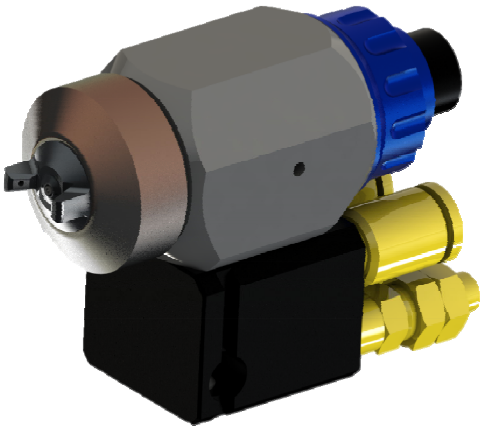
ASAHI SUNAC

Operation and Maintenance Manual

Proximity Air Spray Automatic Gun Dedicated to Rotary Coating

PGB1S
PGB1RA



Ec'Coater™ エコーター

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 suchtime as the product is no longer being used. 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.

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Introduction

Thank you for purchasing our proximity air spray automatic gun dedicated to rotary coating <PGB1S/PGB1RA>.

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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Content

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1 For Your Safety

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 airatomization 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 1kΩ or less for metal (1MΩ 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.

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《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.

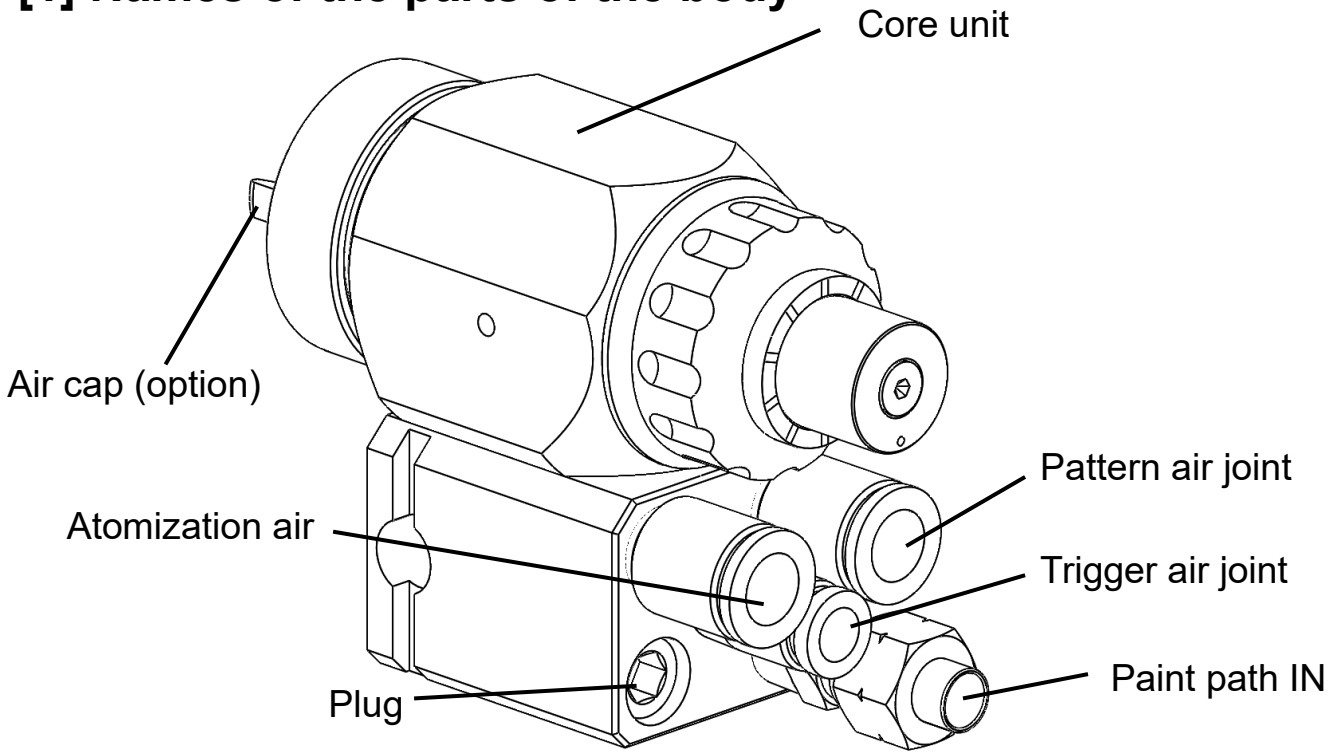
- **Check frequently for paint leaks, air leaks, and loose screw.**

● **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.

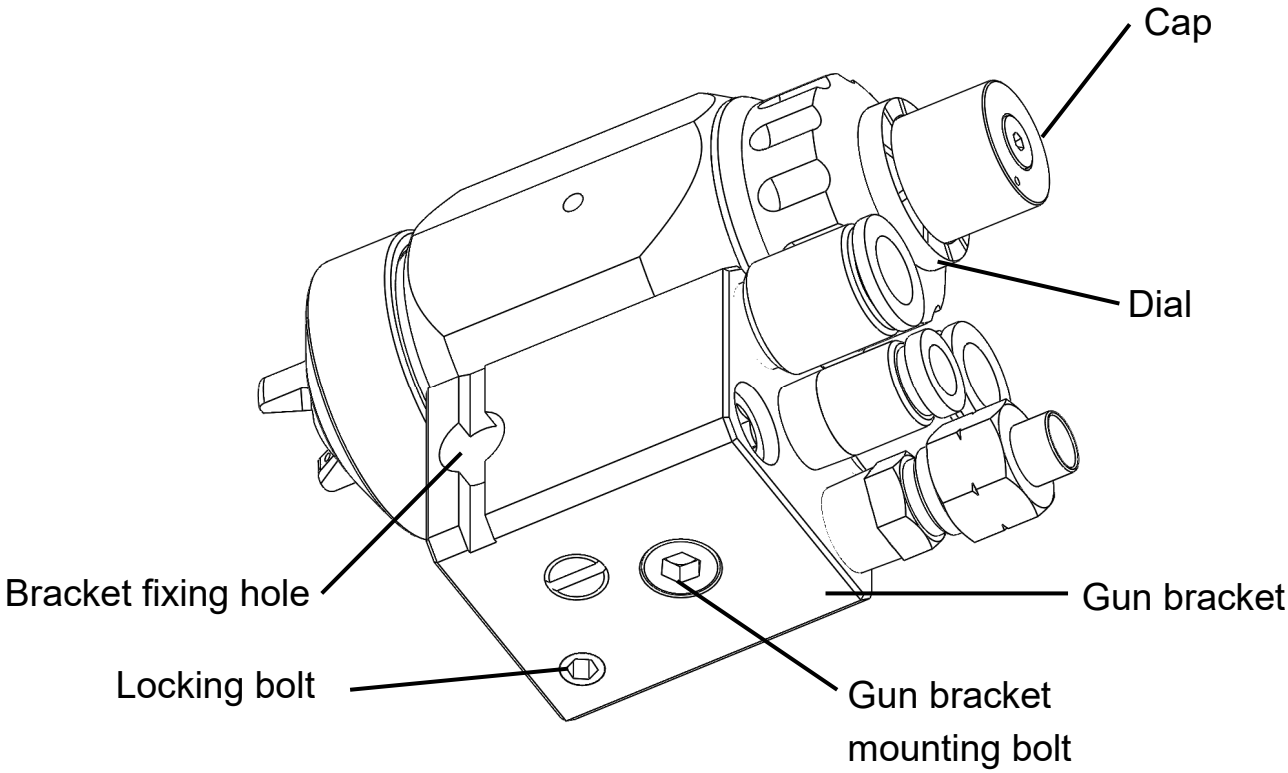
● **When disposing of this product, please dispose of it in accordance with the laws of your country.**

2 Overview of the Equipment

[1] Names of the parts of the body



(Paint path OUT in the case of the circulation mode)



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● **Air cap**

Jets paints, atomization air, and pattern air to atomize paints and form a paint transfer pattern in the paint spray stream.

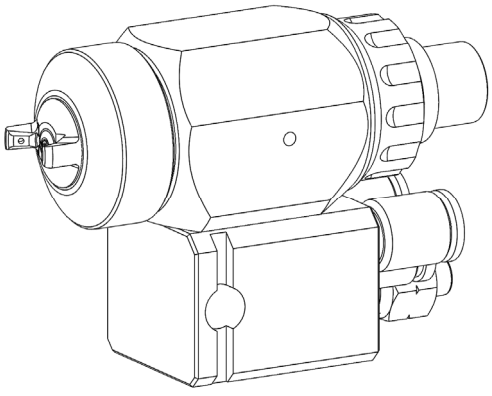
● **Dial**

Capable of fine-adjusting the jetted amount of paint by changing the needle stroke length of the paint valve.
A turn of the cap changes the needle stroke length by 0.5 mm.

