

Operation and Maintenance Manual

Micro Coat Air Spray Automatic Gun

Pearl gun

Low-pressure Air Spray Automatic Gun

Micro Ace



AGB50M
AGB51M



This manual contains important information on warnings and cautions. Read the manual thoroughly before starting to operate the equipment, and follow the instructions. Always keep the manual handy until such time as the equipment is no longer being used, and if your manual is lost or worn badly, do not hesitate to contact our agency, which is closest to you, or Asahi Sunac Corporation, directly, and ask us to send you a new one.

Introduction

Thank you for buying our product, Air Spray Auto Gun Pearl gun <AGB50M>/Low Pressure Air Spray Auto Gun Micro Ace <AGB51M>.

Please be sure to read this operation manual carefully before using this product so that you can always use it under the optimum conditions.

In particular, please fully understand the items in the specifications and use them according to the correct usage.

If you have any questions, please contact us by clearly stating the "product number" and "serial number" and contacting us on the back cover.



Please keep this operation manual in a safe place where you can easily refer to it.

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Please understand the contents of this instruction manual and be sure to follow the handling method.

If you use it without following this instruction manual, **you may injure your body or damage your equipment and fire.**

The following safety precautions should be considered as minimum basic safety measures when using our products.

- **Precautions are displayed in the following two stages.**

**WARNING**

Hazards that can result in death or serious injury.

**CAUTION**

Danger that may result in minor or moderate injury or physical damage only.

- **Other important points are indicated as follows:**

NOTE

Observations to ensure the equipment's performance and functions are fully operational.

In addition, please observe all national and local laws and regulations related to fire, electricity, and safety, as well as the rules and regulations of your own company or business division.

«Range of use suitable for the product»

This product is an automatic spray gun designed to be installed in the coating booth equipped with an exhaust system and used for painting with atomization paint. If you use the product under conditions other than the above, it will be used improperly. Also, please be careful as it may cause an accident.

《Warning and precautions for safe use》



WARNING

Fire and explosion



Preventing fire and explosion in coating shop

- **Do not use halogenated hydrocarbon solvents.**

The aluminum alloy contained in this product's components may undergo a chemical reaction and explode.

- **Do not use this product outside its specifications.**

Using it out of specification range may result in a fire hazard.

- **Provide adequate ventilation with ventilation equipment.**

Volatilized organic solvents and other substances may remain and ignite, creating a risk of fire.

- **Clean the coating room and exhaust system (ducts and fans) regularly.**

If the accumulated powder simply peels off, a spark may occur, which could cause a dust explosion.

In the unlikely event of a fire, paint residue etc. will make it easier for the fire to spread and result in greater damage.

《Warning and precautions for safe use》



WARNING

Fire and explosion



Prevent fire and electric shock caused by faulty earthing

- **All conductive objects in the coating booth (paint containers, peripheral equipment, etc.) must be grounded with an earth wire.**

When paint flows through a pump or hose, static electricity is generated, and poorly grounded conductors can become charged and sparks can discharge, resulting in a fire or electric shock.

- **Always keep the workpiece earthed.**

Risk of fire or electric shock due to spark discharge from charged workpieces.

- **Paint hose must be grounded with an earth wire.**

Static electricity can cause spark discharge, which can result in fire or electric shock.

When paint flows through the injector and paint hose, static electricity is generated and becomes charged.

- **The paint container must be grounded with an earth wire (excluding the insulated stand specifications).**

The paint path can cause the paint container to become charged, a risk of fire or electric shock.

- **Be sure to periodically remove any paint that has stuck to the hanger.**

If paint adheres to the contact part between the hanger and the object, there is a risk of fire or electric shock due to poor earthing.

The ground resistance value should be 1k Ω or less for metal (1M Ω or less for resin) (measurement voltage should be 500V or more).

《Warning and precautions for safe use》



WARNING

Fire and explosion



Prevent fire and electric shock caused by faulty earthing

- **Do not place any items in the coating booth that are not necessary for coating.**

Static electricity can cause spark discharge, which can result in fire or electric shock.

- **Paint operator must take precautions to prevent static electricity.**

Static electricity builds up on the human body, causing sparks to discharge, which may result in fire or electric shock.



Prevent fires caused by ignition of paints and solvents

- **Do not bring any spark-producing devices, matches, lighters, etc.**

Risk of explosion or fire due to ignition of flammable materials.

《Warning and precautions for safe use》



WARNING

Equipment misuse



Preventing accidents caused by poor maintenance

- **Any abnormal noise, vibration or high voltage leakage, immediately stop operation.**

Product damage may result in a fire hazard.

- **Do not operate if any parts are damaged or missing.**

Product damage may result in a fire hazard.

《Warning and precautions for safe use》



WARNING

Human protection



Protection from solvents, air and paint pressure

- **Do not spray paint towards person**

Harmful substances may cause serious injury, including inflammation and poisoning.

Pressurized paint can cause personal injury.

- **Wear protective glasses, a protective mask, and protective gloves*1 when handling paint.**

Harmful substances may cause serious injury, such as inflammation or poisoning.

Carefully read the safety data sheet (SDS*2) of the paint you are using and

take appropriate exposure prevention and protective measures.

*1 When using protective gloves for skin absorption protection or to prevent dirt,

it is necessary to prevent static electricity from building up on the human body.

Be sure to ground it properly. (Recommended protective gloves are those specified in JIS T8118, or earth bands, etc.)

*2 SDS : Safety Data Sheet

- **Clean the coating room and exhaust device (ducts and fans) regularly.**

If the exhaust device does not function properly, harmful substances may cause

serious injury, including inflammation and poisoning.

《Warning and precautions for safe use》



CAUTION

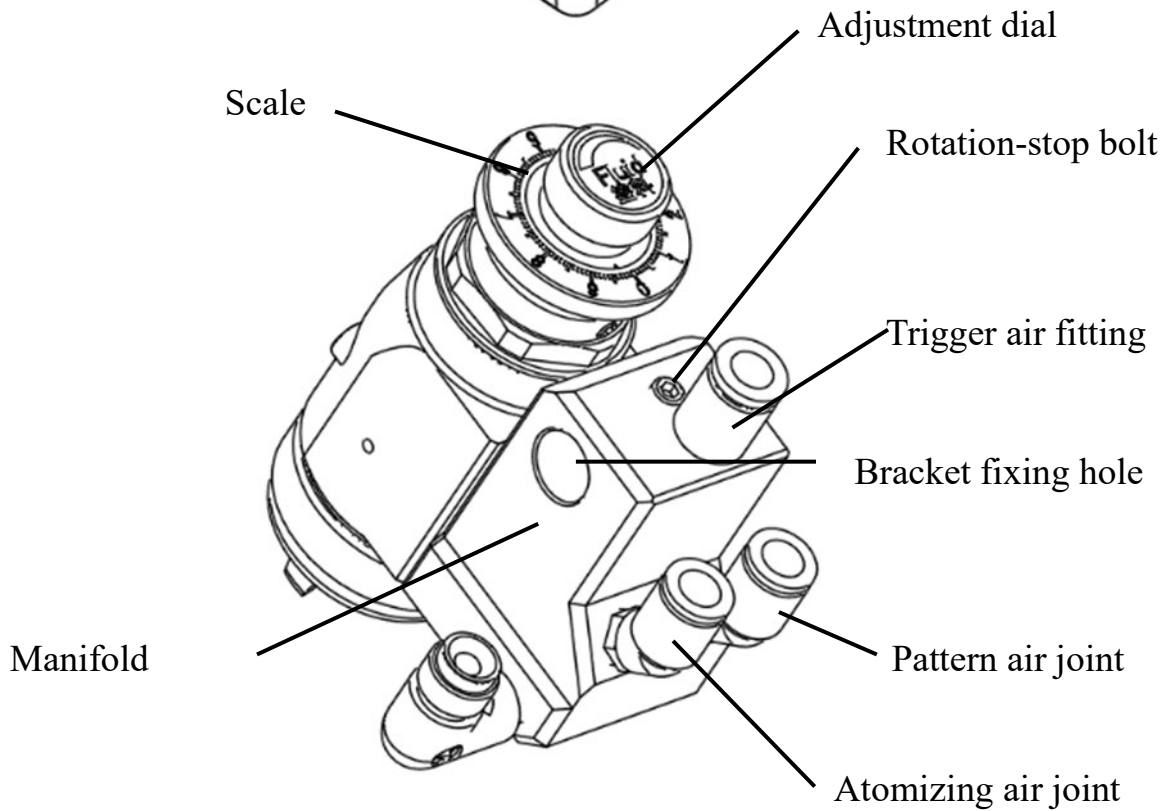
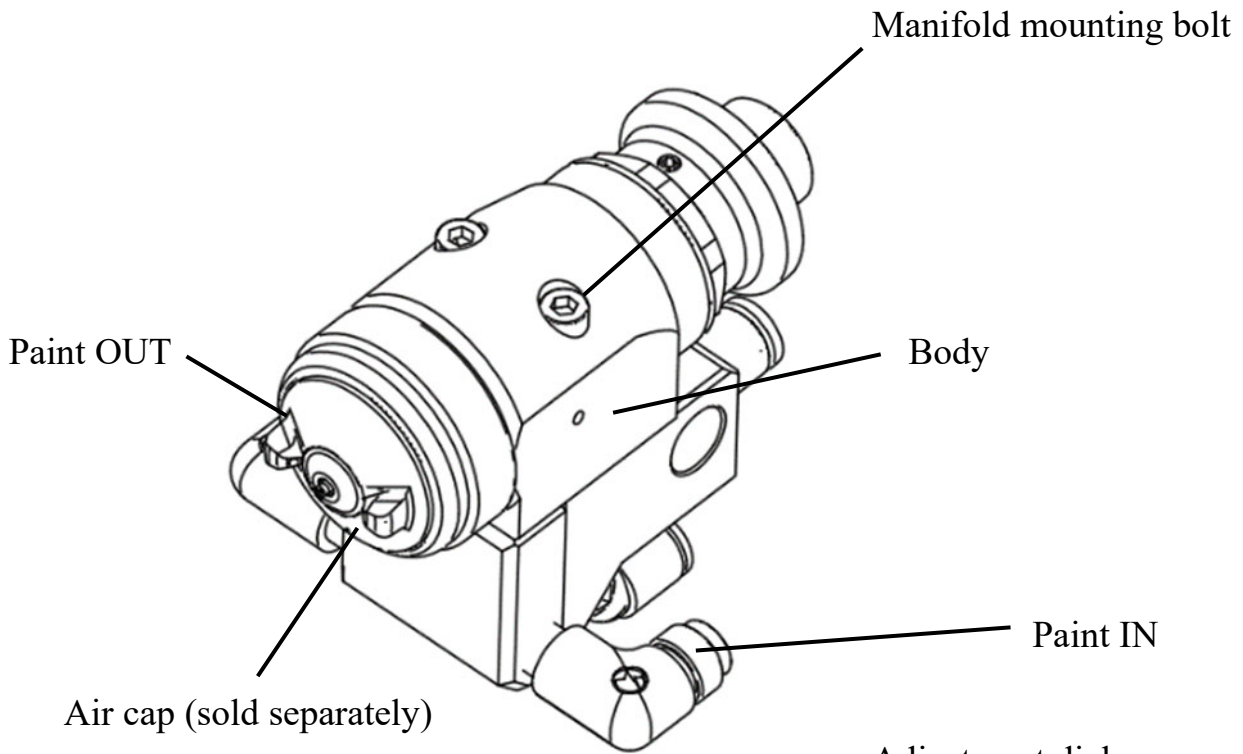
- **Do not use this product outside its specifications.**
Using it out of specification range may result damage to the product.
- **Hoses should be hung from the ceiling or side walls and not dragged across the floor.**
It may cause damage such as scratches.
When using conductive paint, be sure to suspend the paint hose from an insulating material such as a rubber tube.
- **Never use a metal brush to clean the sprayer or its components.**
It may cause scratches, breakdowns, and poor coating results.
The nozzle and electrode are important parts of the sprayer.
If you use a metal brush to scratch it, uniform coating will not be possible.
- **Check frequently for paint leaks, air leaks, and loose screw.**

