill Bit #
336452	00	#55 (.052)
336453	01	#53 (.060)
336454	15	#52 (.064)
336455	02	#50 (.070)
336456	03	#44 (.086)
336457	04	#42 (.093)

TABLE 1: SIDE SEAL CARTRIDGE ASSEMBLY
Items 8 and 9

Item #	Part #	Description	Qty
8	336375	Side Seal Cartridge, A Side	1
	336430	Side Seal Cartridge, A Side, SS	
	336376	Side Seal Cartridge, B Side	
9	336431	Side Seal Cartridge, B Side, SS	1
	336377	Side Seal Housing, A (Incl. 16 x2)	
	340564	Side Seal Housing, B (Incl. 16 x2)	
16	336415	O-Ring, Side Seal Housing (10 PK)	2
52	336378	Spring	1
53	336414	O-Ring, Side Seal (10 PK)	1
54	336379	Side Seal, Poly (2 PK)	1
	336410	Side Seal, Poly (50 PK)	
	336381	Side Seal, SS (2 PK)	
	336411	Side Seal, SS (50 PK)	

CHECK VALVE ASSEMBLY A AND B
Items 10 and 11

Item #	Part #	Description	Qty
55	336418	O-Ring, Check Valve Face (10 PK)	1
56	NA	Check Valve Housing, A Side	1
		Check Valve Housing, B Side	
16	336415	O0 Ring, Housing (10 PK)	1
57	336427	Ball, Check Valve (10 PK)	1
58	336362	Spring	1
59	NA	Spring Retainer	1
60	336422	Filter Screen, 40 Mesh (10PK)	1
	336423	Filter Screen, 60 Mesh (10PK)	

Item #	Part #	Description	Qty
1	336352	Handle	1
2	336426	Front End Assembly (Incl. 8-11, 14-17, 20)	1
3	336654	Fluid Manifold Assembly (Incl. 15, 21-25)	1
4	336429	Safety Stop Assembly (Incl. 29-34)	1
5	336370	Rod And Piston Assembly (Incl. 35-36)	1
6	336366	Valve Stem (Incl. 36 x3)	1
7	336394	Check Valve Assembly, Air (Incl. 16 x1)	1
8	See Table 1	Side Seal Cartridge, A Side	1
9	See Table 1	Side Seal Cartridge, B Side	1
10	336360	Check Valve Assembly, A Side (Incl. 16, 55-60)	1
11	336361	Check Valve Assembly, B Side (Incl. 16, 55-60)	1
12	336359	Shaft Guide, Delrin	1
13	336417	O-Ring, Head/Handle Junction (2 PK)	1
14	336353	Gun Head	1
15	336356	Manifold Screw (2 PK)	2
16	336415	O-Ring, Guide and Housing (10 Pk)	7
17	336437	Guide Assembly (Incl. 16-17)	1
18	See Table 2	Mix Chamber	1
19	See Table 3	Mix Tip	1
20	336738	Grease Fitting	1
21	336355	Fluid Manifold	1
22	336372	Fluid Manifold Valve Assembly	2
23	336335	Pipe Plug, 1/8" NPT, SS	2
24	336357	Swivel Adapter, A Side	1
25	336358	Swivel Adapter, B Side	1
26	336364	Trigger Stud	1
27	336365	Trigger Screw	1
28	336363	Trigger	1
29	336736	Lock Arm	1
30	336420	O-Ring, End Cap (2 PK)	1
31	336373	End Cap	1
32	336735	Spring	1
33	336413	O-Ring, Safety Stop (2 PK)	1
34	336737	Safety Stop Knob	1
35	336419	O-Ring, Air Piston (2 PK)	1
36	336412	O-Ring, Air Valve/Piston Rod (10 PK)	4
37	336367	Spring	1
38	336395	Quick Disconnect Base	1
39	336396	Quick Disconnect Stem	1
40	336374	Muffler	1
41	336400	Spacer	1
42	336399	Gun Clip	1
43	336401	Stud	1
44	336398	Strap	1
45	336436	Flush Manifold Assembly (Incl. 15, 46-47)	1
46	336433	Flush Manifold	1
47	336336	Pipe Plug, 1/4" NPT SS	1
48	336397	Quick Disconnect Air Line Coupler	1
49	336643	Hose Assembly	1
50	336408	Ball Valve	1
-	347411	Cover, ST1 Spray Gun	1
-	336406	Grease Cartridge, 3 OZ	1