

## 1. Air quantity control

To set the air to material ratio, adjust the stepless air micrometer by hexagon socket screw key.

## 2. Exchange of nozzle set

When changing to another nozzle size, make sure that the complete nozzle set is exchanged. A set comprises of air cap, Paint needle and paint nozzle. Insert paint nozzle before putting in paint needle.

### 3. Exchange of the self tensioning sealings

The needle seal is effected by a Teflon seal and a needle packing with self-tensioning compression Spring. To change the packing Please use the socket Spanner Provided.

#### **4. Cleaning and Gun care**

- A) Flush gun thoroughly with solvent
- B) Clean air nozzle with brush. Do not plate the gun into solvent.  
Clogged holes should never be cleaned with improper objects, at the smallest amount of damage
- C) may badly influence the spray pattern.
- D) Slightly oil movable parts.

## Trouble

1. Gun leaks from fluid nozzle.
2. Paint emerges from fluid needle-needle sealing.
3. Spray pattern in sickle shape.
4. Drop-like or oval shaped pattern.
5. Paint spray flutters.
6. Material bubbles or “boils” in paint cup.

## Cause

1. Foreign substances between fluid nozzle and fluid needle prevent sealing.
2. Self tensioning needle sealing damaged or lost.
3. Horn air holes or air circuit clogged
4. Dirt on fluid needle tip or air outlet.
5. Too little material in cup, fluid nozzle not tight, needle sealing damaged, nozzle set dirty or damaged.
6. Atomization air flows through the paint channel to the cup. The paint nozzle is not tight enough. Air nozzle is not completely screwed, the air net clogged and the seat is defective or nozzle insert is damaged.

## Repair

1. Clean fluid needle and fluid nozzle in thinner or use new fluid nozzle.
2. Replace needle sealing.
3. Soak in thinner, after wards clean with nozzle-cleaning needle.
4. Turn air nozzle by 180 degrees. If defective pattern remains, clean paint outlet in air nozzle.
5. Refill material, tighten parts, if necessary clean or replace parts.
6. Tighten parts accordingly, clean or replace.

**SIMALFA®**

## **Model G21 AIR SPRAY GUN, PRESSURE FEED, HVLP**