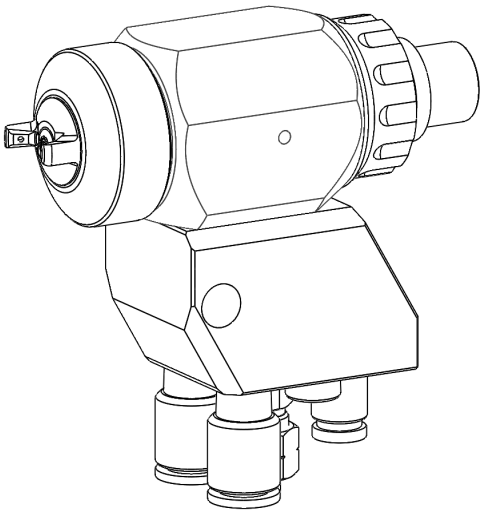
● **Gun bracket mounting bolt**

The core unit and the gun bracket can be easily attached and detached with a bolt.
This enables you to easily perform maintenance without changing the fixing position of the gun.

● **Gun bracket types**



Straight type
<PGB1S>



Rectangular type
<PGB1RA>

3 Specifications

Proximity air spray automatic gun dedicated to rotary coating <PGB1S/PGB1RA>

Model	PGB1S	PGB1RA
Part No.	1853	1854
Nozzle diameter	Φ0.8	
Jetted amount	During coating Max. 100 mL/min (At paint viscosity of 20 mPa·s)	
Built-in valve	Trigger valve/Arrowhead needle system	
Air tube	Pattern air: Maximum flow rate (Φ8 × 6) Max. 100 L/min (ANR) Atomization air: Maximum flow rate (Φ8 × 6) Max. 100 L/min (ANR) Trigger valve: Φ6 × 4	
Gun mounting hole	Φ8.2 mm	
Maximum paint pressure	0.6 MPa	
Maximum air pressure	0.6 MPa	
Dimensions	L87 × W33 × H61 mm	L87 × W33 × H94 mm
Mass	300 g	330 g

4 Operation Procedure and Precautions

[1] Paints

(1) Adjustment of the viscosity of the paint
Adjust the viscosity of the paint in accordance with the coating conditions.
In general, adjust it to a range of about 20 to 40 mPa·s.

(2) Operate the paint pump.
(See the instruction manual for the paint pump.)
If air remains in the paint hose, the paint will become a pulsating state at the time of paint jetting, causing the jetted state of the paint to be unstable. Thoroughly purge the air inside the paint hose.

(3) Adjusting the jetted amount of paint
Adjust the jetted amount of paint with the needle pull distance adjustment dial on the back of the gun.
The adjustment dial can adjust the pull distance by 0.5 mm when it is given a full turn.
Before making this adjustment, turn off the air for gun opening/closing.
Do not adjust the pull distance while jetting the paint (it will cause the adjustment screw to become worn early). Supply an air pressure for gun opening/closing of 0.3 to 0.5 MPa.

[2] Atomization air pressure

(1) The atomization air pressure can be set significantly lower than that of a regular air spray gun, so that paint transfer efficiency will be improved.
Increasing the atomization air pressure will make paint particles fine to some extent and improve finished texture, but at the same time, paint transfer efficiency will decrease and rebound will increase. Thus, do not increase the atomization air pressure more than necessary.

(2) Adjust the atomization air pressure by operating the regulator for atomization air pressure adjustment with the air being jetted from the nozzle. In general, adjust the atomization air pressure within the range of 0.05 to 0.2 MPa.

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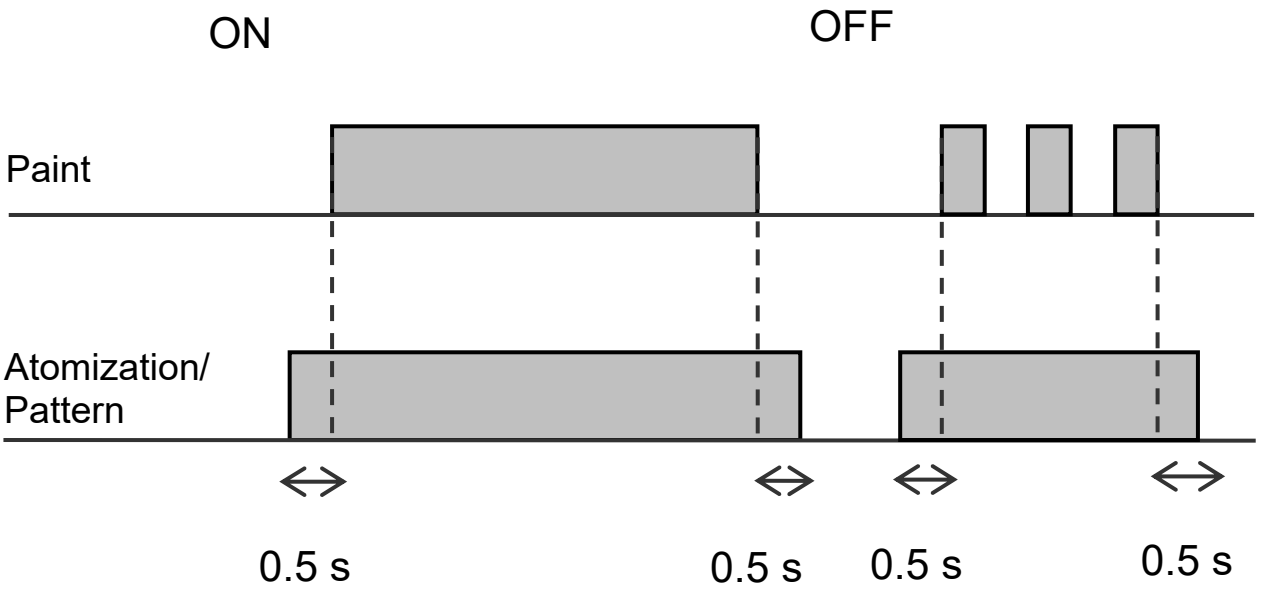
[3] Pattern change air pressure

Adjust the atomization air pressure by changing the spray pattern width while spraying the paint by operating the air regulator for pattern changes.

[4] Adjusting spraying timing

- To prevent atomization defects when the paint is jetted, jet/stop atomization/pattern air by shifting timing as shown in the figure below for approximately 0.5 second before and after spraying.



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[5] Handling during the suspension of and at the end of work

- Procedure for cleaning the nozzle
  Be sure to clean the nozzle during the suspension of and at the end of work.
  (1) Stop the jetting of the paint and air.
  (2) Using a brush (brush made of horsehair or animal or plant hair) impregnated with a solvent, dissolve and clean away the paint adhering to the surface of the nozzle.
  If the paint cannot be removed with a brush, immerse the nozzle in a solvent for several minutes and rub it off while dissolution.
  (3) After cleaning, manually jet atomization air to discharge the solvent that flowed into the air path.

[6] Precautions for operation

⚠ CAUTION

- **Since the nozzle portion is considered to be the lifeline of the coating system, handle it with extreme care to prevent it from falling and getting damaged.**
- **For compressed air to be supplied to the paint gun, use clean air filtrated through an air dryer, an air filter (3 to 5 μm), and an oil mist separator (0.03 to 0.01 μm).**
- **Be sure to filtrate the paint before use.**
- **Whenever paints likely to precipitate are used, thoroughly clean with a solvent so that no paint remains inside after use.**

5 Maintenance and Periodical Inspections

(The numbers in the text are heading numbers or part numbers shown in the exploded views in "9 Components.")

⚠ CAUTION

Before performing maintenance work, release the pressure of air and paint.

[1] Nozzle Maintenance

(1) Detach, disassemble, and clean the nozzle once a month to remove the paint debris that has entered the air path pore.

(2) When two-component paints are used, the nozzle firmly stuck by hardened paint may get damaged if an attempt is made to forcibly disassemble the nozzle. The nozzle shall be securely tightened before supplying a two-component paint. In addition, thoroughly clean the nozzle with a solvent so that no paint remains inside after use.

(3) If the inside of the nozzle is worn, the paint will leak even when the trigger is set to the off position.
The nozzle in this state needs to be replaced. When replacing the nozzle, be sure to replace the needle with a new one as well.

[2] Needle and Nozzle Maintenance

When attaching and detaching the nozzle without detaching the needle, be sure to loosen the paint adjustment valve at the back of the gun to the limit, turn on the trigger air, and pull the needle.

⚠ CAUTION

If the nozzle is attached and detached without pulling the needle, the nozzle and the needle may get damaged and become unable to seat.

[3] Gun Maintenance

(1) When cleaning the air cap or the paint nozzle with the nozzle attached to the gun, release the atomization air and the pattern air after cleaning, and discharge the solvent that has entered the air path.

⚠ CAUTION

When the gun is mounted facing upward and with a tilt, clean it with weak atomization air and pattern air of approximately 0.05 MPa released to prevent the solvent from entering the air path.

(2) Confirm before use every day that the fixed portion of the gun is not loose and the gun does not come into contact with the object to be coated etc.

(3) Whenever two-component paints or paints likely to precipitate are used, thoroughly clean the units with a solvent after use, and periodically disassemble and clean them on a quarterly basis.

