

SPECIFICATIONS

AUTOMATIC AIRSPRAY GUN A 25 F FLOWMAX®

Manual : 0704 573.062.212

Date : 2/04/07

Supersede : 5/06/06

Modif. : Glue added for fluid fittings

ADDITIONAL DOCUMENTATIONS

SPARE PARTS :

GUN, model A 25 F FLOWMAX®

Doc. 573.326.050

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SPECIFICATIONS
AUTOMATIC AIRSPRAY GUN
MODEL A 25 F FLOWMAX®

1. TECHNICAL FEATURES

The gun, model A 25 F is designed for spraying paints, adhesives, water-based materials and UV materials in automatic installations. It can be fitted on fixed supports, automatic machines or robots.

The gun, model A 25 F enables an intensive use. The tightness of the gun is possible via a bellows seal that ensures a high reliability for long.

The assembly of the gun using a modular base allows quick interchangeability, which in turns leads to much reduced down time. Removal and replacement of the gun can be carried out without removing any hoses.

FEATURES	A 25 F FLOWMAX®
Version	Gun with base
Air feed pressure to the gun	Maximum 6 bar / 87 psi
Atomizing air pressure (base)	Maximum 6 bar / 87 psi
Command air pressure	Minimum 4 bar / 58 psi
Fluid pressure	Maximum 6 bar / 87 psi
Air consumption	22 m ³ /h at 2,5 bar 13 c.f.m at 36 psi
Operating temperature	50°C / 122° F
Weight of gun alone	985 g / 1.99 lb
Weight of gun + base	1280 g / 2.82 lb
Materials in contact with the product : - body, nozzle, needle - bellows	Stainless steel PTFE
Fixing of the gun on the base :	2 screws M 6 x 50 + 2 screws M 5 x 50

▪ FITTINGS

Indexes	Filetages (base)	Fittings	Hoses
Fluid (P 1)	F 1/4 NPS	Quick fit (elbow)	Fluid hose, Ø 6x8
Fluid (P 2)	F 1/4 NPS	Quick fit (elbow) or plug	Fluid hose, Ø 6x8
Command air (C)	F 1/8 NPS	Quick fit	Polyamide hose, Ø 4x6
Spraying air (A)	F 1/4 NPS	M 1/4 NPS	Conductive air hose: minimum 8 mm / 5/16 ID (for a 7.5m length)

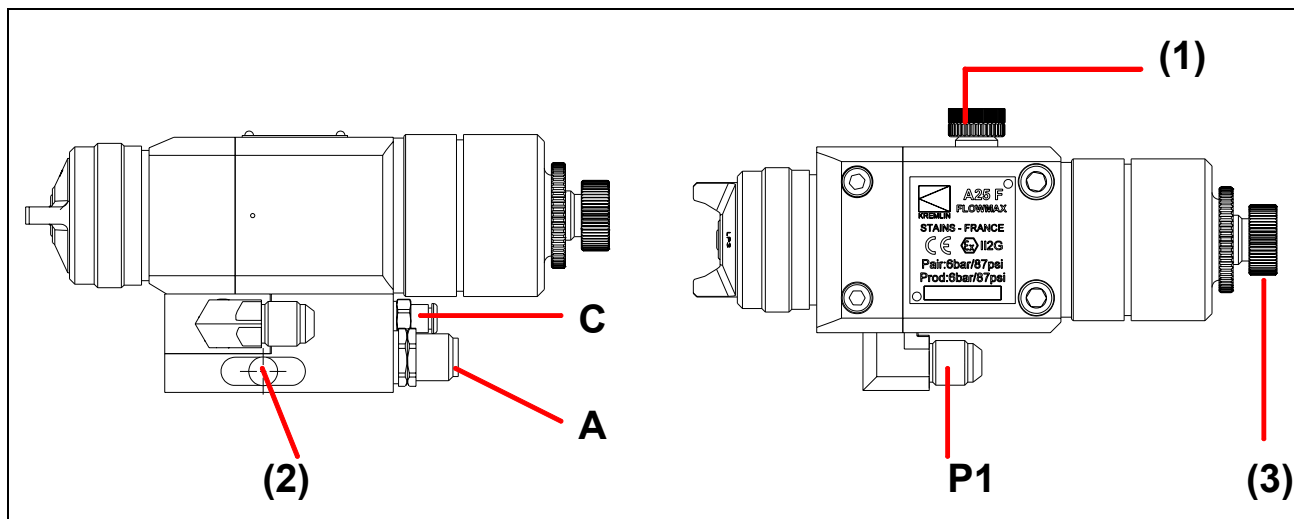
(1)	Fan adjustment	→ fan width adjustment
(2)	Gun mounting pin	support : rod Ø 16 / 5/8", length 100 mm / 4"
(3)	Adjustment knob	→ fluid output adjustment

