

Air Cap HN Series

1

Specifications

1.1 Function of an air cap

An air cap, when attached to the tip of a painting machine, serves to atomize paint and force it into a particular pattern with the help of compressed air.

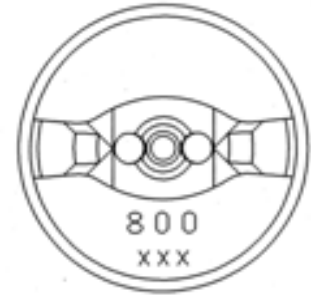
1.2 Appearance of each air cap



400 Air cap



600 Air cap



800 Air cap

"XXX" indicates a manufacturing number.

1.3 Product specifications

Name	400 Air cap	600 Air cap	800 Air cap
Model	HN400	HN600	HN800
Part No.	15F8-001	15F8-101	15F8-201
Specifications	Small-size pattern	Medium-size pattern	Large-size pattern

1.4 Compatible guns

Gun Type	Air electrostatic hand gun			Air spray hand gun	Automatic air electrostatic spray gun	
	HB5000	HB6000	HB-X3	MGB50	EAB500	EAB400
HN400	○	○	○	○	○	○
HN600	○	—	○	○	○	○
HN800	○	○	○	○	○	○

NOTE

For information on paint pressure feed devices, paint regulators, and guns, see their respective instruction manuals.

2

Handling of an Air Cap

2.1 Attaching the air cap

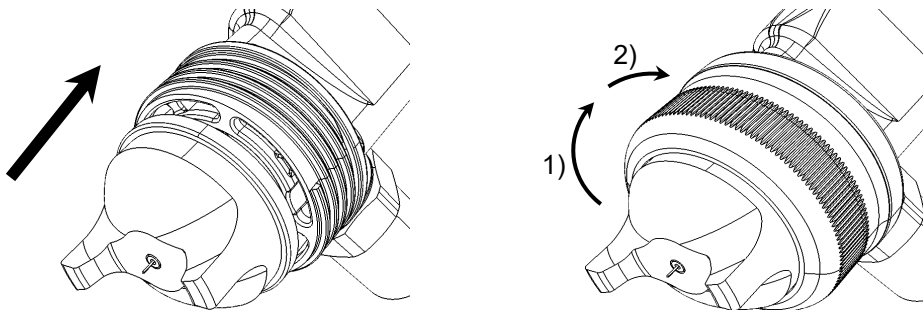
- (1) Firmly attach the air cap to the nozzle by hand.

When attaching it, use caution to prevent the electrode pin from bending due to the air cap.

Also, make sure that the tip of the gun is directed downward during this operation. If not, thinner or solvent may enter the gun.

- (2) Put the retaining nut assy over the air cap.

- 1) Tighten the retaining nut assy tightly and then adjust the angular orientation of the air cap to the direction of obtaining the desired spray pattern.
- 2) Tighten more the retaining nut assy to secure the air cap completely.



2.2 Removing the air cap

To remove the air cap, perform the attachment procedure in reverse order.

CAUTION

The following actions may cause damage to the devices:

The internally threaded portion of the nozzle mounting joint, which is made of plastic, may become damaged if tightened too much. If the air cap is subjected to high impact such as dropping it on the floor, it may become damaged.

Great care must be taken when desorbing.

3








Daily checks

Make the daily checks described below.

3.1 Spray pattern check

Before the start of daily operations, spray some paint onto a test piece, etc. and check the spray pattern for defects as described below.

Two or more defects may occur simultaneously in the case of a paint fault.

What to check	Description	Spray pattern	Typical cause
1. Correct spray pattern	Uniform spray pattern with no thickly painted spots.		
2. Noticeable spray pattern contrast	There is at least one thickly painted spot in the right/left half of the spray pattern.		Pattern air holes are clogged. Atomizing air holes are clogged.
3. Curved spray pattern	Entire spray pattern is curved. (convex or concave)		Pattern air holes are clogged. Air cap is deformed.
4. Slanted spray pattern	Spray pattern is inclined 5% or more with the respect to the orientation of the air cap. (rightward/leftward/upward/downward)		Air cap is inclined in a particular direction. Pattern air holes are clogged.
5. Split spray pattern	There is a noticeable difference in contrast between the right and left halves of the spray pattern.		Pattern air flow rate is too high. Atomizing air flow rate is too low. Atomizing air holes are clogged.
6. Coarsely painted at the edge of the spray pattern.	Thickly painted in the center and coarsely painted at the edge.		Atomizing air flow rate is too low. Atomizing air holes are clogged.
7. Narrow spray pattern	90% or less of the width of a standard spray pattern.		Pattern air flow rate is too low. Pattern air holes are clogged.

Such a problem(s) may also occur due to a worn/damaged air cap, needle electrode assy, or paint nozzle assy.

For information on the needle electrode assy and paint nozzle assy, see the instruction manuals for the electrostatic spray gun used.

3.2 Air cap contaminated with paint

(1) Air cap surface

If the surface of the air cap is contaminated with paint, clean it using a soft cloth or a brush with cleaning solvent.

(2) Air cap holes

If the air cap holes are clogged with paint, submerge the air cap in cleaning solvent and then remove the contaminants using air blows.

If the contaminants cannot be removed, replace the air cap.



CAUTION

The following actions may cause damage to the devices:

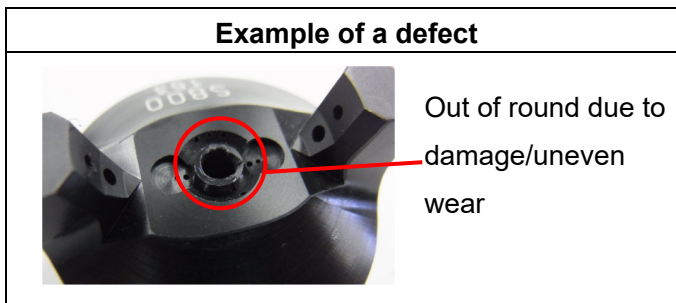
If the air cap is submerged into cleaning solvent for a long period of time, it may deform.

If you use a metal brush such as brass for cleaning the air cap, which is made of plastic, it may become damaged.

If you use a pointed tool, such as a drill, for cleaning the air cap holes, they may become damaged.

(3) Air cap appearance check

Visually check the air cap holes.



If any of the air cap holes are found to be out of round due to damage, replace the air cap.

- If you assign or transfer this machine to a third party, be sure to attach this document to the machine.
- This machine was manufactured in accordance with Japan's legal requirements.
If you use this machine outside Japan, you will need to observe all the safety standards in the country where it is used.

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