(4) If the packing case set (No. 1-8) is damaged, the paint will leak from the check hole in the side face of the gun body.
In this situation, replace the packing case set.

6 Measures against Coating Defects

Symptom of defect	Cause	Measure
1. Atomization is poor.	[1] The atomization air pressure is excessively low.	[1] Set the atomization air pressure to a higher level.
	[2] The jetted amount of paint is excessive.	[2] Reduce the jetted amount of paint, or increase the atomization air pressure.
	[3] The solvent is inappropriate.	[3] Consult the paint manufacturer or Asahi Sunac.
	[4] The jetting portion of the nozzle is damaged.	[4] Repair or replace the nozzle.
2. The paint splashes much.	[1] The spraying distance is inappropriate.	[1] Appropriately adjust the spraying distance. (80 to 120 mm)
	[2] The atomization air pressure or pattern change air pressure is excessively low.	[2] Increase the pressure to an appropriate level.
	[3] The exhaust speed is excessively slow.	[3] Adjust the damper.
3. Paint transfer efficiency is low.	[1] The atomization air pressure or pattern change air pressure is excessively high.	[1] Reduce the pressure to an appropriate level.
	[2] The spraying distance is excessively far.	[2] Appropriately adjust the spraying distance.
	[3] The pull of the exhaust fan is excessively strong.	[3] Adjust the damper.
4. The paint adheres to the nozzle and causes whiskers.	[1] The solvent evaporates excessively fast.	[1] Change the solvent to a slow-evaporating solvent, or add a slow-evaporating solvent to the solvent used.
	[2] Room temperature is excessively high.	[2]-1 Change the solvent to a slow-evaporating solvent. [2]-2 Consider air conditioning equipment.

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Symptom of defect	Cause	Measure
5. Protrusion occurs. (Inclusion of foreign substances)	[1] The inside of the coating booth is not thoroughly cleaned.	[1] Install a dust removing filter in the air intake area inside the coating booth.
	[2] Dust deposits on the coated surface.	[2] Remove dust by air blowing.
	[3] Spray dust deposits.	[3] Adjust the exhaust speed and the exhaust direction.
	[4] The pigment in the paint is inappropriately dispersed.	[4] Filtrate the paint.
6. Orange peel occurs.	[1] The solvent evaporates excessively fast.	[1] Change the solvent to a slow-evaporating solvent.
	[2] The viscosity of the paint is excessively high.	[2] Adjust the viscosity of the paint.
	[3] The paint film is thin.	[3] Adjust the jetted amount of paint, and increase the number of paint applications.
	[4] The spraying distance is far.	[4] Adjust the spraying distance.
7. Cissing occurs.	[1] Degreasing and water draining are insufficient.	[1] Keep surfaces to be coated clean.
	[2] Inclusion of oils and silicones.	[2] Keep the coating environment clean.
	[3] Atomization air and pattern change air, water, and oil are contaminated.	[3] Replace the filter element.
8. The paint sags.	[1] The paint film is excessively thick.	[1] Adjust the jetted amount of paint and the operating speed.
	[2] The viscosity of the paint at the time of paint transfer is excessively low.	[2] Adjust the viscosity of the paint. (20 to 40 mPa·s in general)
	[3] The solvent evaporates excessively slow.	[3] Change the solvent to a fast-evaporating solvent.

Symptom of defect	Cause	Measure
9. Transparency occurs.	[1] The paint film is thin.	[1] Adjust the jetted amount of paint, and increase the number of paint applications.
	[2] The paint is not sufficiently stirred.	[2] Before coating, thoroughly stir the paint.
10. Pinholes (foaming) occur. **(Multiple small holes appear in the paint film, as if stuck by a needle.)**	[1] The temperature of the object to be coated is excessively high.	[1] Lower the temperature of the object to be coated below air temperature.
	[2] The moisture contained in the material is released into the paint film by heating.	[2] Bake the material.
	[3] Atomization air and pattern change air, water, and oil are contaminated.	[3] Replace the filter element.
	[4] The solvent rapidly evaporates, leaving a mark.	[4]-1 Add a slow-evaporating solvent. [4]-2 Make sufficient settings.
11. Blushing (whitening) occurs.	[1] The inside and outside of the coating booth are hot and humid. (Relative humidity: 80% or higher)	[1] Consider air conditioning equipment.
	[2] The diluted solvent evaporates fast, moisture penetrates into the surface layer, and the surface layer blurs white by diffused reflection of light.	[2] Add a solvent that evaporates slower than water.
12. Bubbles form.	[1] Air bubbles are mixed in the paint during stirring.	[1] Stir the paint with care not to form bubbles.
	[2] Drying after water polishing is insufficient.	[2] Thoroughly dry the paint.
	[3] The viscosity of the paint is excessively high.	[3] Adjust the viscosity of the paint.
	[4] The solvent evaporates excessively fast.	[4] Add a slow-evaporating solvent.

7 Troubleshooting

● Automatic air coating equipment

Symptom of failure	Cause	Measure
1. The coating of the paint is interrupted (unsmooth).	[1] The nozzle is not securely tightened.	[1] Retighten the nozzle.
	[2] The O-ring (No. 1-10) is damaged.	[2] Replace the O-ring with a new one.
	[3] The packing case set (No. 1-8) is damaged.	[3] Replace the packing case set with a new one.
	[4] Air is mixed in the paint.	[4] Remove the air, and investigate the paint supply system.
2. The jetted amount of paint reduced.	[1] The needle seat portion is clogged.	[1] Detach and clean the nozzle.
	[2] The air control type paint regulator is clogged.	[2] Disassemble and clean the air control type paint regulator.
3. The paint leaks from the nozzle.	[1] The paint nozzle is worn.	[1] Replace the paint nozzle with a new set.
	[2] The needle is worn.	[2] Replace the needle with a new set.
	[3] The paint pumping pressure is unusually and excessively high.	[3] Reduce the paint pumping pressure. (0.5 MPa or below)

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Symptom of failure	Cause	Measure
4. The opening-closing operation of the paint valve is unstable.	[1] The O-ring (No. 1-12) is swollen with water, or worn.	[1] Replace the O-ring with a new one.
	[2] The paint cut-off operation of the reciprocator is faulty.	[2] Follow the measure against reciprocator failures.

⚠ CAUTION

Do not perform repairs in accordance to methods other than those specified in this instruction manual.

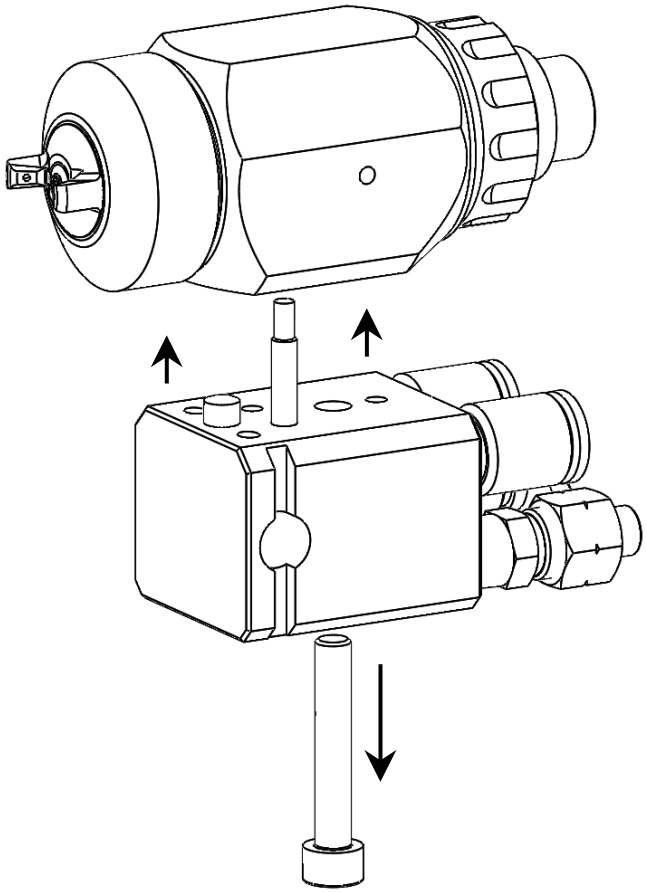
8 Methods for Replacing Parts

Replace and repair parts in accordance with the procedure described below.
Before detaching the gun, wash the paint path with a solvent, drain the solvent, and then close the air valve and release the air pressure. In addition, turn off the control power, and display a sign indicating that work is in progress to prevent the equipment from being operated by mistake.
(The numbers in the text are heading numbers or part numbers shown in the exploded views in "9 Components.")
(The illustration presented in Disassembly method shows the proximity air spray automatic gun <PGB1S>.)

Disassembly method

(1) Detaching the core unit

Unfasten the hexagon socket head cap bolt (No. 3, 03-70530) inserted in the bottom face of the gun.