- **A fire extinguisher should always be kept near the work area.**

In case of a fire, make sure to have equipment that has been regularly inspected installed at all times.

- **When disposing of this product, please dispose of it in accordance with the laws of your country.**

•Name of each part of the main unit



●Nozzle

Paint, atomizing air, and patterned air are ejected to atomize the paint and to form a paint adhesion pattern in the paint spray stream.

●Paint valve

The amount of paint spray can be finely adjusted by changing the needle stroke length of the paint valve.

The needle stroke length changes by 0.5mm by turning the adjustment dial once.

A black line appears on the side of the cap at the rear of the dial every 1mm of needle stroke. Use this as a guide for adjustment.



CAUTION

Do not tighten the adjustment dial until the black line is completely hidden.

Doing so may damage the needle tip and make it impossible to adjust the amount of paint spray.

●Manifold mounting bolt

The gun body and manifold can be easily attached/detached with two manifold mounting bolts.

This allows easy maintenance without changing the fixing position of the gun.

3

Equipment Specifications

Specifications of air spray auto Gun Pearl gun <AGB50M> and low-pressure air spray auto gun Micro Ace <AGB51M>

Model	AGB50M	AGB51M
Part No.	1851-1	1852-1
Nozzle aperture	φ1.0	φ1.1
Amount of spouting	When coating Max. 150mL/min (Paint viscosity 20mPa•s)	When coating Max. 400mL/min (Paint viscosity 20mPa•s)
Built-in valve	Trigger valve/arrowhead needle system	
Air tube	Pattern air: Max. air flow rate (φ8 × 6) MAX 250L/min (ANR) Atomizing air: Max. air flow rate (φ8 × 6) MAX 300L/min (ANR) Trigger valve: φ6×4	
Gun mounting hole	φ13mm	
Maximum paint pressure	0.6MPa	
Max. air pressure	0.6MPa	
Dimensions	W96×H92×L114mm	W96×H92×L114mm
Weight	Approx. 650g (including air cap)	

4

Operation Procedures and Precautions

①Paint

(1)Adjusting Paint Viscosity

Adjust the viscosity according to coating requirements.

In general, adjust the range between 20 and 40mPa•s.

(2)Move the paint pump.

(Refer to the instruction manual for the paint pump.)

If air remains in the paint hose, it becomes pulsatile when paint is spouted, and the spouting condition is not constant. Remove all air from the hose.

(3)Adjusting the amount of paint spray

Adjust with the needle pulling allowance adjustment dial at the rear of the gun.

The adjustment dial is 0.5mm per rotation (1 scale on the dial is 0.05mm), and the drawing allowance can be adjusted.

At this time, turn off the air for opening and closing the gun before adjusting.

Never perform adjustment while ejecting (this will lead to premature wear of the adjustment screw). Supply 0.3 to 0.5MPa of air pressure for opening and closing.

②Atomizing air pressure

(1)Since the atomizing air pressure can be significantly lower than that of a normal air spray gun, coating efficiency is improved.

When the atomizing air pressure is increased, the particles of the paint become finer to some extent and the finished skin can be improved, but at the same time, the coating efficiency decreases and the spreading also increases. Do not increase the atomizing air pressure more than necessary.

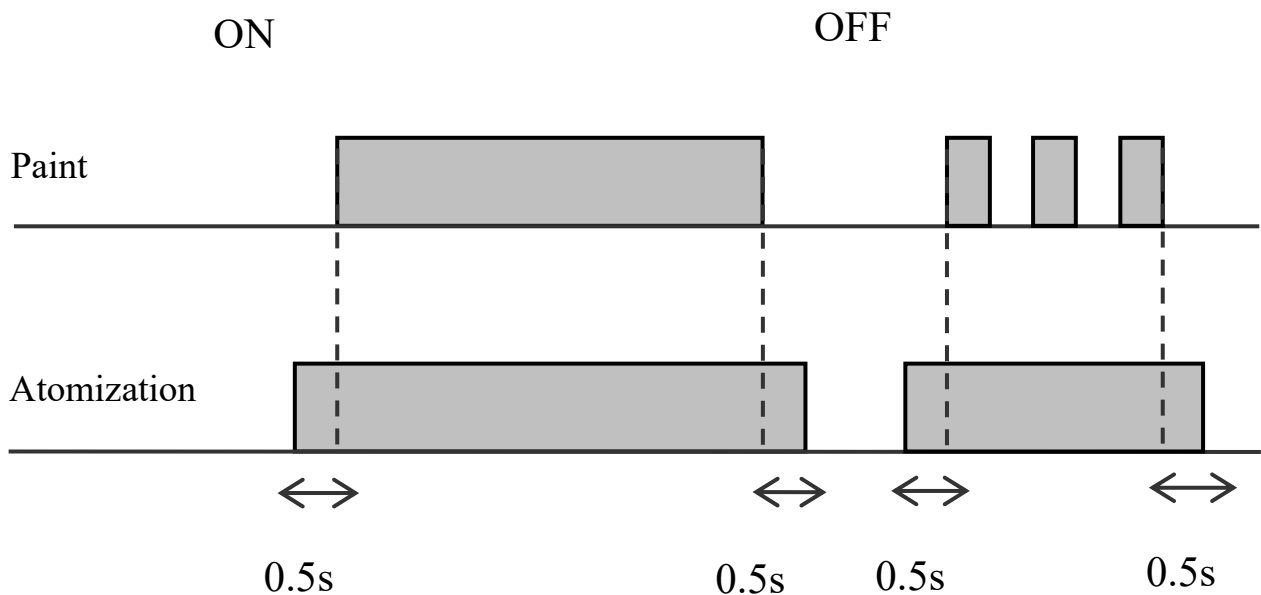
(2) Adjust the atomizing air pressure while blowing air out from the nozzle by operating the regulator for adjusting the atomizing air. Atomizing air pressure typically ranges from 0.05 to 0.3MPa.

③ Air pressure for pattern change

To adjust the pattern change air pressure, operate the air regulator for pattern change to change the spray pattern width while spraying paint.

④ Adjusting the Splay Timing

- Shift the timing as shown in the figure below approximately 0.5 seconds before and after the spraying of paint to prevent poor atomization, and spray/stop the atomized and patterned air.



⑤ Handling of work interruption and termination

● Nozzle Cleaning Procedure

Clean the nozzles whenever work is interrupted or finished.

(1) Stop spraying of paint and air.

(2) Use a solvent-soaked brush (a brush with horsehair and animal and vegetable hair) to wash while melting the paint adhering to the nozzle surface.

If rubbing with a brush does not remove it, soak the nozzle in the solvent for a few minutes and rub it off while melting.

(3) After cleaning, use manual operation to spray atomized air and discharge the solvent flowing into the air passage.

⑥ Precautions for operation



CAUTION

- The nozzles are vital parts of coating system. Handle with care to avoid dropping or scratching the nozzles.
- The compressed air supplied to coating gun must be an air dryer and an air filter (3 to 5 μ m), Use the product in a clean condition through an oil mist separator (0.03 to 0.01 μ m).
- Be sure to filter the paint before use.
- When using paints that tend to precipitate, wash them thoroughly with a solvent so that no paint remains inside after use.

(The numbers shown below correspond to the numbers or part numbers in exploded diagram of "9 Components ")



CAUTION

Release the air pressure and paint pressure before performing maintenance work.

① Maintenance of nozzles

- (1) Remove once a month, disassemble and clean, and remove any paint residue that has entered the air passage pores.
- (2) When a two-part paint is used, it may be damaged if you attempt to decompose the nozzle firmly adhered by the hardened paint. The nozzle is securely tightened before supplying the two-part paint. Also, wash thoroughly with a solvent so that paint does not remain inside after use.
- (3) If the inside of the nozzle is worn, paint will leak even when the trigger is OFF.
It is time to replace the nozzle. When replacing the needle, be sure to replace it with a new one.



