

Instructions



Pro Xp™ Auto Waterborne Air Spray Gun

333012J

EN

Automatic Electrostatic Air spray gun for use when electrostatically spraying conductive waterborne fluids that meet at least one of the following conditions for non-flammability:

- ***Material does not sustain burning in accordance with the Standard Test Method for Sustained Burning of Liquid Mixtures, ASTM D4206.***
- ***Air spray system for use when electrostatically spraying conductive, waterborne fluids that meet at least one of the conditions for non-flammability listed on page 4.***

For professional use only.

100 psi (0.7 MPa, 7 bar) Maximum Air Inlet Pressure

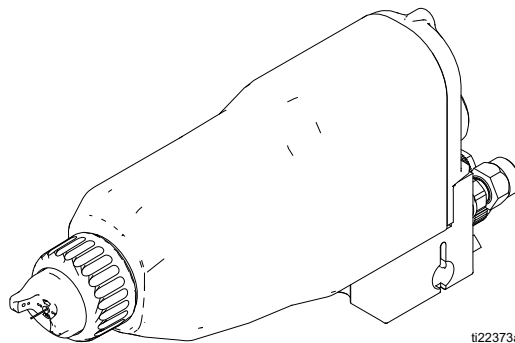
100 psi (0.7 MPa, 7 bar) Maximum Working Fluid Pressure



Important Safety Instructions

Read all warnings and instructions in this manual and in related manuals before using the equipment. Save these instructions.

See page 2 for **Contents** and page 3 for **Models**.



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Models

Part No.	kV	Nozzle	Model	Manifold Mount
LA1M18	60	1.5 mm	Smart	Rear
LA1T18	60	1.5 mm	Standard	Rear

Part No.	Description
24X287	WB 100 Isolation Enclosure
24W597	25' Shielded Waterborne Fluid Hose
24W598	50' Shielded Waterborne Fluid Hose



FM approved for use with fluids that meet the following condition:

- Material does not sustain burning in accordance with the Standard Test Method for Sustained Burning of Liquid Mixtures, ASTM D4206



Models Compliant with EN 50059 when used with fluids that meet the following criteria:

- Material is classified as non-ignitable as defined by EN 50059: 2018.

Related Manuals

Manual No.	Description
332989	Pro Xp Auto Control Module, Instructions
3A2496	WB100 Isolation System, Instructions-Parts

Safety Symbols

The following safety symbols appear throughout this manual and on warning labels. Read the table below to understand what each symbol means.

Symbol	Meaning
	Cleaning Solvent Hazard
	Electric Shock Hazard
	Equipment Misuse Hazard
	Fire and Explosion Hazard
	Pressurized Equipment Hazard
	Splash Hazard
	Ventilate Work Area

Symbol	Meaning
	Wear Personal Protective Equipment
	Toxic Fluid or Fumes Hazard
	Ground Equipment
	Follow Pressure Relief Procedure
	Eliminate Ignition Sources



Safety Alert Symbol

This symbol indicates: Attention! Become Alert! Look for this symbol throughout the manual to indicate important safety messages.

Warnings

The following warnings are for the setup, use, grounding, maintenance, and repair of this equipment. The exclamation point symbol alerts you to a general warning and the hazard symbols refer to procedure-specific risks. When these symbols appear in the body of this manual or on warning labels, refer back to these Warnings. Product-specific hazard symbols and warnings not covered in this section may appear throughout the body of this manual where applicable.

WARNING



FIRE AND EXPLOSION HAZARD

Combustible dust in **work area** can ignite or explode. To help prevent fire and explosion:

- Use only fluids that meet the following flammability requirements:
 - **FM, FMc Approved:**
Material does not sustain burning in accordance with the Standard Test Method for Sustained Burning of Liquid Mixtures, ASTM D4206.
 - **CE-EN 50059 Compliant:**
Material is classified as non-ignitable as defined by EN 50059: 2018.
- **Stop operation immediately** if static sparking occurs or you feel a shock. Do not use equipment until you identify and correct the problem.
- Electrostatic equipment must be used only by trained, qualified personnel who understand the requirements of this manual.
- Ground all equipment, personnel, object being sprayed, and conductive objects in or close to spray area. Resistance must not exceed 1 megohm. See **Grounding** instructions.
- Do not use pail liners unless they are conductive and grounded.
- Check gun resistance, hose resistance, and electrical grounding daily.
- Use and clean equipment only in well ventilated area.
- Interlock the gun air supply to prevent operation unless ventilating fans are on.
- Only use non-flammable solvents when flushing or cleaning equipment.
- Always turn the electrostatics off when flushing, cleaning or servicing equipment.
- Eliminate all ignition sources; such as pilot lights, cigarettes, portable electric lamps, and plastic drop cloths (potential static arc).
- Do not plug or unplug power cords or turn lights on or off when flammable fumes are present.
- Keep spray area free of debris, including solvent, rags and gasoline.
- Keep a working fire extinguisher in the work area.

WARNING



ELECTRIC SHOCK HAZARD

Improper grounding, setup, or usage of an isolated waterborne system can result in electric shock. To help prevent electric shock:

- Ground all equipment, personnel, object being sprayed, and conductive objects in or close to spray area. See **Grounding** instructions.
- Connect the electrostatic gun to a voltage isolation system that will discharge the system voltage when not in use.
- All components of the voltage isolation system that are charged to high voltage must be contained within an isolation enclosure that prevents personnel from making contact with the high voltage components before the system voltage is discharged.
- Follow the **Fluid Voltage Discharge and Grounding Procedure** when instructed to discharge the voltage; before cleaning, flushing, or servicing the system; before approaching the front of the gun; and before opening the isolation enclosure for the isolated fluid supply.
- Do not enter a high voltage or hazardous area until all high voltage equipment has been discharged.
- Do not touch the gun nozzle or electrode, or come within 4 in. (102 mm) of the electrode during gun operation. Follow the **Fluid Voltage Discharge and Grounding Procedure**.
- Interlock the gun air supply with the voltage isolation system to shut off the air supply anytime the isolation system enclosure is opened.
- Only use the red-colored Graco electrically conductive air hose with this gun. Do not use black or gray-colored Graco air hoses.
- Do not splice fluid hoses together. Install only one continuous Graco Waterborne Fluid Hose between the isolated fluid supply and the spray gun.









PRESSURIZED EQUIPMENT HAZARD

Fluid from the equipment, leaks, or ruptured components can splash in the eyes or on skin and cause serious injury.

- Follow the **Pressure Relief Procedure** when you stop spraying/dispensing and before cleaning, checking, or servicing equipment.
- Tighten all fluid connections before operating the equipment.
- Check hoses, tubes, and couplings daily. Replace worn or damaged parts immediately.
-



WARNING

 	<p>EQUIPMENT MISUSE HAZARD</p> <p>Misuse can cause death or serious injury.</p> <ul style="list-style-type: none"> • Do not operate the unit when fatigued or under the influence of drugs or alcohol. • Do not exceed the maximum working pressure or temperature rating of the lowest rated system component. See Technical Specifications in all equipment manuals. • Use fluids and solvents that are compatible with equipment wetted parts. See Technical Data in all equipment manuals. Read fluid and solvent manufacturer's warnings. For complete information about your material, request a Safety Data Sheet (SDS) from your distributor or retailer. • Do not leave the work area while equipment is energized or under pressure. • Turn off all equipment and follow the Pressure Relief Procedure when equipment is not in use. • Check equipment daily. Repair or replace worn or damaged parts immediately with genuine manufacturer's replacement parts only. • Do not alter or modify equipment. Alterations or modifications may void agency approvals and create safety hazards. • Make sure all equipment is rated and approved for the environment in which you are using it. • Use equipment only for its intended purpose. Call your distributor for information. • Route hoses and cables away from traffic areas, sharp edges, moving parts, and hot surfaces. • Do not kink or over bend hoses or use hoses to pull equipment. • Keep children and animals away from work area. • Comply with all applicable safety regulations.
 	<p>PLASTIC PARTS CLEANING SOLVENT HAZARD</p> <p>Many solvents can degrade plastic parts and cause them to fail, which could cause serious injury or property damage.</p> <ul style="list-style-type: none"> • Use only compatible water-based solvents to clean plastic structural or pressure-containing parts. • See Technical Specifications in this and all other equipment instruction manuals. Read fluid and solvent manufacturer's MSDSs and recommendations.
	<p>TOXIC FLUID OR FUMES HAZARD</p> <p>Toxic fluids or fumes can cause serious injury or death if splashed in the eyes or on skin, inhaled, or swallowed.</p> <ul style="list-style-type: none"> • Read Safety Data Sheet (SDS) to know the specific hazards of the fluids you are using. • Store hazardous fluid in approved containers, and dispose of it according to applicable guidelines.
	<p>PERSONAL PROTECTIVE EQUIPMENT</p> <p>Wear appropriate protective equipment when in the work area to help prevent serious injury, including eye injury, hearing loss, inhalation of toxic fumes, and burns. This protective equipment includes but is not limited to:</p> <ul style="list-style-type: none"> • Protective eyewear, and hearing protection. • Respirators, protective clothing, and gloves as recommended by the fluid and solvent manufacturer

Introduction

How the Electrostatic Air Spray Gun Works

The automatic electrostatic air spray gun operates very similar to a traditional air spray gun. The atomization and fan air are emitted from the air cap. The atomization air breaks up the fluid stream and controls the droplet size. The fan air controls the shape and width of the spray pattern. The fan and atomization air can be adjusted independently.

Operating the Spray Function

Applying a minimum of 60 psi (0.42 MPa, 4.2 bar) air pressure to the gun manifold's cylinder air fitting (CYL) will retract the gun piston, which opens the air valves and a short time later opens the fluid needle. This provides the proper air lead and lag when triggering the gun. A spring returns the piston when the cylinder air is shut off.

Operating the Electrostatics

To operate the electrostatics, apply air pressure to the gun manifold's turbine air fitting (TA) through a Graco Grounded Turbine Air Hose. The air enters the manifold and is directed to the inlet of the power supply turbine. The air spins the turbine, which then provides electrical power to the internal high voltage power supply. The fluid is charged by the spray gun electrode. The charged fluid is attracted to the nearest grounded object, wrapping around and evenly coating all surfaces.



Gun Features and Options

- The gun is designed for use with a reciprocator, and can be mounted directly on a 1/2 in. (13 mm) rod. With additional brackets, the gun can be mounted for robotic applications.
- The gun's quick-disconnect design enables its removal without disconnecting the air lines to the gun.
- Gun functions are activated from a separate controller that sends the appropriate signal to the actuating solenoids.

Smart Gun Features

Smart gun models with the Pro Xp Auto Control Module have the ability to:

- Display the spraying voltage and current
- Change the gun voltage setting
- Display the gun turbine speed
- Store spray profiles
- Communicate equipment faults to a PLC
- Display and set maintenance totalizers
- Use a PLC to select a spray profile

				
<p>To reduce the risk of electric shock, do not use the optional Pro Xp Auto Control Module readings to determine if your system is discharged. The display modules will only display the system voltage while the gun's power supply is operating. Follow the Fluid Voltage Discharge and Grounding Procedure on page 24 to ensure the system is discharged.</p>				

See the Pro Xp Auto Control Module manual 332989 for more information.

Spraying Waterborne Fluids Electrostatically

This electrostatic air spray gun is designed to spray only waterborne fluids which meet at least one of the following flammability requirements:

FM, FMc Approved:

- Material does not sustain burning in accordance with the Standard Test Method for Sustained Burning of Liquid Mixtures, ASTM D4206.

CE-EN 50059 Compliant:

- Material is classified as non-ignitable as defined by EN 50059: 2018.

When connected to a voltage isolation system, all of the fluid in the spray gun, fluid hose, and isolated fluid supply is charged to high voltage, which means that the system has more electrical energy than a solvent-based system. Therefore, only non-flammable fluids (as

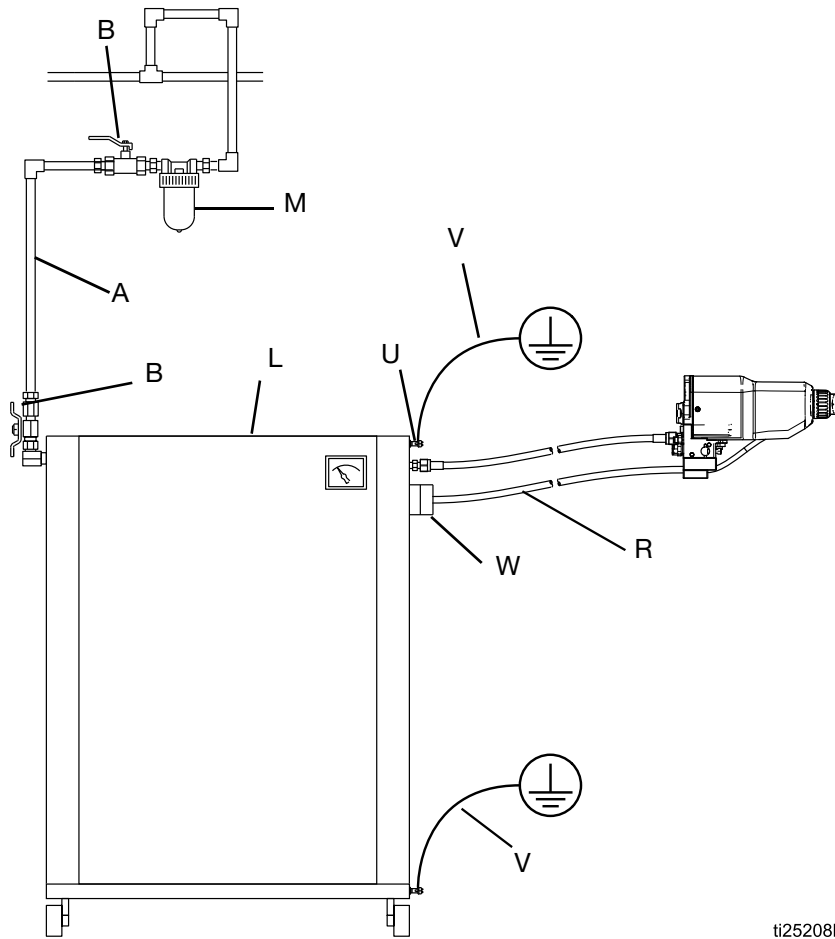
defined above) can be sprayed with the system or used to clean, flush, or purge the system.

Precautions must be taken when using electrostatic waterborne equipment to avoid potential shock hazards. When the electrostatic air spray gun charges the isolated fluid to high voltage, it is similar to charging a capacitor or a battery. The system will store some of the energy while spraying and retain some of that energy after the spray gun is shut off. Do not touch the gun nozzle or come within 4 in. (102 mm) of the electrode until the stored energy is discharged. The amount of time it takes to discharge the energy depends on the system design. Follow the **Fluid Voltage Discharge and Grounding Procedure on page 24** before approaching the front of the spray gun.

System Overview

Typical Waterborne System Installation

FIGURE 1 shows a typical electrostatic waterborne air spray system. It is not an actual system design. For assistance in designing a system to suit your particular needs, contact your Graco distributor.



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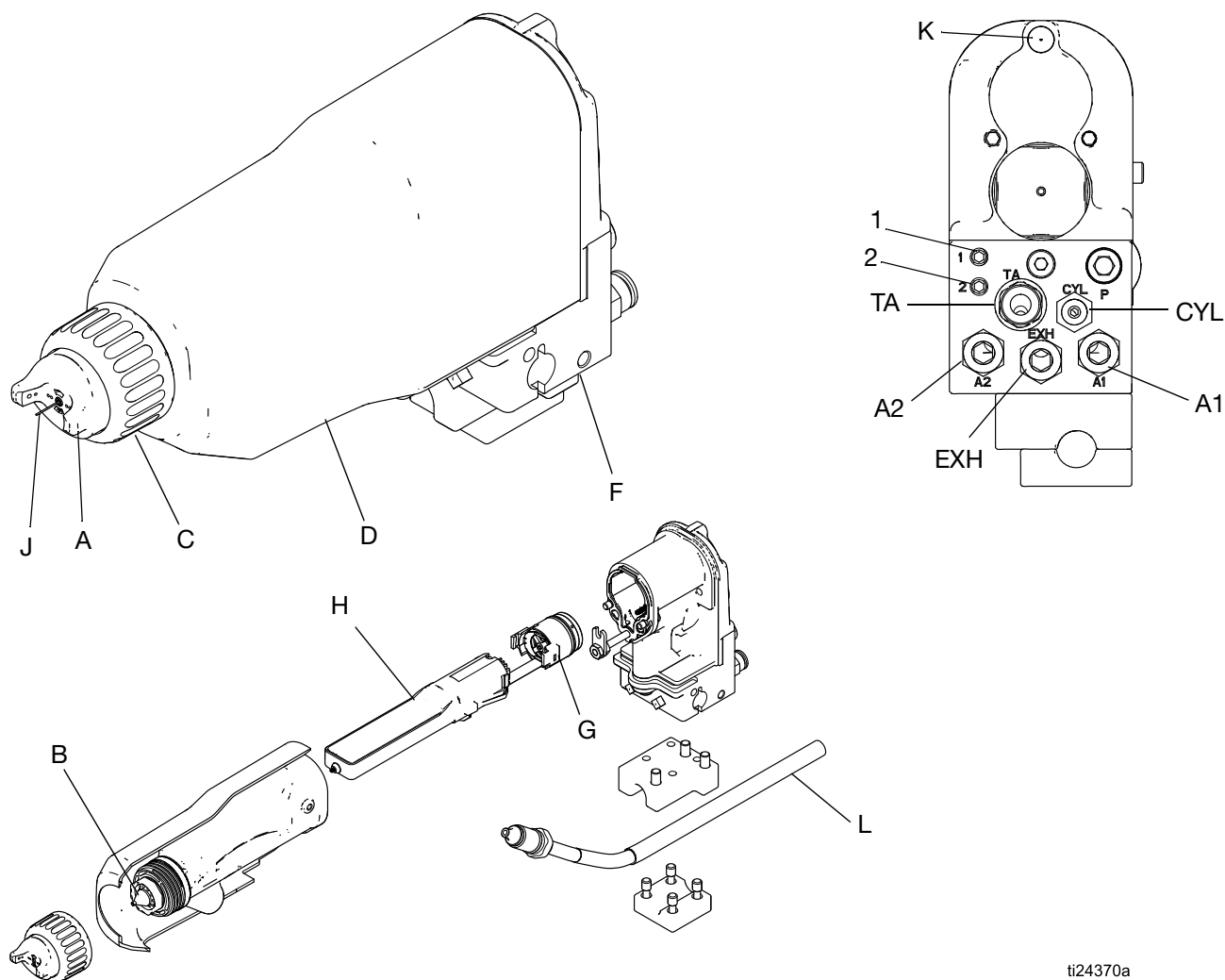
FIG. 1. Typical Installation Pro Xp Auto Waterborne System

Key:

- A Main Air Supply Line
- B* Bleed-Type Air Shutoff Valve
- L Isolated Enclosure
- M Air Line Filter
- R Graco Waterborne Fluid Hose
- U Ground Terminal
- V* Main Ground Wire
- W Strain Relief/Ground Fitting

* These items are required for safe operation and are included with the WB 100.

Gun Overview



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FIG. 2. Gun Overview

Key

A	Air Cap
B	Fluid Nozzle
C	Retaining Ring
D	Shroud
F	Manifold
G	Alternator
H	Power Supply
J	Electrode
L	Waterborne Fluid Hose

Manifold Fittings and Indicators

A1	Atomization Air Inlet Fitting
A2	Fan Air Inlet Fitting
CYL	Cylinder Air Inlet Fitting
1	Fiber Optic Fitting Transmit (Operational on Smart models only)
2	Fiber Optic Fitting Receive (Operational on Smart models only)
K	ES Indicator Light (standard models only)
TA	Turbine Air Inlet Fitting (to drive turbine)
EXH	Exhaust Outlet Fitting

Installation

System Requirements

Basic Guidelines

When spraying waterborne fluids electrostatically:




- The gun must be connected to a voltage isolation system, which isolates the fluid supply from ground and allows voltage to be maintained at the tip of the gun.
- The gun must be connected to a voltage isolation system that will discharge the system voltage when the gun is not in use.
- There should be a bleed resistor to drain off the system voltage when the spray gun is not in use.
- All components of the voltage isolation system that are charged to high voltage must be contained within an isolation enclosure that prevents personnel from making contact with the high voltage components before the system voltage is discharged.
- The gun turbine air hose must be interlocked with the voltage isolation system to shut off the turbine air supply anytime the isolation system enclosure is opened or entered.
- The voltage isolation system must be interlocked with the spray area entrance to automatically discharge the voltage and ground the fluid whenever someone opens the enclosure or enters the spray area.
- The system should not have any severe arcing occurring when the isolation mechanism opens and closes. Severe arcing will shorten the life of the system components.

Graco Waterborne Fluid Hose

Use a Graco Waterborne Fluid Hose between the voltage isolation system fluid outlet and the gun fluid inlet. See **Accessories on page 67** for available hoses. The hose consists of an inner PTFE tube, a conductive layer covering the PTFE tube, and an outer cover.

If a hose failure occurs where high voltage arcs through the inner tube, voltage will be discharged to ground through the conductive hose layer. When properly installed, the conductive hose layer is grounded through its connection to the grounded enclosure.





Install the System

				
<p>Installing and servicing this equipment requires access to parts which may cause electric shock or other serious injury if work is not performed properly.</p> <ul style="list-style-type: none"> • Do not install or service this equipment unless you are trained and qualified. • Comply with all local codes and regulations. 				

Warning Signs

Mount warning signs in the spray area where they can easily be seen and read by all operators. An English Warning Sign is provided with the gun.

Ventilate the Spray Booth

				
<p>Do not operate the gun unless ventilating air flow is above the minimum required value. Provide fresh air ventilation to avoid the buildup of flammable or toxic vapors when spraying, flushing, or cleaning the gun. Interlock the gun air and fluid supply to prevent operation unless ventilating air flow is above the minimum required value.</p>				

The spray booth must have a ventilation system.

Electrically interlock the gun air and fluid supply with the ventilators to prevent gun operation any time that the ventilation air flow falls below minimum values. Check and follow all local codes and regulations regarding air exhaust velocity requirements. Verify the operation of the interlock at least once a year.

NOTE: The minimum allowable air exhaust velocity is 60 feet/minute (19 linear meters/minute). High velocity air exhaust will decrease the operating efficiency of the electrostatic system.

Install the Air Line Accessories

See FIGURE 3.