On the modular base, you can fit :

- either 2 product fittings → product circulation
- or 1 product fitting and a plug

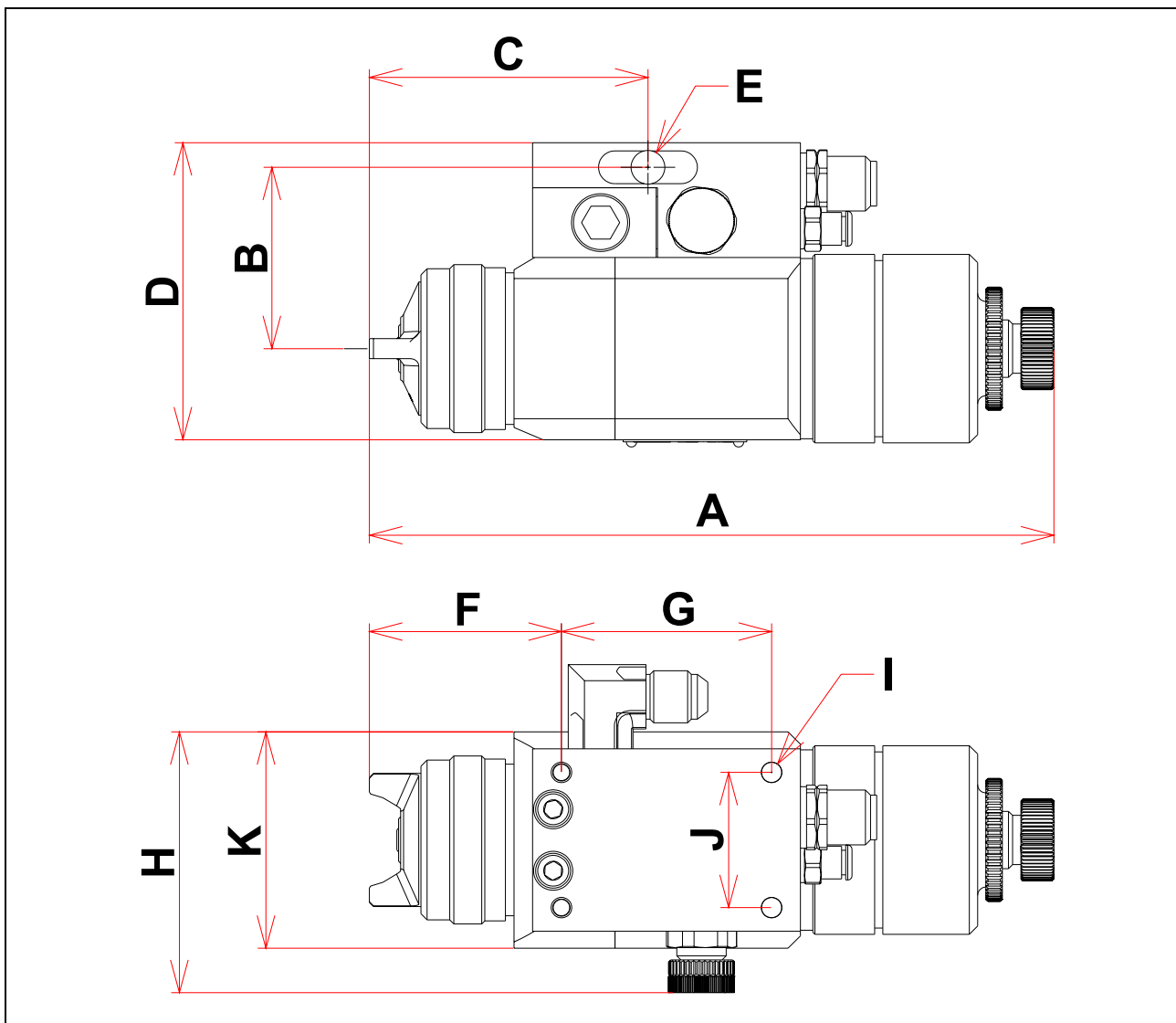


Applicate glue on the threading of the fluid fittings or of the plug (glue similar to Loctite 577).



■ DIMENSIONS

Dimensions	Ind.	A	B	C	D	E	F	G	H	I	J	K
	mm	166 + 10	44,25	67,6	72,5	Ø 8,2	46,6	51	63,65	Ø 5	33	52,8
	"	6.5 + 0.4	1.74	2.66	2.85	7/32	1.83	2	2.50	31/32	1.3	2.08



■ OUPUT AND PRESSURE

A 25 F	Fluid output (cm3/mn)	Fan width (cm)	Air output (m3/h)
+ 7 N 3C	200	26	22
+ 9 N 3C	250	30	22
+ 12 N 3C	300	34	22

Fluid viscosity : 20 s CA n° 4 (= 40 centipoises)
 Air pressure = 2,5 bar / 36 psi

2. DISASSEMBLY - REASSEMBLY



WARNING :

