

SPECIFICATIONS

AIRSPRAY GUN

M 22

HTi - HPA

Manual : 0808 573.054.212

Date : 4/08/08

Supersede : 02/07/07

Modif. : update (§ 1)

ADDITIONAL DOCUMENTATIONS

SPARE PARTS : AIRSPRAY GUN , model M 22 G (Doc. 573.322.050)

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SPECIFICATIONS
GRAVITY AIRSPRAY GUN, model M 22
HTi - HPA

1. TECHNICAL FEATURES

Guns recommended to spray varnishes, lacquers, shades, polyurethanes, two components...

The HTi guns are pneumatic guns with a high transfer efficiency. Two projectors, models EP 5 and E 5 K HVLP can be fitted on the same gun.

The guns, model HPA, with high spraying quality, enable to spray any kind of materials (low or high viscosity).

FEATURES	HTi (E 5 K HVLP aircap)	HTi (EP 5 aircap)	HPA (EN 5 aircap)
Maximum air supply pressure (network)	6 bar / 87 psi		
Air pressure at the gun handle	From 1,5 to 2,5 bar / from 22 to 36 psi	From 2 to 3 bar / from 29 to 44 psi	From 2 to 4 bar / from 29 to 58 psi
Air flow	27,2 m3/h to 2 bar / 16 CFM to 29 psi	20,2 m3/h to 2,5 bar / 11.9 CFM to 36 psi	26,5 m3/h to 2,5 bar / 15.6 CFM to 36 psi
Fluid supply	Gravity cup (0,6 liter)		
Weight (gun without cup)	530 g / 1.17 lb		
Weight (gun with cup)	690 g / 1.52 lb		
Shades and hydro or solvent based varnishes			
- low viscosity	* * * *	* * *	* * *
- middle viscosity	* * * *	* * * *	* * * *
- high viscosity	* *	* * *	* * * *
Minimum transfer rate (EN 13966-1 standard)	76 % ± 2 %	74 % ± 2 %	-
Maximum fluid temperature	50° C / 120° F		
Nozzle, needle, fluid passage	Stainless steel / Stainless steel / anodized aluminium		
White cup (acetale resin)	For hydro and solvent based paints		
Grey cup (PEHD)	For PU and pre catalysed materials		

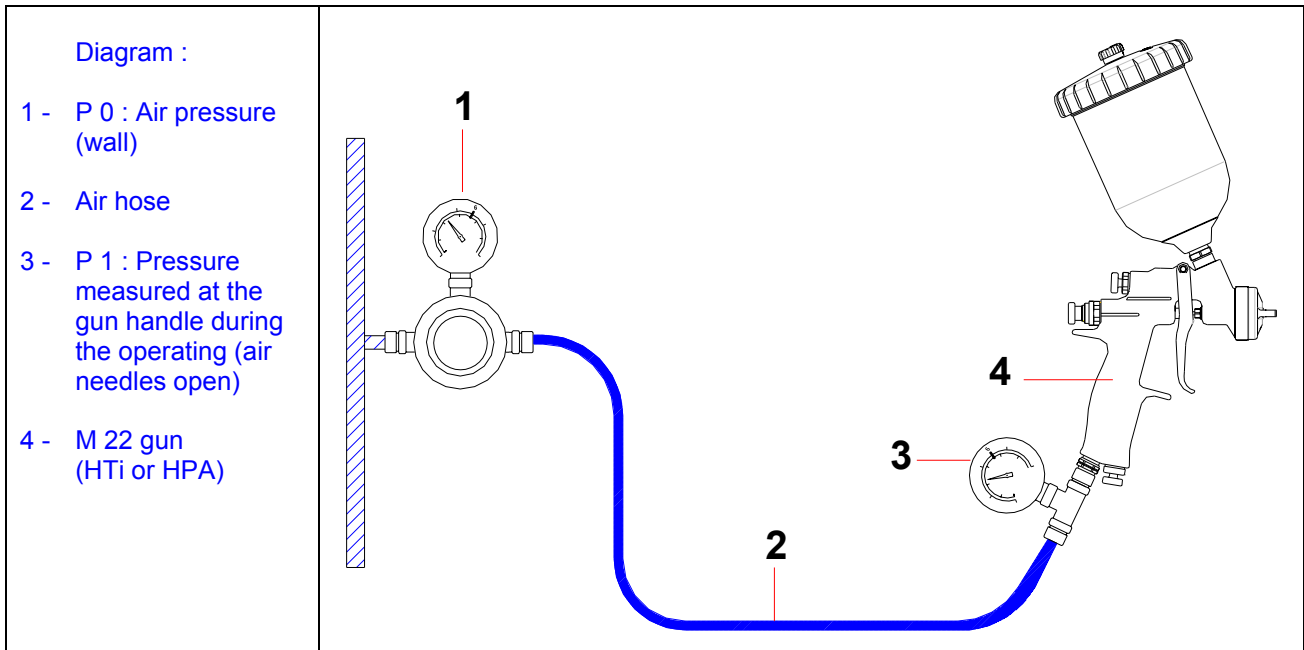
Note : For HVLP compliance, the maximum inlet air pressure at the gun handle must not exceed 29 psi (2 bar) to maintain 10 psi (0,68 bar) or less at the air cap. Testing for HVLP compliance was performed using the specified HVLP test air cap, the fan control fully open and a pressure gauge on the air inlet fitting at the gun handle. It may also be a requirement of some regulatory agencies that users have the appropriate test air cap available on site to verify that the gun is being operated within the regulatory limitations.

