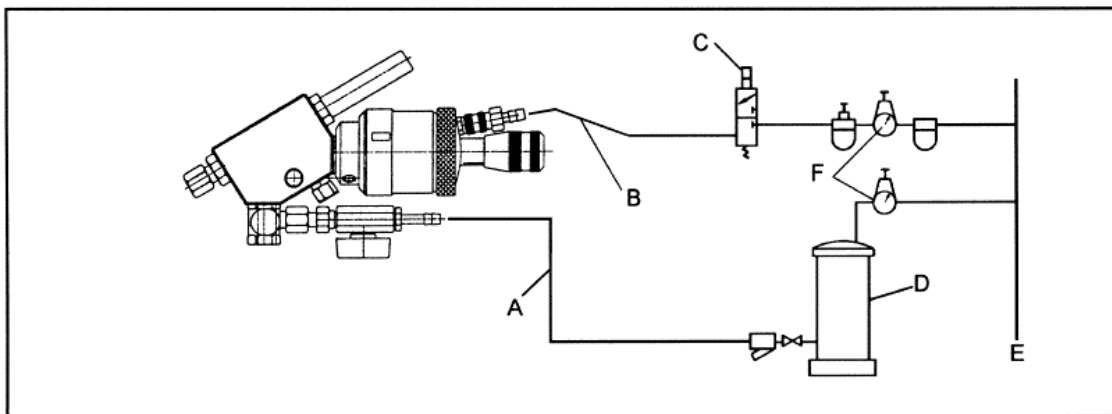
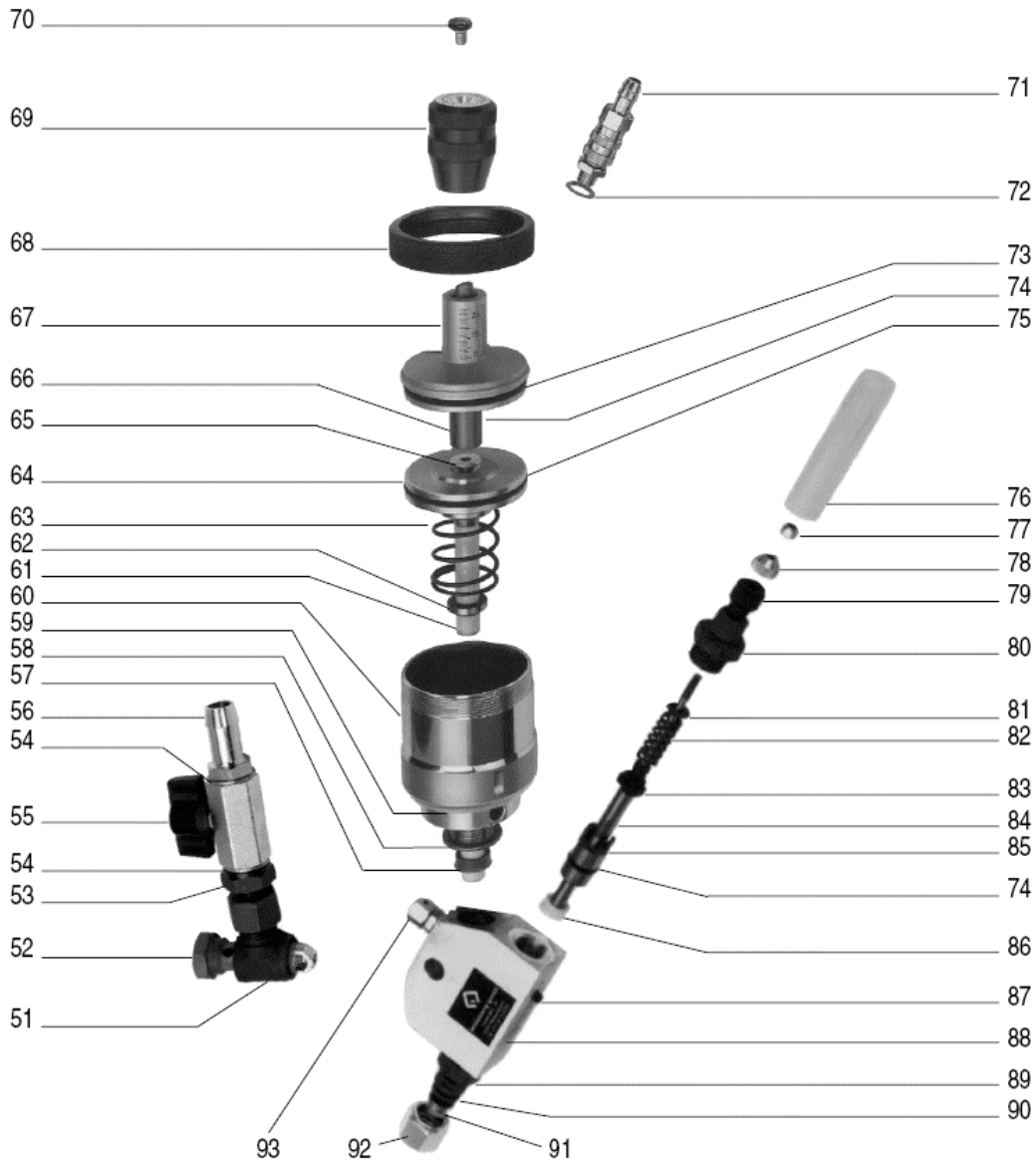