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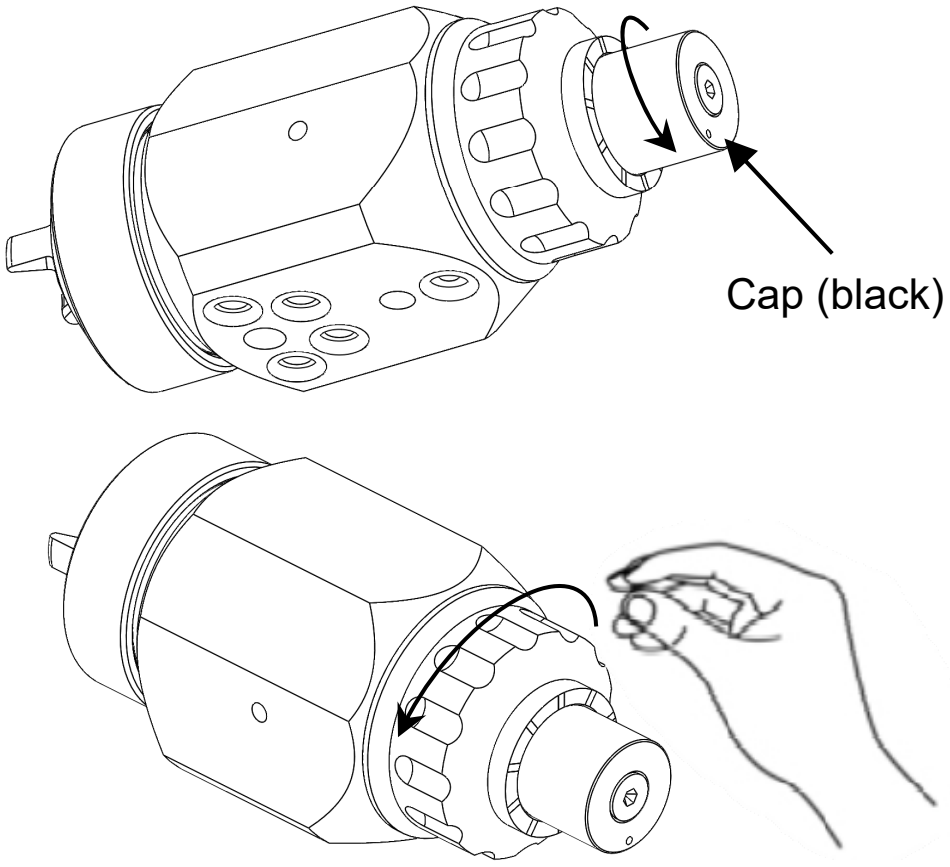
(2) Detaching the dial

[1] Turn to loosen the cap (black) all the way until it stops.

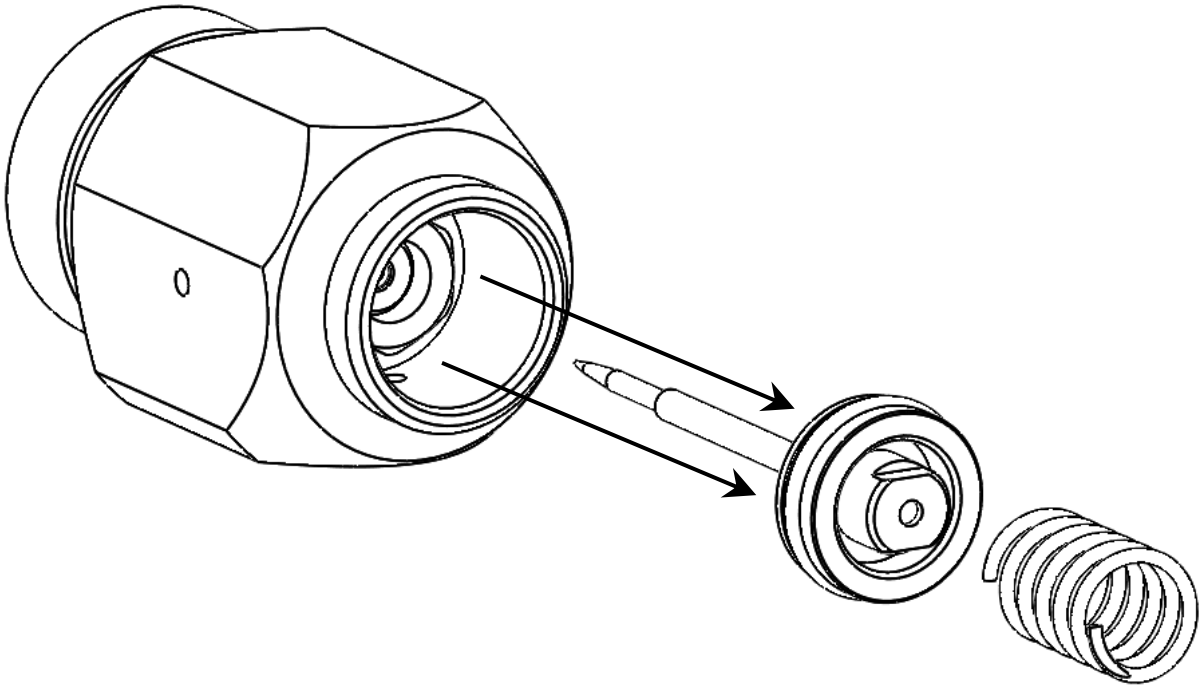
[2] Turn the dial (No. 1-6, 1781-006) by hand to detach it from the gun body.



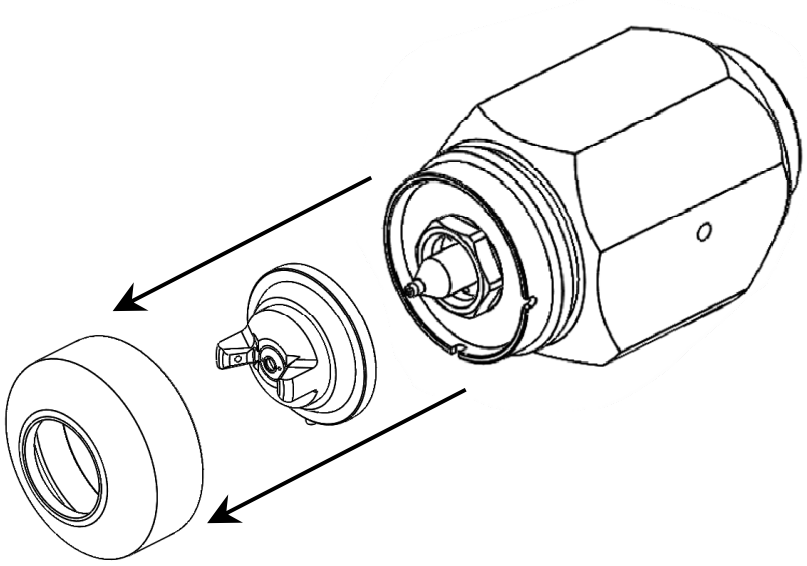
⚠ CAUTION

When detaching the paint valve from the gun body, take extreme care not to lose the spring (No. 1-5, 1781-005).

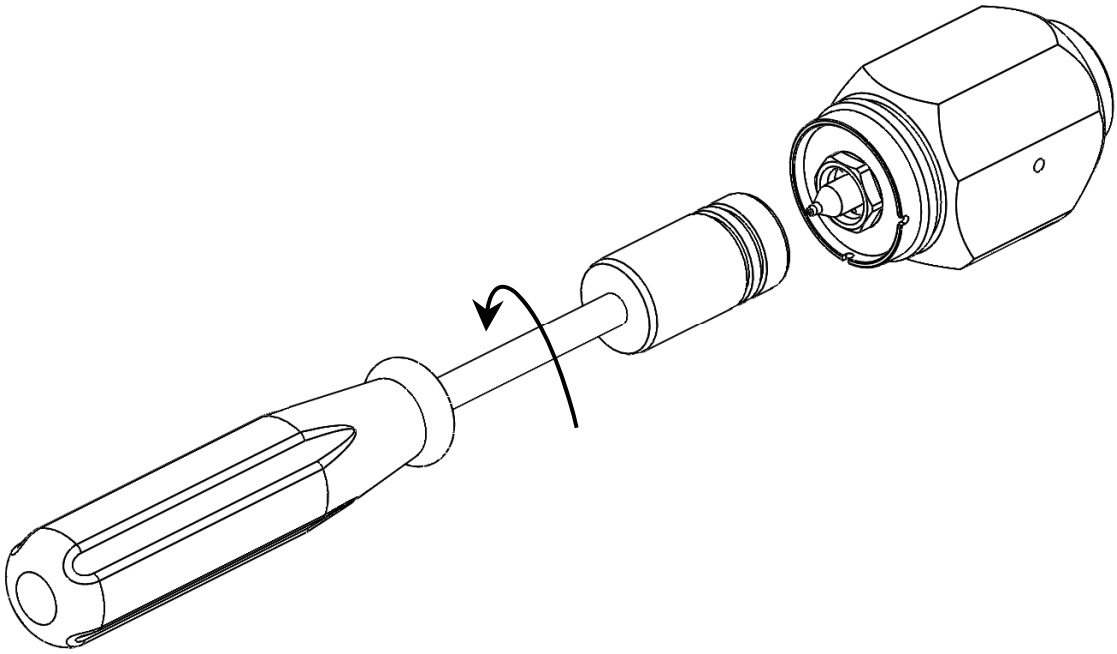
(3) Detaching the piston and the needle
Using long-nose plier or another tools, pull out the piston (No. 1-4, 1781-004) and the needle (No. 1-3, 1781-003) from the back of the gun.