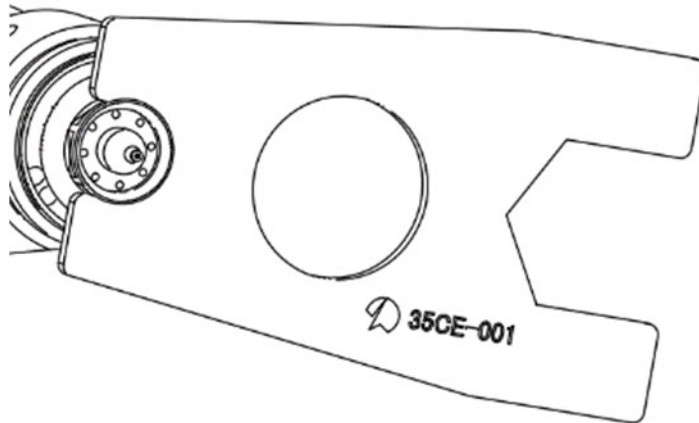
CAUTION

After replacement, when using for the first time, close the paint flow adjustment valve at the rear of the gun lightly until it is fully closed, and then release the required amount. This ensures that the needle is familiar with the nozzle and improves seatness.

(4)When mounting the nozzle, do not tighten it with excessive force (max. 3.0N·m).



CAUTION



Too much tightening may deform the hexagon part of the nozzle. Be sure to use the plate wrench (35CE-001) provided with the accessory tool to tighten.

If the nozzle hexagon part is deformed, it may become impossible to insert the nozzle into the body.

An O-ring seal is adopted for the nozzle mounting part of this gun, and sealing is performed in the O-ring radial direction.

When the rear end of the nozzle comes into contact with the gun body, it is not necessary to tighten any further.

②Needle and Nozzle Maintenance

- (1)When mounting or removing the nozzle without removing the needle, be sure to loosen the paint control valve at the rear of the gun to the limit, turn on the trigger air, and pull the needle.



CAUTION

Installing or removing the needle without pulling it may damage the nozzle needle and prevent it from seating.

③Maintaining the Gun

- (1)When cleaning the air cap or paint nozzle with the nozzle attached to the gun, release the atomized air and patterned air after cleaning, and discharge the solvent that has entered the air passage.



CAUTION

If the gun is installed inclined upward, clean with the atomized air and patterned air released with weak air to the extent of 0.05MPa to prevent solvent from entering the air passage.

- (2)Check daily before use that the fixed part of the gun is not loose and that the gun does not hit the object to be painted.
- (3)When using two-part paints or paints that tend to precipitate, wash them thoroughly with a solvent after use, and periodically disassemble and clean them once every three months.
- (4)If the packing case set of No.4 is damaged, paint leakage will occur from the check hole on the side of the gun body. Replace the packing case set with a new one.

6

Paint problems and solutions

Phenomena of defect	Cause	Measures
1. Atomization is poor.	(1) Atomizing air pressure is too low.	(1) Increase atomizing air pressure.
	(2) Paint discharge rate is too much.	(2) Decrease paint discharge rate or increase atomizing air pressure.
	(3) Solvent is not proper.	(3) Consult paint manufacturer or us.
	(4) Nozzle discharge portion is damaged.	(4) Repair or replace the nozzle.
2. Paint splashes a lot.	(1) Spraying distance is not proper.	(1) Optimize spraying distance. (200 to 300 mm).
	(2) Atomizing air or pattern change air is too low.	(2) Increase to optimum pressure.
	(3) Exhaust speed is too slow.	(3) Implement damper adjustment.
3. Coating efficiency is low.	(1) Atomizing air or pattern change air is too high.	(1) Decrease to optimum pressure.
	(2) Spraying distance is too far.	(2) Optimize spraying distance.
	(3) Pulling of exhaust fan is too strong.	(3) Implement damper adjustment.
4. Paint adhered to nozzle generates beardlike adherents.	(1) Solvent evaporates too fast.	(1) Change to or add solvent that evaporates more slowly.
	(2) Room temperature is too high.	(2)-1 Change to solvent that evaporates more slowly. (2)-2 Examine air conditioning equipment.

Phenomena of defect	Cause	Measures
5. Small bumps are generated on paint surface.	(1) Dust in coating booth.	(1) Install dust removing filter to suction area of coating booth.
	(2) Dust is adhered to surface to be coated.	(2) Blow off dust.
	(3) Spray dust is adhered.	(3) Adjust the exhaust speed and exhaust direction.
	(4) Dispersion of paint pigment is poor.	(4) Filter the paint.
6. Orange peel (crater, pock mark) is generated.	(1) Solvent evaporates too fast.	(1) Change to solvent that evaporates more slowly.
	(2) Room temperature is too high.	(2) Change to solvent that evaporates more slowly.
	(3) Temperature of product to be coated is too high.	(3) Lower temperature of product to be coated below air temperature.
	(4) Air velocity in coating booth is too fast.	(4) Lower the air velocity. (0.3 to 0.5 m/sec on surface to be coated.)
7. Repelling is generated.	(1) Product to be coated is not cleaned properly.	(1) Perform cleaning thoroughly.
	(2) Exhaustion of baking oven is poor.	(2) Perform exhaustion thoroughly.
	(3) Atomizing air, pattern change air, water and oil are dirty.	(3) Replace the filter element.
8. Paint flows (runs) on surface.	(1) Paint film is too thick.	(1) Adjust paint discharge rate and operation speed.
	(2) Viscosity of paint is too low.	(2) Adjust paint viscosity. (Normally, 11 to 30 seconds/FC#4)
	(3) Solvent evaopporates too slow.	(3) Change to solvent that evaporates faster.

Phenomena of defect	Cause	Measures
9. Paint is transparent	(1) Discharge rate is small.	(1) Adjust paint discharge rate and number of painting (reciprocator operation speed).
	(2) Viscosity of paint is too low.	(2) Adjust paint viscosity.
10. Small hole (Pin hole) are generated.	(1) Temperature of product to be coated is too high.	(1) Lower temperature of product to be coated below air temperature.
	(2) Undercoating is not dried sufficiently.	(2) Perform drying thoroughly.
	(3) Atomizing air, pattern change air, water and oil are dirty.	(3) Replace the filter element.
	(4) Solvent evaporates too fast.	(4) Add solvent that evaporates more slowly.
	(5) Setting is not sufficient.	(5) Perform setting properly.
11. Blushing is generated.	(1) Humidity inside and outside coating booth is high. (Relative humidity is 80% or more.)	(1)-1 Change to solvent that evaporates more slowly. (1)-2 Examine air conditioning equipment.
	(2) Selection of solvent is not proper.	(2) Consult paint manufacturer and replace with proper solvent.
12. Foaming is generated.	(1) Atomizing air, pattern change air, water and oil are dirty.	(1) Replace the filter element.
	(2) Drying is insufficient after wet rubbing.	(2) Perform drying thoroughly.
	(3) Paint film is too thick.	(3) Adjust paint discharge rate.
	(4) Solvent evaporates too fast.	(4) Add solvent that evaporates more slowly.

●Automated Air coating Engineer

Phenomenon of failure	Cause	Countermeasures
1.Coating shortness of breath Be in the state (Zensok)	①Nozzle tightening failure.	①Retighten the nozzle.
	②No.22 Damaged O-ring.	②Replace the O-ring with a new one.
	③ No.4 packing case set was damaged.	③Replace packing case sets with new products.
	④Air mixed in the paint.	④Bleed air and check the paint supply system.
2.Paint spray volume is low.	①Clogged needle seat.	①Remove the nozzle and clean it.
	② Clogged air-controlled paint regulator.	②Dismantle and wash.
3.Paint leaks from nozzle	①Worn paint nozzles.	①Replace the paint nozzle with a new set.
	②Needle wear.	②Replace the needle with a new set.
	③Paint pressure feed pressure is too high.	③Reduce the pressure of paint pumping (Below 0.5MPa).

Phenomenon of failure	Cause	Countermeasures
4.Unstable open/close operation of paint	①No.20 O-ring swelling, Wear	①Replace the O-ring with a new one.
	②Reciprocator paint Cutting operation failure.	②Follow the failure countermeasures for the reciprocator.
5.Paint from nozzle does not stop	①No.20 O-ring burned on the cylinder.	①Replace the O-ring with a new one.
	② Paint residue or dust got caught in the needle.	②Remove the paint nozzle and clean the needle.



Note

Do not attempt to service this product in any way other than that specified in this instruction manual.

8

Parts replacement method

Replace and repair parts according to the following procedure.

Before removing the gun, clean the paint passage with solvent and discharge it. Then, close the air valve and release the air pressure. Also, turn off the control power and indicate that work is in progress to prevent accidental operation.

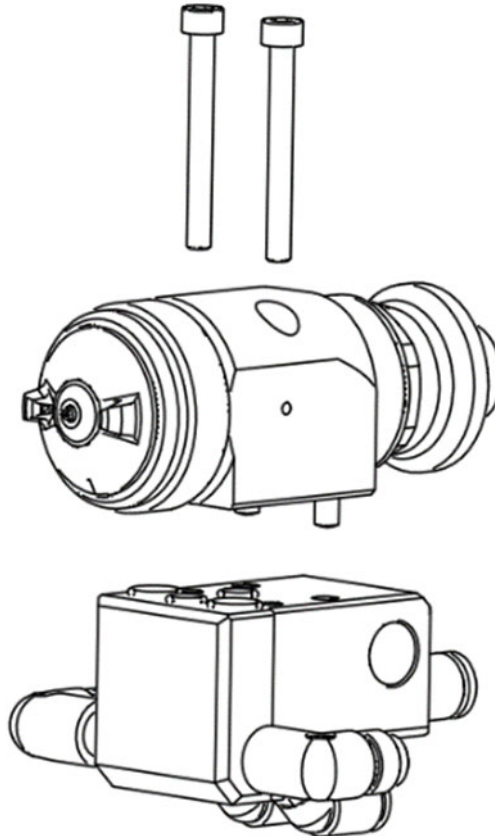
(The numbers in the text are the heading numbers and part numbers in "9 Components.")