1. Install a bleed-type master air valve (L) on the main air line (W) to shut off all air to the gun.
2. Install an air line filter/water separator on the gun air line to ensure a dry, clean air supply to the gun. Dirt and moisture can ruin the appearance of your finished workpiece and can cause the gun to malfunction.
3. Install a bleed-type air pressure regulator (M) on each of the air supply lines (B, C, D, E) to control air pressure to the gun.
4. Install a solenoid valve (K) on the cylinder air line (E) to actuate the gun. The solenoid valve must have a quick exhaust port.
5. Install a solenoid valve (K) to actuate the turbine.



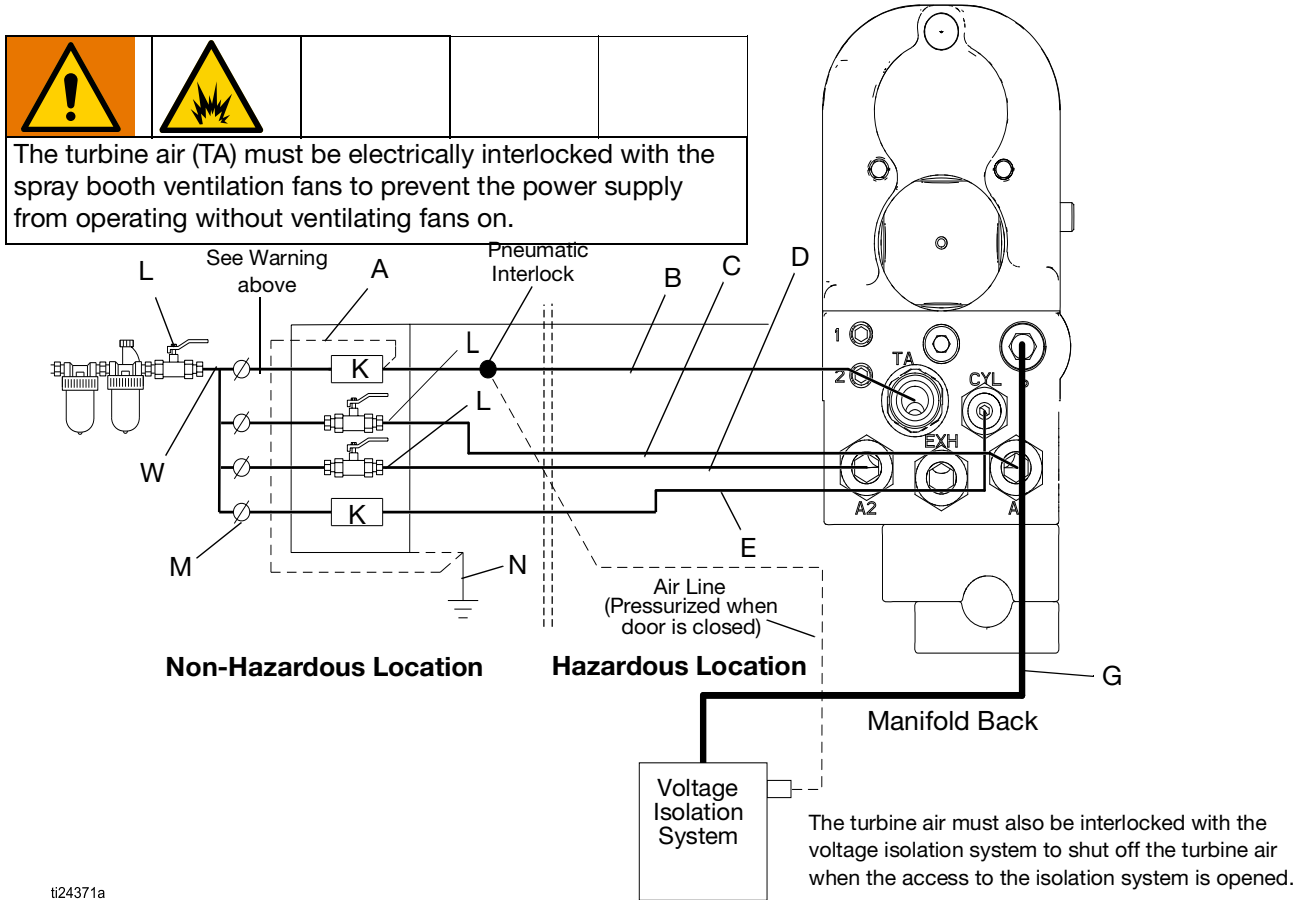
Trapped air can cause the gun to spray unexpectedly, which can result in serious injury, including splashing fluid in the eyes or on the skin. The solenoid valves (K) must have a quick exhaust port so trapped air will be relieved between the valve and gun when the solenoids are shut off.

Install the Fluid Line Accessories

1. Install a fluid filter and drain valve at the pump outlet.
2. Install a fluid regulator on the fluid line to control fluid pressure to the gun.

Typical Installation

FIGURE 3 shows a typical electrostatic air spray system. It is not an actual system design. For assistance in designing a system to suit your particular needs, contact your Graco distributor.



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FIG. 3. Typical Installation

Key to FIGURE 3

A	Air Hose Ground Wire
B	Graco Grounded Turbine Air Hose (TA)
C	Atomizing Air Hose, 5/16 in. (8 mm) OD (A1)
D	Fan Air Hose, 5/16 in. (8 mm) OD (A2)
E	Cylinder Air Hose, 5/32 in. (4 mm) OD (CYL)
G	Graco Waterborne Fluid Supply Hose

K	Solenoid Valve, requires quick exhaust port
L	Bleed-Type Master Air Valve
M	Air Pressure Regulator
N	True Earth Ground
W	Main Air Line

Install the Gun

1. Loosen the manifold's two set screws (29) and slide the manifold (20) onto a 1/2 in. (13 mm) mounting rod. See FIGURE 4.
2. Position the gun and tighten the two set screws.

For added positioning reliability, insert a 1/8 in. (3 mm) locating pin into the slot (NN) in the bracket and through a hole in the rod. See the detail in FIGURE 4.

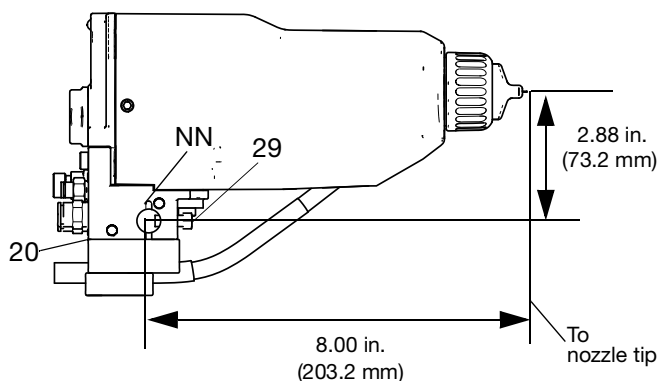


FIG. 4. Mounting

Install the Pro Xp Auto Control Module

The Pro Xp Auto Control Module is required for use with smart models. To install a Pro Xp Auto Control Module, see the module instruction manual 332989.

Connect the Air Line

FIGURE 3 shows a schematic of air line connections, and FIGURE 5 shows the manifold connections. Connect the air lines as instructed.

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To reduce the risk of a fire, explosion, or electric shock, the Graco Grounded Turbine Air Hose must be interlocked with:

- The isolation system to shut off the turbine air supply anytime the enclosure is opened or entered.
- The ventilators to prevent operation of the power supply unless the ventilating fans are on.

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To reduce the risk of electric shock or other serious injury, the red-colored Graco Grounded Turbine Air Hose must be used for the turbine air supply hose, and the hose ground wire must be connected to a true earth ground. Do not use the black or gray-colored Graco air hoses.

1. Connect the Graco Grounded Turbine Air Hose (B) to the gun's turbine air inlet (TA) and connect the hose ground wire (A) to a true earth ground (N). The gun turbine air inlet fitting has left-hand threads to prevent connecting another type of air hose to the turbine air inlet. See Accessories on page 67 for further information about the hose.
2. Check the Check Gun Electrical Grounding on page 21.

Ground the Cabinet

Ground the Isolation System

Ground the isolation system per the instructions in your isolation system manual.

Connect the main ground wire (V) to a true earth ground.

Manifold Connections

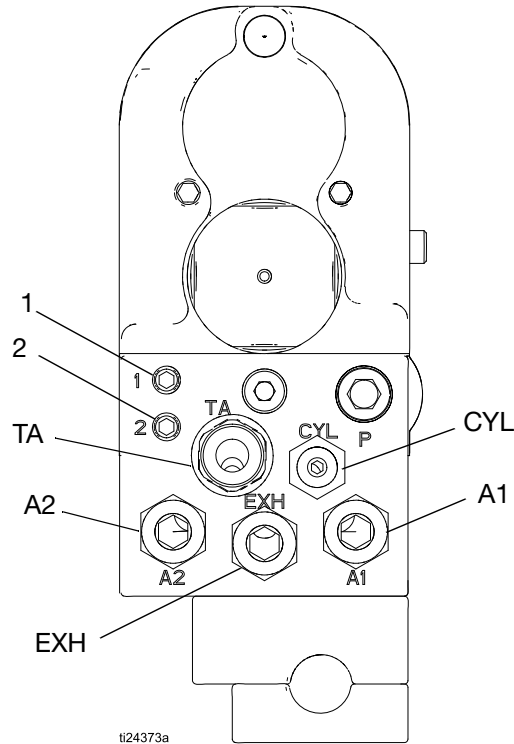


FIG. 5. Manifold Connections

A1	Atomization Air Inlet Fitting Connect a 5/16 in. (8 mm) OD tube between this fitting and the air supply.
A2	Fan Air Inlet Fitting Connect a 5/16 in. (8 mm) OD tube between this fitting and the air supply.
CYL	Cylinder Air Inlet Fitting Connect a 5/32 in. (4 mm) OD tube between this fitting and the solenoid. For quicker response, use the shortest hose length possible.
1	Fiber Optic Fitting Transmit (Operational on Smart models only) Connect the Graco Fiber Optic cable (see page 20).
2	Fiber Optic Fitting Receive (Operational on Smart models only) Connect the Graco Fiber Optic cable (see page 20).
EXH	Exhaust Connect a 5/16 in OD exhaust tube to route the turbine exhaust air. (3 ft. max length)
TA	Turbine Air Inlet Fitting Connect the Graco Electrically Conductive Air Hose between this fitting (left-hand thread) and the solenoid. Connect the air hose ground wire to a true earth ground.



Connect the Waterborne Fluid Hose

NOTE: The Graco warranty is void if the spray gun is connected to a non-Graco voltage isolation system or if the gun is operated above 60 kV.

Always use a Graco Waterborne Fluid Hose between the voltage isolation system fluid outlet and the gun fluid inlet. The waterborne fluid hose (600) consists of an inner PTFE tube (T), a conductive layer (C), and an abrasion-resistant outer jacket (J). The conductive layer is connected to ground at the isolation enclosure.

Before connecting the waterborne fluid hose to the gun, blow it out with air and flush with water to remove contaminants. Flush the gun before using it. See **Flushing on page 28**.

Flushing on page 28.

				
To reduce the risk of electric shock, install only one continuous Graco Waterborne Fluid Hose between the isolated fluid supply and the spray gun. Do not splice hoses together.				

1. Remove the air cap (25) and shroud (26).

NOTICE

Be careful not to cut into the inner tube (T) of the hose when stripping the hose. Nicks or cuts in the PTFE tube will cause premature hose failure.

2. For the waterborne fluid hose to fit properly, it must be stripped and assembled to the dimensions shown in FIGURE 6. Apply dielectric grease to the inner tube (T) of the hose. Slide the fitting (F) onto the tub (T). Press the barbed fitting (G) into the tube until its shoulder bottoms on the tube. A new Graco

Waterborne Fluid Hose comes fully assembled to these dimensions.

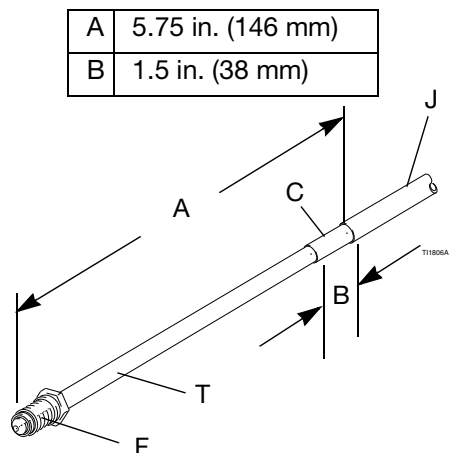


FIG. 6. Waterborne Hose Dimensions

3. Generously apply dielectric grease (40) to the o-ring (603) and the threads of the fitting (602). Pull the fitting back 1-1/2 in. (38 mm) and apply grease to the exposed PTFE hose to fill the area between the hose and the fitting. Make sure the barrel inlet is clean and dry, then screw the fitting into the fluid inlet of the gun barrel (1).
4. Secure hose in strain relief bracket on the gun by tightening the four plastic screws.

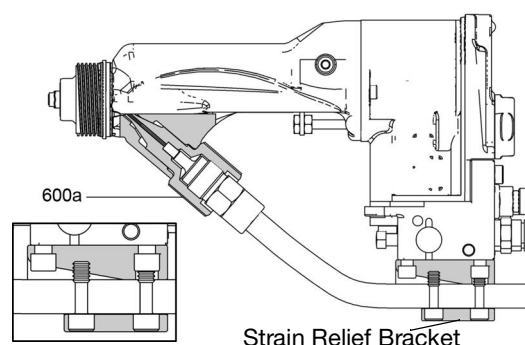


FIG. 7. Connect the Waterborne Fluid Hose

- Connect the other end of the hose to the isolated fluid supply. The hose comes with the proper dimensions for connection with the WB 100 and Hydroshield isolation system. Adjust hose dimensions as needed for use with other isolation systems.



For Shielded Hose Systems:

Conductive hose layer (FC) must be grounded through its connection to the isolation system's grounded enclosure (L) or grounded fence. To maintain grounding continuity, the conductive hose layer (FC) must be engaged in the ferrule when the strain relief nut is tightened. Failure to properly install the hose in the strain relief could result in an electric shock.

- Check the **Check Gun Electrical Grounding on page 21**.
- Connect the other end of the fluid hose to the fluid outlet of the isolated fluid supply. See FIGURE 9



To reduce the risk of electric shock, the areas of the Graco Waterborne Fluid Hose that are accessible to personnel during normal operation must be covered by the outer hose jacket (FJ). The portion of the inner hose layer (FT) not covered by the outer jacket must be inside the voltage isolation system enclosure (E).

The conductive hose layer (FC) must be grounded through its connection to the isolation system's grounded enclosure (E).

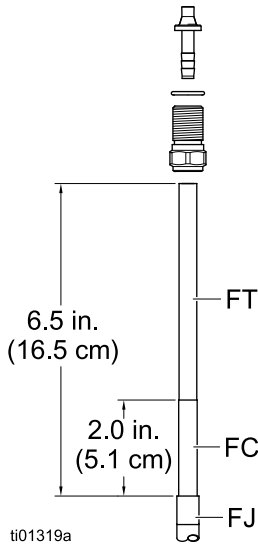


FIG. 8. Shielded Hose Dimensions at WB100 Enclosure

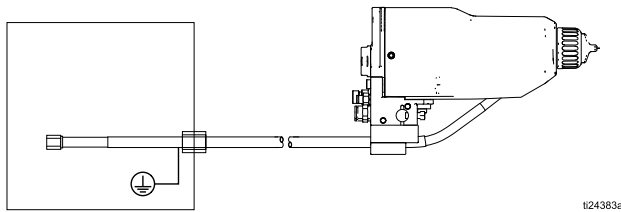


FIG. 9. Shielded Fluid Hose Connection at Non-Graco Isolation Enclosure

- Connect the end of the tube (FT) to the pump fluid outlet fitting.
- Reinstall the shroud (26) and air cap (25).

Fiber Optic Cable Connection

(Operational on Smart models only)

NOTE: Only use the supplied fiber optic cable.

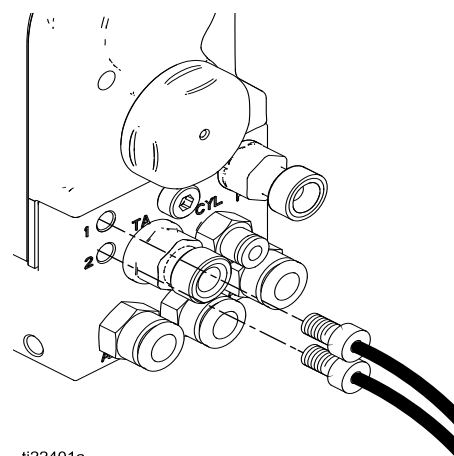
The fiber optic cable allows the gun to communicate with the Pro Xp Auto Control Module.

For a 1 Gun System

1. Connect Port 1 of the gun 1 manifold to Port 1 of the Control Module.
2. Connect Port 2 of the gun 1 manifold to Port 2 of the Control Module.

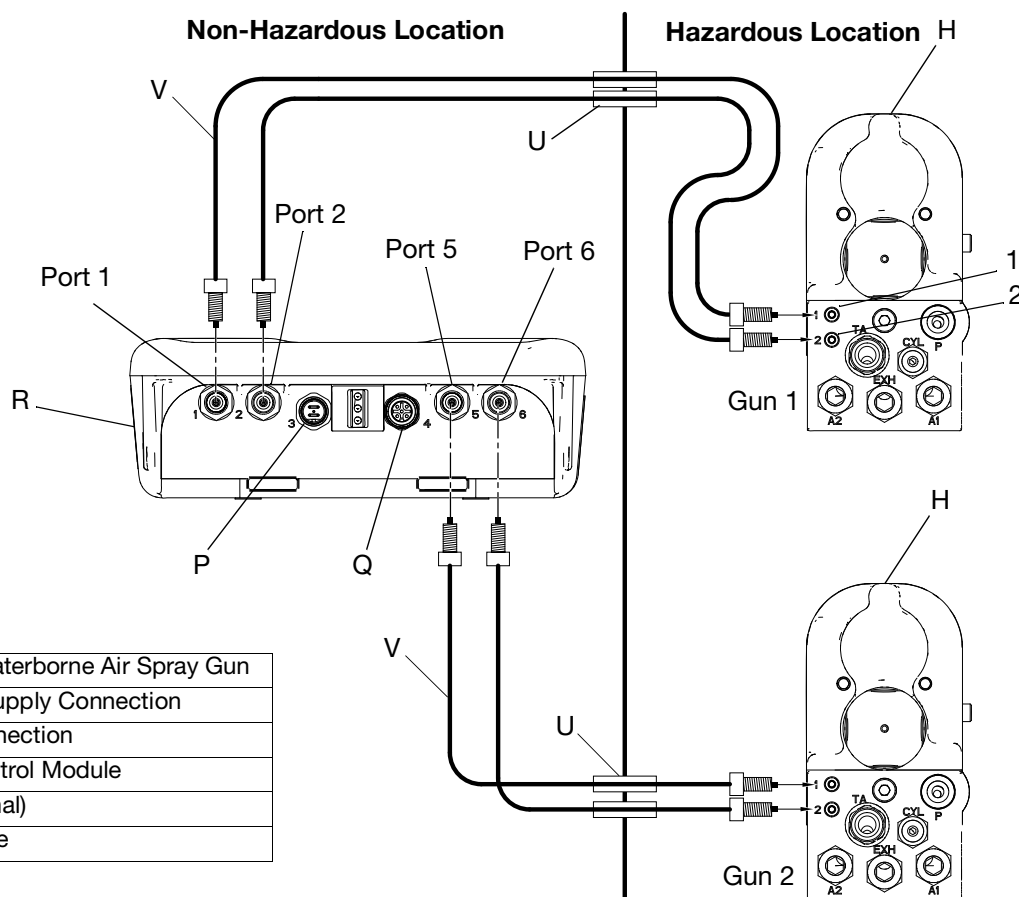
For a 2 Gun System

1. Connect Port 1 of the gun 2 manifold to Port 5 of the Control Module.
2. Connect Port 2 of the gun 2 manifold to Port 6 of the Control Module.



ti22401a

FIG. 10. Making Fiber Optic Connections



Key for FIGURE 11

H	PRO Xp Auto Waterborne Air Spray Gun
P	24 Volt Power Supply Connection
Q	Remote I/O Connection
R	Pro Xp Auto Control Module
U	Bulkhead (optional)
V	Fiber Optic Cable

FIG. 11. Fiber Optic Schematic

Grounding






The equipment must be grounded to reduce the risk of static sparking and electric shock. Electric or static sparking can cause fumes to ignite or explode. Improper grounding can cause electric shock. Ground all equipment, personnel, objects being sprayed, and conductive objects in or close to the spray area. The resistance must not exceed 1 megohm. Grounding provides an escape wire for the electric current.

When operating the electrostatic gun, any ungrounded objects (such as people, containers, and tools) in the spray location can become electrically charged.

The following are minimum grounding requirements for a basic electrostatic waterborne system. Your system may include other equipment or objects which must be grounded. Your system must be connected to a true earth ground. Check ground connections daily. Check your local electrical codes and regulations for detailed grounding instructions.

- *Electrostatic Air Spray Gun:* ground the gun by connecting the red-colored Graco Grounded Air Hose to the turbine air inlet and connecting the air hose ground wire to a true earth ground. See **Check Gun Electrical Grounding on page 21.**
- *Graco Waterborne Fluid Hose:* the hose is grounded through the conductive layer. See **Connect the Waterborne Fluid Hose on page 17.**
- *Voltage Isolation System:* electrically connect the voltage isolation system to a true earth ground.
- *Air compressors and hydraulic power supplies:* ground the equipment according to the manufacturer's recommendations.
- *All air and fluid lines* must be properly grounded. *All electrical cables* must be properly grounded.
- *All persons entering the spray area:* shoes must have conductive soles, such as leather, or personal grounding straps must be worn. Do not wear shoes with non-conductive soles such as rubber or plastic.
- *Object being sprayed:* keep the workpiece hangers clean and grounded at all times. Resistance must not exceed 1 megohm.
- *The floor of the spray area:* must be electrically conductive and grounded. Do not cover the floor with cardboard or any non-conductive material which would interrupt grounding continuity.
- *Flammable liquids in the spray area:* must be kept in approved, grounded containers. Do not use plastic containers. Do not store more than the quantity needed for one shift.
- *All electrically conductive objects or devices in the spray area:* including fluid containers and wash cans, must be properly grounded.
- *Fluid and waste containers:* ground all fluid and waste containers in the spray area. Do not use pail liners unless they are conductive and grounded. When flushing the spray gun, the container used to catch the excess fluid must be electrically conductive and grounded.
- *All solvent pails:* use only approved, grounded metal containers, which are conductive. Do not use plastic containers. Use only non-flammable solvents. Do not store more than the quantity needed for one shift.