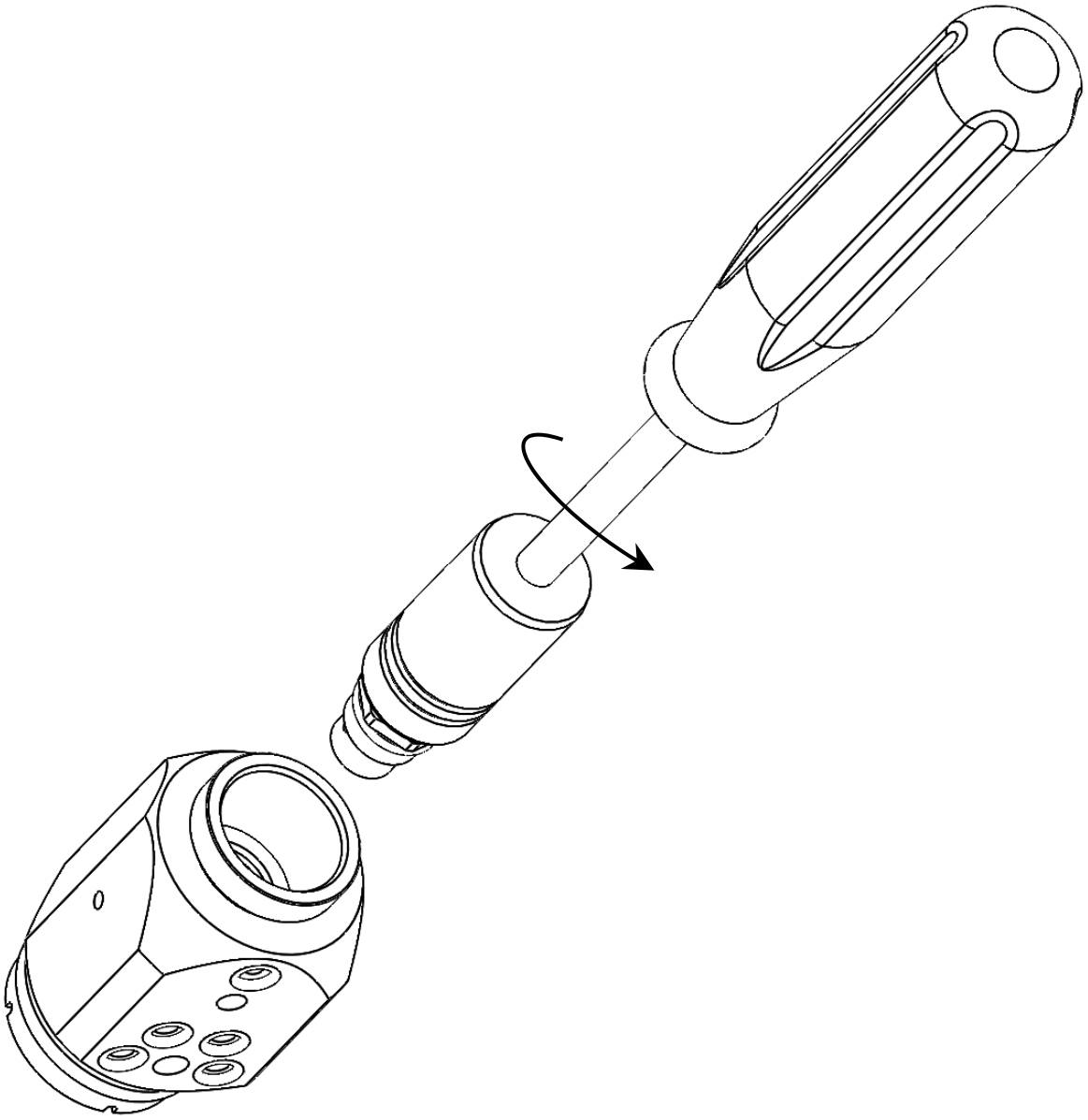
(4) Detaching the air cap
Detach the air cap by detaching the retainer (No. 1-7, 1781-007) that fastens the air cap to the gun body.



(5) Detaching the paint nozzle
Using the attached box spanner (No. 6, 332-0130), detach the paint nozzle (No. 1-2, 1781-002) from the gun body.

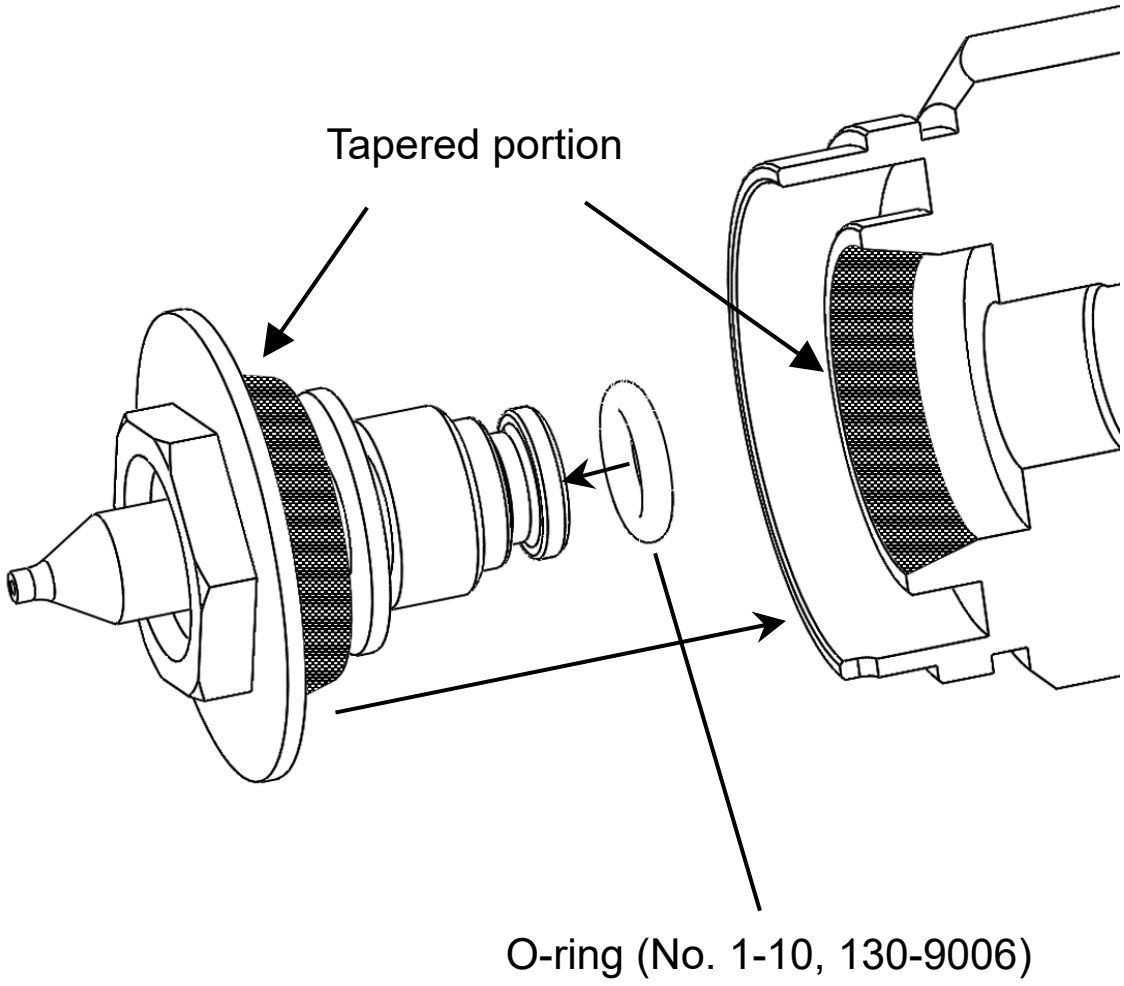


(6) Detaching the packing case set
Using the attached box spanner (No. 6, 332-0130), detach the packing case set (No. 1-8, 1826-004) from the gun body.
The packing case set will deform if it is disassembled, and will therefore need to be replaced in the form of an assembly.