(The illustration of how to disassemble is the trace spray auto gun pearl gan <AGB50M>.)

Disassembly method

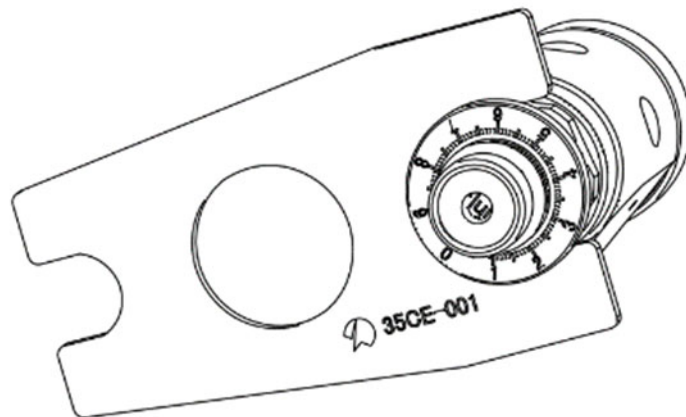
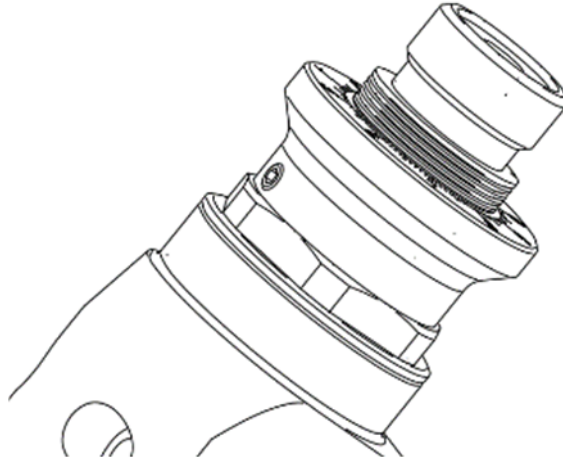
(1) Removing the manifold

Remove No. 9 hexagon socket head cap screw (03-80545) at the top of the gun.



(2) Removing the paint valve

- ① No.12 Loosen the cap (1826-017) to the limit.
- ② No.9 Hang the special plate wrench (35CE-001) (Hex32) of the accessory tool on the spring retainer (1826-013), and remove the paint valve from the gun body.

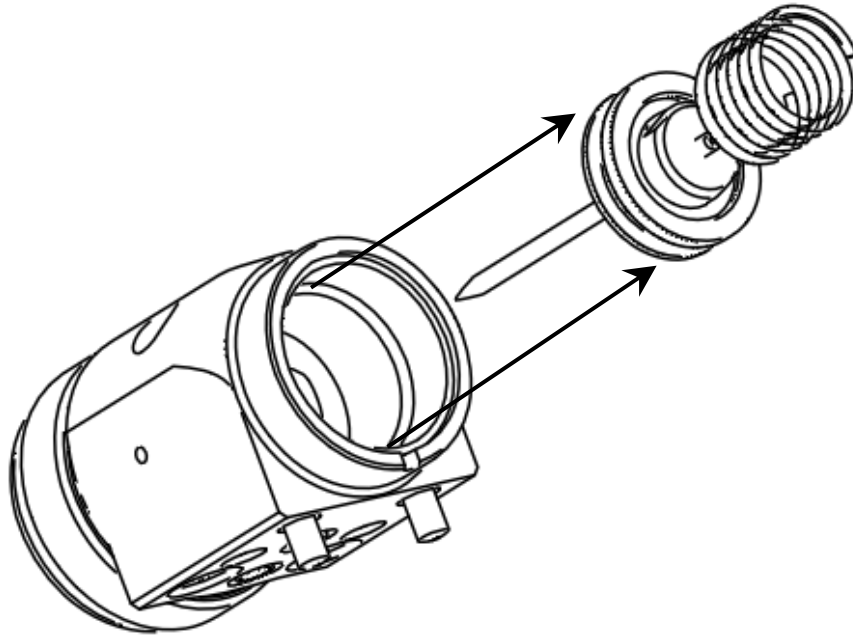


Note

Be careful not to lose Spring No.8 (1826-012) when removing the paint valve from the gun body.

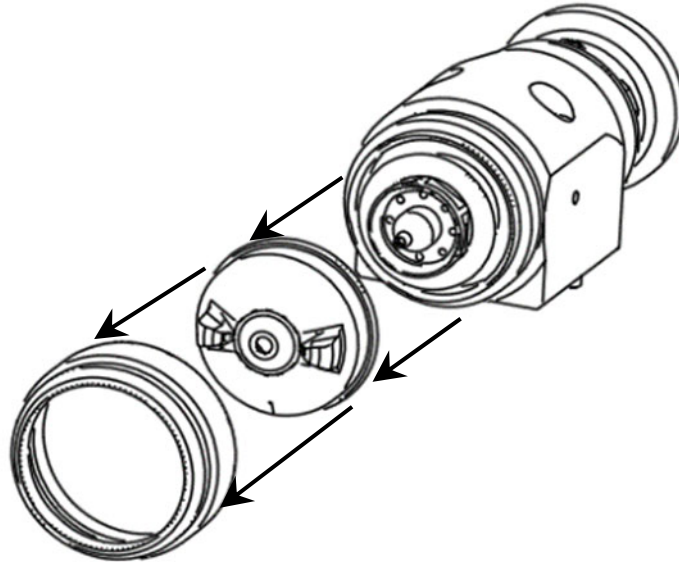
(3) Removing the Piston and Needle

Pull out No.6 piston (1826-008) No.5 needle (1826-007) from the rear of the gun using a radio pliers, etc.



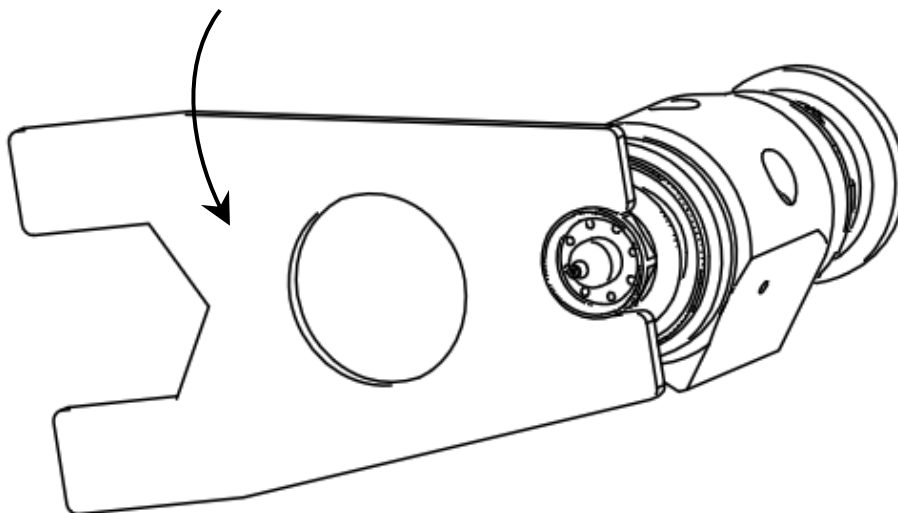
(4) Removing the air cap

Remove the No.4 retainer (1826-006) fixing the No.A air cap to the gun body, and remove the air cap.



(5) Removing the paint nozzle

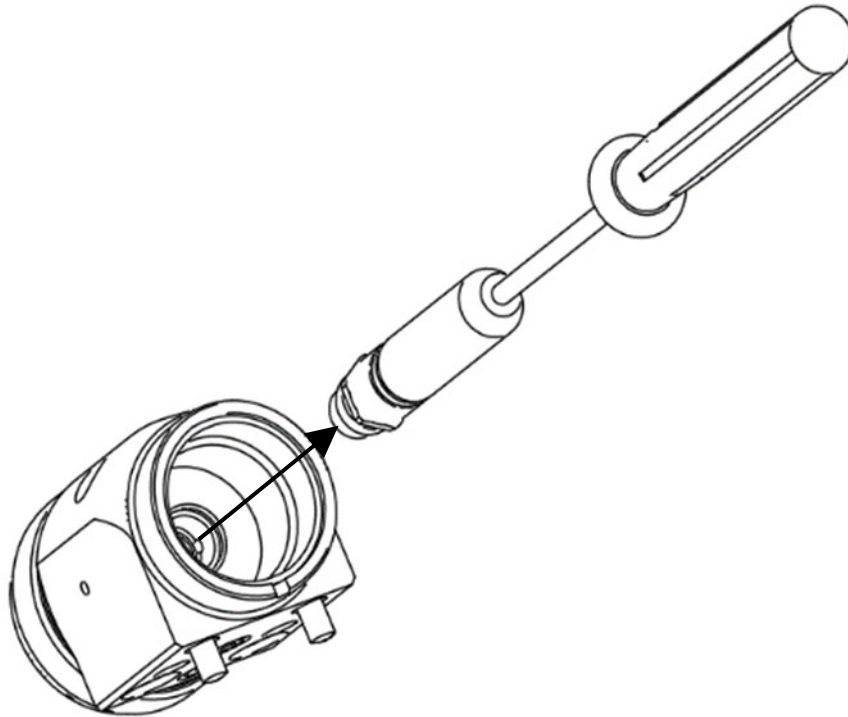
Remove No.2 paint nozzle from the gun body using the special plate spanner (35CE-001) (Hex18) of the accessory tool.



(6) Removal of packing case sets

Remove packing case set No. 3 (1826-004) from the gun body using the box spanner (332-130) of the accessory tool.