Check Gun Electrical Grounding

				
<p>Megohmmeter Part No. 241079 is not approved for use in a hazardous location. To reduce the risk of sparking, do not use the megohmmeter to check electrical grounding unless:</p> <ul style="list-style-type: none"> • The gun has been removed from the hazardous location; • Or all spraying devices in the hazardous location are turned off, ventilation fans in the hazardous location are operating, and there are no flammable vapors in the area (such as open solvent containers or fumes from spraying). <p>Failure to follow this warning could cause fire, explosion, and electric shock and result in serious injury and property damage.</p>				

Graco Part No. 241079 Megohmmeter is available as an accessory to check that the gun is properly grounded.

1. Have a qualified electrician check the electrical grounding continuity of the spray gun and turbine air hose.
2. Make sure the red-colored turbine air hose (B) is connected and the hose ground wire is connected to a true earth ground.
3. Turn off the air and fluid supply to the gun. Follow the **Pressure Relief Procedure on page 24**. The fluid hose must not have any fluid in it.

4. Measure the resistance between the turbine air inlet fitting (TA) and a true earth ground (N). If the resistance is greater than 100 ohms, check the tightness of the ground connections and be sure the turbine air hose ground wire is connected to a true earth ground. If the resistance is still too high, replace the turbine air hose

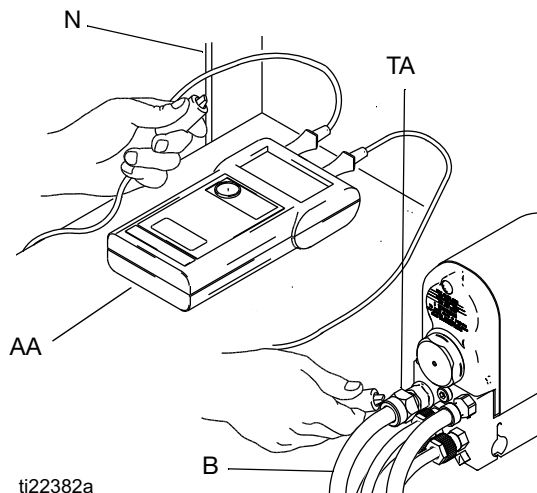


FIG. 12. Check Gun Electrical Grounding

5. If using the WB100 use an ohmmeter (AA) to measure the resistance between the cabinet ground lug (214) and a true earth ground (CC). The resistance must be less than 100 ohms.

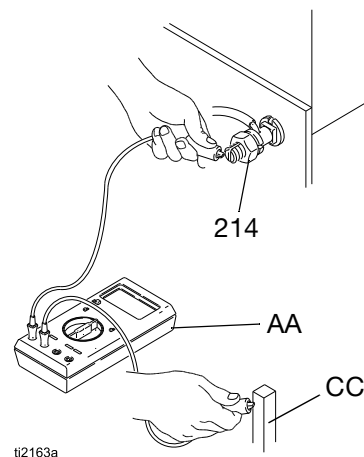


FIG. 13. Check Cabinet Grounding

Install the Fabric Cover

See FIGURE 14.

1. Install a fabric cover (XX) over the front of the gun and slide it back to cover the exposed tubing and hoses at the back of the manifold.
2. Route the exhaust tube (YY) outside the cover. This enables you to monitor the exhaust tube for the presence of any paint or solvent. See **Check for Fluid Leakage on page 30**. Strap down the exhaust tube to prevent it from moving around.

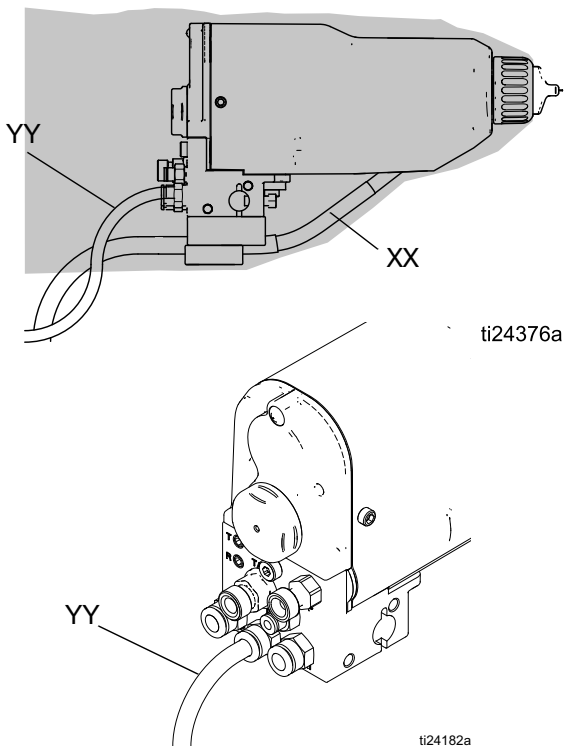


FIG. 14. Fabric Cover

Check Fluid Viscosity

A viscosity cup and stopwatch are needed to check fluid viscosity.

1. Completely submerge the viscosity cup in the fluid. Lift the cup out quickly, starting the stopwatch as soon as the cup is completely removed.
2. Watch the stream of fluid coming from the bottom of the cup. As soon as there is a break in the stream, shut off the stopwatch.
3. Record the fluid type, elapsed time, and size of the viscosity cup.
4. If the viscosity is too high or too low, contact the material supplier. Adjust as necessary.

Flush Before Using Equipment

The equipment was tested in fluid at the factory. To avoid contaminating your fluid, flush the equipment with a compatible solvent before using the equipment. See **Flushing on page 28**.



Operation

Operating Checklist

Check the following list daily, before starting to operate the system, to help ensure you of safe, efficient operation.

- | | |
|--|--|
| <p><input type="checkbox"/> All operators are properly trained to safely operate an automatic electrostatic waterborne air spray system as instructed in this manual.</p> <p><input type="checkbox"/> All operators are trained in the Fluid Voltage Discharge and Grounding Procedure on page 24.</p> <p><input type="checkbox"/> All operators are trained in the Pressure Relief Procedure on page 24.</p> <p><input type="checkbox"/> The electrostatics are turned off and system voltage is discharged according to the Fluid Voltage Discharge and Grounding Procedure on page 24, before any person enters the isolation enclosure, before cleaning, and before performing any maintenance or repair.</p> <p><input type="checkbox"/> The warning sign provided with the gun is mounted in the spray area where it can be easily seen and read by all operators.</p> <p><input type="checkbox"/> The system is thoroughly grounded and the operator and all persons entering the spray area are properly grounded. See Grounding on page 20.</p> <p><input type="checkbox"/> The Graco Waterborne Fluid Hose is in good condition with no cuts or abrasions of the PTFE layer. Replace hose if damaged.</p> <p><input type="checkbox"/> The condition of the gun's electrical components has been checked as instructed in Electrical Tests on page 31.</p> <p><input type="checkbox"/> All fluid hose connections are tight.</p> <p><input type="checkbox"/> Ventilation fans are operating properly.</p> <p><input type="checkbox"/> Workpiece hangers are clean and grounded.</p> <p><input type="checkbox"/> All debris, including flammable fluids and rags, is removed from the spray area.</p> | <p><input type="checkbox"/> All conductive objects in the spray area are electrically grounded and the floor of the spray area is electrically conductive and grounded.</p> <p><input type="checkbox"/> All flammable fluids in the spray booth are in approved, grounded containers.</p> <p><input type="checkbox"/> The manifold exhaust tubes have been checked for the presence of any fluid as instructed in Check for Fluid Leakage on page 30.</p> <p><input type="checkbox"/> Fluids used must meet the following flammability requirements:</p> <p>FM, FMc Approved:
Material does not sustain burning in accordance with the Standard Test Method for Sustained Burning of Liquid Mixtures, ASTM D4206.</p> <p>CE-EN 50059 Update Compliant:
Material is classified as non-ignitable as defined by EN 50059: 2018</p> |
|--|--|

Fluid Voltage Discharge and Grounding Procedure

				
<p>The fluid supply is charged with high voltage until the voltage is discharged. Contact with the charged components of the voltage isolation system or spray gun electrode will cause an electric shock. To avoid an electric shock, follow the Fluid Voltage Discharge and Grounding Procedure:</p> <ul style="list-style-type: none"> • whenever you are instructed to discharge the voltage • before cleaning, flushing, or servicing the system equipment • before approaching the front of the gun • or before opening the isolation enclosure for the isolated fluid supply. 				





An accessory grounding rod, part No. 210084, is available to discharge any voltage remaining on a system component. Contact your Graco distributor to order.

1. Turn off the turbine air to all spray guns connected to the isolated fluid supply and wait 30 seconds.
2. Discharge the voltage at the voltage isolation system by following the procedure specified in the voltage isolation system instruction manual.
3. Touch the pump, supply pail, and electrode of the gun with a grounded rod to make sure the voltage has been discharged. If you see an arc, verify that the electrostatics are turned off or see **Electrical Troubleshooting on page 39** or the voltage isolation system manual for other possible problems. Resolve the problem before proceeding.

Pressure Relief Procedure



Follow the Pressure Relief Procedure whenever you see this symbol.

				
<p>This equipment stays pressurized until pressure is manually relieved. To help prevent serious injury from pressurized fluid, such as splashing, follow the Pressure Relief Procedure when you stop spraying and before cleaning, checking, or servicing the equipment.</p>				

1. Follow the **Fluid Voltage Discharge and Grounding Procedure on page 24**.
2. Relieve fluid pressure in the fluid supply and voltage isolation system as instructed in their instruction manuals.
3. Turn off all the air to the spray gun except the cylinder air, which triggers the gun. If an air pilot fluid regulator is used in the system, air pressure is also needed at the regulator air inlet.

The air shut-off device must bleed the air out of the system.

4. Trigger the gun into a grounded metal waste container to relieve the fluid pressure.
5. Turn off all remaining air supplies to the gun.
6. Turn off the main air supply by closing the bleed-type master air valve on the main air supply line. Leave the valve closed until you are ready to spray again.

Fill the Fluid Supply



Follow the instructions in your isolation system manual to fill the fluid supply and prepare for dispensing fluid. See **Related Manuals on page 3**.

Select a Fluid Nozzle and Air Cap



To reduce the risk of an injury, follow the **Pressure Relief Procedure** before removing or installing a fluid nozzle and/or air cap.

The gun is shipped with the fluid nozzle and air cap installed. See Fluid Nozzle Selection Chart on page 56 and **Air Cap Selection Chart on page 59** for available sizes.

Operating the Spray Function

Applying a minimum of 60 psi (0.41 MPa, 4.1 bar) air pressure to the gun manifold's cylinder air fitting (CYL) will retract the gun piston, which opens the air valves and a short time later opens the fluid needle. This provides the proper air lead and lag when triggering the gun. A spring returns the piston when the cylinder air is shut off.

Adjust the Spray Pattern

Follow the steps below to establish the correct fluid flow and air flow. Do not turn on the turbine air (TA) yet.



To reduce the risk of fire and explosion, only use this equipment with fluids that meet at least one of the following conditions for non-flammability:

- Material does not sustain burning in accordance with the Standard Test Method for Sustained Burning of Liquid Mixtures, ASTM D4206.
- Materials which cannot be ignited, in any mixture with air, by an energy source of less than 500 mJ.



Contact with the charged components of the spray gun will cause an electric shock. Do not touch the gun nozzle or electrode or come within 4 in. (102 mm) of the front of the gun during operation.



To reduce the risk of component rupture, which can cause serious injury, do not exceed the maximum working pressure of the lowest rated system component. This equipment has a 100 psi (0.7 MPa, 7 bar) maximum working air and fluid pressure.

1. Follow the **Fluid Voltage Discharge and Grounding Procedure on page 24**.
2. Follow the **Pressure Relief Procedure on page 24**.
3. Select and install the appropriate air cap for your application.

NOTE: To select a different size fluid nozzle or air cap, see **Fluid Nozzle Selection Chart on page 56** and **Air Cap Selection Chart on page 59**. To install the fluid nozzle and air cap, see **Air Cap/Nozzle Replacement on page 42**.

4. Loosen the air cap retaining ring, and rotate the air cap for a vertical or horizontal spray pattern. See FIGURE 15. Tighten the retaining ring until the air cap is held firmly in place; you should not be able to rotate the air cap horns by hand.

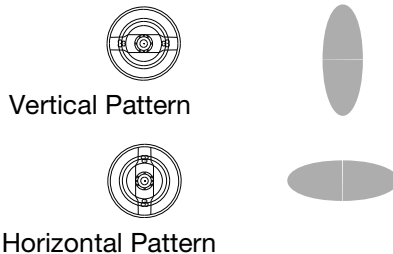


FIG. 15. Air Cap Positions

5. Adjust the fluid flow with the fluid pressure regulator. Refer to the **Fluid Nozzle Performance Charts on page 57** to set the fluid pressure for various fluid flows, according to the size of the fluid nozzle being used.

6. Use the air pressure regulator on the atomization air supply line (A1) to adjust the degree of atomization. See FIGURE 5. For example, for a fluid flow rate of 10 ounces per minute (0.3 liters per minute), a typical atomization pressure would be 20-30 psi (1.4-2.1 bar, 0.14-0.21 MPa) at the gun manifold.
7. Use the air pressure regulator on the fan air supply line (A2) to adjust the pattern size.
 - For the most efficiency, always use the lowest air pressure possible.
 - When increasing to a long, flat pattern, it may be necessary to increase the supply of fluid to the gun to maintain the same amount of coverage over a large area.
 - See **Spray Pattern Troubleshooting on page 36** to correct spray pattern problems.

Adjust the Electrostatics

1. Shut off the fluid supply.
2. Prepare the isolation system for high voltage operation. See **Fill the Fluid Supply on page 25**.
3. Turn on the turbine air (TA) and adjust the air pressure per the settings in Table 1 . Set the proper pressure at the turbine air hose inlet *when air is flowing*.

Table 1: Approximate Dynamic Turbine Air Pressures

Turbine Air Hose Length ft (m)	Air pressure at turbine air hose inlet for full voltage psi (bar, MPa)
15 (4.6)	54 (3.8, 0.38)
25 (7.6)	55 (3.85, 0.38)
36 (11)	56 (3.9, 0.39)
50 (15.3)	57 (4.0, 0.40)
75 (22.9)	59 (4.1, 0.41)
100 (30.5)	61 (4.3, 0.43)

4. Check the turbine speed of the gun by checking the indicator light on the standard gun body or for the smart gun check the actual turbine speed on the Pro Xp Auto Control Module. See the following table. Adjust the air pressure as necessary to keep the indicator light green or the values within 400-750 Hz.

Smart models display values, standard models display color indicator lights



Table 2: Indicator Colors/Values

Indicator Color	Description
Green 400-750 Hz	When spraying, the indicator should remain green, indicating sufficient air pressure to the alternator turbine.
Amber <400	If the indicator changes to amber after 1 second, the air pressure is too low. Increase air pressure until the indicator is green.
Red >750	If the indicator changes to red after 1 second, the air pressure is too high. Decrease air pressure until the indicator is green. Excessive turbine speed can shorten the bearing life and will not increase the voltage output.




5. Check the voltage output by reading the kV meter on the isolated enclosure. 45-55 kV is normal.

See **Electrical Troubleshooting on page 39** to correct voltage problems.

Spraying

				
To reduce the risk of electric shock, do not touch the gun electrode or come within 4 in. (10 cm) of the nozzle during gun operation.				

1. Apply a minimum of 60 psi (4.2 bar, 0.42 MPa) air pressure to the cylinder air fitting (CYL) to activate the on/off sequence of atomization air (A1), fan air (A2), and fluid (P).
2. Turn the gun functions on and off by using the air solenoid valves on the cylinder (CYL) and turbine (TA) air supply lines.
3. To change to a smart model lower voltage setting, see the Pro Xp Auto Control Module manual.

				
If any fluid leakage from the gun is detected, stop spraying immediately. Fluid leakage into the gun shroud could cause fire or explosion and result in serious injury and property damage. See Check for Fluid Leakage on page 30 .				

Triggering the Fluid Alone

1. Shut off and relieve the air pressure to the atomization (A1) and fan (A2) air lines, using the bleed-type air shutoff valves.
2. Apply 60 psi (4.2 bar, 0.42 MPa) air pressure to the cylinder air fitting (CYL) to trigger the fluid.

Shutdown

				
To reduce the risk of an injury, follow the Pressure Relief Procedure whenever you are instructed to relieve the pressure.				

1. Follow the **Fluid Voltage Discharge and Grounding Procedure on page 24**.
2. Follow the **Pressure Relief Procedure on page 24**.
3. Flush and clean the equipment. See **Maintenance on page 28**.

Maintenance



To reduce the risk of an injury, follow the **Pressure Relief Procedure** and the **Fluid Voltage Discharge and Grounding Procedure** before doing any maintenance on the gun or system.

Daily Care and Cleaning Checklist

Check the following list daily upon completion of equipment usage.

- Flush the gun. See **Flushing on page 28**.
- Clean the fluid and air line filters.
- Clean the outside of the gun. See **Clean Outside of Gun on page 29**.
- Clean the air cap and fluid nozzle daily, minimum. Some applications require more frequent cleaning. Replace the fluid nozzle and air cap if they are damaged. See **Clean the Air Cap and Fluid Nozzle on page 29**.
- Check the electrode and replace if broken or damaged. See **Electrode Replacement on page 43**.
- Check for fluid leakage from the gun and fluid hoses. See **Check for Fluid Leakage on page 30**. Tighten fittings or replace equipment as needed.
- Check Gun Electrical Grounding on page 21**.

Flushing

- Flush before changing fluids, before fluid can dry in the equipment, at the end of the day, before storing, and before repairing equipment.
- Flush at the lowest pressure possible. Check connectors for leaks and tighten as necessary.

- Flush with a fluid that is compatible with the fluid being dispensed and the equipment wetted parts.



To reduce the risk of fire and explosion, turn off the turbine air (TA) before flushing the gun and always ground equipment and waste container. To avoid static sparking and injury from splashing, always flush at lowest possible pressure.

Follow the **Fluid Voltage Discharge and Grounding Procedure on page 24**, before flushing.

Only flush, purge, or clean the gun with fluids that meet at least one of the following flammability requirements:

FM, FMc Approved:

Material does not sustain burning in accordance with the Standard Test Method for Sustained Burning of Liquid Mixtures, ASTM D4206.

CE-EN 50059 Compliant:

Material is classified as non-ignitable as defined by EN 50059: 2018.

NOTICE

Do not use methylene chloride as a flushing or cleaning solvent with this gun as it will damage nylon components.

1. Turn off the turbine air and wait 30 seconds for the voltage to bleed off.
2. Discharge the system voltage. See **Fluid Voltage Discharge and Grounding Procedure on page 24**.
3. Follow the **Pressure Relief Procedure on page 24**.
4. Remove and clean the air cap.
5. Change the fluid source to non-flammable solvent.
6. Trigger the gun to flush the fluid passages clean.

Clean Outside of Gun

NOTICE

- Clean all parts with a non-conductive, compatible solvent. Conductive solvents can cause the gun to malfunction.
- Fluid in the air passages could cause the gun to malfunction and could draw current and reduce the electrostatic effect. Fluid in the power supply cavity can reduce the turbine life. Whenever possible, point the gun down when cleaning it. Do not use any cleaning method which could allow fluid into the gun air passages.

1. Follow the **Fluid Voltage Discharge and Grounding Procedure on page 24.**
2. Flush the gun. See **Flushing on page 28.**
3. Follow the **Pressure Relief Procedure on page 24.**
4. Clean the outside of the gun with a compatible solvent. Use a soft cloth. Wring out excess fluid from cloth. Point the gun down to prevent solvent from entering the gun passages. Do not immerse the gun.



Clean the Air Cap and Fluid Nozzle

Equipment Needed

- soft bristle brush
- compatible solvent

Procedure

1. Follow the **Fluid Voltage Discharge and Grounding Procedure on page 24.**
2. Flush the gun. See **Flushing on page 28.**

3. Remove the air cap assembly (24, 25) and shroud (26). See FIGURE 16.
4. Wipe the fluid nozzle (4), shroud (26), and exterior of the gun clean with a cloth dampened in solvent. Avoid getting any solvent into the air passages. Whenever possible, point the gun down when cleaning it.
5. If it appears that there is paint inside the fluid nozzle (4) air passages, remove the gun from the line for servicing. See **Air Cap/Nozzle Replacement on page 42** to remove the fluid nozzle for cleaning or replacement.
6. Clean the air cap (25) with the soft bristle brush and solvent or submerge the air cap in suitable solvent and wipe it clean. Do not use metal tools.
7. Slide the shroud (26) onto the gun.
8. Carefully install the air cap (25). Be sure to insert the electrode (3) through the center hole of the air cap. Rotate the air cap to the desired position.
9. Make sure the u-cup (24a) is in place on the retaining ring (1). The lips must face forward. Tighten the retaining ring until the air cap is held firmly in place; you should not be able to rotate the air cap horns by hand.
10. **Test Gun Resistance on page 31.**

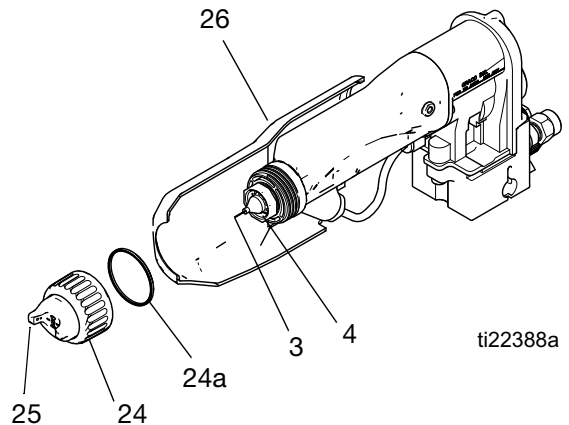






FIG. 16. Clean Air Cap and Fluid Nozzle

Check for Fluid Leakage

				
<p>If any fluid leakage from the gun is detected, stop spraying immediately. Fluid leakage into the gun shroud could cause fire or explosion and result in serious injury and property damage.</p>				

				
<p>To reduce the risk of an injury, follow the Pressure Relief Procedure when you stop spraying and whenever you are instructed to relieve the pressure.</p>				

During operation, periodically check all openings of the gun shroud (ZZ) for the presence of fluid. See FIGURE 17. Fluid in these areas indicates leakage into the shroud, which could be caused by leaks at the fluid tube connections or fluid packing leakage.