Attaching method

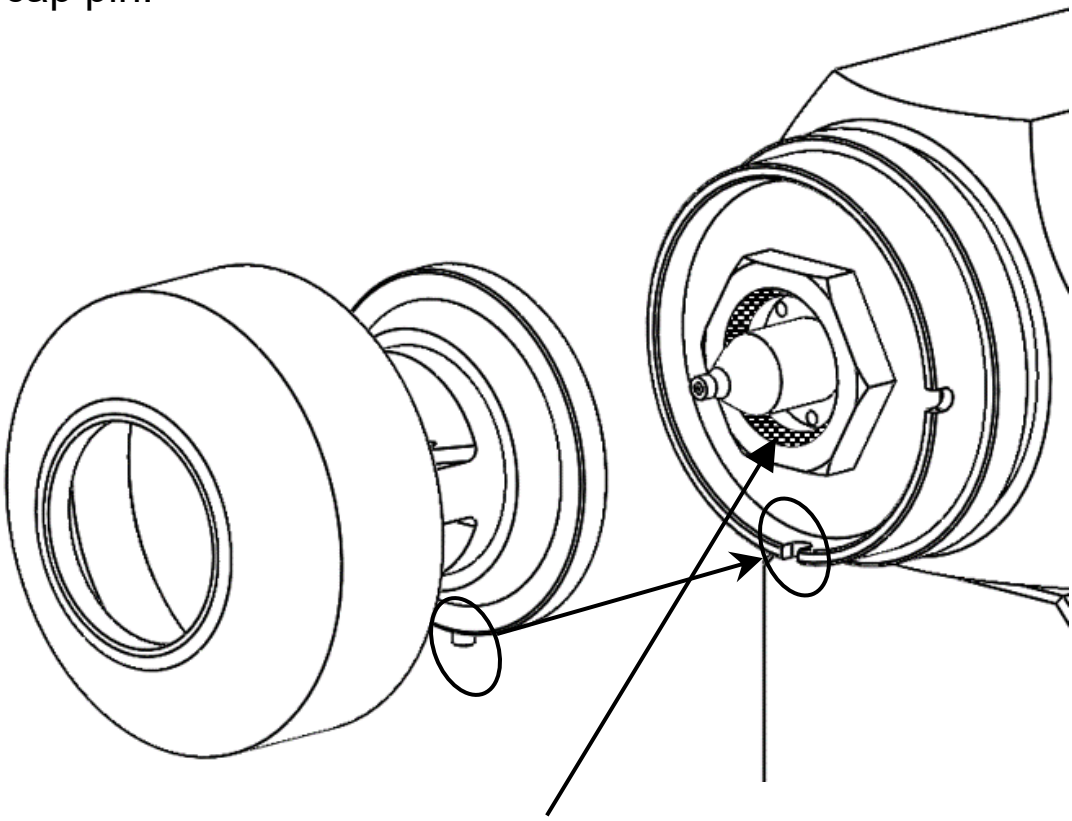
(1) Attaching the paint nozzle
Before attaching the paint nozzle (No. 1-2, 1781-002), confirm that there is no dirt or scratch on the tapered portion described below. In addition, be sure to attach the O-ring (No. 1-10, 130-9006).



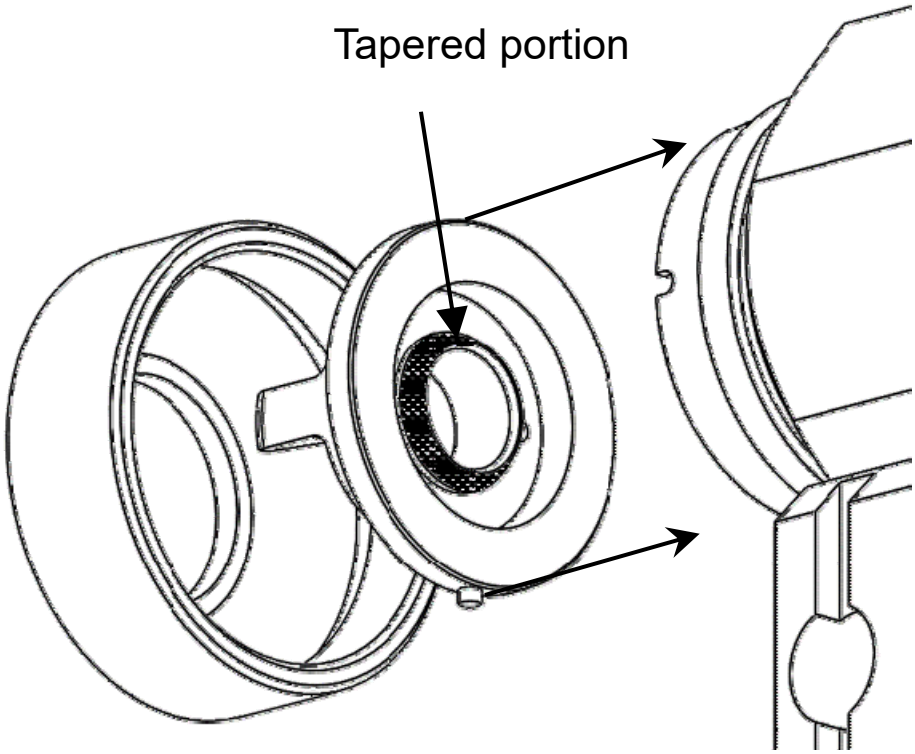
(2) Attaching the air cap

Before attaching the air cap, confirm that there is no dirt or scratch on the tapered portion described below.

In addition, attach the air cap by aligning the position of the air cap pin.



Tapered portion



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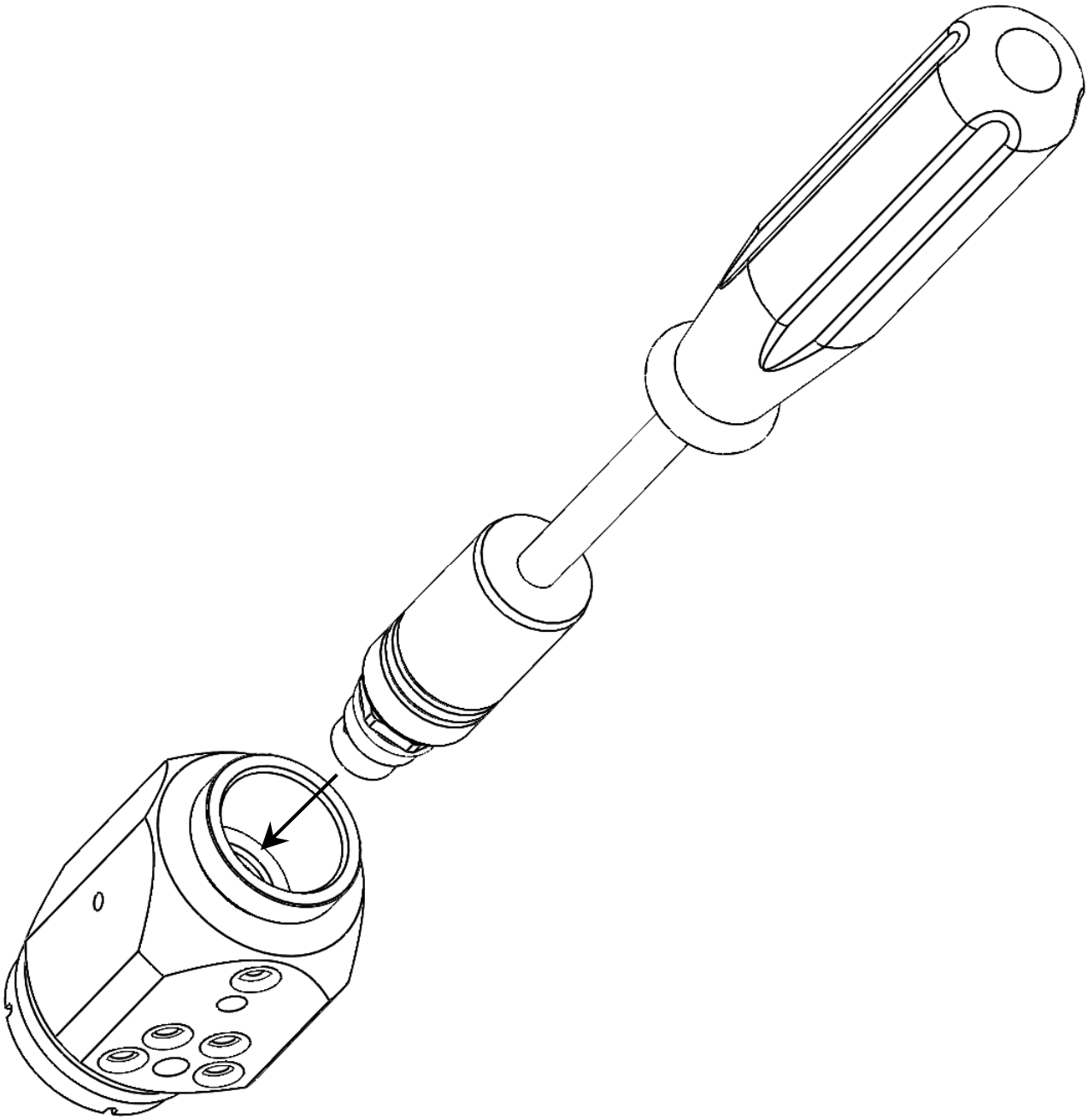
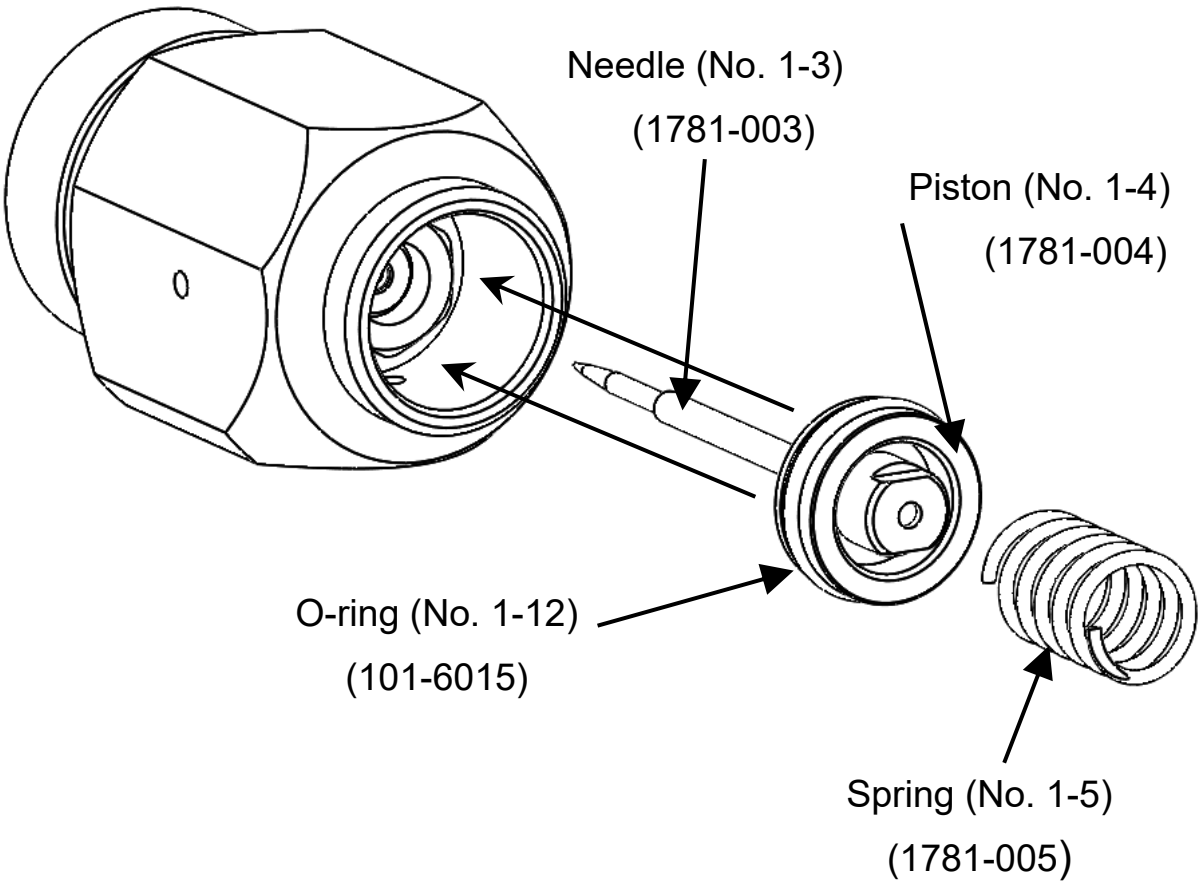
(3) Attaching the packing case set
Using the attached box spanner (No. 6, 332-0130), attach the packing case set (No. 1-8, 1826-004) to the gun body.

