



HVLP AIR CAP AND FLUID NOZZLE CHART

MODEL NO.	AIR CAPS	Press / Siphon	*MAX GUN INLET PRESS. FOR HVLP	FAN CONTROL	SCFM @ MAX GUN INLET	AIR CAP RING	AVAILABLE FLUID NOZZLES TIPS	NEEDLES / marking on needle
CAT SLP	23-1308	pressure	29**	60-1504 (S)	13.5	Included	33-0208 0.8mm (.022)	40-1308 (308)
	23-1310	pressure	29**		13.5		33-0210 1.0mm (.040")	40-1310 (310)
	23-1312	pressure	29**		13.5		33-0212 1.2mm (.049")	40-1312 (312)
	23-1313	pressure	29**		13.5		33-0213 1.3mm (.052")	40-1313 (313)
	23-1314	pressure	29**		13.5		33-0214 1.4mm (.055")	40-1314 (314)
	23-1315	pressure	29**		13.5		33-0215 1.5mm (.059")	40-1315 (315)
	23-1317	pressure	29**		13.5		33-0217 1.7mm (.070")	40-1317 (317)
	23-1319	pressure	29**		13.5		33-0219 1.9mm (.075")	40-1319 (319)
	23-1322	pressure	29**		13.5		33-0222 2.2mm (.086")	40-1322 (322)

*Note: Air cap test gages are available to confirm HVLP compliance.

Actual fluid nozzle and air cap combinations are determined by application (see application chart page 4)

Coating Atomization Technologies
P.O.Box 17820, Boulder CO 80308
(888) 820-4498
Fax(303) 438-5708
www.sprayCAT.com

Operation and Maintenance Instructions for *CAT SLP* Spray Guns

Operation

1. Connect air supply hose at handle of gun.
2. Connect a pressurized fluid supply or paint siphon cup to the gun fluid inlet.
3. Fluid flow can be controlled using the fluid control knob, this restricts flow by limiting needle travel. It is best to control fluid flow by proper selection of fluid orifice size and use the fluid control knob to “fine tune flow rate”.
4. Fan width can be adjusted using the fan control knob. Turning the knob clockwise narrows the fan.

Maintenance

IMPORTANT! Routine cleaning and maintenance is essential to insure proper gun operation. Several states prohibit spraying solvent into the atmosphere and require the use of covered gun cleaner.

1. If a gun cleaner is being used, connect and clean the gun in the gun cleaner according to the manufactures instructions.
2. If a gun cleaner is not being used:
For pressure setups, remove air cap and clean separately using clean solvent.
Connect a pressurized solvent supply to the fluid inlet, trigger the gun allowing solvent to flow thru the gun until clean.
For siphon setups, first clean the siphon cup thoroughly then spray clean solvent thru the gun until clean.

NOTE: Gun head disassembly is not recommended for normal cleaning and maintenance.

Gun head disassembly and reassembly instructions:

Gun head disassembly

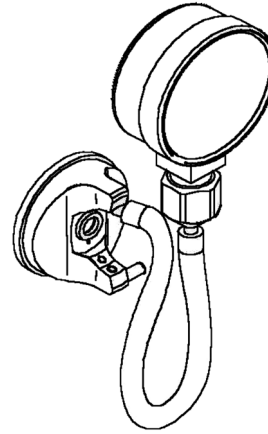
To remove the nozzle carrier (4) and air cap adapter (6):

1. Remove the air cap (1), fluid nozzle tip (2), fluid nozzle body (3), and needle (13)
2. Remove the needle seal cartridge (23)
3. Loosen the locknut (8) and remove fluid inlet (9) using a 5/8” open-end wrench
4. The nozzle carrier and air cap adapter will now slide forward from the gun body (11).

Gun head reassembly

1. Install a new o-ring (7) on the air cap adapter.
2. Install a new o-ring 98-8026 (5) onto the air cap adapter.
3. Install the thread locknut (8) onto the fluid inlet as far as possible.
4. Slide the nozzle carrier (4) into air cap adapter (6) and insert into the gun body as far as possible. Be sure the nozzle carrier extends into the hole at the back of the gun head. Install the needle seal (23) but do not tighten.
5. Rotate the nozzle carrier until the fluid inlet port in the nozzle carrier is aligned with the threaded hole in the body. While in this position, insert the fluid inlet (9) and tighten firmly.
6. Tighten the needle seal (23) to approx. 12 ft.-lb. torque.
7. Tighten the fluid inlet (9) to approx. 25 ft.-lb. torque.
8. Tighten the locknut (8) to approx. 33 ft.-lb. torque.