If fluid is seen in these areas, stop spraying immediately. Discharge the system voltage, relieve the pressure, then remove the gun for repair.

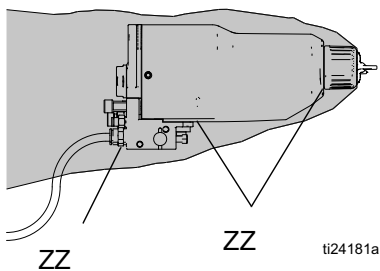





FIG. 17. Check for Fluid Leakage

Electrical Tests

Use the following procedures to test the condition of the power supply and gun body, and electrical continuity between components. See **Power Supply Removal and Replacement on page 47**.

Use megohmmeter Part No. 241079 (AA) and an applied voltage of 500 V. Connect the leads as shown.

				
<p>Megohmmeter Part No. 241079 (AA-see FIGURE 18) is not approved for use in a hazardous location. To reduce the risk of sparking, do not use the megohmmeter to check electrical grounding unless:</p> <ul style="list-style-type: none"> • The gun has been removed from the hazardous location; • Or all spraying devices in the hazardous location are turned off, ventilation fans in the hazardous location are operating, and there are no flammable vapors in the area (such as open solvent containers or fumes from spraying). <p>Failure to follow this warning could cause fire, explosion, and electric shock and result in serious injury and property damage.</p>				

Test Gun Resistance

1. Flush and dry the fluid passage.
2. Trigger the gun and measure resistance between the electrode needle tip (3) and the turbine air fitting. The resistance should be 90-120 megohms. If outside this range, go to Test Power Supply Resistance on page 32. If in range, and there are other performance concerns, see **Check all possible remedies in the Troubleshooting Chart before disassembling the gun, on page 33**, for other possible causes of poor performance.

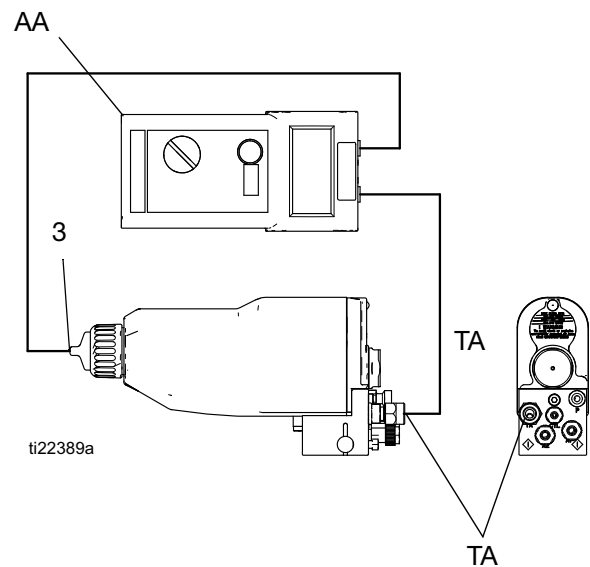


FIG. 18. Test Gun Resistance

Test Power Supply Resistance

1. Remove the power supply (7), **page 47**.
2. Remove the turbine alternator (8) from the power supply, **page 48**.
3. Measure resistance from the power supply's ground strips (EE) to the spring (7a). See FIGURE 19.
4. The resistance should be 90-115 megohms. If outside this range, replace the power supply. If in range, proceed to the next test.
5. Refer to **Electrical Troubleshooting on page 39** for other possible causes of poor performance.
6. Be sure the spring (7a) is in place before reinstalling the power supply.

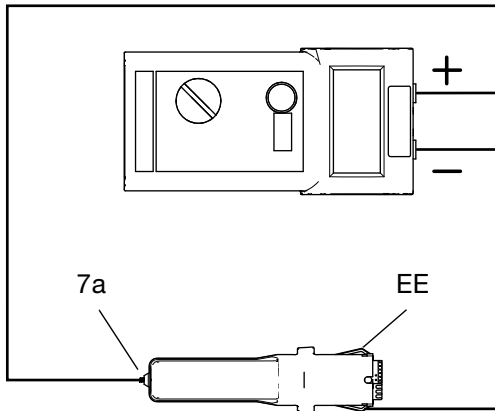


FIG. 19. Test Power Supply Resistance

Test Electrode Resistance

Remove the electrode (3). See **Electrode Replacement on page 43**. Measure the resistance between the contact (HH) and the electrode wire (GG). The resistance should be 8-30 megohms. If out of range, replace the electrode.

If the gun resistance is still out of range after testing the power supply and electrode:

- Check that the conductive o-ring (4a) is making contact with the barrel pin.
- Check that the power supply spring (7a) is making contact with the barrel pin.

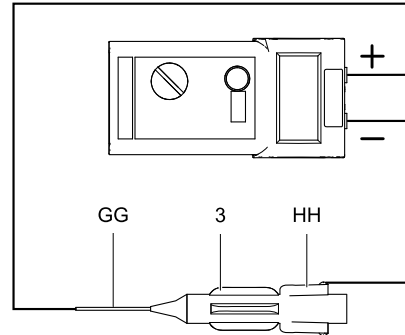


FIG. 20. Test Electrode Resistance

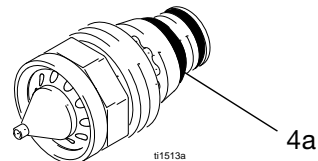




FIG. 21 Nozzle Conductive O-Ring

Troubleshooting

				
<p>Installing and servicing this equipment requires access to parts which may cause an electric shock or other serious injury if the work is not performed properly. Do not install or repair this equipment unless you are trained and qualified.</p> <p>Follow the Fluid Voltage Discharge and Grounding Procedure on page 24 before checking or servicing the system and whenever you are instructed to discharge the voltage.</p>				

				
<p>To reduce the risk of an injury, follow the Pressure Relief Procedure whenever you are instructed to relieve the pressure.</p>				

Check all possible remedies in the Troubleshooting Chart before disassembling the gun.

Voltage Loss Troubleshooting

Normal spraying voltage for a system using the waterborne gun is 45-55 kV. The system voltage is lower due to spraying current demands and voltage isolation system losses.

A loss of spraying voltage can be caused by a problem with the spray gun, fluid hose, or voltage isolation system, since all of the system components are electrically connected through the conductive, waterborne fluid.

Before troubleshooting or servicing the voltage isolation system itself, you need to determine which component in the system is most likely causing a problem. Possible causes include the following:

Spray Gun

- Fluid leakage.
- Dielectric breakdown at the fluid hose connection or fluid packings.
- Not enough air pressure for the alternator turbine.
- Faulty power supply.
- Excessive over spray on gun surfaces.
- Fluid in the air passages.

Waterborne Fluid Hose

- Dielectric failure of the hose (pin-hole leak in the PTFE layer)
- Air gap in the fluid column between the gun and the isolated fluid supply, causing a low voltage reading on the isolation system voltage meter.

Voltage Isolation System

- Fluid leakage.
- Dirty interior.
- Dielectric breakdown of hoses, seals, or connections.
- Isolators not functioning properly.

Visual Checks

First, check the system for any visible faults or errors to help isolate whether the spray gun, fluid hose or voltage isolation system has failed. A voltage probe and meter, part no. 245277, is helpful for diagnosing voltage problems and is required for some of the troubleshooting tests that follow.

1. Check that all of the air and fluid tubes and hoses are properly connected.
2. Check that the voltage isolation system valves and controls are properly set for operation.
3. Check that the interior of the isolated enclosure is clean.
4. Check that the spray gun and voltage isolation system have sufficient air pressure.
5. Check that the spray gun and voltage isolation system have sufficient air pressure.
6. Check that the gun turbine air (TA) is turned on and the pressure is set correctly.
7. Check that the voltage isolation system's enclosure door is closed and that any safety interlocks are engaged and working properly.
8. Make sure the voltage isolation system is in the "isolate" mode, where it is isolating the fluid voltage from ground.
9. To eliminate air gaps in the fluid column, spray enough fluid to purge the air out between the voltage isolation system and the spray gun. An air gap in the fluid hose can break the electrical continuity between the spray gun and the isolated fluid supply and cause a low voltage reading on a voltage meter connected to the isolated fluid supply.
10. Check the spray gun cover and barrel for accumulated over spray. Excessive over spray can create a conductive path back to the grounded gun body. Install a new gun cover and clean the exterior of the gun.
11. Inspect the entire system for any visible fluid leakage and repair any fluid leaks that are found. Pay special attention to the following areas:
 - Packing area of the spray gun.
 - Fluid hose: check for leakage or any bulges in the outer cover, which may indicate an internal leak.
 - Internal voltage isolation system components

Tests

If you still have no voltage, separate the spray gun and hose from the voltage isolation system and check whether the gun and hose alone will hold voltage with the following test.

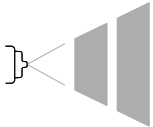


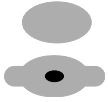
1. Flush the system with water and leave the lines filled with water.
 2. Discharge the system voltage, see **Fluid Voltage Discharge and Grounding Procedure on page 24**
 3. Follow the **Pressure Relief Procedure on page 24**.
 4. Disconnect the fluid hose from the voltage isolation system.

Avoid allowing any water to leak out of the fluid hose as that could cause a significant air gap in the fluid column up to the gun electrode, which can break the conductivity path and conceal a potential failure area.
 5. Position the end of the hose as far as possible away from any grounded surface. The end of the hose must be at least 1 ft. (0.3 m) from any ground. Make sure that no one is within 3 ft. (0.9 m) of the end of the hose.
 6. Turn the turbine air to the gun on. Measure the voltage at the gun electrode with a voltage probe and meter.
 7. Discharge the system voltage by waiting 30 seconds and then touching the gun electrode with a grounded rod.
 8. Check the meter reading:
 - If the meter reading is 45 to 55 kV, the gun and fluid hose are okay, and the problem is in the voltage isolation system.
 - If the meter reading is below 45 kV, the problem is in the gun or fluid hose.
 9. Flush the fluid hose and gun with enough air to dry out the fluid passages.
 10. Turn the turbine air to the gun on. Measure the voltage at the gun electrode with a voltage probe and meter.
 11. If the meter reading is 55-60 kV, the gun power supply is okay, and there is probably a dielectric breakdown somewhere in the fluid hose or gun. Continue with step 12.
- If the reading is below 55 kV, do the **Electrical Tests on page 31** to check the gun and power supply resistance. If those tests show the gun and power supply are okay, continue with step 12.
12. A dielectric breakdown is most likely in one of the following three areas. Repair or replace the component that is failing.
 - a. Fluid hose:
 - Check for leakage or any bulges in the outer cover, which may indicate a pin-hole leak through the PTFE layer. Disconnect the fluid hose from the gun, and look for signs of fluid contamination on the outside of the PTFE portion of the fluid tube.
 - Inspect the end of the hose connected to the voltage isolation system. Look for cuts or nicks.
 - Make sure the hose is properly stripped (see **Connect the Waterborne Fluid Hose on page 17**). Restrip or replace the hose.
 - b. Fluid packings:
 - Remove the packing assembly from the gun (see **Fluid Packing Rod Removal on page 43**), and look for signs of fluid leakage or any blackened areas, which would indicate arcing is occurring along the packing rod.
 - c. Fluid hose connection to the spray gun:
 - A breakdown at the fluid hose connection joint would be caused by fluid leaking past the o-ring seals on the end of the hose. Remove the hose at the gun connection and look for signs of fluid leakage along the PTFE tube.
 13. Before reassembling the gun, clean and dry the gun fluid inlet tube. Repack the inner spacer of the fluid packing rod with dielectric grease and reassemble the gun.
 14. Reconnect the fluid hose.
 15. Check the gun voltage with the voltage probe and meter before filling the gun with fluid.

Spray Pattern Troubleshooting

Check all possible remedies in the Troubleshooting Chart before disassembling the gun.

Some spray pattern problems are caused by the improper balance between air and fluid.

Problem	Cause	Solution
Fluttering or spitting spray. 	No fluid.	Refill supply.
	Loose, dirty, damaged nozzle/seat.	Air Cap/Nozzle Replacement on page 42.
	Air in fluid supply.	Check fluid source. Refill.
Improper spray pattern. 	Damaged nozzle or air cap.	Replace, Air Cap/Nozzle Replacement on page 42.
	Fluid buildup on air cap or nozzle.	Clean. Clean the Air Cap and Fluid Nozzle on page 29.
	Fan air pressure too high.	Decrease.
	Fluid too thin.	Increase viscosity.
	Fluid pressure too low.	Increase.
	Fan air pressure too low.	Increase.
	Fluid too thick.	Reduce viscosity.
	Too much fluid.	Decrease flow.
Streaks.	Did not apply 50% overlap.	Overlap strokes 50%.
	Dirty or damaged air cap.	Clean, Clean the Air Cap and Fluid Nozzle on page 29 or replace, see Air Cap/Nozzle Replacement on page 42.

Gun Operation Troubleshooting

Problem	Cause	Solution
Excessive spray fog.	Atomizing air pressure too high.	Decrease air pressure as low as possible.
	Fluid too thin.	Increase viscosity.
"Orange Peel" finish.	Atomizing air pressure too low.	Increase air pressure; use lowest air pressure necessary.
	Poorly mixed or filtered fluid.	Remix or refilter fluid.
	Fluid too thick.	Reduce viscosity.
Fluid leaks from the fluid packing area	Worn packings or rod.	Replace; see Air Cap/Nozzle Replacement on page 42.
Air leaks from the air cap	Worn piston stem o-rings.	Replace, see Piston Repair on page 45.
Fluid leakage from the front of the gun	Worn or damaged packing rod.	Replace, see Packing Rod Repair on page 44.
	Worn fluid seat.	Replace fluid nozzle (4) and/or electrode needle (3). See Air Cap/Nozzle Replacement on page 42.
	Loose fluid nozzle.	Tighten, See Air Cap/Nozzle Replacement on page 42
	Damaged nozzle o-ring.	Replace; see Air Cap/Nozzle Replacement on page 42.

Problem	Cause	Solution
Gun does not spray	Low fluid supply.	Add fluid if necessary.
	Damaged air cap.	Replace; see Air Cap/Nozzle Replacement on page 42.
	Dirty or clogged fluid nozzle.	Clean; see Clean the Air Cap and Fluid Nozzle on page 29.
	Damaged fluid nozzle.	Replace, see Air Cap/Nozzle Replacement on page 42.
	Piston not actuating.	Check cylinder air. Check piston o-ring (11d); see Piston Repair on page 45.
	Actuator arm is out of position.	Check actuator arm and nuts. See Adjust the Actuator Arm on page 46.
Dirty air cap	Misaligned air cap and fluid nozzle.	Clean fluid buildup off air cap and fluid nozzle seat; see Clean the Air Cap and Fluid Nozzle on page 29.
	Damaged nozzle orifice.	Replace nozzle (4); see page 42
	Fluid is coming on before the air.	Check actuator arm and nuts. See Adjust the Actuator Arm on page 46.
Air leaks from manifold	Manifold is not tight	Tighten manifold screws
	Worn or missing o-rings	Replace o-rings. See Air Cap/Nozzle Replacement on page 42.
Fluid leaks at the quick-disconnect.	Manifold is not tight.	Tighten manifold screws.
	Fluid hose o-rings are worn or missing.	Inspect or replace o-rings
	Hose not seated properly.	Make sure the hose was stripped and installed correctly. See Connect the Waterborne Fluid Hose on page 17.



Electrical Troubleshooting

Problem	Cause	Solution
Voltage still present at gun after following the Fluid Voltage Discharge and Grounding Procedure on page 24.	Turbine air is not turned off.	Turn off.
	Did not wait long enough for voltage to discharge.	Wait longer before touching electrode with grounded rod. Check for bleed resistor failure.
	Air pocket in fluid line leaves fluid near gun isolated.	Determine cause and correct. Purge air from fluid line.
	Voltage isolation system failed.	Service voltage isolation system.

Poor wrap	Turbine air is not turned on.	Turn on.
	Booth exhaust velocity is too high.	Reduce velocity to within code limits.
	Atomizing air pressure too high.	Decrease.
	Fluid pressure too high.	Decrease.
	Incorrect distance from gun to part.	Should be 8-12 in. (200-300 mm).
	Poorly grounded parts.	Resistance must be 1 megohm or less. Clean workpiece hangers.
	Faulty gun resistance.	See Test Gun Resistance on page 31 .
	Fluid leaks from the packing (2d) and causes a short.	Clean the packing rod cavity, or replace the packing rod. See Packing Rod Repair on page 44 .
	Faulty turbine alternator.	See Turbine Removal and Replacement page 48
	No power.	Check power supply, alternator, and alternator ribbon cable. See Power Supply Removal and Replacement on page 47 .
	Spilled paint, dried paint, or other contaminants inside the WB100 Enclosure, causing a short circuit.	Check power supply, alternator, and alternator ribbon cable. See Power Supply Removal and Replacement on page 47 .
Grounding cylinder not retracted	Check operation of grounding cylinder.	
ES indicator light is not lit (standard models only)	No power	Check power supply, turbine, turbine ribbon cable. See Power Supply Removal and Replacement on page 47 and Turbine Removal and Replacement on page 48 .
ES indicator light is amber (standard models only)	Turbine speed is too low	Increase air pressure until indicator is green.
ES indicator light is red (standard models only)	Turbine speed is too high	Decrease air pressure until indicator is green
No voltage or low voltage reading on the smart gun Pro Xp Auto Control Module	Damaged fiber optic cable or connection.	Check; replace damaged parts. See the Pro Xp Auto Control Module manual 332989.
	Turbine air is not turned on.	Turn on.
	Poor wrap.	See causes and solutions under Poor Wrap, see Poor wrap on page 40 .
Pro Xp Auto Control Module displays event code (smart models only)		See manual 332989 for Event Code Troubleshooting.

Repair

Prepare the Gun for Service

				
<p>Installing and servicing this equipment requires access to parts which may cause an electric shock or other serious injury if the work is not performed properly. Do not install or repair this equipment unless you are trained and qualified.</p> <p>Contact with the charged components of the spray gun will cause an electric shock. Do not touch the gun nozzle or electrode or come within 4 in. (102 mm) of the front of the gun during operation or until performing the Fluid Voltage Discharge and Grounding Procedure.</p>				

				
<p>To reduce the risk of an injury, follow the Pressure Relief Procedure before checking or servicing any part of the system and whenever you are instructed to relieve the pressure.</p>				

- Check all possible remedies in **Troubleshooting** before disassembling the gun.
- Use a vise with padded jaws to prevent damage to plastic parts.
- Lubricate some packing rod parts (2) and certain fluid fittings with dielectric grease (44), as specified in the text.
- Lightly lubricate o-rings and seals with non-silicone grease. Order Part No. 111265 Lubricant. Do not over-lubricate.
- Only use genuine Graco parts. Do not mix or use parts from other PRO Gun models.
- Air Seal Repair Kit 24W390 is available. The kit must be purchased separately. Kit parts are marked with an asterisk, for example (6a*).
- Fluid Seal Repair Kit 24W391 is available. The kit must be purchased separately. Kit parts are marked with a symbol, for example (2a‡).

Remove the Gun from the Manifold

1. Follow the **Fluid Voltage Discharge and Grounding Procedure** on page 24.
2. Flush and clean the gun, see **Daily Care and Cleaning Checklist** on page 28.
3. Follow the **Pressure Relief Procedure** on page 24.
4. Remove the air cap (25) and shroud (26), see **Air Cap/Nozzle Replacement** on page 42.
5. Loosen the fluid hose strain relief bracket.
6. Disconnect the fluid hose fitting (602) from the gun barrel (1).
7. Loosen two manifold screws (21) and remove gun.

The screws (21) should stay on the manifold and the five o-rings (18) should stay on the gun.

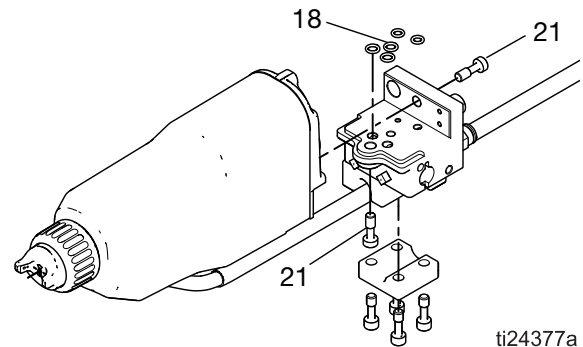


FIG. 22 Remove Gun from Manifold

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Install the Gun on the Manifold

1. Make sure the five o-rings (18) are in place.
2. Secure the gun to the manifold by tightening the two manifold screws (21).
3. Make sure the hose fittings and barrel are clean and dry, then **Connect the Waterborne Fluid Hose** on page 17.
4. Tighten strain relief screws.
5. Reinstall the gun cover (26) and air cap (25).

Air Cap/Nozzle Replacement

1. **Prepare the Gun for Service on page 41.**
2. Remove the retaining ring (24) and air cap (25). See FIGURE 23.
3. Remove the fluid nozzle (4) assembly with the multi-tool (44).

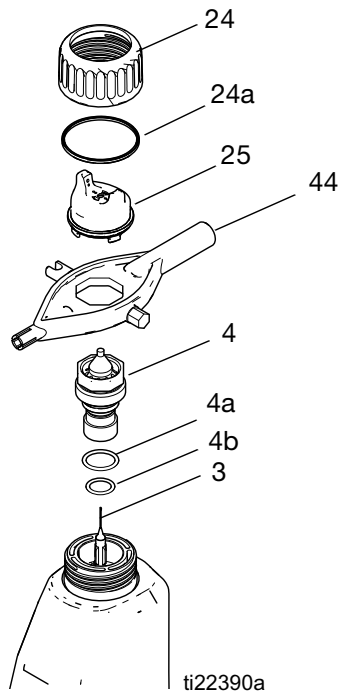


Fig. 23. Air Cap/Nozzle Replacement

<p>The nozzle contact ring (4a) is a conductive contact ring, not a sealing o-ring. To reduce the risk of fire and explosion or electric shock:</p> <ul style="list-style-type: none"> • Do not remove the nozzle contact ring (4a) except to replace it. • Never operate the gun without the contact ring in place. • Do not replace the contact ring with anything but a genuine Graco part. 				

Use non-silicone grease, Part No. 111265, on the small o-ring (4b). Do not over-lubricate. Do not lubricate the contact ring (4a).

4. Make sure the conductive contact ring (4a) and the small o-ring (4b) are in place on the nozzle (4). Lightly lubricate the small o-ring (4b).