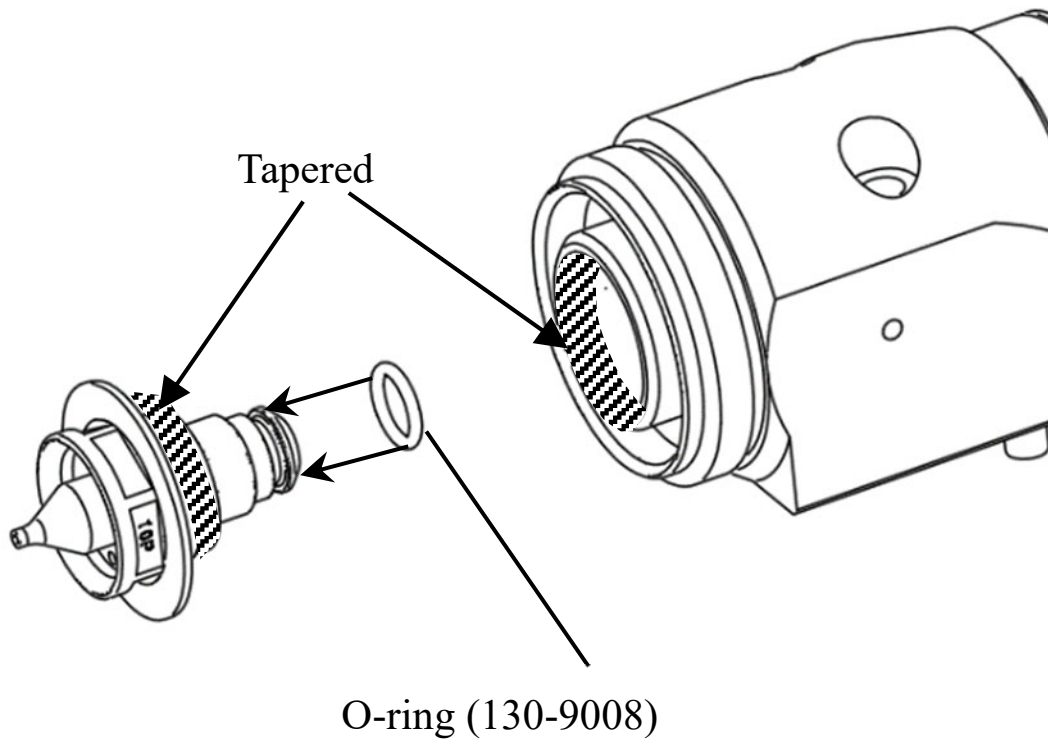
The packing case set will be deformed when disassembled. It will be replaced by the assembly.



Mounting method

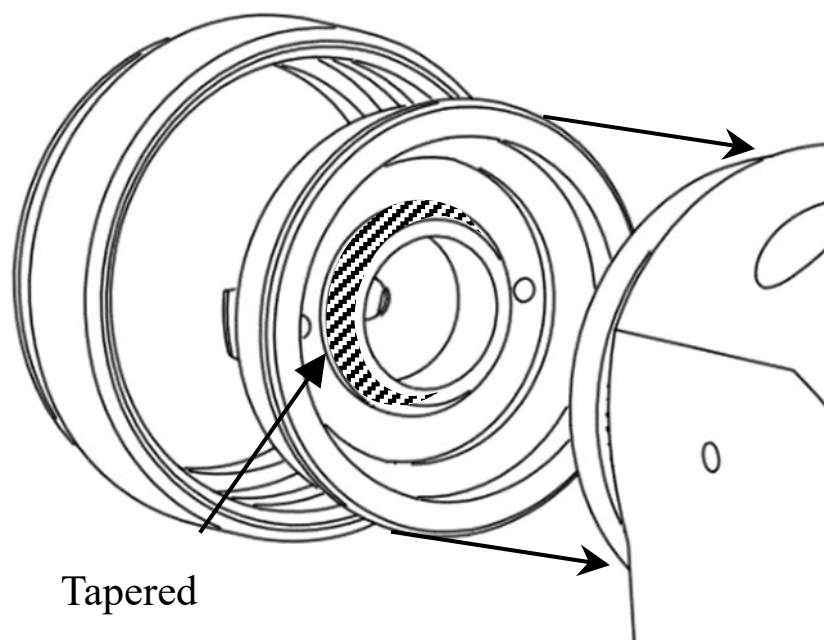
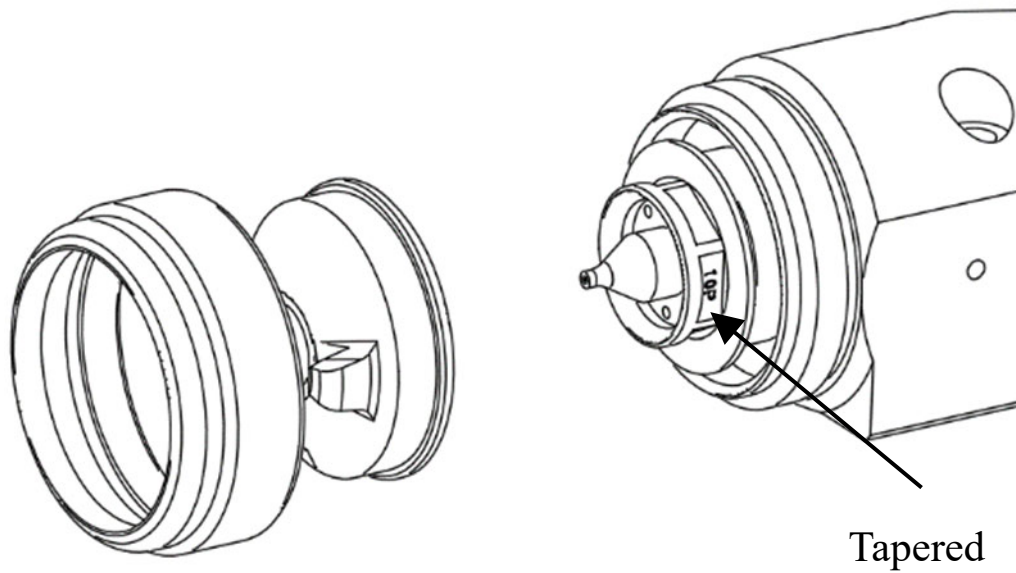
(1) Installing the Paint Nozzle

- ① When attaching No.2 paint nozzle, make sure that there is no dust or scratches on the tapered part below. Also, be sure to attach No. 17 O-ring (130-9008).



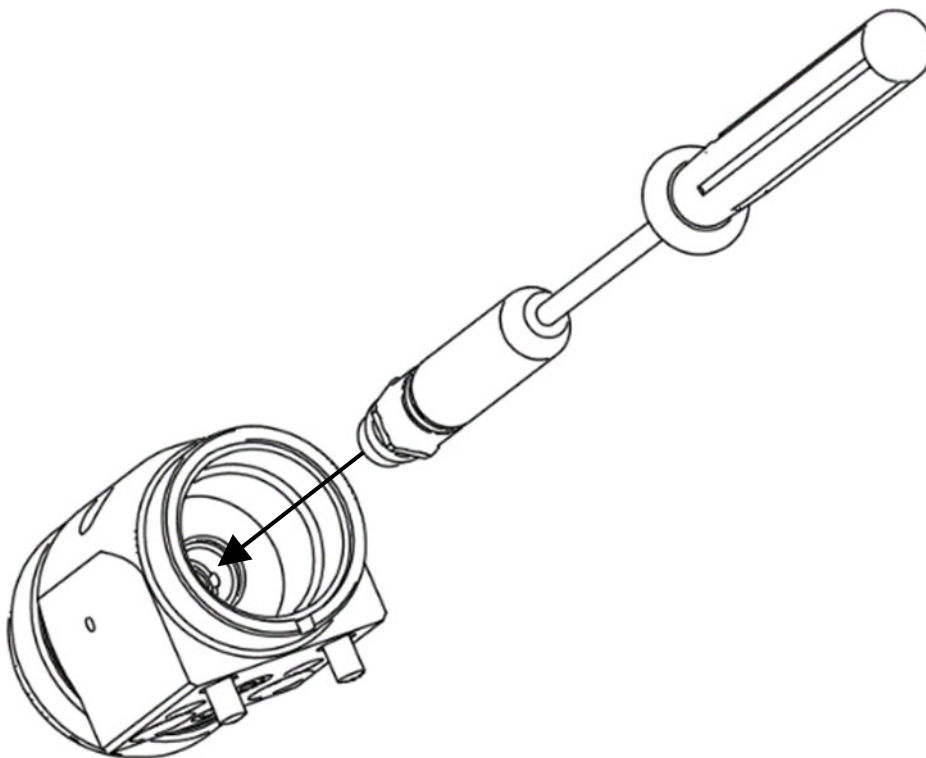
(2) Replacing the Air Cap

When attaching the air cap, make sure that there is no dust or scratches on the tapered portion shown below.



(3) Installing the packing case set.

