



# Wood Finishing Solutions

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A full line of applicators and spray packages for wood applications.

PROVEN QUALITY. LEADING TECHNOLOGY.

# Spray Technologies

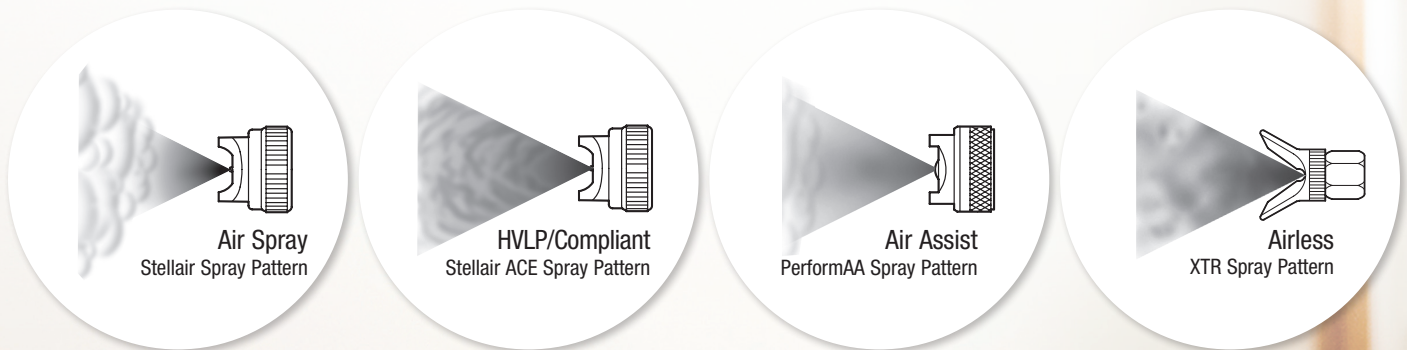
	Air Spray	Compliant	HVLP	Air-Assisted	Airless
Fluids (viscosity)	Low to Medium	Low to Medium	Low to Medium	Low to High	Medium to High
Finish Quality	Class A Decorative	Class A Decorative	Class A Decorative	Decorative Coating	Medium to Coarse
Max Spray Rate	20 oz/min	15 oz/min	10 oz/min	35 oz/min	> 40 oz/min
Transfer Efficiency* (test standards)					
ASTM D-5009	17 - 25%	25 - 32%	25 - 32%	30 - 40%	27 - 35%
EN 13966	60 - 70%	70 - 78%	70 - 78%	75 - 85%	70 - 80%
Typical Fluid Pressure**	5 - 20 psi	5 - 15 psi	4 - 10 psi	300 - 1500 psi	1000 - 2500 psi
Typical Atomizing Pressure**	10 - 60 psi	5 - 35 psi	5 - 30 psi	5 - 30 psi	0 psi
SCFM Requirements***	13 scfm	11 scfm	15 scfm	4 scfm	0 scfm
Graco Applicator	Stellair	Stellair ACE	Stellair ACE	PerformAA™	PerformAA
Graco Fluid Transfer Technology	Cup Guns Pressure Pots Triton®	Cup Guns Pressure Pots Triton	Cup Guns Pressure Pots Triton	Merkur® Merkur ES	Merkur Merkur ES

\*Using ASTM standard - 50% is the maximum transfer efficiency due to conveyor methods of spraying. EN standard sprays on a flat panel.

\*\*Pressure measured at the gun inlet under flow conditions. For best results, use the lowest fluid and air pressure for the job by determining flow rate and viscosity.

\*\*\*SCFM requirements are shown for gun only, and are averages. Pump air consumption is approximately 1.5 scfm for diaphragm pumps, and 2-5 scfm for piston pumps. Note: typical air compressor sizing is 1 HP per 4 scfm.

## SPRAY TECHNOLOGIES



## DEFINITIONS

### AIR SPRAY/CONVENTIONAL

The most widely used finishing method. Referred to as an automotive finish or Class A finish. Easy to use, flexible and provides the finest finish quality and the lowest transfer efficiency.

### COMPLIANT

A controlled air spray technology that reduces bounceback and overspray. The finish quality is compatible to air spray, air consumption is lower than HVLP and the spray rates are higher than HVLP.

### HVLP

A controlled, compliant air spray technology that reduces bounceback and overspray. Finish quality is comparable to air spray, however atomization is generally coarser and spray rates are lower.

### AIR ASSIST

Combines the hydraulic atomization of airless with the atomization of air spray. Ideal for many finishing and coating applications, air assist offers high production levels and a relatively smooth finish - perfect for wood furniture topcoats or fabricated metal parts.

### AIRLESS

Directs fluid under high pressure through a controlled orifice to accomplish airless atomization. Ideal for quickly applying high volumes of coatings to large surfaces. Most often used to apply protective, rather than decorative coatings.

# Stain Applications

Toners, NGR and stains should be applied at low pressures due to the viscosity of the materials. Below are recommendations for low pressure equipment which will apply material with the consistency required to best enhance the wood's color.



