



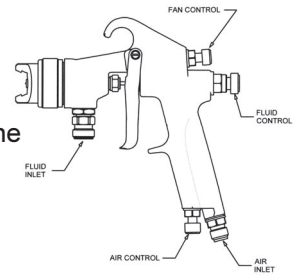
AIR CAPS, FLUID ORIFICES AND NEEDLES AVAILABLE FOR THE FE-Line Fine Finish SPRAY GUN

AIR CAPS	APPROXIMATE CFM	AVAILABLE FLUID NOZZLES TIPS	NEEDLES / marking on needle
23-1308	13.5	33-0208 0.8mm (.022")	40-1808 (08)
23-1310	13.5	33-0210 1.0mm (.040")	40-1810 (1810)
23-1312	13.5	33-0212 1.2mm (.046")	40-1812 (1812)
23-1313	13.5	33-0213 1.3mm (.052")	40-1813 (1813)
23-1314	13.5	33-0214 1.4mm (.055")	40-1814 (1814)
23-1315	13.5	33-0215 1.5mm (.059")	40-1815 (1815)
23-1317	13.5	33-0217 1.7mm (.070")	40-1817 (1817)

Operation and Maintenance Instructions for *FE-Line Fine Finish* Spray Guns

Operation

1. Connect air supply hose at handle of gun.
2. Connect a pressurized fluid supply 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:
 - 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.

NOTE:

- **Gun disassembly is not recommended for normal cleaning and maintenance.**
- **Not recommended to soak entire spray gun in solvent.**

Gun disassembly and reassembly instructions:

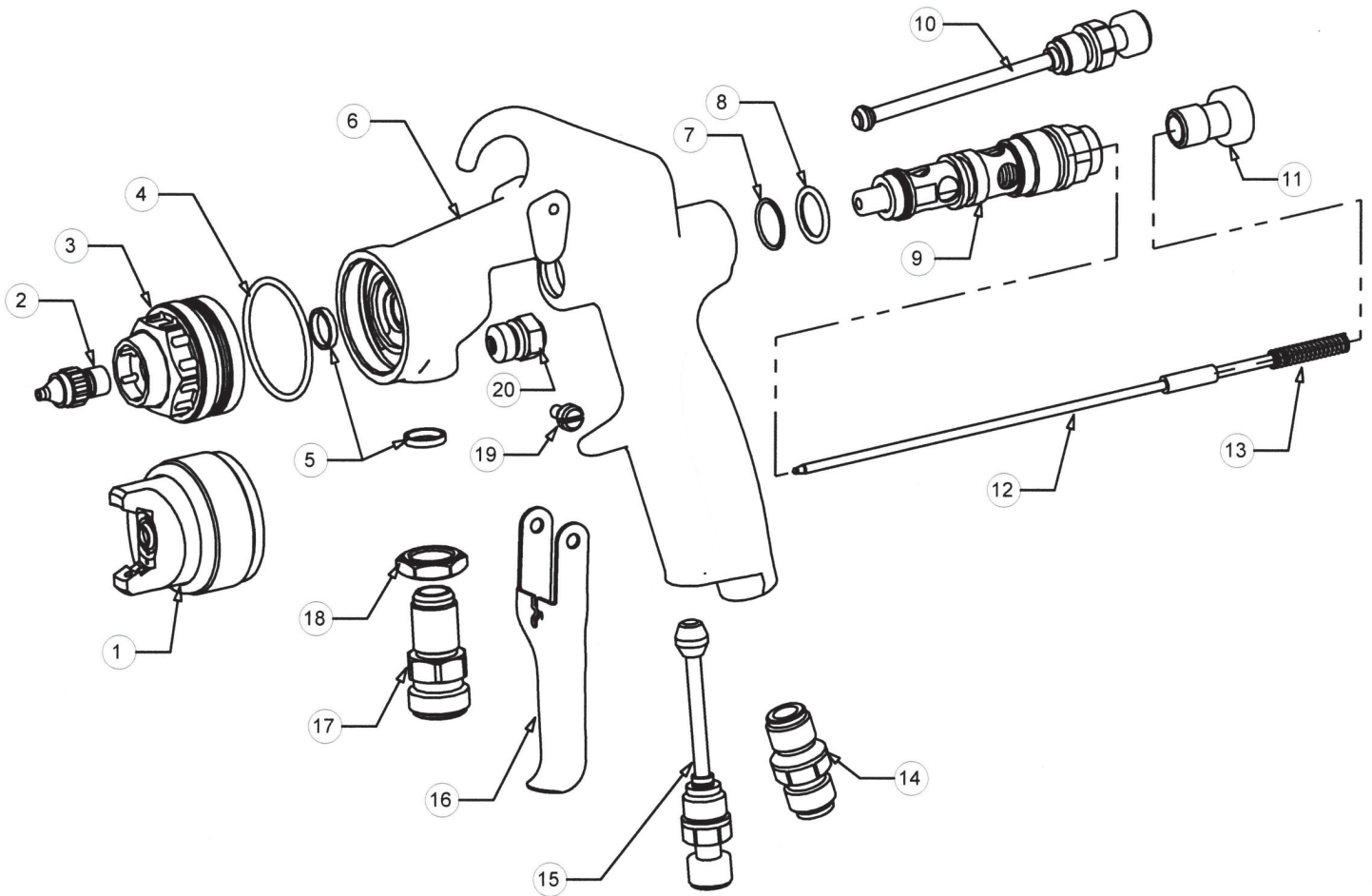
- **Have repair kit # 10-140 available before gun disassembly.**