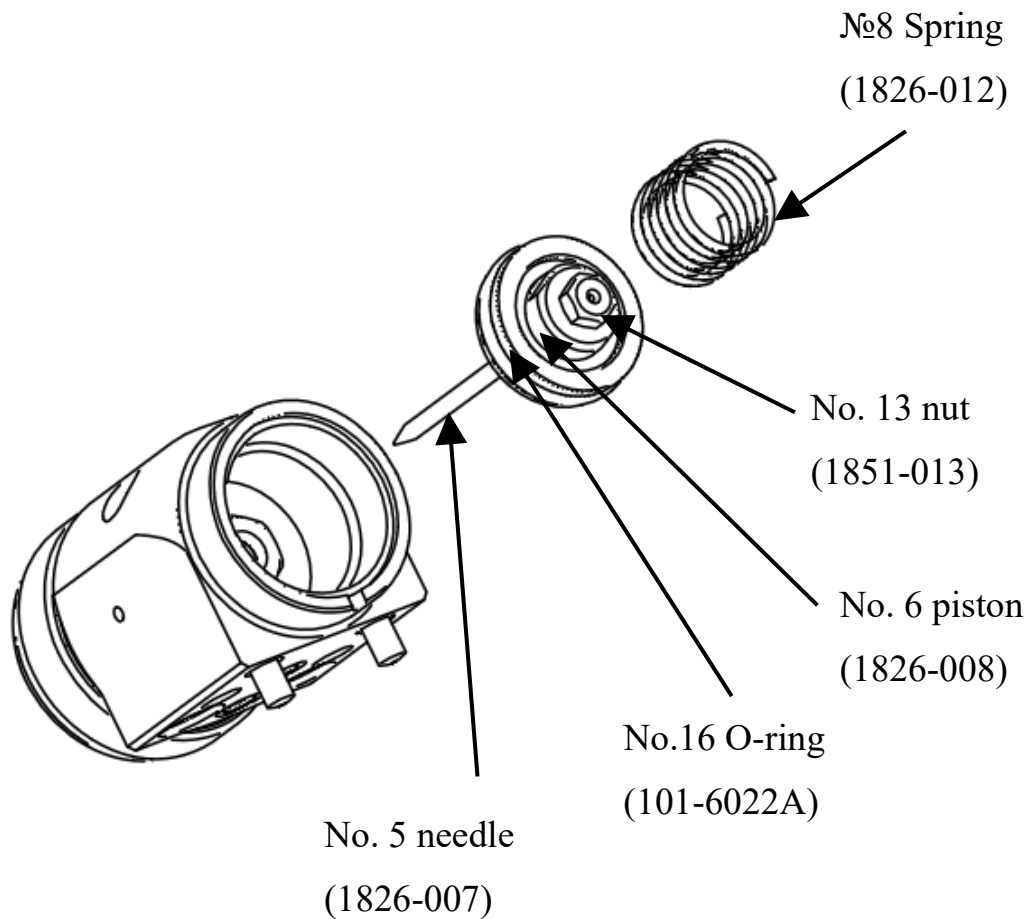
Attach packing case set No. 3 (1826-004) to the gun body using the box spanner (332-130) of the accessory tool.



No.7 needle
(1826-007)

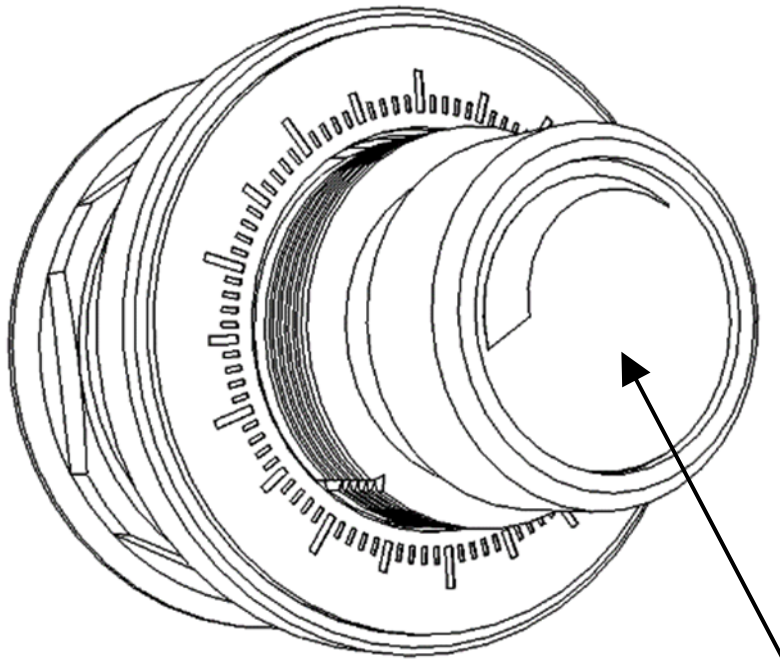
(4)Installing the piston and needle

Insert No.5 needle (1826-007), No.6 piston (1826-008), No.16 O-ring (101-6022A), No.13 nut (1851-013), No.8 spring (1826-012) into the body assembly.



(5) Preparing to Install Paint Valves

- ① №12 Loosen the cap (1826-017) slowly until it stops.



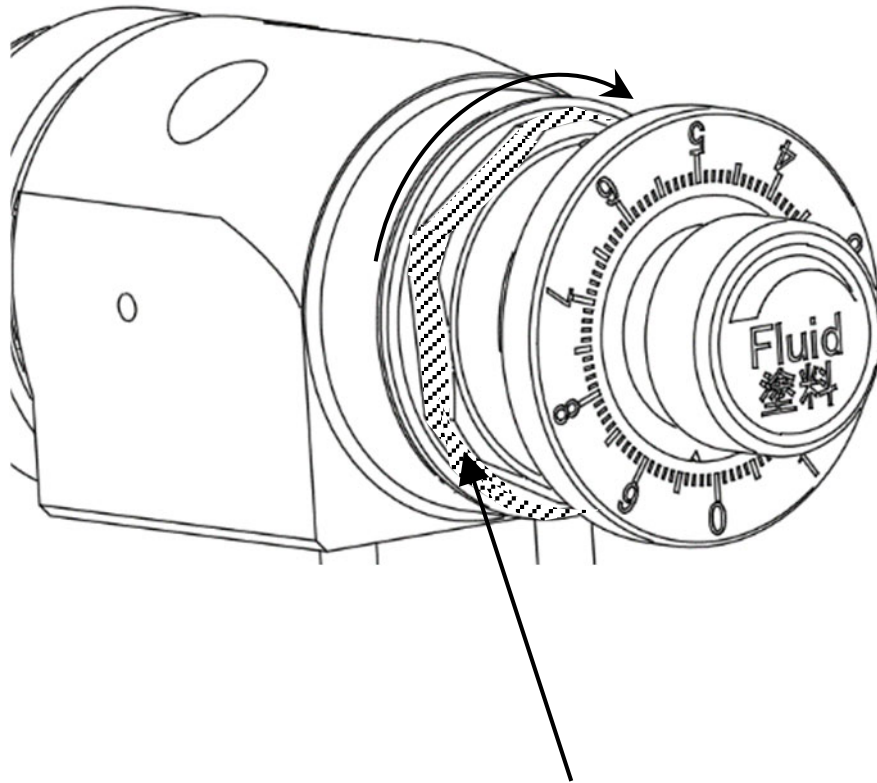
№12 Cap
(1826-017)



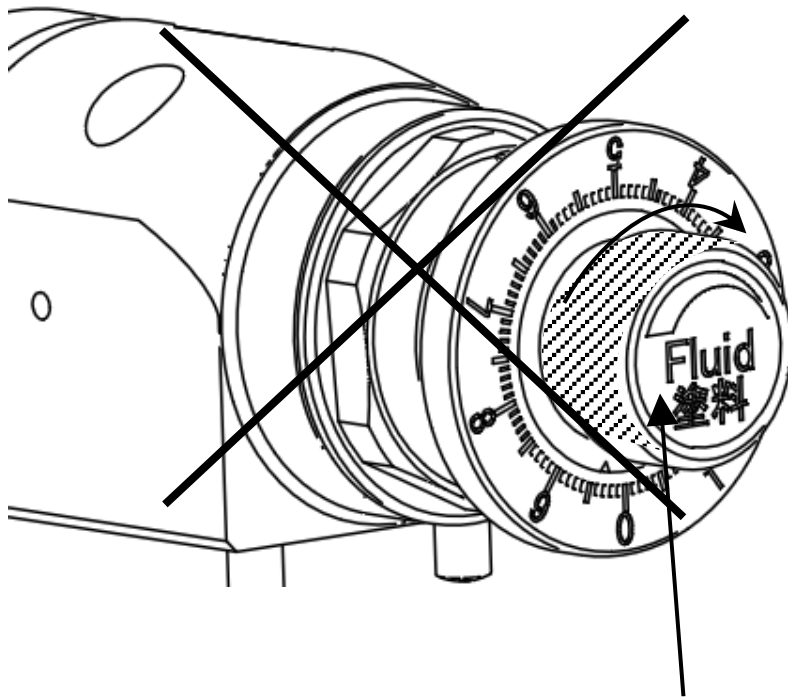
Note

Be sure to loosen the cap until it stops with the valve fully open. Otherwise, the paint nozzle and needle may be damaged and the seat may become

②№9 Hold HEX32 of the spring retainer (1826-013) and temporarily tighten it to the gun body.



№9 Spring retainer
(1826-013)HEX32



No.12 Cap
(1826-017)

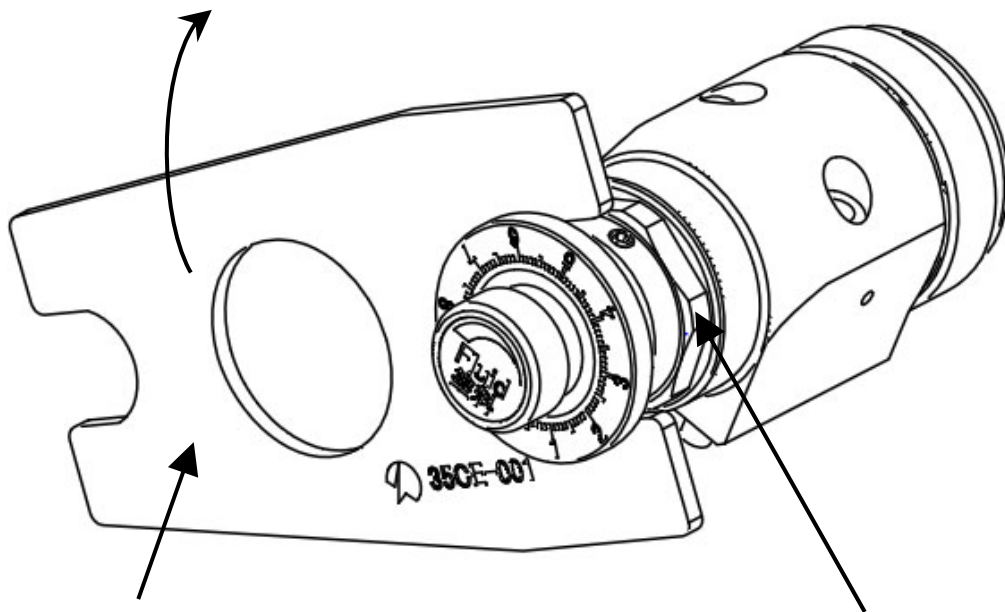


Note

Be sure to hold the spring retainer (HEX32) and tighten it temporarily to the gun body. If you hold the cap and tighten it, the needle stroke will not open completely, and the paint nozzle and needle may be damaged during assembly.