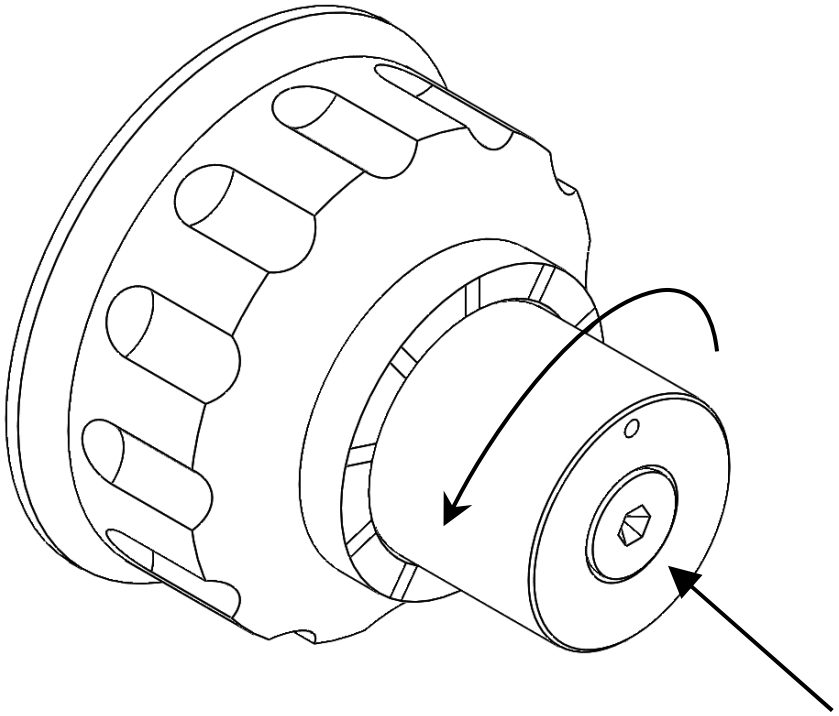


(4) Attaching the piston and the needle
Assemble the needle (No. 1-3, 1781-003), the piston (No. 1-4, 1781-004), the O-ring (No. 1-12, 101-6015), and the spring (No. 1-5, 1781-005), and insert the assembly into the body.



(5) Preparations for attaching the dial

[1] Turn to loosen the cap (black) all the way until it stops.

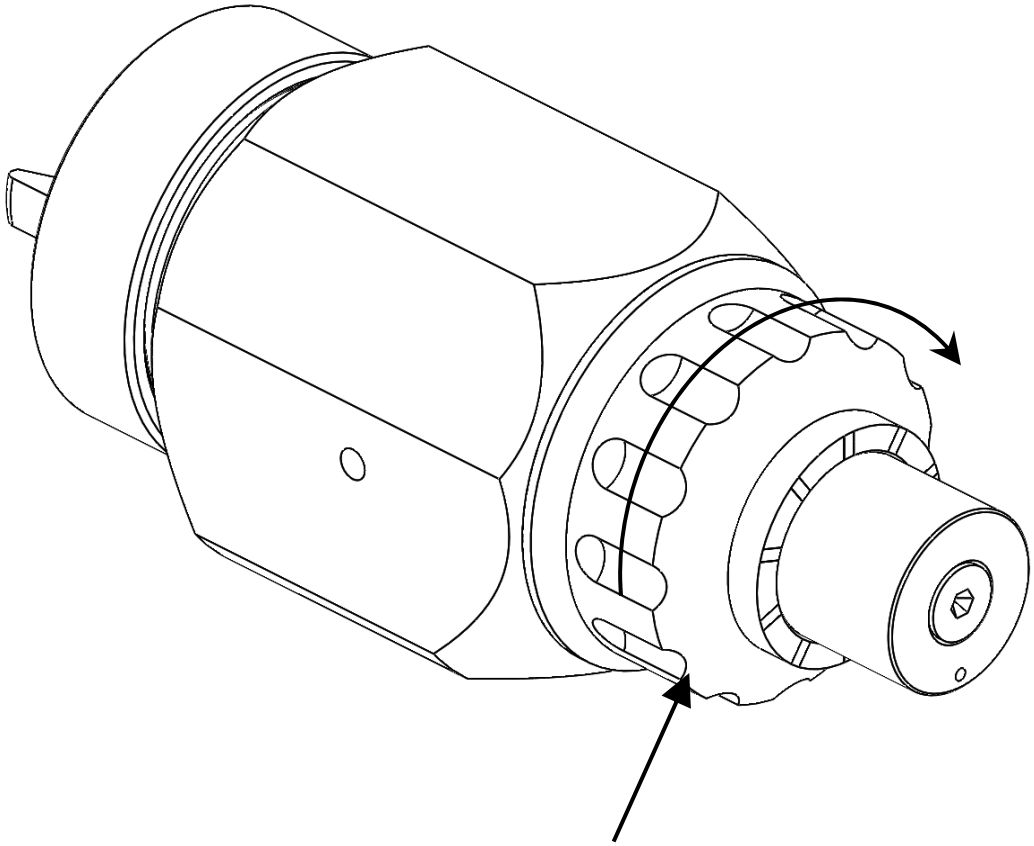


Cap (black)