Make sure the electrode needle (3) is finger-tight (See **Electrode Replacement on page 43**).

5. Install the fluid nozzle (4) with the multi-tool (44). Tighten until the fluid nozzle seats in the gun barrel (1/8 to 1/4 turn past hand-tight).
6. Assemble the shroud.
7. Carefully install the air cap (25). Be sure to insert the electrode (3) through the center hole of the air cap. Rotate the air cap to the desired position.
8. Make sure the u-cup (24a) is in place on the retaining ring (24). The lips must face forward. Tighten the retaining ring until the air cap is held firmly in place; you should not be able to rotate the air cap horns by hand.
9. **Test Gun Resistance on page 31.**
10. Install the gun onto the manifold and bracket.

Electrode Replacement

1. Follow the steps in **Prepare the Gun for Service on page 41**.
2. Remove the air cap and nozzle, **Air Cap/Nozzle Replacement on page 42**.
3. Unscrew the electrode (3) with the multi-tool (44), FIGURE 24.

NOTICE

To avoid damaging the plastic threads, be very careful when installing the electrode.

4. Apply low-strength (purple) or equivalent thread sealant to the electrode and packing rod threads. Install the electrode finger-tight. Do not over tighten.
5. Install the fluid nozzle, see **Air Cap/Nozzle Replacement on page 42**.
6. **Test Gun Resistance on page 31**.
7. Install the air cap, see **Air Cap/Nozzle Replacement on page 42**.
8. Install the gun onto the manifold and bracket.

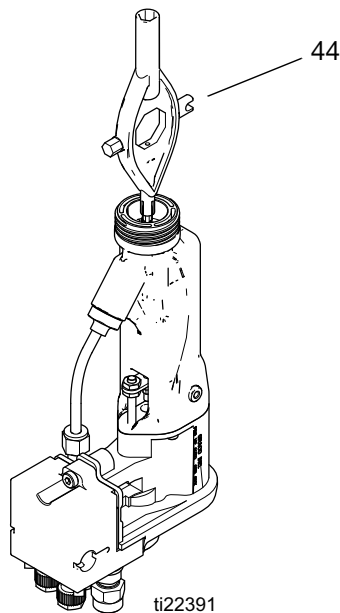


FIG. 24. Electrode Replacement

Fluid Packing Rod Removal

You may replace the packing rod as an assembly, as described below, or as individual parts (see **Packing Rod Repair on page 44**). The assembly is pre-adjusted at the factory.

1. Follow the steps in **Prepare the Gun for Service on page 41**.
2. Remove the air cap, see **Air Cap/Nozzle Replacement on page 42**. Remove the gun shroud (26).
3. Remove the jam nut (16) and actuator arm (15) and adjustment nut (16). See FIGURE 28.

The fluid nozzle (4) must be in place when removing or installing the jam nut and actuator arm.

4. Remove the fluid nozzle (4) and electrode (3). See **Electrode Replacement on page 43**.
5. Remove the packing rod (2), using the multi-tool (44).

NOTICE

Clean all parts in non-conductive solvent compatible with the fluid being used, such as xylol or mineral spirits. Use of conductive solvents can cause the gun to malfunction.

6. Check all parts for wear or damage and replace if necessary.

Before installing the packing rod, clean the internal surface of the barrel (1) with a soft cloth or brush. Check for marks from high voltage arcing. If marks are present, replace the barrel.

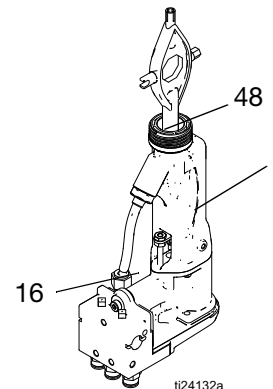


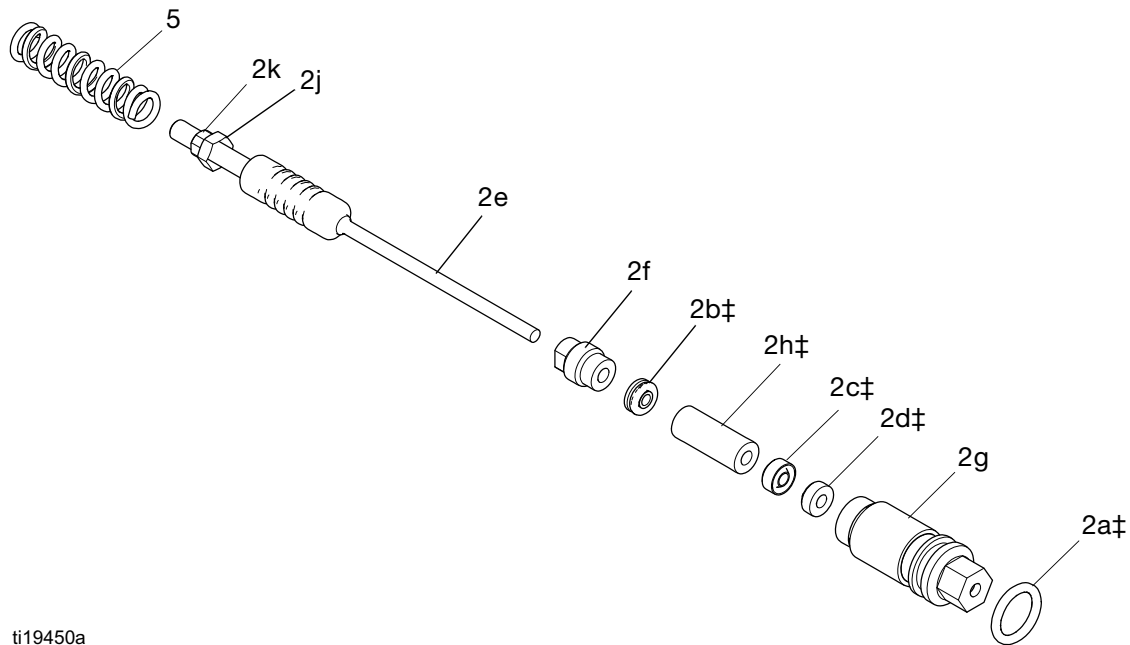
FIG. 25. Fluid Packing Removal

Packing Rod Repair

You may replace the packing rod as individual parts, as described below, or as an assembly (see **Fluid Packing Rod Removal on page 43**). The assembly is pre-adjusted at the factory.

Before installing the fluid packing rod into the gun barrel, make sure the internal surfaces of the barrel are clean. Remove any residue with a soft brush or cloth. Check the inside of the barrel for marks from high voltage arcing. If marks are present, replace the barrel.

1. Place the packing nut (2f) and seal (2b†) on the fluid rod (2e). Flats on the packing nut must face the back of the fluid rod. The seal o-ring must face away from the packing nut.
2. Fill the inner cavity of the spacer (2h†) with dielectric grease (43). Place the spacer on the fluid rod (2e) in the direction shown. Generously apply dielectric grease to the outside of the spacer.
3. Place the fluid packing (2c†) on the packing rod (2e) with its lips facing the front of the rod. Install the needle packing (2d†) with the male end toward the fluid packing, then install the housing (2g).
4. Lightly tighten the packing nut (2f). The packing nut is properly tightened when there is 3 lb (13.3N) of drag force when sliding the packing housing (2g) assembly along the rod. Tighten or loosen the packing nut as needed.
5. Install the o-ring (2a†) on the outside of housing (2g). Lubricate the o-ring with non-silicone grease, Part No. 111265. Do not over-lubricate.
6. Install the spring (5) against the nut (2j) as shown.
7. Install the packing rod assembly (2) into the gun barrel. Using the multi-tool (44), tighten the assembly until just snug.
8. Install the electrode. See **Electrode Replacement on page 43**.
9. Install the nozzle and air cap. See **Air Cap/Nozzle Replacement on page 42**.
10. See **Test Gun Resistance on page 31**.



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FIG. 26. Packing Rod

Piston Repair

1. Follow the steps in **Prepare the Gun for Service on page 41.**
2. Remove the air cap, see **Air Cap/Nozzle Replacement on page 42.** Remove the gun shroud (26).
3. Remove the jam nut (16), actuator arm (15), and adjustment nut (16). See FIGURE 28.

The fluid nozzle (4) must be in place when removing or installing the jam nut and actuator arm.

4. Remove piston cap (13) from the rear of the gun.
5. Push on the piston rod (11) to push the piston out the back of the gun.
6. Inspect the o-rings (11d, 11e, 11f, 11g) for damage. See Table 3 and FIGURE 27.
7. Lubricate the o-rings (11d, 11e, 11f, 11g) with non-silicone grease, Part No. 111265. Do not over-lubricate.
8. Align the two stems (11c) with the holes in the gun body and press the piston assembly into the back of the gun until it bottoms.
9. Install and adjust the actuator arm, see **Adjust the Actuator Arm on page 46.**

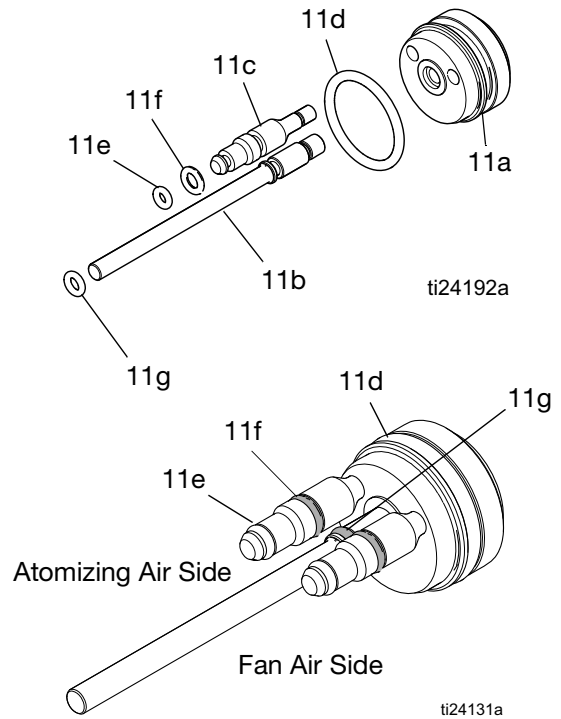


FIG. 27. Piston O-Rings

Table 3: Piston O-Rings

Description	Function
Shaft O-Ring (11g)	Seals cylinder air along the piston rod (34b). Replace if air leaks along rod.
Front O-Ring (11e)	Air shutoff seal. Replace if air leaks from air cap when gun is de-triggered.
Back O-Ring (11f)	Separates cylinder air from fan and atomizing air.
Piston O-Ring (11d)	Replace if air leaks from small vent hole at back of manifold when gun is triggered.
O-rings included in air seal repair kit 24W390	

Adjust the Actuator Arm

The fluid nozzle (4) must be in place when removing or installing the jam nut and actuator arm.

See FIGURE 28.

1. Install the adjustment nut (16b), actuator arm (15), and jam nut (16a) onto the piston rod (11b).
2. Position the parts so there is a 0.125 in. (3 mm) gap between the actuator arm (15) and the fluid packing rod nut (E). This allows the atomizing air to actuate before the fluid.
3. Tighten the adjustment nut (16b) against the actuator arm (15). Check that the 0.125 in. (3 mm) gap has been maintained. In addition, there should be 3 mm of electrode needle travel when the gun is triggered. Adjust the jam nut position to obtain these dimensions. Tighten the jam nut (16a)
4. **Test Gun Resistance on page 31.**
5. Install the gun shroud (26) and air cap (25).
6. **Install the Gun on the Manifold on page 41.**

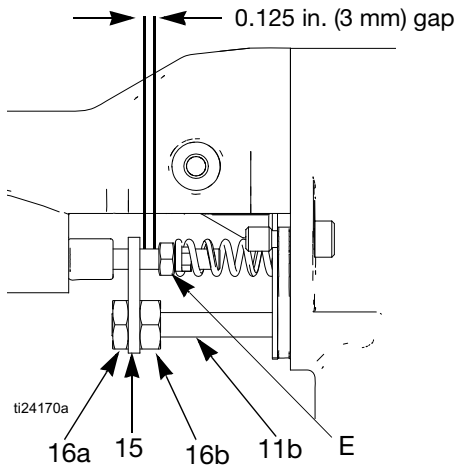


FIG. 28. Actuator Arm Adjustment

Barrel Removal

1. Follow the steps in **Prepare the Gun for Service on page 41.**
2. Remove the air cap, see **Air Cap/Nozzle Replacement on page 42.** Remove the gun shroud (26).
3. Remove the adjustment nuts (16a, 16b) and actuator arm (15). See FIGURE 28.
4. Loosen the two screws (19). See FIGURE 29.

NOTICE

To avoid damaging the power supply, pull the gun barrel (1) straight away from the gun body (10). If necessary, gently move the gun barrel from side to side to free it from the gun body.

5. Hold the gun body (10) with one hand and pull the barrel (1) straight off the body. See FIGURE 29.

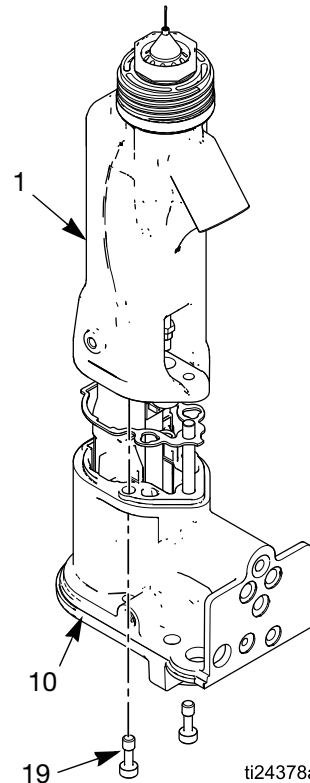


FIG. 29. Barrel Removal

Barrel Installation

See FIGURE 30

1. Verify the gasket (9) and grounding spring (6) are in place and the gasket air holes are aligned properly. Replace the gasket if damaged.
2. Make sure the spring is in place on the tip of the power supply (7). Liberally apply dielectric grease to the tip of the power supply. Place the barrel (1) over the power supply and onto the gun body (10).
3. Tighten the two barrel screws (19) oppositely and evenly (about a half turn past snug or 20 in-lbs). Do not over-tighten.

NOTICE

To avoid damaging the gun barrel, do not over-tighten the screws (19).

4. Install and adjust the actuator arm (15), jam nut (16), and adjustment nut (16). See **Adjust the Actuator Arm on page 46**.
5. **Test Gun Resistance on page 31**.
6. Install the gun shroud (26) and air cap.
7. **Install the Gun on the Manifold on page 41**.

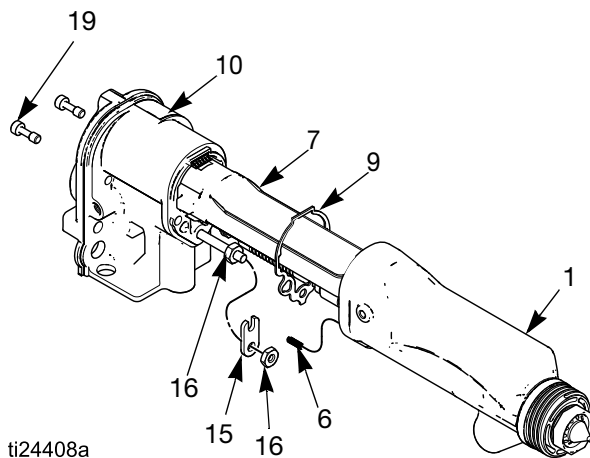


Fig. 30. Barrel Installation

Power Supply Removal and Replacement

- Inspect the gun body power supply cavity for dirt or moisture. Clean with a clean, dry rag.
 - Do not expose gasket (9) to solvents.
1. Follow the steps in **Prepare the Gun for Service on page 41**.
 2. Follow the steps in **Barrel Removal on page 46**.

NOTICE

Be careful when handling the power supply (7) to avoid damaging it.

3. Grasp the power supply (7) with your hand. With a gentle side to side motion, free the power supply/turbine assembly from the gun body (10), then carefully pull it straight out.

Smart models only: Disconnect the flexible circuit (30) from the socket at the top of the gun body.

4. Inspect the power supply and turbine for damage.
5. To separate the power supply (7) from the turbine (8), disconnect the 3-wire ribbon connector (PC) from the power supply.

Smart models only: Disconnect the 6-pin flexible circuit (30) from the power supply.

Slide the turbine up and off the power supply.

6. See **Test Power Supply Resistance on page 32**. Replace the power supply if necessary. To repair the turbine, see **Turbine Removal and Replacement on page 48**.

NOTICE

To prevent damage to the cable and possible interruption of the ground continuity, bend the turbine's 3-wire ribbon cable (PC) upward and back, so the bend faces the power supply and the connector is at the top.

7. Connect the 3-wire ribbon connector (PC) to the power supply.

Smart models only: Connect the 6-pin flexible circuit (30) to the power supply.

Tuck the ribbon forward, under the power supply. Slide the turbine (8) down onto the power supply (7).

8. Insert the power supply/turbine assembly in the gun body (10). Make sure the ground strips (EE) make contact with the gun body.

Smart models only: Align the connector of the 6-pin flexible circuit (30) with the socket (CS) at the top of the gun body. See FIGURE 31.

Push the connector securely into the socket as you slide the power supply/turbine assembly into the gun body.

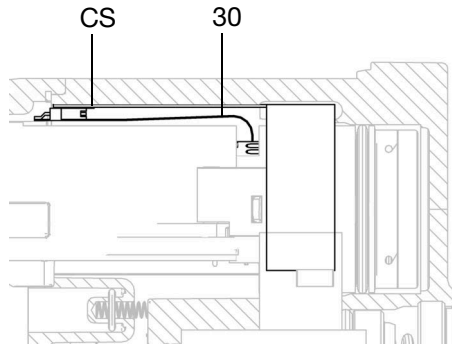


FIG. 31. Connect Flexible Circuit

9. Make sure the gasket (9), ground spring (6), and power supply spring (7a) are in place. Replace gasket (9) if damaged. Assemble the barrel (1) to the body (10). See **Barrel Installation on page 47**.
10. See **Test Gun Resistance on page 31**.

Turbine Removal and Replacement

Replace turbine bearings after 2000 hours of operation. Order Part No. 24N706 Bearing Kit. Parts included in the kit are marked with a symbol (◆). See FIGURE 32 through FIGURE 34.

1. Follow the steps in **Prepare the Gun for Service on page 41**.
2. Remove the power supply/turbine assembly and disconnect the turbine. See **Power Supply Removal and Replacement on page 47**.
3. Measure resistance between the two outer terminals of the 3-wire connector (PC); it should be 2.0–6.0 ohms. If outside this range, replace the turbine coil (8a).
4. Using a flat blade screwdriver, pry the clip (8h) off the housing (8d). Remove the cap (8f), using a thin blade or screwdriver.
5. If necessary, rotate the fan (8e) so its blades clear the four bearing tabs (T) of the housing (8d).

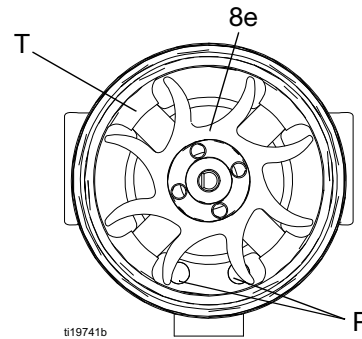


FIG. 32. Fan Orientation

6. Push the fan and coil assembly (8a) out the front of the housing (8d).

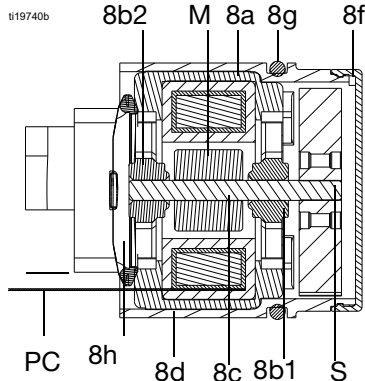


FIG. 33. Turbine Cross-Section.

NOTICE

Do not scratch or damage the magnet (M) or shaft (S). Do not pinch or damage the 3-wire connector (PC) when disassembling and reassembling the bearings.

7. Hold the coil assembly (8a) on a workbench with the fan end facing up. Using a wide blade screwdriver, pry the fan (8e) off the shaft (S).
8. Remove the top bearing (8b2).
9. Remove the bottom bearing (8b1).
10. Install the new bottom bearing (8b1.) on the long end of the shaft (S). The flatter side of the bearing must face away from the magnet (M). Install in the

coil (8a) so the bearing blades are flush with the surface of the coil.