■ AIR AND FLUID SUPPLY

M 22 guns, model HTi & HPA	Elements mounted on the spray gun (depending on model)	Air and fluid supply
Air	Fitting : M 1/4 NPS (+ MM 1/4 BSP not mounted)	Air hose (non-static hose) HTi : minimum 8 mm int. ID (for a 7.5 m / 24.6 ft length) HPA : minimum 7 mm ID (for a 7.5 m / 24.6 ft length)
Fluid	White or grey gravity cup (0,6 liter)	Option : white cup (0,25 liter)

■ PRESSURE AND AIR CONSUMPTION OF THE GUNS

Air pressure adjustment with or without gauge at the gun handle.



HTi gun + E5 K HVLP aircap + hose Ø 8 mm (7.5 m / 24.6 ft length)	HPA gun + EN 5 aircap + hose Ø 7 mm (7.5 m / 24.6 ft length)
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P 0		P 1		P 0		P 1	
(bar)	(psi)	(bar)	(psi)	(bar)	(psi)	(bar)	(psi)
2,25	33	1,5	22	2,5	36	1,5	22
3	44	2	29	3,2	46	2	29
3,5	51	2,5	36	3,8	55	2,5	36
4,2	61	3	44	4,5	65	3	44
4,75	69	3,5	51	5	72	3,5	51

HTi + E 5 (K HVLP) aircap	HTi + EP 5 aircap	HPA + EN 5 aircap
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Air pressure (P 1)	Air flow rate					
	(m3/h)	(CFM)	(m3/h)	(CFM)	(m3/h)	(CFM)
1,5 bar / 21.75 psi	21,5	12.7	14	8.2	-	-
2 bar / 29 psi	27,2	16	17	10	22,8	13.4
2,5 bar / 36 psi	32,9	19.4	20,2	11.9	26,5	15.6
3 bar / 43.5 psi			23	13.6	30,2	17.8
3,5 bar / 50.8 psi			26	15.3	36,9	21.7
4 bar / 58 psi					40,6	23.9

Nozzle	Fluid flow (*)					
	(cm3/mn)	(oz/mn)	(cm3/mn)	(oz/mn)	(cm3/mn)	(oz/mn)
13	170	6	173	6.1	210	7.4
14	200	7	214	7.6	238	8.4
15	245	8.6	229	8.1	256	9
18	260	9.2	275	9.7	282	10
22	284	10	342	12.1	345	12.2

Distance gun aircap - surface to be painted	Fan width with nozzle 14 (*)					
	(cm)	(")	(cm)	(")	(cm)	(")
15 cm	30	12	25	10	26	10
20 cm	33	13	28	11	28	11
25 cm	39	15	32	13	30	12

(*)	Fluid viscosity : 20 s CA n° 4 (= 40 centipoises) For HTi + E 5 K HVLP : P 1 = 2 bar / 29 psi For HTi + EP 5 : P 1 = 2,5 bar / 36 psi For HPA + EN 5 : P 1 = 2,5 bar / 36 psi
	Optimum fan adjustment

2. DISASSEMBLY - REASSEMBLY



WARNING :