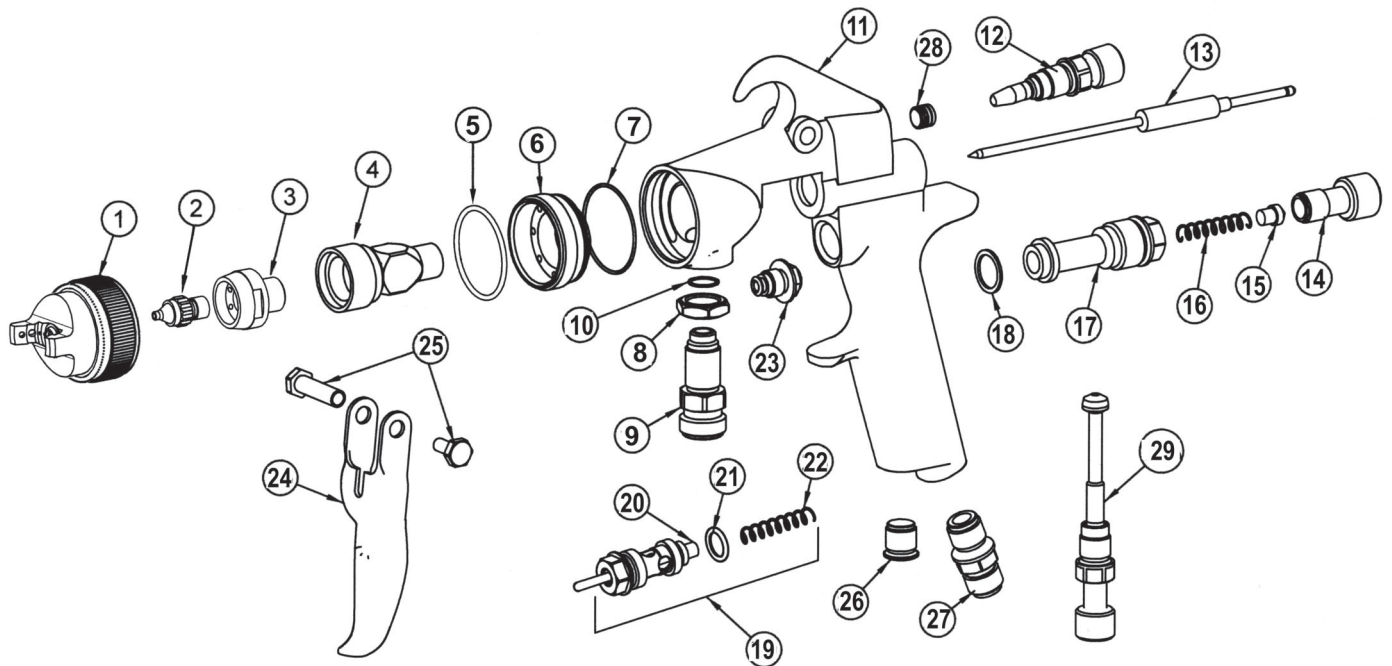
ITEM NUMBER	PART NUMBER	DESCRIPTION
1	See Air Cap Chart	Air Cap Cap
2	See Air Cap Chart	Fluid Nozzle Tip
3	33-1202	Fluid Nozzle Body
4	60-L31H	Nozzle Carrier
5	98-8026	O-Ring
6	60-34H	Air Cap Adapter
7	60-131	O-Ring
8	60-128	Locknut
9	60-126	Fluid Inlet
10	60-124	Fluid Inlet Seal
11	60-1120	CAT SLP Gun body
12	60-1504	Fan Control Assembly
13	See Air Cap Chart	Fluid Needle
14	60-202	Fluid Control Knob
15	See KIT NO. 10-106	Spring Seat*
16	See KIT NO. 10-106	Needle Return Spring*
17	60-201	Rear Bushing
18	See KIT NO. 10-106	Seal*
19	60-1520	Air Valve Assembly
20	60-302**	Air Valve Poppet
21	See KIT NO. 10-106	Seal*
22	See KIT NO. 10-106	Air Valve Spring*
23	60-1400*	Needle Seal Cartridge
24	60-2101	Trigger
25	60-1033	Trigger Pivot Set
26	60-122	Plug (optional)
27	60-104	Air Inlet Fitting
28	98-0109	Allen Plug
29	60-1510	Inlet Air Control



HVLP AIR CAP TEST GAGES	
FOR CAT SLP GUNS	23-1310-G
	23-1313-G
	23-1314-G
	23-1315-G
	23-1317-G
	23-1319-G
	23-1322-G

* Included in KIT NO. 10-106

** Included with Air Valve Assembly 60-1520



CAT SLP NOZZLE SELECTION CHART

Material	Orifice Size	Air Consumption
Filler	1.5	29 psi @ 13.5 cfm
Primer, Washprimer, Epoxy	1.3 - 1.5	29 psi @ 13.5 cfm
Sealer	1.3	29 psi @ 13.5 cfm
Single Stage	1.0 - 1.2	29 psi @ 13.5 cfm
Base Coat	1.0	29 psi @ 13.5 cfm
Clear Coat	1.0 - 1.2	29 psi @ 13.5 cfm
High Solids Clears	1.0 - 1.3	29 psi @ 13.5 cfm
Stains	1.0	29 psi @ 13.5 cfm

KITS FOR CAT SLP GUNS

HVLP Kits	Orifice Size	Air Cap	Orifice (Tip)	Needle
JK1308	0.8	23-1308	33-0208	40-1308
JK1310	1.0	23-1310	33-0210	40-1310
JK1312	1.2	23-1312	33-0212	40-1312
JK1313	1.3	23-1313	33-0213	40-1313
JK1314	1.4	23-1314	33-0214	40-1314
JK1315	1.5	23-1315	33-0215	40-1315
JK1317	1.7	23-1317	33-0217	40-1317
JK1319	1.9	23-1319	33-0219	40-1319
JK1322	2.2	23-1322	33-0222	40-1322