11. Press the new top bearing (8b2.) onto the short end of the shaft so the bearing blades are flush with the surface of the coil (8a). The flatter side of the bearing must face away from the coil.
12. Hold the coil assembly (8a) on a workbench with the fan end facing up. Press the fan (8e.) onto the long end of the shaft (S).The fan blades must be oriented as shown in FIGURE 32.
13. Carefully press the coil assembly (8a) into the front of the housing (8d.) while aligning the pin on the coil with the slot in the housing. The 3-wire connector (PC) must be positioned below the wider notch (W) of the housing tabs, as shown in Fig. 45. Be sure the coil alignment pins (P) are positioned as shown in Fig. 44.
14. Rotate the fan (8e) so its blades clear the four bearing tabs (T) at the back of the housing. Ensure that the blades of the bottom bearing (8b1.) align with the tabs.
15. Seat the coil fully into the housing (8d.). Secure with the clip (8h.),ensuring that its tabs engage the slots in the housing.
16. Ensure that the o-ring (8g) is in place. Install the cap (8f).
17. Install the turbine on the power supply, and install both parts in the gun body. See **Power Supply Removal and Replacement on page 47.**

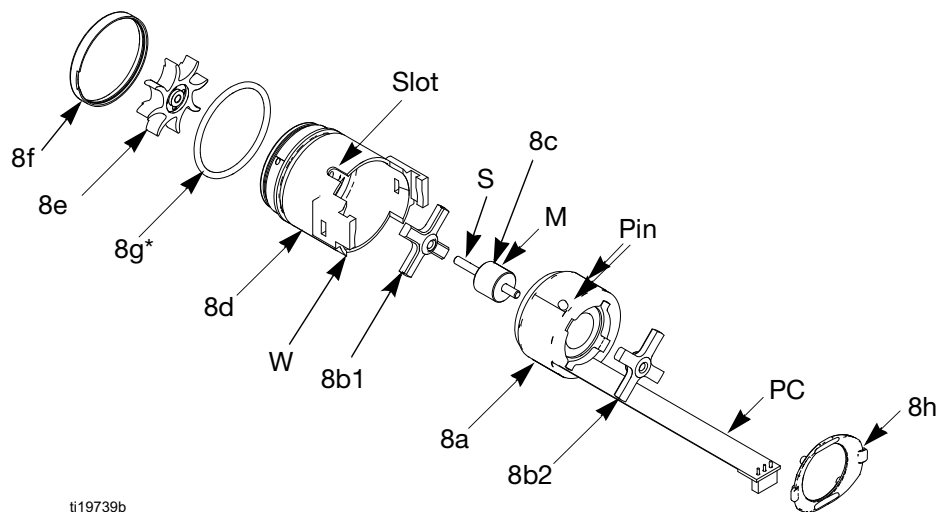

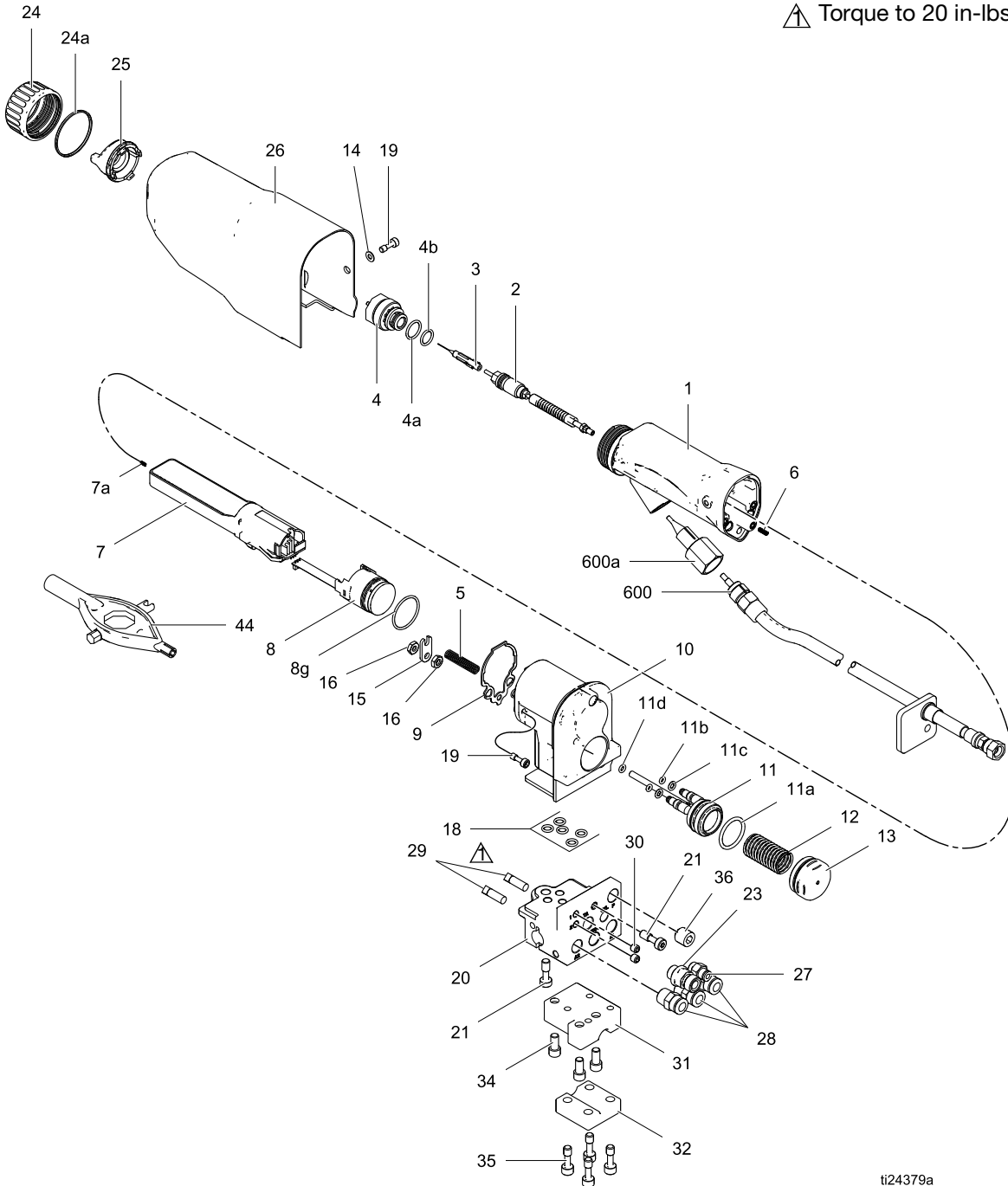


FIG. 34. Turbine

Parts

Standard Pro Xp Auto Waterborne Air Spray Gun Models LA1T18, Waterborne, Rear Manifold, Series B

 Torque to 20 in-lbs (2 N•m)




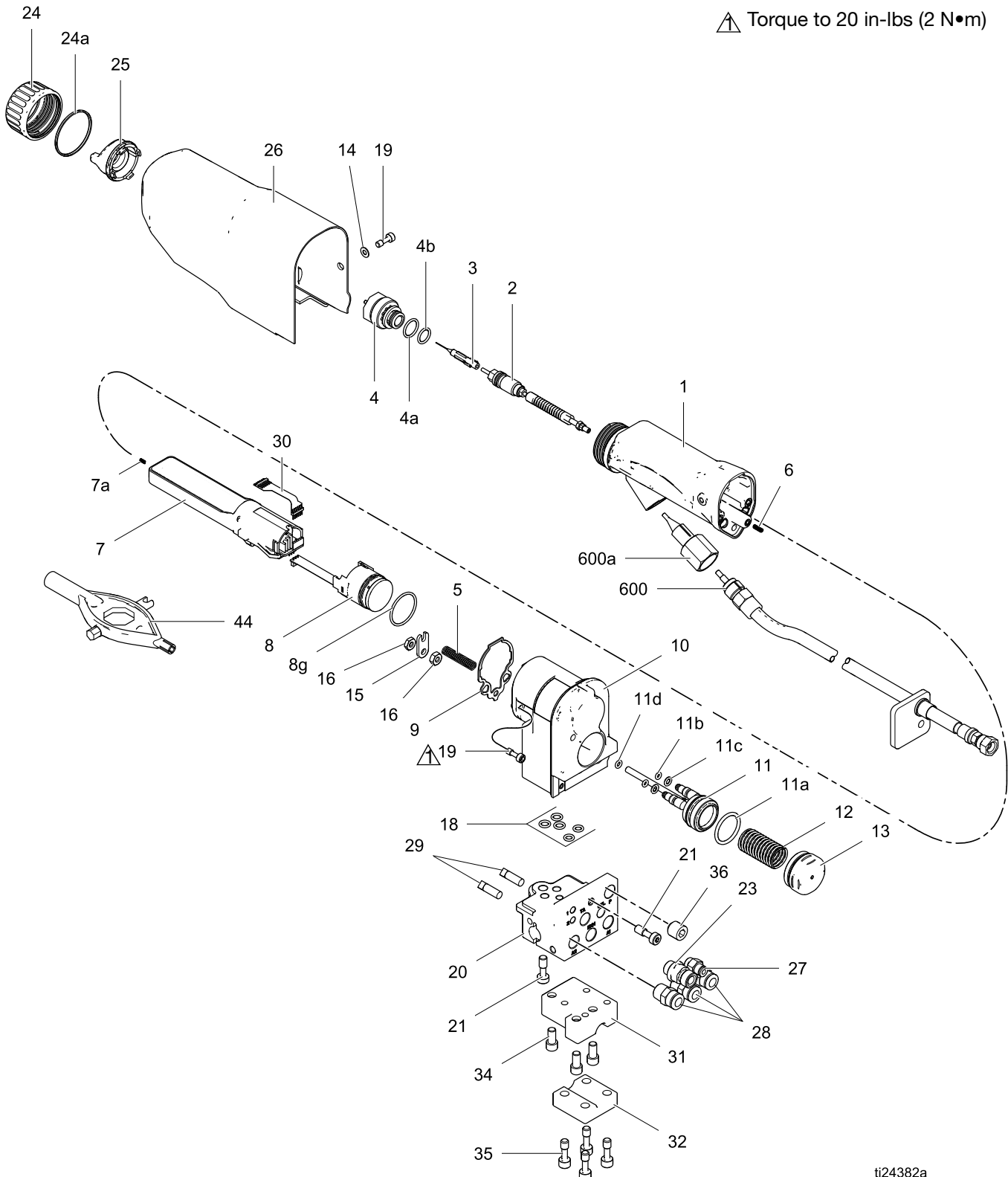
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LA1T18, Waterborne, Rear Manifold, Series B

Ref. No.	Part No.	Description	Qty	Ref. No.	Part No.	Description	Qty	
1	24W873	BODY, gun assembly (includes 9)	1	24	24N644	RING, retainer, assy; includes 24a	1	
2	24N655	See Packing Rod Assembly on page 54.		24a	198307	PACKING, u-cup; UHMWPE	1	
3	24N652	NEEDLE, electrode, WB	1	25	24N477	AIR CAP, machining, black	1	
4	24N616	NOZZLE, fluid; includes 4a and 4b	1	26	24W389	COVER, shroud, Auto XP WB	1	
	4a	24N645	O-RING, conductive	1	27	114263	FITTING, connector, male	1
	4b	111507	O-RING; fluoroelastomer	1	28	115950	FITTING, connector, 1/4npt (M), 5/16T	3
5	185111	SPRING, compression	1	29	110465	SCREW, set	2	
6	197624	SPRING, compression	1	30	102207	SCREW, set, SCH	2	
7	24N662	POWER SUPPLY, 60 kV, WB	1	31*		BRACKET, strain relief, WB tube	1	
7a	24N979	SPRING	1	32*		CLAMP, strain relief, SM WB	1	
8	24N664	See Turbine Assembly on page 55.		34*	GC2248	SCREW, SHDC, SS, 0.250x.50	3	
8g*	110073	O-RING, packing	1	35*	24X482	FASTENER, retainer (pack of 4)	1	
9	25N921	GASKET, barrel	1	36	117560	SCREW, set, socket head	1	
10	24W381	BODY, Auto XP, STD, WB (includes 18, 19)	1	37	070303	LUBRICANT, grease	1	
11	24W396	PISTON, assy, actuation, auto	1	38	070311	SEALANT, anaerobic	1	
11a	17B704	O-RING, packing	1	39	070321	LUBRICANT, grease	1	
11b	111504	O-RING, packing	2	40	116553	GREASE, dielectric; 1 oz (30 ml) tube (not shown)	1	
11c	112319	O-RING, packing	2	43	179791	TAG, warning (not shown)	1	
11d	111508	O-RING, packing	1	44	276741	MULTI-TOOL (shipped loose)	1	
12	112640	SPRING, compression	1	45	107460	TOOL, wrench, ball end	1	
13	24W397	CAP, piston, actuation	1	600	24W597	See , page 63		
14	513505	WASHER, plain #10 SST	1	600a	16N953	See , page 63		
15	24W398	ARM, fluid actuator, XP (Includes 16 qty 2)	1			Replacement Warning labels, signs, tags, and cards are available at no cost.		
16	100166	NUT, full hex	2			Included in air seal repair kit 24W390 (purchase separately)		
18	111450	PACKING, O-RING	5			* Included in WB hose mount kit 24W878 (purchase separately)		
19	24N740	SCREW, ES gun (Includes 2)	4			❖ Included in Rear Manifold Repair Kit 24W392 (purchase separately)		
20	24W392	MANIFOLD, rear inlet, Auto XP (includes 21, 23, 27, 28, 29, 36)	1			Included in Turbine Assembly 24N664 (purchase separately). See Turbine Assembly on page 55.		
21	24W399	SCREW, modified, 1/4-20, XP Auto	2					
23	24W411	FITTING, Adapter, M12 TO 1/4, LH, XP	1					

Smart Pro Xp Auto Waterborne Air Spray Gun Model LA1M18, Waterborne, Rear Manifold, Series B

 Torque to 20 in-lbs (2 N•m)



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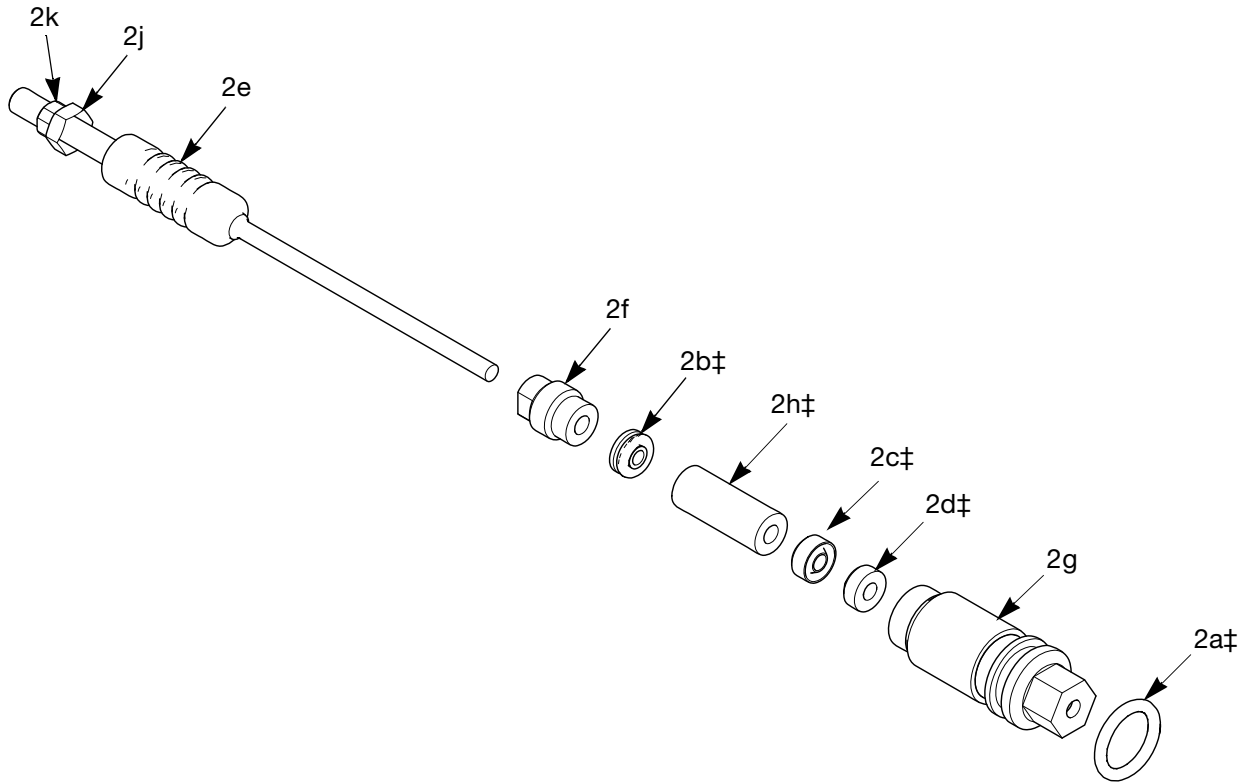
LA1M18, Waterborne, Rear Manifold, Series B

Ref. No.	Part No.	Description	Qty	Ref. No.	Part No.	Description	Qty
1	24W873	BODY, gun assembly (includes 9)	1	31*		BRACKET, strain relief, WB tube	1
2	24N655	See Packing Rod Assembly on page 54.	1	32*		CLAMP, strain relief, SM WB	1
3	24N652	NEEDLE, electrode	1	34*	GC2248	SCREW, SHDC, SS, 0.250x0.50	3
4	24N616	NOZZLE, fluid; includes 4a and 4b	1	35*	24X482	FASTENER, retainer (pack of 4)	1
4a	24N645	O-RING, conductive	1	36	117560	SCREW, set. socket head	1
4b	111507	O-RING; fluoroelastomer	1	37	070303	GREASE, lubricant	1
5	185111	SPRING, compression	1	38	070311	SEALANT, anaerobic	1
6	197624	SPRING, compression	1	39	070321	GREASE, lubricant	1
7	24N662	POWER SUPPLY, 60 kV, WB	1	40	116553	GREASE, dielectric; 1 oz (30 ml) tube (not shown)	1
7a	24N979	SPRING	1	43	179791	TAG, warning (not shown)	1
8	24N644	See Turbine Assembly on page 55.		44	276741	MULTI-TOOL (shipped loose)	1
8g	110073	O-RING, packing	1	45	107460	TOOL, wrench, ball end	1
9	25N921	GASKET, barrel		80	24W035	CONTROL MODULE, Pro Xp Auto (not shown). See 332989.	1
10	24W866	BODY, assy, Auto XP, WB, Smart, Rear (includes 10, 19)	1	600	24W597	See , page 63	
11	24W396	PISTON, assy, actuation, auto	1	600a	16N953	See , page 63	
11a	17B704	O-RING, packing	1			Replacement Warning labels, signs, tags, and cards are available at no cost.	
11b	111504	O-RING, packing	2	*		Included in WB Hose Mount Kit 24W878 (purchase separately)	
11c	112319	O-RING, packing	2			Included in air seal repair kit 24W390 (purchase separately)	
11d	111508	O-RING, packing	1			Included in Turbine Assembly 24N664 (purchase separately). See Turbine Assembly on page 55.	
12	112640	SPRING, compression	1				
13	24W397	CAP, piston, actuation	1				
14	513505	WASHER, plain #10 SST	1				
15	24W398	ARM, fluid actuator, XP	1				
16	100166	NUT, full hex	2				
18	111450	PACKING, O-RING	5				
19	24N740	SCREW, ES gun (includes 2)	4				
20	24W392	MANIFOLD, rear inlet, Auto XP (includes 21, 23, 27, 28, 29, 36)	1				
21	24W399	SCREW, modified, 1/4-20, XP Auto	2				
23	24W411	FITTING, Adapter, M12 TO 1/4, LH, XP	1				
24	24J234	RING, retainer, assy; includes 24a	1				
24a	198307	PACKING, u-cup; UHMWPE	1				
25	24N477	AIR CAP, machining, black	1				
26	24W389	COVER, shroud, Auto XP WB	1				
27	114263	FITTING, connector, male	1				
28	115950	FITTING, connector, 1/4npt (M), 5/16T	3				
29	110465	SCREW, set	2				
30	245265	CIRCUIT, flexible	2				

Packing Rod Assembly

Part No. 24N655 Packing Rod Assembly

Includes items 2a-2k



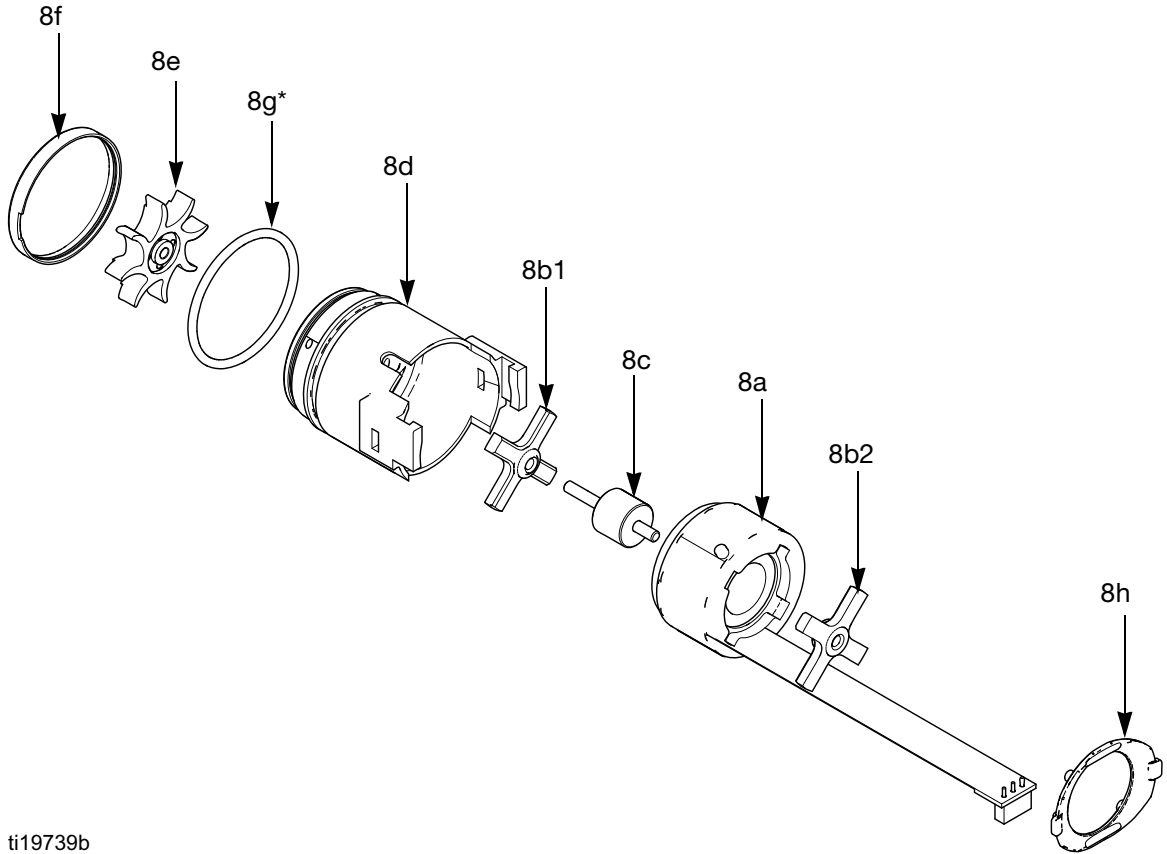
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Ref. Part No. No.	Description	Qty	Ref. Part No. No.	Description	Qty
2a‡	111316 O-RING	1	2j*	----- NUT, trigger adjustment (part of item 2e)	1
2b‡	116905 SEAL	1	2k*	----- NUT, trigger adjustment (part of item 2e)	1
2c‡	178409 PACKING, fluid	1			
2d‡	178763 PACKING, needle	1			
2e	24N703 ROD, packing (includes items 2j and 2k)	1			
2f	197641 NUT, packing	1			
2g	185495 HOUSING, packing	1			
2h‡	186069 SPACER, packing	1			

‡ These parts are included in Fluid Seal Repair Kit 24W391 (purchase separately).
 * These parts are included in Trigger Adjustment Nut Kit 24N700 (purchase separately).
 Parts labeled ----- are not available separately

Turbine Assembly

Part No. 24N664 Turbine Assembly

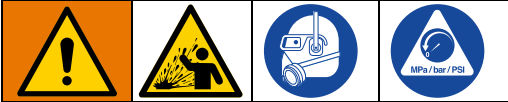


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Ref. Part No.	Part No.	Description	Qty	Ref. Part No.	Part No.	Description	Qty
8a	24N705	COIL, turbine	1	8g*	110073	O-RING	1
8b◆	24N706	BEARING KIT (includes two bearings, item 8e fan, and one item 8h clip)	1	8h◆	24N709	CLIP; package of 5 (one clip included with item 15b)	1
8c	24Y264	SHAFT KIT (includes shaft and magnet)	1	9*	25N921	GASKET, barrel (not shown).	1
8d◆	24N707	HOUSING; includes item 8f	1	* These parts are included in Air Seal Repair Kit 24W390 (purchase separately).			
8e◆	-----	FAN; part of item 8b	1	◆ These parts are included in Bearing Kit 24N706 (purchase separately).			
8f	-----	CAP, housing; part of item 8d	1	Parts labeled ----- are not available separately			

Air Caps and Fluid Nozzles

Fluid Nozzle Selection Chart



To reduce the risk of an injury, follow the **Pressure Relief Procedure** before removing or installing a fluid nozzle and/or air cap.