Before any intervention on the spray gun, shut off the compressed air supply and depressurize the systems by controlling the opening of the spray gun.

■ CHANGING THE SPRAY GUN

Shut off the air and product feeds to the gun.

Depressurize the circuits.

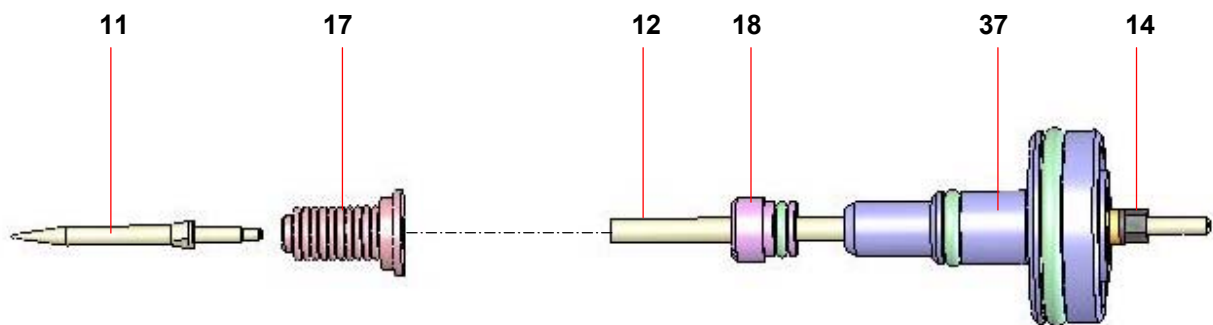
Remove the 4 screws (ind. 28).

Take out the gun.

Fit the new gun and change the seals (ind. 24 and 27).

Re-fit the 4 screws (ind. 28).

■ NEEDLE AND BELLOWS



NEEDLE END (11)

Unscrew the cylinder (41) paying attention to the springs 39 and 40.

Unscrew the 4 screws (30) and remove the front body (23) from the gun.

Hold the nut (14) located at the end of the needle by means of a wrench and unscrew the needle end (11) using an other wrench.

Fit a new end, the thread must be slightly glued, then screw it into the needle rod (12) to stop.