High Velocity Spray Gun type HDP-II



Technical Data

Air pressure/spray gun	75–90 p.s.i.
Material (compound) pressure	50–90 p.s.i.
Hose ID; air	3/8"
Hose ID; material (compound)	1/2"
3-way valve - normally closed – port size	3/8" NPT
Minimum flow \varnothing	1/4"
Spray amount per shot (adjustable)	0.2–3 cm ³
Air consumption/spray gun	approx. 0.75 m ³ /h

Installation diagram

A	Compo connection
B	Air connection
C	Solenoid valve
D	Pressure vessel or pump
E	Main line (air)
F	Pressure control

Spare parts list

Item no.	Description	Part no.	Item no.	Description	Part no.
	Original WIDOBORG High Velocity Spray Gun Type HDP-II	104442	76	Cap	101630
			77	Hexagon nut	101656
			78	Knurled nut	101095
			79	Compression screw	101044
51	Banjo connection	101818	80	Threaded bushing	101036
52	* Check valve assembly	101249	81	Spring plate	101052
53	Connection piece	101354	82	* Compression spring	101060
54	Sealing ring	101850	83	Collar	101079
55	Stop cock	101826	84	* Needle valve	101087
56	Hose connection	111724	85	Guide bushing	101028
57	* Cup seal	101664	86	* Cup seal	101621
58	* Usit sealing ring	101672	87	Grub screw	101605
59	Cylinderflange	103128	88	Gun body	101010
60	Cylinder	111481	89	Insert assembly	101109
61	* Plunger	101150	90	* Valve seat	101290
62	Strip ring	103136	92	Retaining nut	101117
63	* Compression spring	111457	93	Bleed valve assembly	101346
64	* Flat seal for piston assembly	101648			
65	Countersunk screw	101699	91	Standard Nozzle 0°	103004
66	Spindle	111511	91	Standard Nozzle 20°	103209
67	Cylinder cover	111503	91	Standard Nozzle 40°	103403
68	Retaining nut	111554	91	Standard Nozzle 65°	103659
69	Knurled knob	111538	91	Standard Nozzle 90°	103900
70	Flat head screw	111546	91	Standard Nozzle 120°	104000
71	Quick connection	111562	91	Barrel Nozzle 40°	105406
72	Sealing ring	111570	91	Barrel Nozzle 65°	105651
73	* O-ring	101702	91	Barrel Nozzle 90°	105902
74	O-ring	101613	91	Barrel Nozzle 120°	106011
75	* Piston assembly	111473			

Parts marked with * should be kept in stock.



Installation

1. Mount gun on a support. Use 12 mm (15/32") Ø hole in gun body.
2. Connect compressed air to quick connection no. 71.
Please use clean lubricated air.
3. Install 3-way control valve (minimum flow Ø, 1/4") as close as possible to the gun.
When using a 3-way solenoid valve, valve is "normally closed" when de-energized. Actuation of valve can be made through an automatic timer or manually.
4. Connect material feed (compound hose) to connection no. 56. A dirt trap (strainer) in feed line is recommended. Strainer mesh size: 30.

Start-up

1. Open material shut-off valve no. 55.
2. Open bleed valve nut no. 93 slightly until material emerges.
3. Actuate control valve to vent gun and then close bleed valve nut no. 93.
Adjust compression spring no. 82 by means of compression screw no. 79 so needle valve no. 84 opens upon actuation of control valve.
4. Adjust quantity of spray by means of knurled knob no. 69.

Care and maintenance

To avoid damaging seals, never immerse spray gun in hot water or aggressive cleaning fluids. Clean dismantled nozzle with compressed air. Keep all moving parts clean and oil lightly when servicing.

Removal of needle valve no. 84.

Unscrew compression screw no. 79. Unscrew bushing no. 80 from gun body no. 88 and pull out needle valve. When replacing needle valve make sure to check valve seat no. 90 (both sides can be used) or if both sides are worn, also replace valve seat no. 90.

Replacement of plunger no. 61.

Unscrew retaining nut no. 68 (at air connection end) and remove complete cylinder cover no. 67. Pull out complete piston assembly no. 75 including plunger no. 61.

Unscrew countersunk screw no. 65 and push out plunger no. 61 from piston assembly no. 75. When reassembling, tighten screw firmly and secure threads with a locking fluid.

Changing of nozzle

Unscrew retaining nut No. 92 and remove nozzle and valve seat no. 90.



Tips for trouble shooting

No compound emerges from nozzle

Insufficient air pressure: increase to 75 – 90 psi

Gun not properly vented:

Open bleed valve assembly no. 93 to vent. Pull back needle valve by hand to let air escape; this also serves as a check if compound pressure is available.

Nozzle blocked:

Remove nozzle and clean.

Check valve no. 52 binds or leaks:

Clean or replace.

Strainer in dirt trap blocked:

Remove and clean.

Material hardened in feed line:

Clean line and stop cock no. 55.

Plunger no. 61 binds, does not retract:

Replace compression spring no. 63 or piston assembly no. 75 and/or cup seal no. 57.

Gun dribbles:

Compression screw no. 79 loose: tighten. Needle valve no. 84 or valve seat no. 90 worn: replace parts including compression spring no. 82.

When using buffing compound:

To obtain trouble free operation and minimum rate of wear, use airless compositions suitable for high pressure applications.

We reserve the right to make changes for the purposes of improvements and technical progress.