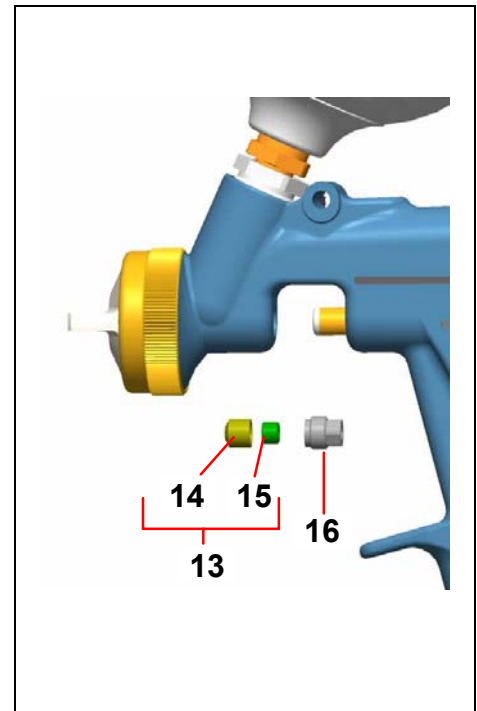
Before any action on the gun, shut off the compressed air supply and depressurize the systems by triggering the gun.

■ PROJECTOR

- Remove the aircap (1) and soak it in solvent.
- Unscrew the nozzle (7).
- Remove the needle stop (21) and the spring (20).
- Remove the needle (11) by the rear.
- Remount the new nozzle (7) and tighten it securely with the KREMLIN wrench.
- Remount the new needle (11), the spring (20) and the stop (21).
- Remount the air cap (1) and tighten the ring (2) carefully.

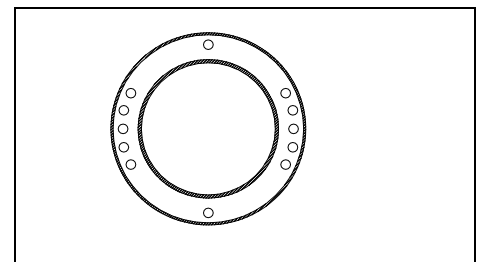
■ PACKING ASSEMBLY (IND. 13)

- Make sure there is no more paint inside the gun.
- Completely unscrew the needle stop (21). Remove the spring (20).
- Remove the needle (11) by the rear.
- Dismount the trigger (37) by removing the screw (39) and the spindle (38).
- Unscrew the packing holder (16).
- Take off the needle packing (13) and replace it:
The packing (13) is composed of 2 parts (14 and 15 - refer to the drawing).
- Insert the bearing (15) into the part (14) and replace the whole in the gun.
- Screw the packing holder (16) moderately.
- Insert the new needle, the lubricated spring (20) and the needle stop (21).
- Tighten up the packing holder (16) and unscrew it by a 1/4 turn.
- Remount the trigger (37).
- Feed paint.
- If there is a leak, screw slightly.



■ DISTRIBUTION RING (IND. 35)

Respect the ring assembly instruction (refer to the opposite drawing).



■ **AIR VALVE (IND. 22)**

- Unscrew the needle stop (21).
- Remove the needle spring (20) and the needle (11).
- Unscrew the sleeve (17).
- Remove the valve spring, the valve (22) and the valve carrier (28).
- Remount the valve carrier (28) on the new air valve (22).
- Install the new assembly, the lubricated valve spring (29) into the gun body.
- Screw the sleeve (17).
- Remount the other parts : the needle (11), the lubricated spring (20) and the needle stop (21).
- Screw the milled nut (19) to regulate the needle stroke.

■ **REPLACEMENT OF THE AIR VALVES SEAL (IND. 26)**

Remove the air valve (22).
(refer to previous paragraph).

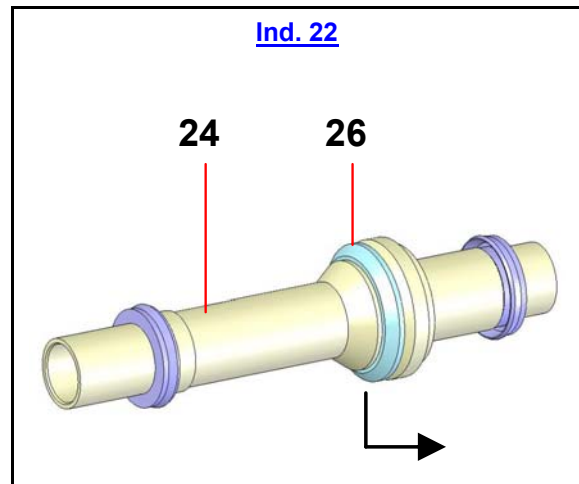
Remove the seal (26).

Place the new seal (26) in its housing. Lubricate it.