Fluid Nozzle Part No.	Orifice Size, mm (in.)	Color	Description
24N619	0.55 (.022)	Black	Standard nozzles (STD) for standard coatings
24N613	0.75 (.029)	Black	
26D094	0.9 (.035)	Black	
25N895	1.0 (.042)	Green	
25N896	1.2 (.047)	Gray	
24N616	1.5 (.055)	Black	
25N897	1.8 (.070)	Brown	
24N618	2.0 (.079)	Black	
25N831	1.0 (.042)	Green	Precision high wear nozzles (PHW) with hardened SST seat and damage resistant SST tip; for standard coatings, abrasives, and metallics
25N832	1.2 (.047)	Gray	
25N833	1.5 (.055)	Black	
25N834	1.8 (.070)	Brown	
24N620	0.75 (.029)	Blue	High wear nozzles (HW) with hardened ceramic seat, for abrasives and metallics
24N621	1.0 (.042)		
24N622	1.2 (.047)		
24N623	1.5 (.055)		
24N624	1.8 (.070)		
24N625	2.0 (.079)		
24N729	-----	Black	Round spray large pattern nozzle for use with large pattern round spray air cap only
25N835	-----	Black	Round Spray medium or small pattern nozzle for use with medium or small pattern round spray air caps only

Fluid Nozzle Performance Charts

Use the following procedure to select the proper fluid nozzle for your application.

1. For each fluid nozzle performance chart, find the point on the graph corresponding to your desired flow rate and viscosity. Mark the point on each graph with a pencil.
2. The thick vertical line in each graph represents the target flow rate for that nozzle size. Find the graph that has the marked point closest to the thick vertical line. This is the recommended nozzle size for your application. Significantly exceeding the target flow rate may result in lower spray performance due to excessive fluid viscosity.
3. From the marked point, move across to the vertical scale to find the required fluid pressure. If the required pressure is too high, use the next largest nozzle size. If the fluid pressure is too low, (<0.35 bar, 3.5 kPa, 5 psi), use the next smallest nozzle size.

Key to Fluid Nozzle Performance Charts

NOTE: Fluid pressures are measured at the spray gun inlet.



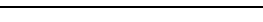

260 Centipoise Fluid	
160 Centipoise Fluid	
70 Centipoise Fluid	
20 Centipoise Fluid	

Table 4: Orifice Size: 0.55 mm (0.022 in.)

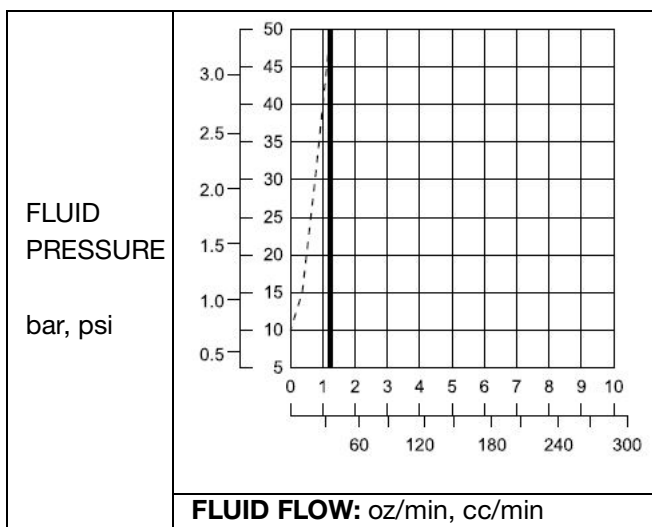


Table 5: Orifice Size: 0.75 mm (0.030 in.)

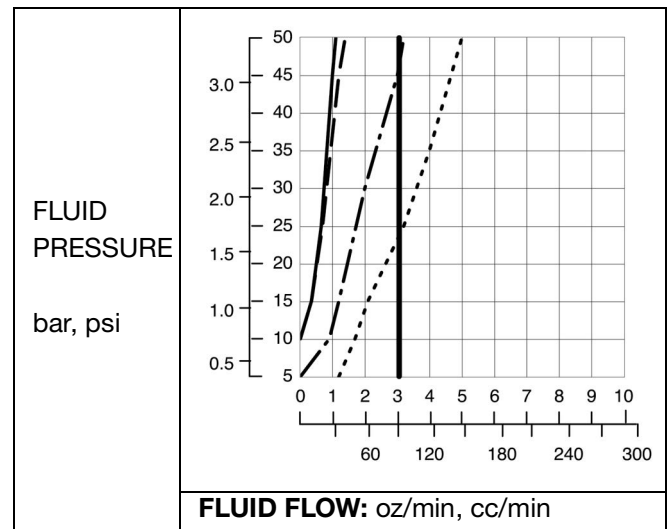


Table 6: Orifice Size: 1.0 mm (0.040 in.)

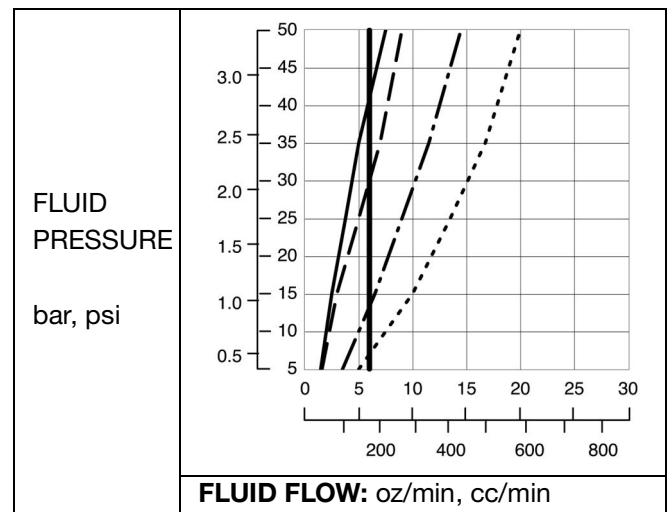


Table 7: Orifice Size: 1.2 mm (0.047 in.)

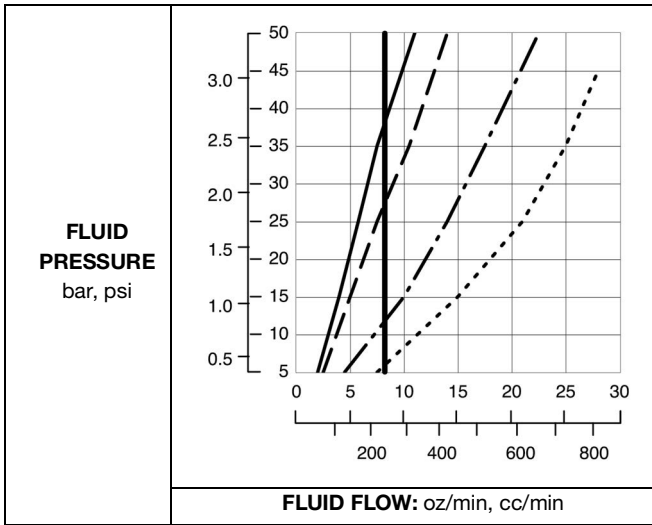


Table 9: Orifice Size: 1.8 mm (0.070 in.)

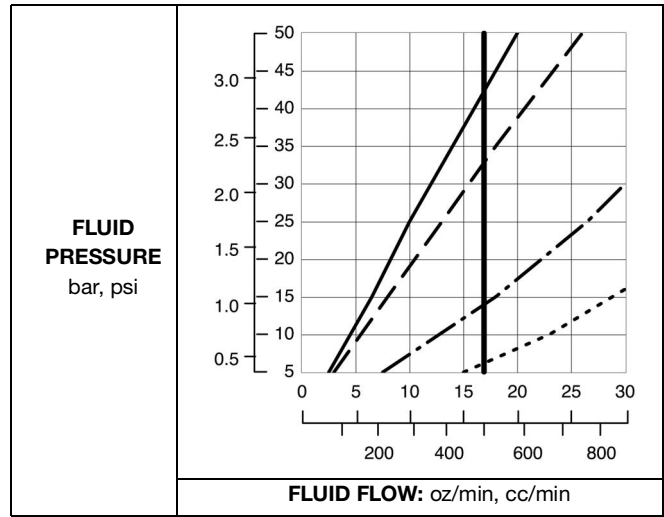


Table 8: Orifice Size: 1.5 mm (0.059 in.)

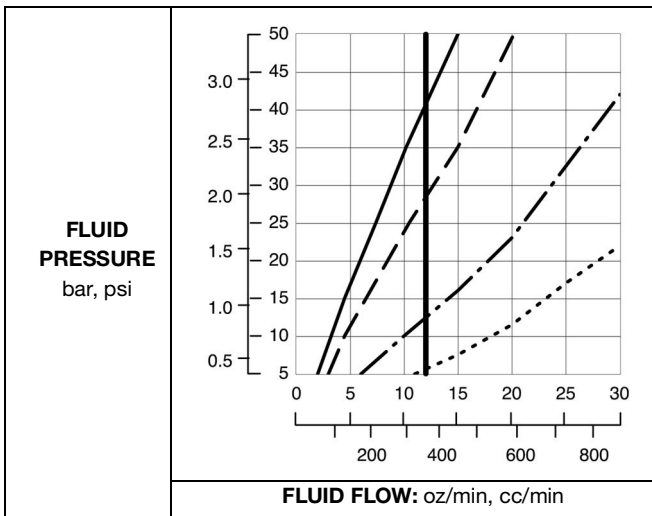
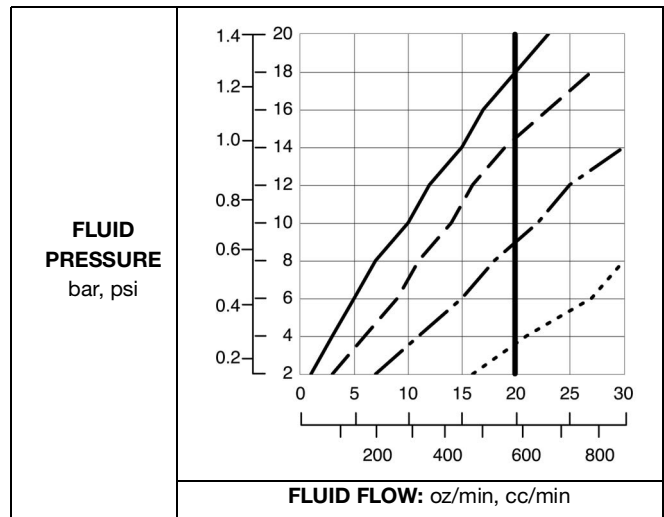
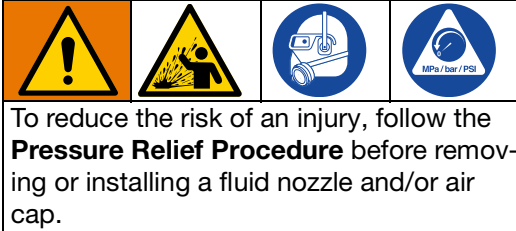


Table 10: Orifice Size: 2.0 mm (0.079 in.)



Air Cap Selection Chart



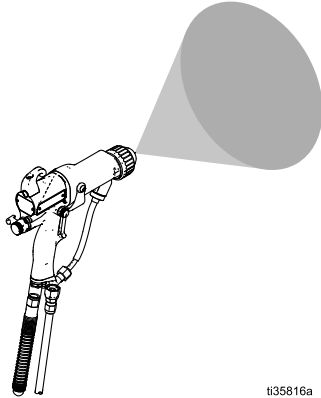
The charts in this section can assist you in selecting an air cap.

- Keep in mind that more than one air cap can meet your finish requirements.
 - When selecting an air cap, consider coating properties, part geometry, pattern shape, pattern size, and operator preferences.
- NOTE:** All air cap pattern shapes and lengths in the following chart were measured under the following conditions. Pattern shape and length are material dependent.
- *Distance to target:* 10 in. (254 mm)
 - *Atomizing air pressure:* 20 psi (138 kPa, 1.38 bar)
 - *Fan air pressure:* 20 psi (138 kPa, 1.38 bar)
 - *Fluid flow rate:* 10 oz/min (300 cc/min)

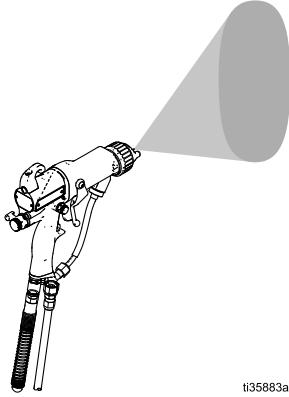
Pattern Shape

NOTE: Pattern shapes are influenced by the material viscosity, flow rate, and air pressure settings. The gun may not maintain the intended design shape under all conditions.

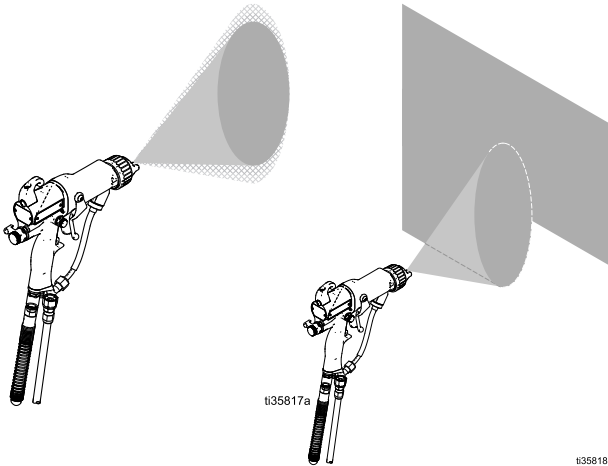
- **Round patterns** have a swirling, slow, round cone pattern for excellent finish and transfer efficiency.



- **Fan patterns** have two styles: round ends and tapered ends.
 - **Fan patterns with round ends** are versatile. They can be used in any application and are often the best option for smaller parts or cut-in painting.



- **Fan patterns with tapered ends** are best for achieving even coating thickness with overlapping paint passes.



General Fan Pattern Air Caps: Descriptions

Part No.	Color	Description	Guidelines for Use
24N477	Black	Standard	Most versatile air cap. Recommended for most materials and applications. Class A finish. Often used in waterborne applications.
24W279	Green		
24N438	Black	Alternate	Similar to the standard air cap with an alternate arrangement of atomizing air.
24N376	Black	Long Pattern	Longest spray pattern, optimized for painting large parts with overlapping paint passes. Often used in waterborne applications.
24N276	Blue		
24N277	Red		
24N278	Green		
24N274	Black	Short Pattern	Shorter pattern, optimized for painting with overlapping passes.

General Fan Pattern Air Caps: Specifications

Part No.	Color	Description	Pattern Shape	Nominal Pattern Length in. (mm)	Recommended Fluid Viscosity*	Recommended Production Rates**	Atomization	Cleanliness
24N477	Black	Standard	Round end	15-17 (381-432)	Light to medium	Standard	Best	Good
24W279	Green							
24N438	Black	Alternate	Round end	15-17 (381-432)	Light to medium	Standard	Best	Good
24N376	Black	Long Pattern	Tapered end	17-19 (432-483)	Light to medium	Standard	Better	Better
24N276	Blue							
24N277	Red							
24N278	Green							
24N274	Black	Short Pattern	Tapered end	12-14 (305-356)	Light to medium	Standard	Good	Best

*Fluid Viscosity, in centipoise (cp) at 70°F (21°C).
Centipoise = centistokes x fluid specific gravity.

Light to medium	20-70 cp
Medium to heavy	70-360 cp
High solids	360+ cp

**Recommended Production Rates

Standard	300 cc/min to 500 cc/min (10 oz/min to 17 oz/min)
Low	100 cc/min to 300 cc/min (3 oz/min to 10 oz/min)
High	500 cc/min to 600 cc/min (17 oz/min to 20 oz/min)
Very High	600 cc/min to 750 cc/min (20 oz/min to 25 oz/min)

Specialty Fan Pattern Air Caps: Descriptions

Part No.	Color	Description	Guidelines for Use
25E670	Black	Soft Spray	For painting small, lightweight parts with a slow-moving spray pattern. Optimized for low production rates.
24N275	Black	Aerospace	Optimized for aerospace coatings. <ul style="list-style-type: none"> • Class A finish • Light, medium, and heavy viscosity, and high solid coatings • Very high production rates
24N279	Black	Solids	Optimized for medium and heavy viscosity and high solid coatings at standard production rates.
24N439	Black	Solids High Flow	Required for use with 2.0 mm nozzles. Optimized for medium and heavy viscosity and high solid coatings at high production rates.
25E671	Black	HVLP	For applications where HVLP is required.

Specialty Fan Pattern Air Caps: Specifications

Part No.	Color	Description	Pattern Shape	Nominal Pattern Length in. (mm)	Recommended Fluid Viscosity*	Recommended Production Rates**	Atomization	Cleanliness
25E670	Black	Soft Spray	Round end	10-12 (254-305)***	Light to medium	Low	Better	Good
24N275	Black	Aerospace	Tapered end	14-16 (356-406)	Light, medium, and heavy viscosity, and high solids	Very High	Good	Best
24N279	Black	Solids	Round end	14-16 (356-406)	Medium to heavy viscosity and high solids	Standard	Best	Good
24N439	Black	Solids High Flow	Tapered end	11-13 (279-330)	Medium to heavy viscosity and high solids	High	Best	Better
25E671	Black	HVLP	Round end	14-16 (356-406)	Light to medium	Standard	Good	Good

*Fluid Viscosity, in centipoise (cp) at 70°F (21°C). Centipoise = centistokes x fluid specific gravity.

Light to medium	20–70 cp
Medium to heavy	70–360 cp
High solids	360+ cp

**Recommended Production Rates

Standard	300 cc/min to 500 cc/min (10 oz/min to 17 oz/min)
Low	100 cc/min to 300 cc/min (3 oz/min to 10 oz/min)
High	500 cc/min to 600 cc/min (17 oz/min to 20 oz/min)
Very High	600 cc/min to 750 cc/min (20 oz/min to 25 oz/min)

***The soft spray air cap was measured with the fluid flow rate adjusted to 3.5 oz/min (100 cc/min).

Round Pattern Air Caps: Descriptions

Part No.	Color	Description	Guidelines for Use
24N318	Black	Large Pattern	Conventional round pattern design for larger patterns up to 8 in (20 cm). Swirling, slow, round cone pattern for excellent finish and transfer efficiency.
25N837	Black	Medium Pattern	Dual inner and outer atomizing air design for improved atomization at low air flows. For medium patterns up to 6 inches (15cm). Swirling, slow, round cone pattern for excellent finish and transfer efficiency.
25N836	Black	Small Pattern	Dual inner and outer atomizing air design for improved atomization at low air flows. For small patterns up to 4 inches (10cm). Swirling, slow, round cone pattern for excellent finish and transfer efficiency.

Round Pattern Air Caps: Specifications

Part No.	Color	Description	Pattern Shape	Nominal Pattern Diameter in. (mm)	Recommended Fluid Viscosity*	Recommended Production Rates	Atomization	Cleanliness
24N318	Black	Large Pattern	Round end	8 (203)	Light to medium	Low	Good	Good
25N837	Black	Medium Pattern	Round end	6 (152)	Light to medium	Low	Better	Good
25N836	Black	Small Pattern	Round end	4 (102)	Light to medium	Low	Better	Good

*Fluid Viscosity, in centipoise (cp) at 70°F (21°C).
Centipoise = centistokes x fluid specific gravity.

Light to medium	20–70 cp
Medium to heavy	70–360 cp
High solids	360+ cp

**Recommended Production Rates

Standard	300 cc/min to 500 cc/min (10 oz/min to 17 oz/min)
Low	100 cc/min to 300 cc/min (3 oz/min to 10 oz/min)
High	500 cc/min to 600 cc/min (17 oz/min to 20 oz/min)
Very High	600 cc/min to 750 cc/min (20 oz/min to 25 oz/min)

Shielded Waterborne Fluid Hose 24W597

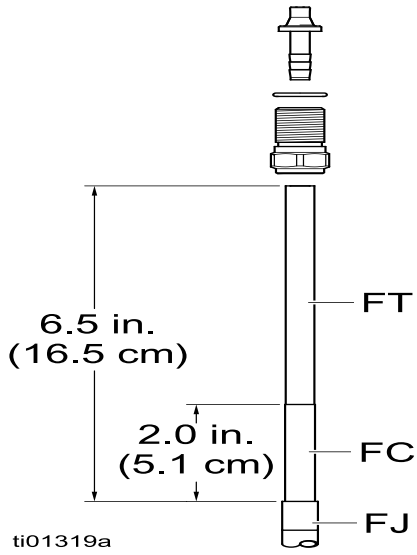


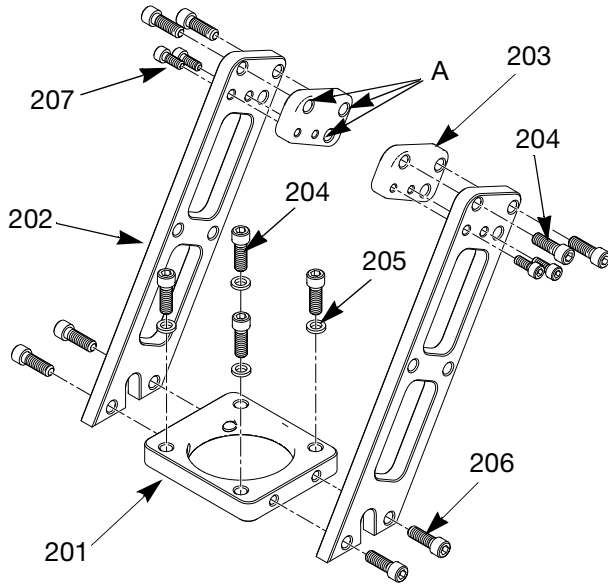
FIG. 35 : Shielded Waterborne Fluid Hose 24W597

Ref. No.	Part No.	Description	Qty
600	24W597	HOSE, assy, fluid, WB, 25 ft (7.6m)	1
	24W598	HOSE, assy, fluid, WB, 50 ft (15.2 m)	1
600a	537107	HOSE, PTFE 1/4 ID	1
600b	16N953	FITTING, connector, barrel, WB	1
600c	102982	PACKING, o-ring	1
600d	16N916	FITTING, seal, fluid, WB	1

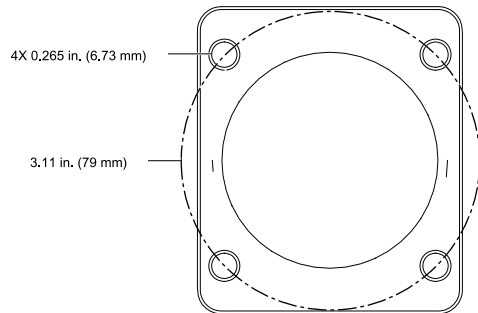
Robot Mount Bracket Assembly

Part No. 24X820 Mounting Bracket Assembly

Includes items



Ref. No.	Part No.	Description	Qty
201	- - -	PLATE, mounting	1
202	- - -	LEG	2
203	- - -	SPACER	2
204	112222	SCREW, cap, 1/4-20 x 1.0 in.	8
205	GC2042	WASHER, fender	2
206	111788	SCREW, cap, 1/4-20 x 0.75 in.	4
207	17A612	SCREW, cap, 10-24 x 0.5 in.	4
	- - -	Robot adapter plates (not shown; order separately); See Table 11 on page 66	



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NOTE: Alignment holes (A) enable orienting gun spray angle at either 60° or 90° for either gun type.