(6) Paint Valve Installation

№9 Hang the special plate wrench (35CE-001) (Hex32) of the accessory tool on the spring retainer (1826-013), and attach the paint valve to the gun body.



Specialized plate wrench
(35CE-001) for accessory tool

№9 Spring retainer
(1826-013)

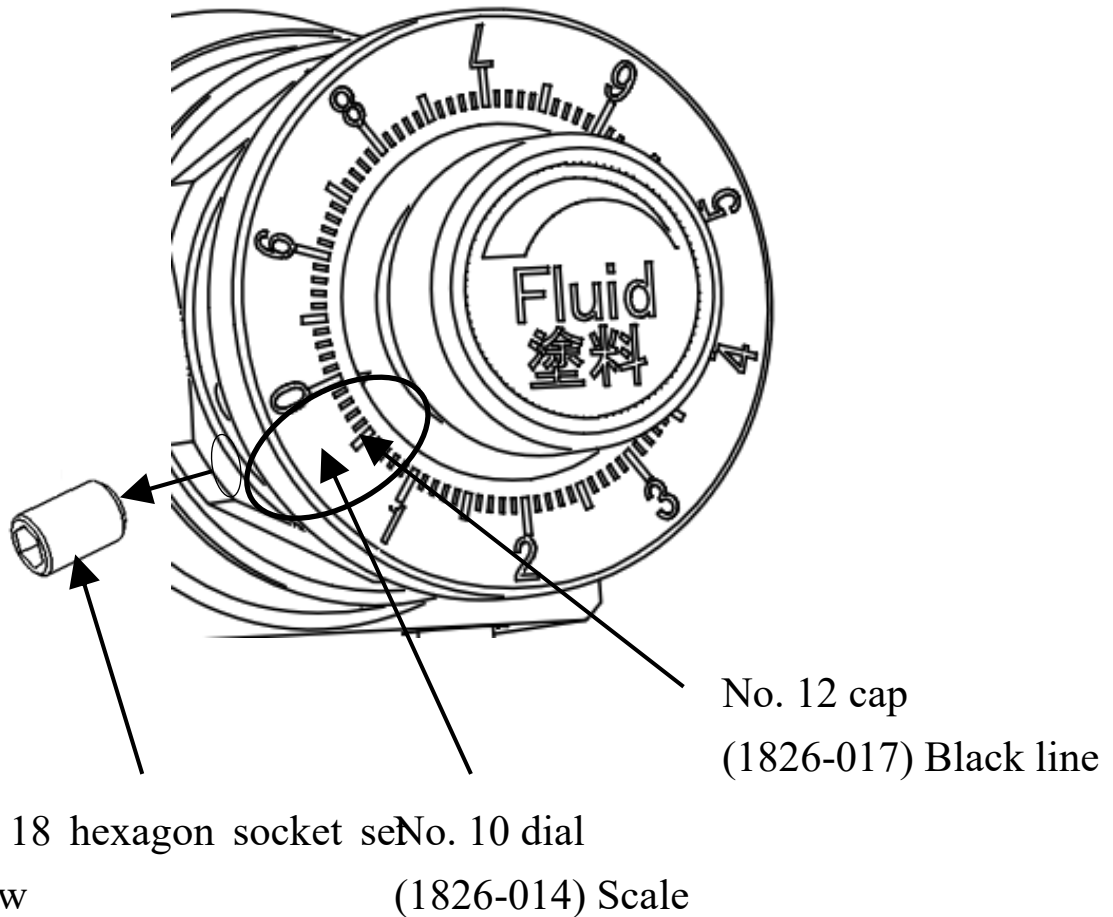


Note

When installing the spring retainer, be sure to use the accessory tool. Mounting with other than the supplied tool may damage the HEX part of the spring retainer.

(7) Zero point adjustment

- ① Tighten cap No. 12 (1826-017) slowly until it stops.
- ② Loosen two No. 18 hexagon socket set screws (83-70404) and align the position of No. 10 dial (1826-014) with the black line of No. 12 cap (1826-017).



Note

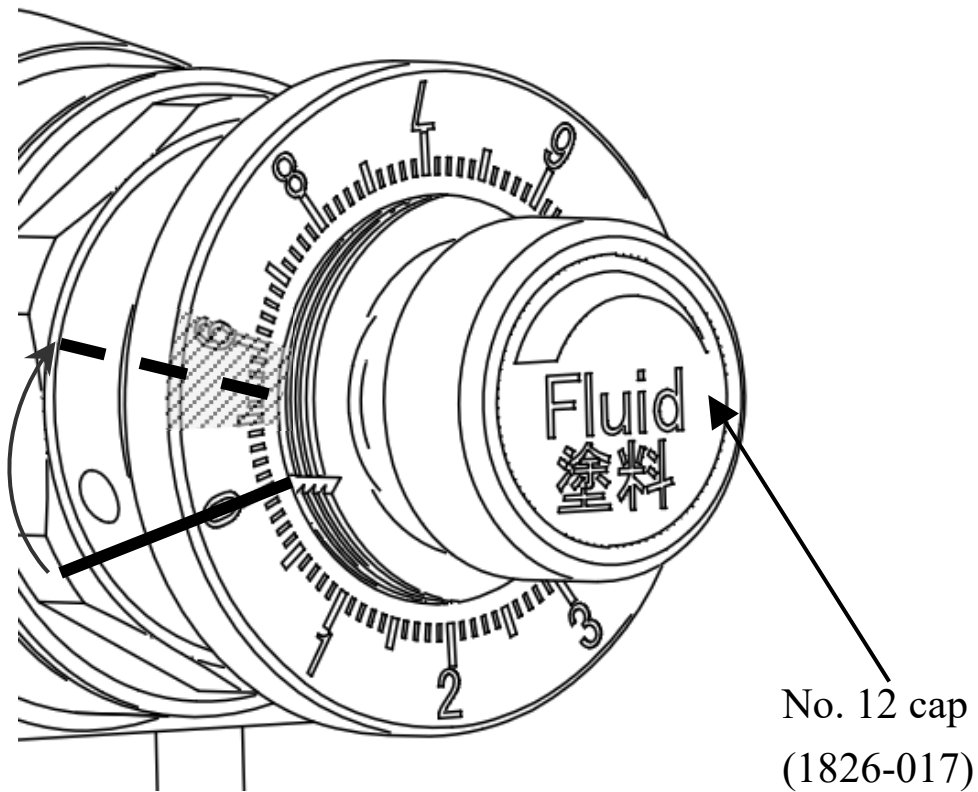
Do not tighten the cap to align the scale in ②. Too much tightening may damage the paint nozzle/needle and prevent the seat from seating.

(8)Improvement of sheet quality

After adjusting the zero point, slowly tighten the No.12 cap (1826-017) black wire between 5 and 10 graduations.



Range of 5 to 10 graduations



Note

If the cap is tightened outside the range of 5 to 10 graduations, the needle and paint nozzle will not be pressed properly, and the sheet may become

(9) Adjusting the dial position

Loosen the two No. 18 hexagon socket set screws (83-70404), align the 0-engraved part of No. 10 dial (1826-014) with the black line position of No. 12 cap (1826-017), and fix with No. 18 hexagon socket set screws (83-70404).

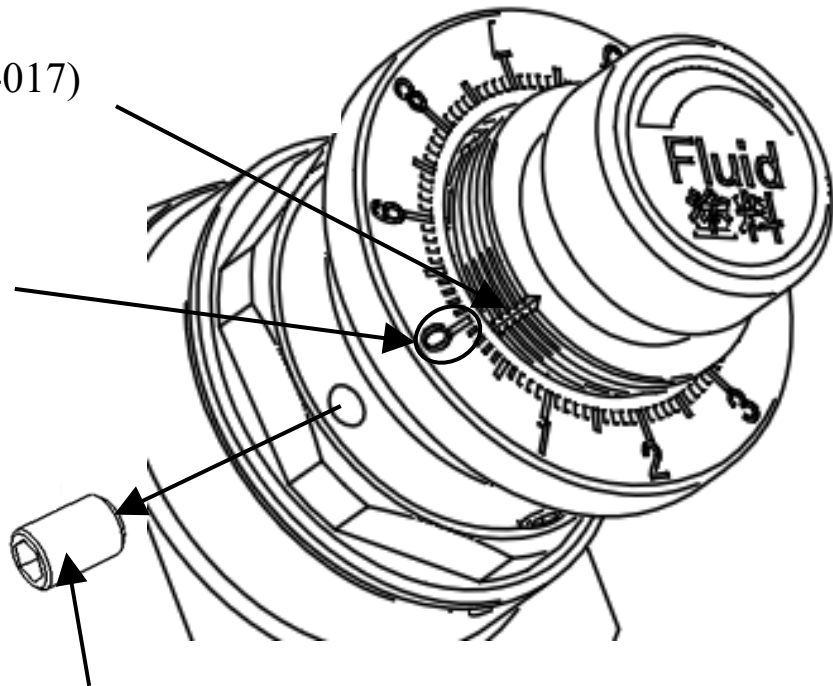
No. 12 cap

Black line (1826-017)

No. 10 dial

(1826-014)

0 engraved part



No. 18 hexagon socket set
screw



Note

Never tighten from the 0 position after adjusting the dial. Otherwise, the paint nozzle and needle may be damaged and the seat may become impossible.

Table 1 AGB50M (1851-1)/AGB51M (1852-1) Gun Body Bill of Materials

Number	Part Number	Product name	Quantity	Remarks
1	1851	AGB50M (gun body)	1	Set product
	1852	AGB51M (gun body)	1	Set product
2	1851-102	Manifold	1	
3※	130-9006	O-ring	2	
4※	130-9009	O-ring	2	
5※	139E-021	Spacer	2	
6	30G-0801	45-degree elbow union	2	
7	3210-101	Elbow nipple	2	
8	378-0801	Hexagon socket head	1	
9	03-80545	Hexagon socket head cap	2	
10	83-70606	Hexagon socket set screw	1	

●When using non-circulating type, prepare a plug (1851-100) and a hexagon socket head plug (244-2001) separately.