When reassembling :

➡ **Carefully, insert the valve into the gun body carrying out a rotary motion so as to preformate the valve seal (26).**

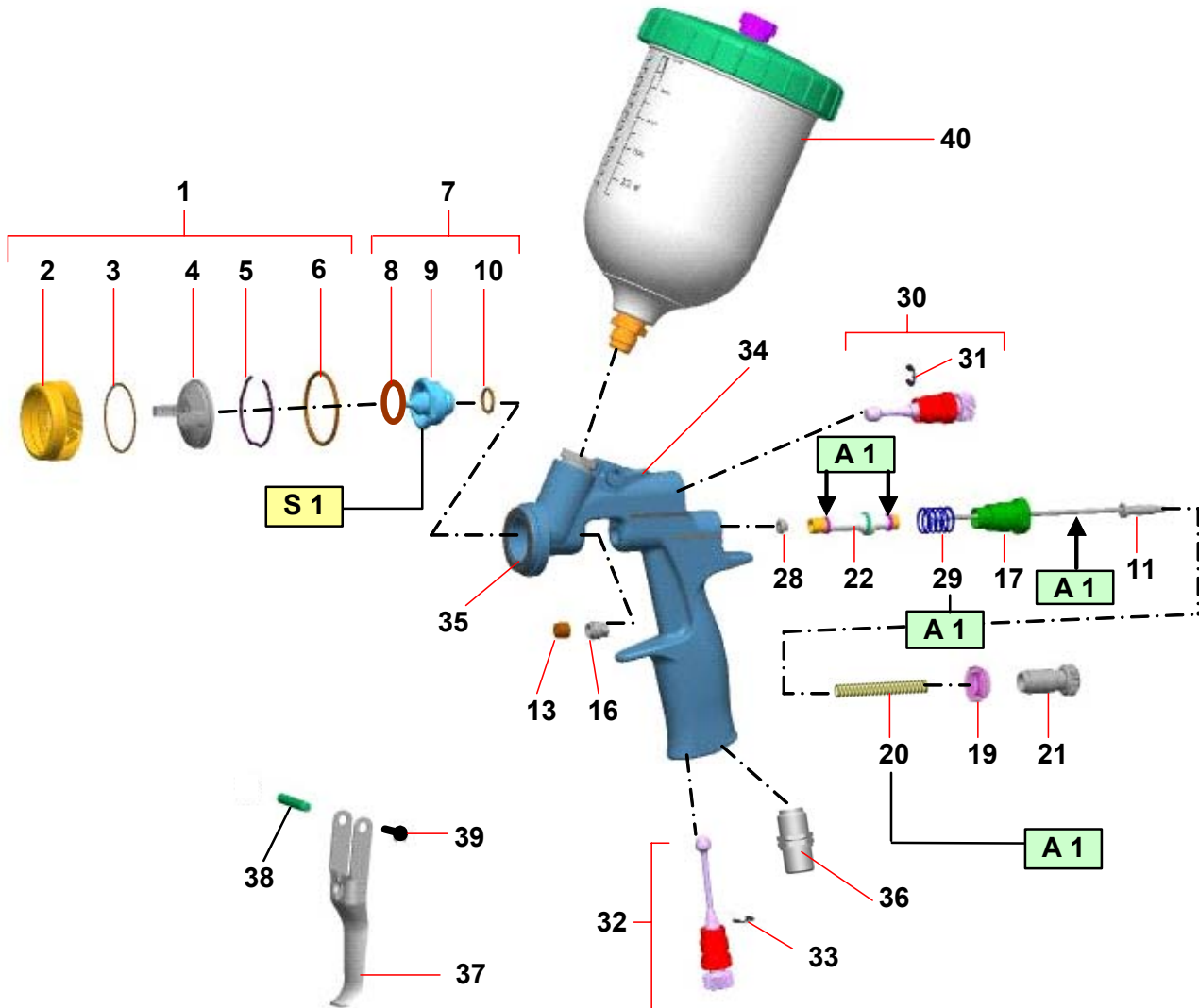
Reassemble the other parts as previously indicated.



Before reassembling the different components :

- **Clean the parts with the appropriate cleaning solvent with a brush.**
- **Install new seals after having lubricated them with PTFE grease.**
- **Install new parts if necessary.**

3. ASSEMBLY INSTRUCTIONS



Index	Instructions	Description	Part number
A 1	PTFE Grease	"TECHNILUB" grease (10 ml)	560.440.101
S 1	Screwing torque	18 Nm / 13.3 ft/Lbs	