Table 11: Robot Adapter Plates

Adapter Plate	Robot	Bolt Circle	Mounting Screws	Locating Pin Circle	Locating Pins
24Y128	MOTOMAN EPX1250	27.5 mm (1.083 in)	4X M5 x 0.8	27.5 mm (1.083 in)	5 mm
24Y129	MOTOMAN PX1450	32 mm (1.260 in)	8X M6 x 1.0	---	---
	MOTOMAN EPX2850, Three-roll type				
24Y634	MOTOMAN EPX2050	102 mm (4.02 in)	6X M6 x 1.0	102 mm (4.02 in)	2X 4 mm
	ABB IRB 580				
	ABB IRB 5400				
24Y650	MOTOMAN EPX2700	102 mm (4.02 in)	6X M6 x 1.0	102 mm (4.02 in)	2X 5 mm
	MOTOMAN EPX2800				
	MOTOMAN EPX2900				
	KAWASAKI KE610L				
	KAWASAKI KJ264				
	KAWASAKI KJ314				
24Y172	ABB IRB 540	36 mm (1.42 in)	3X M5	---	---
24Y173	ABB IRB 1400	40 mm (1.58 in)	4X M6	---	---
24Y768	FANUC PAINT MATE 200iA	31.5 mm (1.24 in)	4X M5	31.5 mm (1.24 in)	1X 5 mm
	FANUC PAINT MATE 200iA/5L				
24Y769	FANUC P-145	100 mm (3.94 in)	6X M5	100 mm (3.94 in)	1X 5 mm

Accessories

Smart Model Accessories and Fiber Optic Cables

Part No.	Description
24W035	Pro Xp Auto Control Module. See 332989 for details.

Fiber Optic Cables for Gun

See item V in FIGURE 11 on page 19. Connect gun manifold to Pro Xp Auto Control Module. See 332989.

Part No.	Description
24X003	Fiber Optic Cable, 25 ft (7.6 m)
24X004	Fiber Optic Cable, 50 ft (15 m)
24X005	Fiber Optic Cable, 100 ft (30.5 m)
Fiber Optic Cable Repair Kit	
24W875	Parts necessary to replace damaged ends on one cable assembly.

Air Line Accessories

Grounded Air Hose with stainless steel braid ground path (Red)

100 psi (7 bar, 0.7 MPa) Maximum Working Pressure

0.315 in. (8 mm) ID; 1/4 npsm(f) x 1/4 npsm(f) left-hand thread

Part No.	Description
235068	6ft(1.8m)
235069	15 ft (4.6 m)
235070	25 ft (7.6 m)
235071	36 ft (11 m)
235072	50 ft (15 m)
235073	75 ft (23 m)
235074	100 ft (30.5 m)

Bleed-Type Master Air Valve

300 psi (21 bar, 2.1 MPa) Maximum Working Pressure

Relieves air trapped in the air line between this valve and the pump air motor when closed.

Part No.	Description
107141	3/4 npt

Air Line Shutoff Valve

150 psi (10 bar, 1.0 MPa) Maximum Working Pressure

For turning air to gun on or off.

Part No.	Description
224754	1/4 npsm(m) x 1/4 npsm(f) left-hand thread.

Fluid Line Accessories

Shielded Waterborne Fluid Hose

Part No.	Description
24W597	25 ft (7.6 m)
24W598	50 ft (15.2 m)

System Accessories

Part No.	Description
222011	Ground wire for grounding pump and other components and equipment in the spray area. 12 gauge, 25 ft (7.6 m).

Signs

Part No.	Description
186118	English Warning Sign. Available at no charge from Graco.

Round Spray Kits

To convert a standard air spray gun to a round spray air cap.

Part No.	Description
24X794	Large Pattern Kit
25N837	Medium Pattern Kit
25N836	Small Pattern Kit

Test Equipment

Part No.	Description
241079	Megohmmeter. 500 V output, 0.01–2000 megohms. Use for ground continuity and gun resistance tests. Not for use in hazardous areas.
722886	Paint Resistance Meter. Use for fluid resistivity test. See manual 307263. Not for use in hazardous areas.
722860	Paint Probe. Use for fluid resistivity test. See manual 307263. Not for use in hazardous areas.
245277	Test Fixture, High Voltage Probe, and kV Meter. Use to test the electrostatic voltage of the gun, and the condition of the turbine and power supply when being serviced. See manual 309455. Also requires 24R038 Conversion Kit.
24R038	Voltage Tester Conversion Kit. Converts the 245277 Test Fixture for use with the Pro Xp Gun turbine. See manual 406999.

Gun Accessories

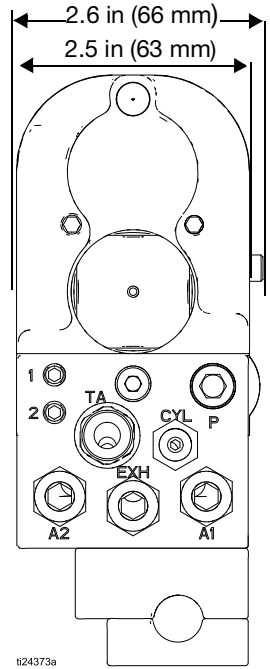
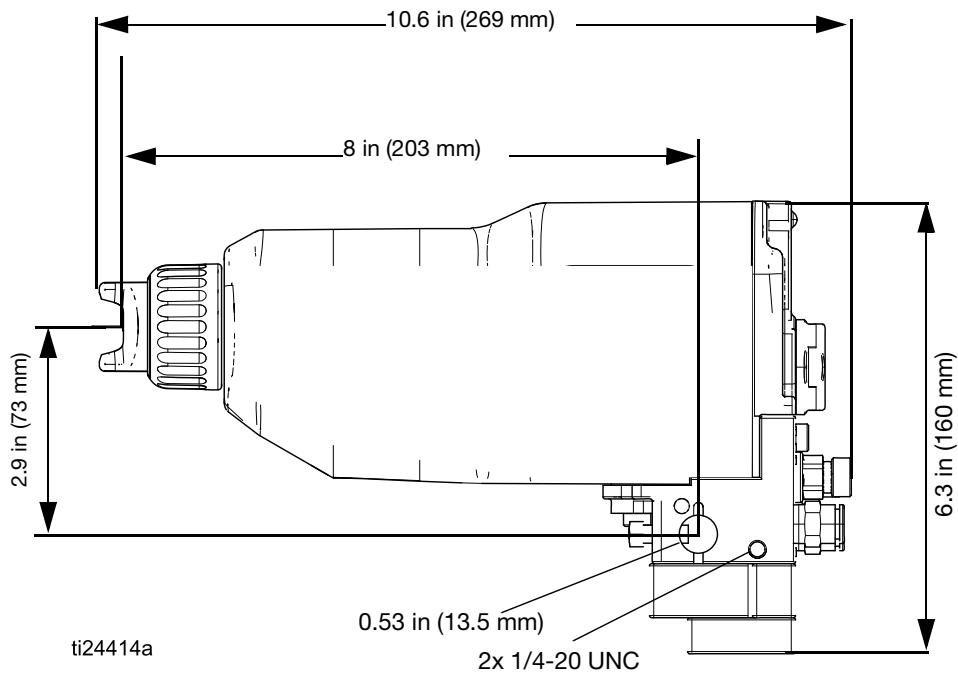
105749	Cleaning Brush
111265	Non-silicone Lubricant, 4 oz (113 g).
116553	Dielectric Grease. 1 oz (30 ml)
24V929	Gun Covers

Conversion and Repair Kits

24W390	Air Seal Repair Kit
24W391	Fluid Seal Repair Kit
24N706	Turbine Bearing Repair Kit

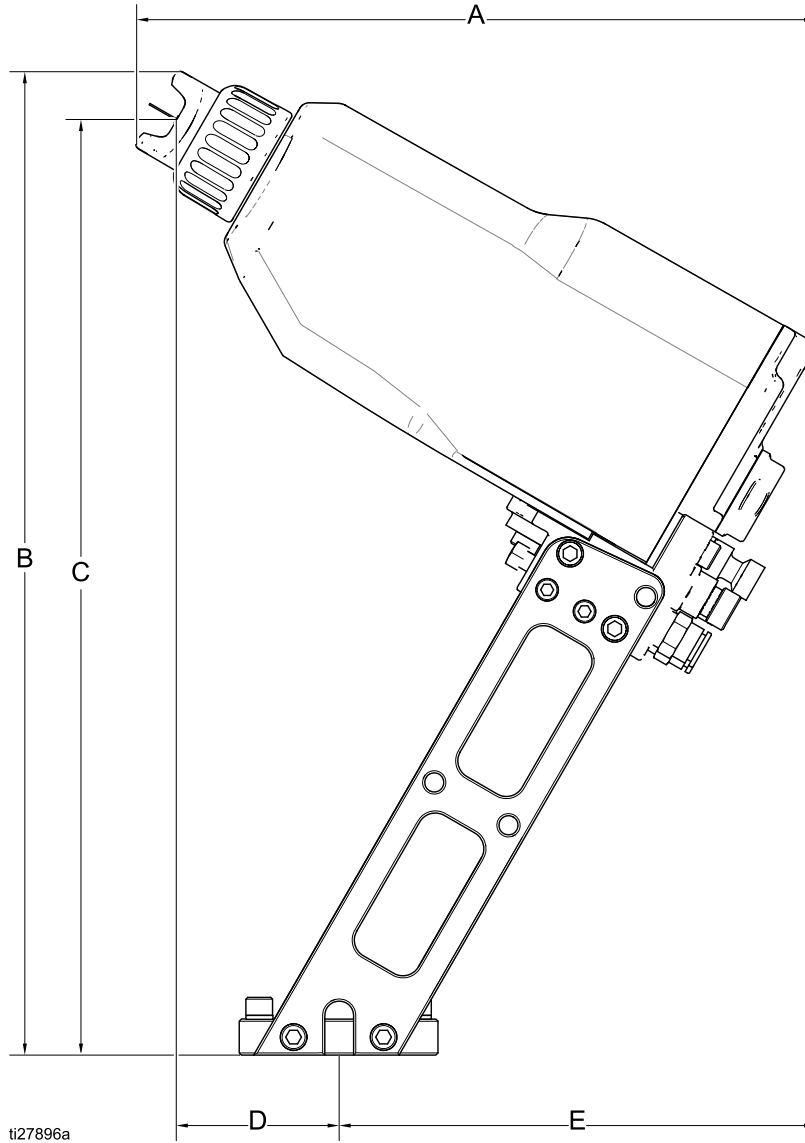
Dimensions

Rear Inlet Manifold



Robot Mount Gun Dimensions

Typical configuration for a robot with rear-manifold gun.

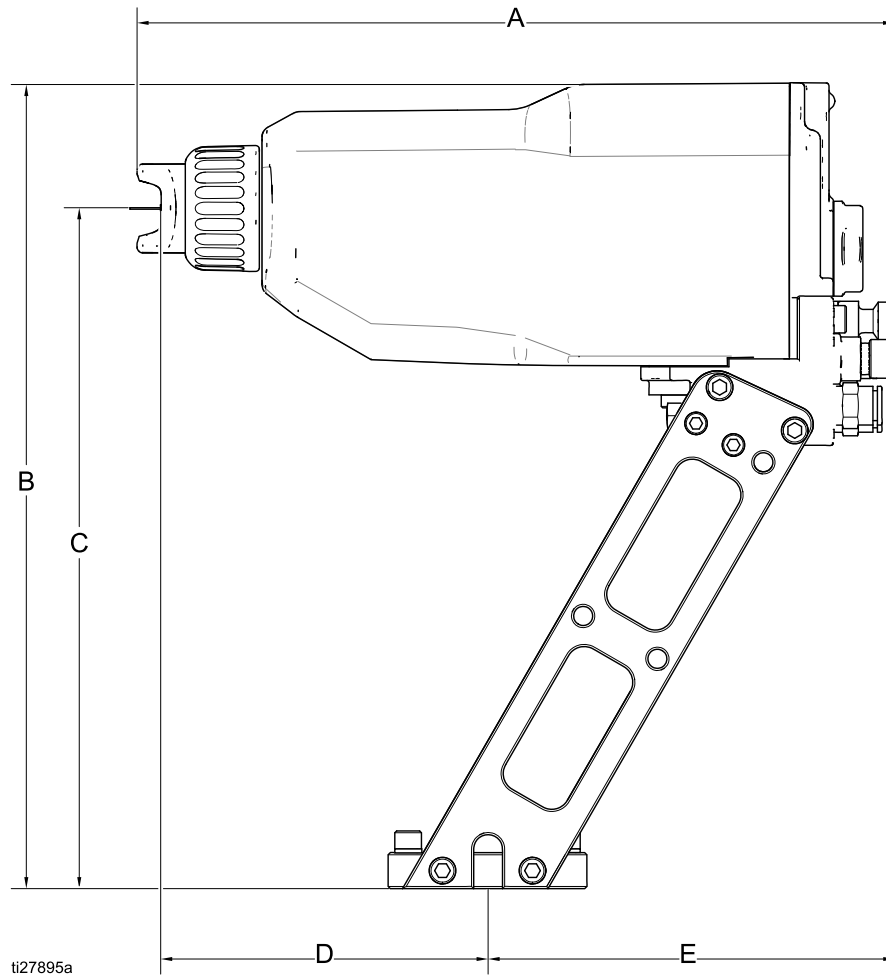


NOTE: Gun shown positioned for 60° spray setting in Robot Mount Bracket 24X820.

FIG. 36. Dimensions, Gun with a Rear Manifold, 60° Position

A	B	C	D	E
9.5 in. (24.1 cm)	13.7 in. (34.8 cm)	13.0 in. (33.0 cm)	2.3 in. (5.8 cm)	6.7 in. (17.0 cm)

Typical configuration for a robot with rear-manifold gun.



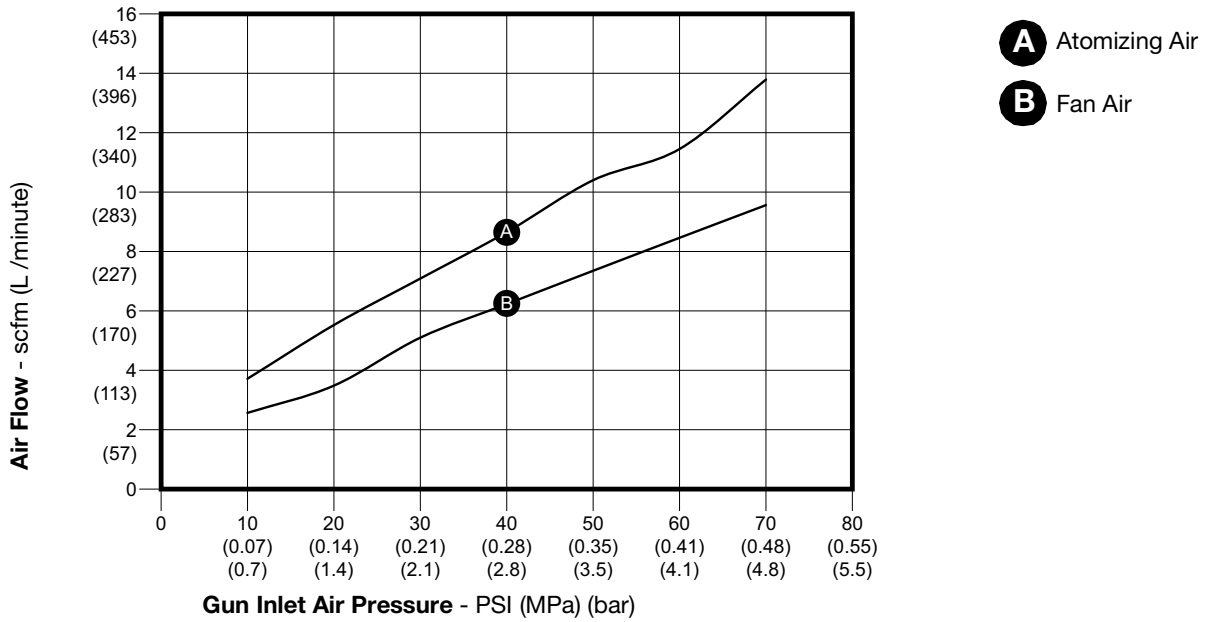
NOTE: Gun shown positioned for 90° spray setting in Robot Mount Bracket 24X820.

FIG. 37. Dimensions, Gun with a Rear Manifold, 90° Position

A	B	C	D	E
10.5 in. (26.7cm)	11.2 in. (28.4 cm)	9.5 in. (24.1 cm)	4.5 in. (11.4 cm)	5.7 in. (14.5 cm)

Air Flow

The gun requires 6 scfm (170 l/min) of turbine air flow (see **Technical Specifications**). The following graph shows additional air consumption. For example, if both fan and atomizing air are set at 30 psi (2.1 bar) inlet pressure, the gun uses about 5 scfm (142 l/min) fan air and about 7 scfm (198 l/min) atomizing air. Add these amounts to the turbine air for a total of 18 scfm (510 l/min) air consumption. Air flow was tested using air cap 24N477.



Technical Specifications

Pro Xp Auto Waterborne Air Spray Gun		
	US	Metric
Maximum fluid working pressure	100 psi	0.7 MPa, 7 bar
Maximum working air pressure	100 psi	0.7 MPa, 7 bar
Maximum air pressure at gun inlet	40 psi	0.28 MPa, 2.8 bar
Maximum fluid operating temperature	120°F	48°C
Paint conductivity range	2000 microsiemens max	
Short circuit current output	125 microamperes	
Gun Weight (Approximate)	2.6 lb	1.2 kg
Air Consumption		
Required turbine air flow	6 scfm	170 l/min
Typical total air flow with 24N477 air cap at 30 psi (2 bar) atomizing air and fan air inlet pressure	18 scfm	510 l/min
Voltage Output		
Standard Models	60 kV	
Smart Models	30-60 kV	
Noise (dBa)		
Sound Power (measured per ISO Standard 9216)	at 40 psi: 90.4 dB(A) at 100 psi: 105.4 dB(A)	at 0.28 MPa, 2.8 bar: 90.4 dB(A) at 0.7 MPa, 7 bar: 105.4 dB(A)
Sound Pressure (measured 1 m from gun)	at 40 psi: 87 dB(A) at 100 psi: 99 dB(A)	at 0.28 MPa, 2.8 bar: 87 dB(A) at 0.7 MPa, 7 bar: 99 dB(A)
Inlet/Outlet Sizes		
Turbine air inlet fitting, left-hand thread	1/4 npsm(m)	
Atomizing air inlet fitting	5/16 in. OD nylon tube (8 mm)	
Fan air inlet fitting	5/16 in. OD nylon tube (8 mm)	
Cylinder air inlet fitting	5/32 in. OD nylon tube (4 mm)	
Fluid inlet fitting	1/4-18 npsm(m)	
Materials of Construction		
Wetted Parts	Stainless Steel; Nylon, Acetal, Ultra-High Molecular Weight Polyethylene, Fluoroelastomer, PEEK, Tungsten Carbide, Polyethylene	

California Proposition 65

CALIFORNIA RESIDENTS

 **WARNING:** Cancer and reproductive harm. – www.P65warnings.ca.gov.

Graco Pro Xp Warranty

Graco warrants all equipment referenced in this document which is manufactured by Graco and bearing its name to be free from defects in material and workmanship on the date of sale to the original purchaser for use. With the exception of any special, extended, or limited warranty published by Graco, Graco will, for a period of twelve months from the date of sale, repair or replace any part of the equipment determined by Graco to be defective. However, any deficiency in the barrel, gun body, trigger, hook, internal power supply, and alternator (excluding turbine bearings) will be repaired or replaced for thirty-six months from the date of sale. This warranty applies only when the equipment is installed, operated and maintained in accordance with Graco's written recommendations.

This warranty does not cover, and Graco shall not be liable for general wear and tear, or any malfunction, damage or wear caused by faulty installation, misapplication, abrasion, corrosion, inadequate or improper maintenance, negligence, accident, tampering, or substitution of non-Graco component parts. Nor shall Graco be liable for malfunction, damage or wear caused by the incompatibility of Graco equipment with structures, accessories, equipment or materials not supplied by Graco, or the improper design, manufacture, installation, operation or maintenance of structures, accessories, equipment or materials not supplied by Graco.

This warranty is conditioned upon the prepaid return of the equipment claimed to be defective to an authorized Graco distributor for verification of the claimed defect. If the claimed defect is verified, Graco will repair or replace free of charge any defective parts. The equipment will be returned to the original purchaser transportation prepaid. If inspection of the equipment does not disclose any defect in material or workmanship, repairs will be made at a reasonable charge, which charges may include the costs of parts, labor, and transportation.

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Original instructions. This manual contains English. MM 333012

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