➡ **The screwing is important : it ensures a good tightness of the bellows.**

BELLOWS (17)

Same operations as previously indicated.

Take off the needle end (11) and remove bellows (17).

Mount the new bellows into the groove of the air body (26).

Remount the needle end (see above).

NEEDLE ROD (12)

After removing the needle end (11) and the bellows (17), hold nut (14) and take off the needle by the rear.

Clean the needle rod.

When reassembling :

Hold the gun vertically.

Place the cone-shaped tool (47) at the end of the needle rod (12).

Slide the whole inside the gun.

The cone-shaped tool enables the needle to cross the needle bearing (18) without damaging the seal inside it. The seal ensures the air tightness.

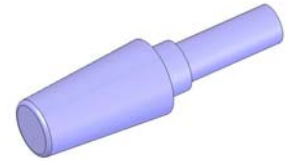
Remount the bellows (17) and the needle end (11).

Mount the springs (39 and 40).

Screw the cylinder (41).

Unscrew first the needle adjustment knob (42) and remount the nozzle (6) and the aircap (1).

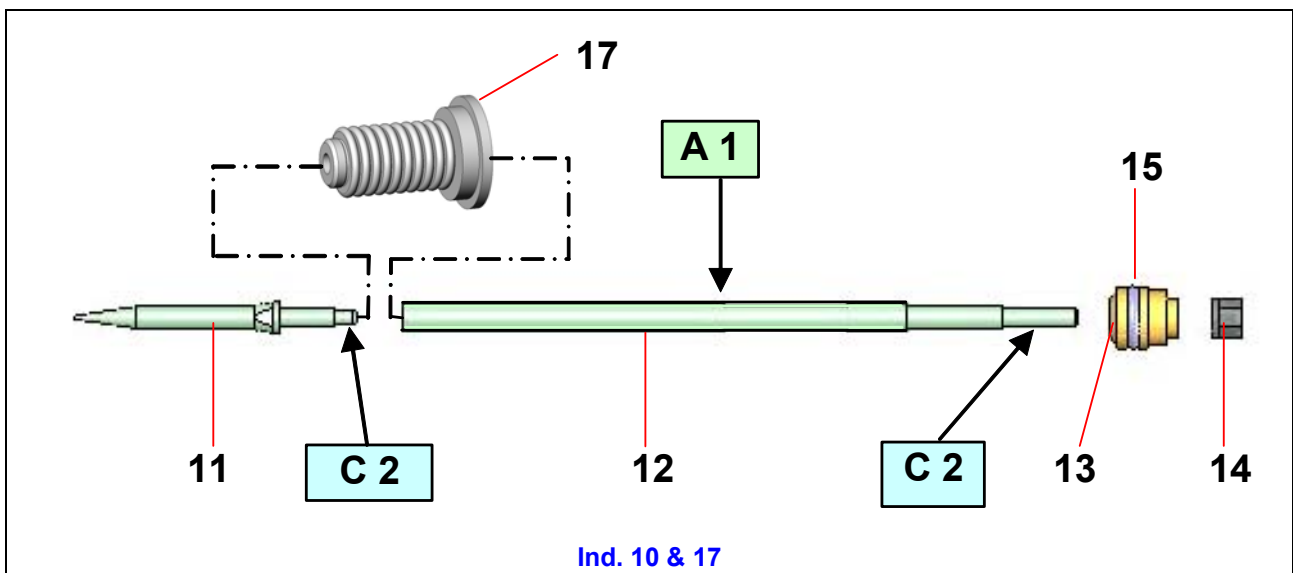
Ind. 47

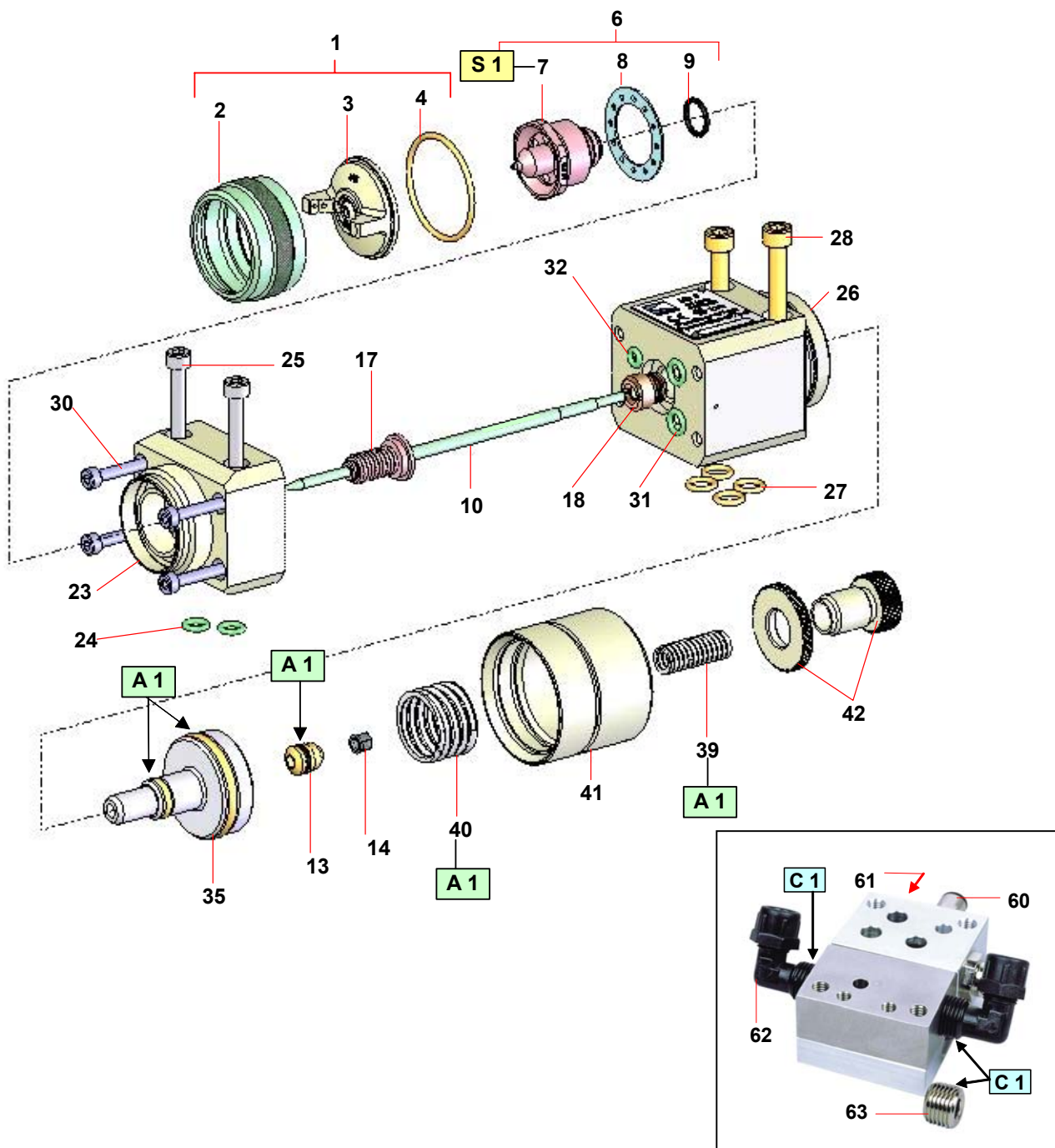


When reassembling the different components :

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

3. ASSEMBLY INSTRUCTIONS





Index	Instructions	Description	Part number
A 1	PTFE grease	"SUPER LUB" grease (10 ml)	560.440.101
C 1	Medium strength Anaerobic Pipe sealant	Loctite 577	-
C 2	Low strength - Anaerobic Adhesive (similar as Loctite 222)	Glue bottle (50 ml)	554.180.010
S 1	Screwing torque	18 Nm / 13.3 ft/lbs	