Disassembly

1. Remove the trigger by removing both trigger screws (19).
2. Remove fluid control knob (11).
3. Remove needle return spring (13) and needle (12).
4. Remove air valve assembly (9) using a 9/16" wrench.
5. Using a 7/16" wrench remove the needle seal cartridge (20).
6. Using a 13 mm wrench remove the side port control (10).
7. Using a 13 mm wrench remove the air control (15).
8. Using a 11/16" wrench loosen locknut (18), using a 5/8" wrench remove fluid inlet (17).
9. Remove air cap (1), remove fluid tip (2) using a 3/8" wrench.
10. Using a 1" wrench remove head insert (3).

Reassembly

1. Install a new o-rings (7) and (8) on air valve assembly, lightly lubricate o-rings with vasoline and reinstall air valve (9) into gun body.
2. Install new seal (5) in gun body (6). Install new o-ring (4) on head insert (3). Reinstall head insert into gun body and tighten. Reinstall fluid tip (2) and tighten.
3. Install new seal (5) in gun body. Reinstall and tighten fluid inlet (17). Tighten locknut (18) after fluid inlet has been tightened.
4. Remove the shipping pin from a new needle seal cartridge. Install new needle seal cartridge (20).
5. Reinstall side port control (10), air control (15).
6. Reinstall needle (12), needle return spring (13) and fluid control knob (11).
7. Reinstall air cap (1).



ITEM NO.	PART NO.	DESCRIPTION	ITEM NO.	PART NO.	DESCRIPTION
1	See Air Cap Chart	Air Cap*	11	60-1312	Fluid Control Knob
2	See Air Cap Chart	Fluid Tip*	12	See Air Cap Chart	Needle*
3	60-35	Head Insert	13	60-211	Needle Return Spring**
4	98-8026	O-Ring**	14	60-104	Air Inlet Fitting
5	60-137	Seal**	15	60-1319	Air Control
6	60-1301CL	Gun Handle	16	60-2111	Trigger
7	98-5125	O-Ring**	17	60-132	Fluid Inlet
8	98-5225	O-Ring**	18	60-128	Locknut
9	60-1320	Air Valve Assembly	19	60-1315	Trigger Pivot Screw (2)
10	60-1317	Side Port Control	20	60-1329	Needle Seal Cartridge**

*See air cap selection chart on pages 1 & 4

**Indicates part included in repair kit # 10-140

FLUID NOZZLE / AIR CAP SELECTION CHARTS

FE-Line Fine Finish - Pressure Feed Spray Guns

MATERIAL TYPE	FLUID ORIFICE x AIR CAP	MAXIMUM PATTERN WIDTH	CFM
Very Thin less than 16 sec. Zahn #2 inks , dyes, solvents, stains	0.8 mm x 1308 1.0 mm x 1310	11 11	13.5 13.5
Thin 16 to 20 sec. Zahn #2 lacquers, enamels, primers, sealers	1.2 mm x 1312 1.3 mm x 1313	11 11	13.5 13.5
Medium 21 to 30 sec. Zahn #2 automotive base coat enamels, primers epoxies, urethanes automotive clear coat	1.3 mm x 1313 1.4 mm x 1314 1.5 mm x 1315	11 11 11	13.5 13.5 13.5
Heavy over 30 sec. Zahn #2 heavy body primers high solid enamels high solid automotive coatings adhesives	1.7 mm x 1317	11	13.5