## Stellair Spray Gun

Part #: 2004179

- HVLP spray
- Pressure feed
- 0.040" nozzle

Wood air cap for stellar results with low viscosity material, such as stains and toners

Expert-approved ergonomics proven to reduce fatigue potential and improve painter productivity

Available in Conventional (2004178)



## Stellair Ace Spray Gun

Part #: 2005974

- HVLP/LVMP spray
- Pressure feed
- 0.042" (1.1 mm) nozzle
- Includes 6' (1.8m) hose

Lightweight due to unique construction

Speedy serviceability improves uptime



## AirPro Gravity Gun

Part #: 289011

- Conventional spray, gravity feed
- 0.055" nozzle
- Includes 20 oz plastic cup

Superior value air spray gun

3M™ PPS™ cup compatible

Available in HVLP (289014)



## Mini Finex Spray Gun

Part #: 289259

- HVLP, gravity feed
- 0.047" nozzle
- Includes 4 oz plastic cup

Superior value air spray gun

3M™ PPS™ cup compatible

Optional glaze nozzle (24F733) available



## PerformAA Airless Spray Gun

Part #: 26B519

- Airless spray
- Up to 1500 psi

Airless air cap and fine finish spray tips for high quality finish

Optimized weight and ergonomics for operator comfort



## Stellair Auto Spray Gun

Part #: 25F164

- Conventional spray
- General industry air cap
- 0.042" nozzle

Consistent spray pattern for high quality finish

Indexing air cap for pattern placement repeatability

Available in HVLP (25F171) and compliant (25F18)



## Triton Air Spray Package

Part #: 2006381

- 100 psi fluid and air pressure
- Stellair Ace LVMP/HVLP spray gun
- Pail mount, stainless steel pump

Double diaphragm design for smooth changeover and low pulsation

Quick and easy flushing reduces material waste

- Cart Mount (2006386)
- Wall Mount (2008001)
- Stand Mount (2006382)



## Triton Air Spray Package

Part #: 233485

- 100 psi fluid and air pressure
- Stellair HVLP spray gun
- Cart mount, stainless steel pump

Double diaphragm design for smooth changeover and low pulsation

Quick and easy flushing reduces material waste

Available with conventional (233483) or compliant (234914) Stellair gun

## Top Coat Applications

Top coats and lacquers are generally applied with medium pressure equipment due to the mil thickness required for a high quality finish. Air assist equipment will deliver optimal flow rates while maximizing transfer efficiency and increasing productivity.



### PerformAA Spray Gun

Part #: 26B502

- Air assist spray
- HVLP compliant
- Up to 1500 psi

Wood lacquer air cap and fine finish spray tips for high quality finish

Optimized weight and ergonomics for operator comfort

Available in 5000 psi with swivel (26B512)



### PerformAA Auto Spray Gun

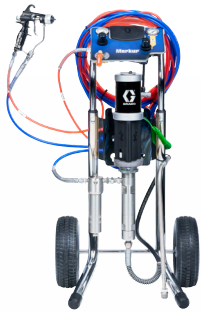
Part #: 26B571

- Air assist spray
- HVLP compliant
- Up to 4000 psi

Air cap alignment index marks for pattern placement repeatability

Graco gauge air cap alignment tool to quickly reset exact cap orientation (26B736)

Wood lacquer air cap and fine finish spray tips for high quality finish



### Merkur Spray Package

Part #: G15C17

- 15:1 air-assisted pump, 0.4 gpm
- PerformAA 15 wood lacquer gun
- Cart mount with 25 ft hose set

Pump outlet filter improves material cleanliness for enhanced spray performance

Easy flush pump lower allows fast color change and reduced solvent usage

Wall mount version (G15W11)

Available with PerformAA 15 general finishing gun cart mount version (G15C09) and wall mount version (G15W07)



### Merkur ES Spray Package

Part #: 24J251

- 15:1 air assist plated-steel pump
- PerformAA 15 wood lacquer gun
- Stand mount with 25 ft hose set

Quick flush pump reduces material and solvent usage

Available with PerformAA 15 general finishing gun on a stand mount (24F151) and wall mount (24F150)

Stainless steel lower version on a stand mount (24F159) and wall mount (24F158)

## Adhesive Applications

Adhesive applications vary in requirements from a bead of material to a full spray pattern. Low pressure equipment will assist in delivering the adhesive to the wood.



### Stellair Spray Gun

Manual Pressure Feed gun part #: 2004173

Automatic gun part #: 25F210

- Conventional spray
- Pressure feed
- 0.051" nozzle



### Stellair Trim Spray Gun

Manual Pressure Feed gun part #: 2004175

Automatic gun part #: 25F204

- HVLP spray
- Pressure feed
- 0.42 (1.1) nozzle

## Trim Applications

Trim air cap produces a well defined edge with minimal overspray, essential for narrow part spraying.

All written and visual data contained in this document are based on the latest product information available at the time of publication. Graco reserves the right to make changes at any time without notice.

Call today for product information or to request a demonstration.

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