※Marks indicate consumables. Prepare spare parts according to the conditions of use.

AGB50M
1851

AGB51M
1852

※ 1851<AGB50M> and 1852<AGB51M> differ only in No,2 and A.

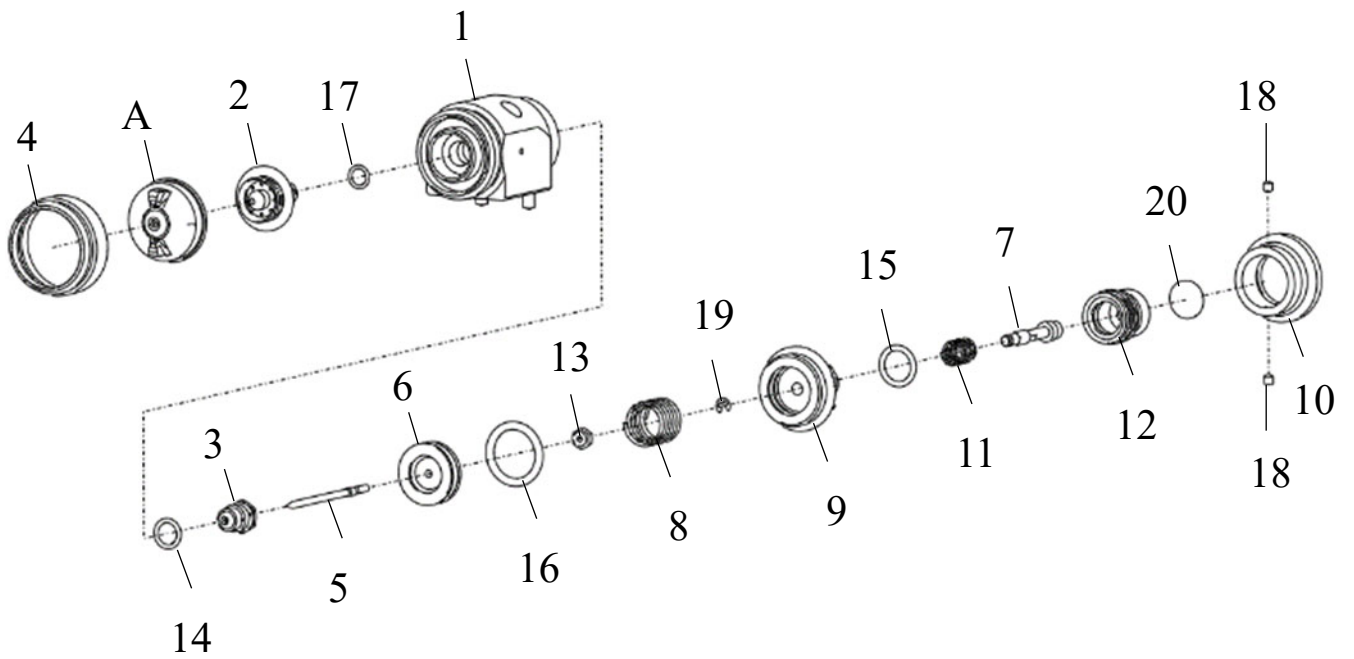


Table 1 AGB50M (1851)/AGB51M (1852) Bill of Materials

Number	Part Number	Product name	Quantity	Remarks
1	1851-001	Body (with pin)	1	Set product
2※	1826-003	Paint nozzle	1	AGB50M
	1827-003		1	AGB51M
3※	1826-004	Packing case set	1	Set product
4	1826-006	Retainer	1	
5※	1826-007	Needle	1	
6	1826-008	Piston	1	
7	1826-011	Shaft	1	
8	1826-012	Spring	1	
9	1826-013	Spring retainer	1	
10	1826-014	Dial	1	
11	139E-015	Spring	1	
12	1826-017	Cap	1	
13	1851-013	Nut	1	
14※	101-6010	O-ring	1	
15	101-9014	O-ring	1	
16※	101-6022A	O-ring	1	
17※	130-9008	O-ring	1	
18	83-70404	Hexagon socket set screw	2	
19	57-70300	E type retaining ring	1	
20	331C-001	Valve nameplate	1	
21	35CE	Accessory tool	1	
A	(Separate arrangement)	Air cap	1	See Table 2

●Prepare a cover (139E-031) of the dial (1826-014) according to the usage conditions.

※Marks indicate consumables. Prepare spare parts according to the conditions of use.

Table 2 Air Cap (Optional) Compatibility Table

Gun type	Model	Part Number	Pattern width	Applicable nozzle part number
AGB50M	HN400A	15F9-001	150mm	1826-003
AGB51M	HN600A	15F9-101	300mm	1827-003
	HN800A	15F9-201	400mm	

※ The pattern width is a number under the following conditions.

Splay Distance 250mm

Spray amount 150 mL/min(HN 400 A)

250mL/min(HN600A)

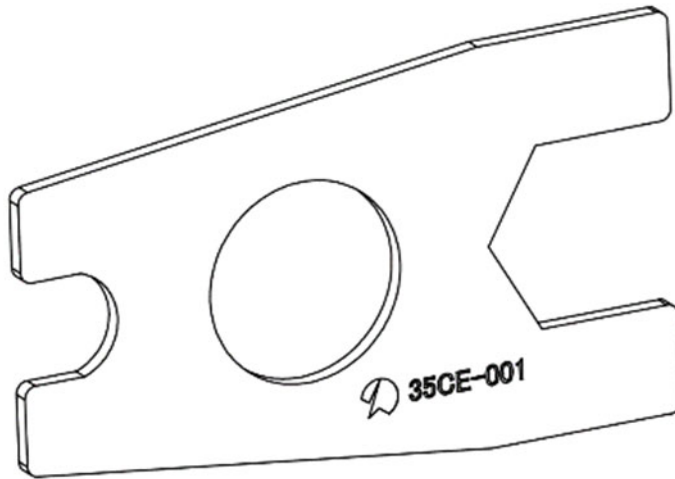
350mL/min(HN800A)

Note: The pattern width may vary depending on the paint, viscosity, and amount of spray.

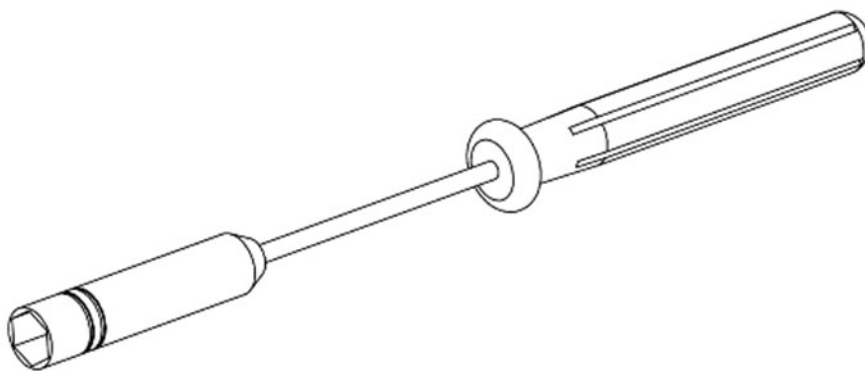
Accessory

35CE

Specialized plate wrench Part No. : 35CE-001



Box spanner Part No.: 332-130



Please use record the details that you conduct a maintenance service, such as replacement of a part, tear-down cleaning, post-failure repair, etc.

Equipment name			Pearl gun <AGB50M> Microace <AGB51M>	Purchase date:		
Date of service			Portion worked on	Description	Result	Who serviced
						In-house / Dealer / Asahi Sunac
						In-house / Dealer / Asahi Sunac
						In-house / Dealer / Asahi Sunac
						In-house / Dealer / Asahi Sunac
						In-house / Dealer / Asahi Sunac
						In-house / Dealer / Asahi Sunac
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						In-house / Dealer / Asahi Sunac
						In-house / Dealer / Asahi Sunac
						In-house / Dealer / Asahi Sunac

Note: Due to continuous improvements and modifications, the configurations specified herein are subject to change without prior notice.

ASAHI SUNAC CORPORATION (the “Company”) shall provide the original purchaser (the “Purchaser”) with warranty service for a period of 6 months from the date of purchase of the product, as follows:

- Should you find defects in design or workmanship with regard to parts, ship them back to the Company, with freight prepaid. The Company shall repair or replace the parts free of charge and reimburse the freight charges, provided that, as a result of an inspection and investigation of the parts conducted by the Company, the defects are deemed to be attributable to the factors within the Company’s responsibility.
- In the following cases, free after-sales service is not provided.
 1. Failure resulting from an inappropriate method of installing this equipment.
 2. Failure resulting from a use method not conforming to this instruction manual or mishandling.
 3. Failure resulting from insufficient maintenance management of this equipment and incorrect handling such as non-conformance to the procedures specified in this instruction manual.
 4. Failure resulting from unauthorized alteration or structure change of this equipment without the Company’s consent.
 5. Failure due to force majeure such as earthquake, disaster, flood disaster or lightning.
 6. Warranty for consumables worn or deteriorated even in the case where this equipment is used correctly.
 7. Repair after the machine has been used outside Japan, and shipping cost.
 8. In addition to the above, failure due to circumstances beyond our control.
- As for items such as parts purchased by the Company from another manufacturer, the warranty of that manufacturer shall apply.
- As for any parts deemed to be defective, the Company shall not be held liable for any expenses beyond the provision of repair or replacement parts free of charge.
- The Company shall not be held liable for any damage to the Purchaser caused by factors not attributable to the Company, such as misuse of product, etc.

[MEMO]

[MEMO]

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- When a transfer of title of this equipment takes place, please see to it that this Operation and Maintenance Manual is handed over to the new owner.
 - This equipment is manufactured in compliance with the Laws and Regulations of Japan.
In the rare eventuality of this equipment being used outside Japan, compliance with the safety standards of the relevant countries is of course mandatory.
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4th Edition: November 26, 2025

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