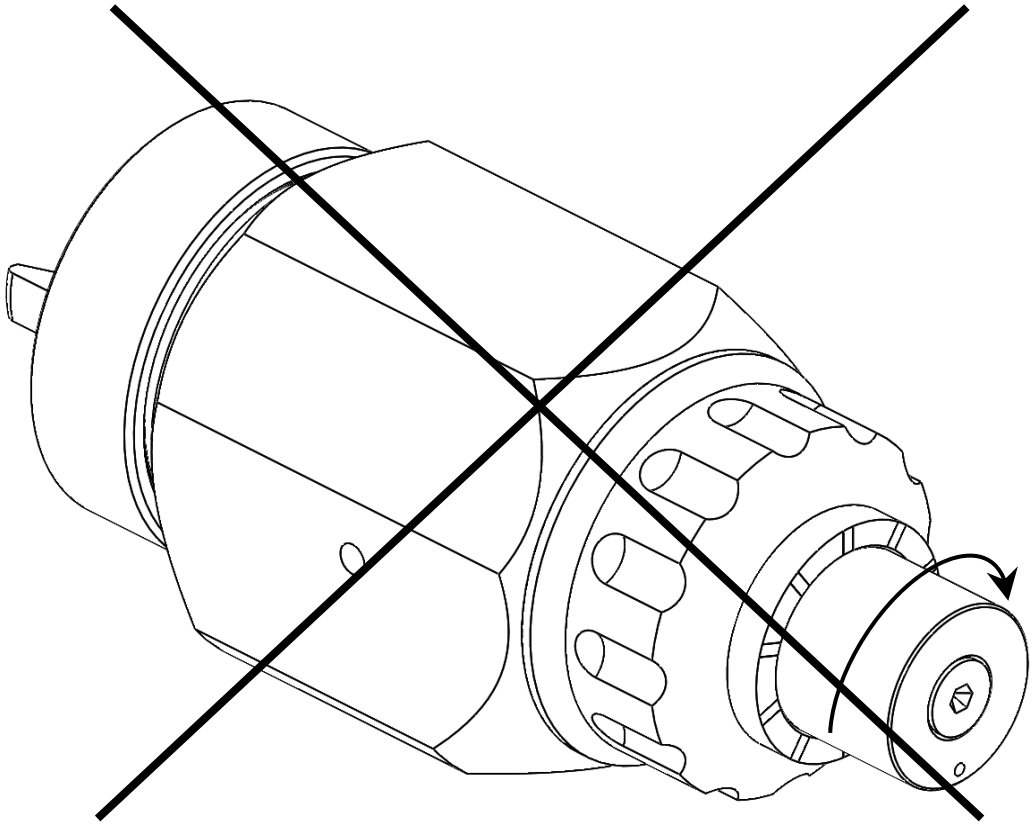
⚠ CAUTION

Turn to loosen the cap all the way until it stops. Otherwise, the paint nozzle and the needle may get damaged and become unable to seat.

[2] Holding the semi-circular groove portion of the dial (No. 1-6, 1781-006) and tighten the dial into the gun body.



Dial (No. 1-6)
(1781-006)

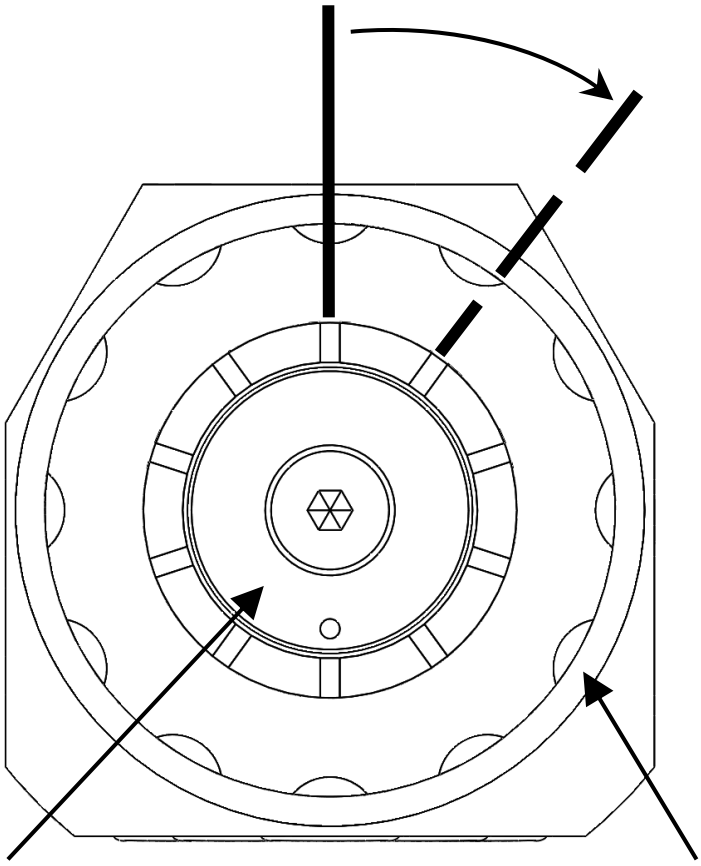


⚠ CAUTION

When attaching the dial to the gun body, be sure to hold the semi-circular groove portion and tighten the dial into the gun body. If the dial is tightened into the gun body by holding the cap, both of the dial and the cap will turn, and the needle stroke will fail to fully open, resulting in damage to the paint nozzle and the needle at the time of assembly.

(6) Improving seatability
When using the gun for the first time after the paint nozzle and the needle are replaced, the paint nozzle will fit well to the needle by retightening the cap (black), and seatability will be consequently improved.

[1] Slowly tighten the cap (black).
[2] After the cap stops, slowly retighten it per scale.



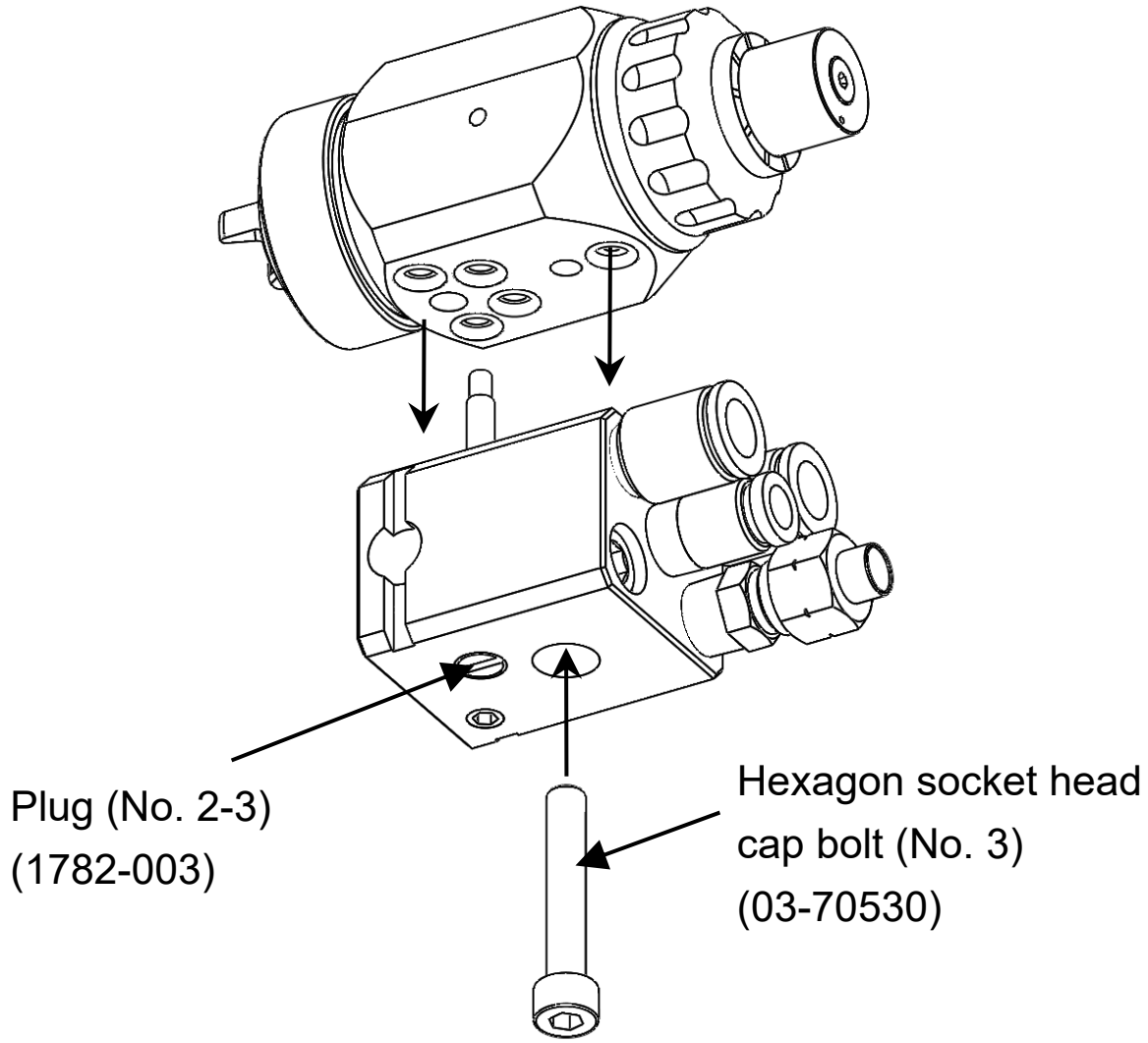
Cap (black)

Dial (No. 1-6)
(1781-006)

⚠ CAUTION

If the cap is excessively tightened, the appropriate fitting between the needle and the paint nozzle may be lost, and they may become unable to seat. Retighten the cap at per scale or less.

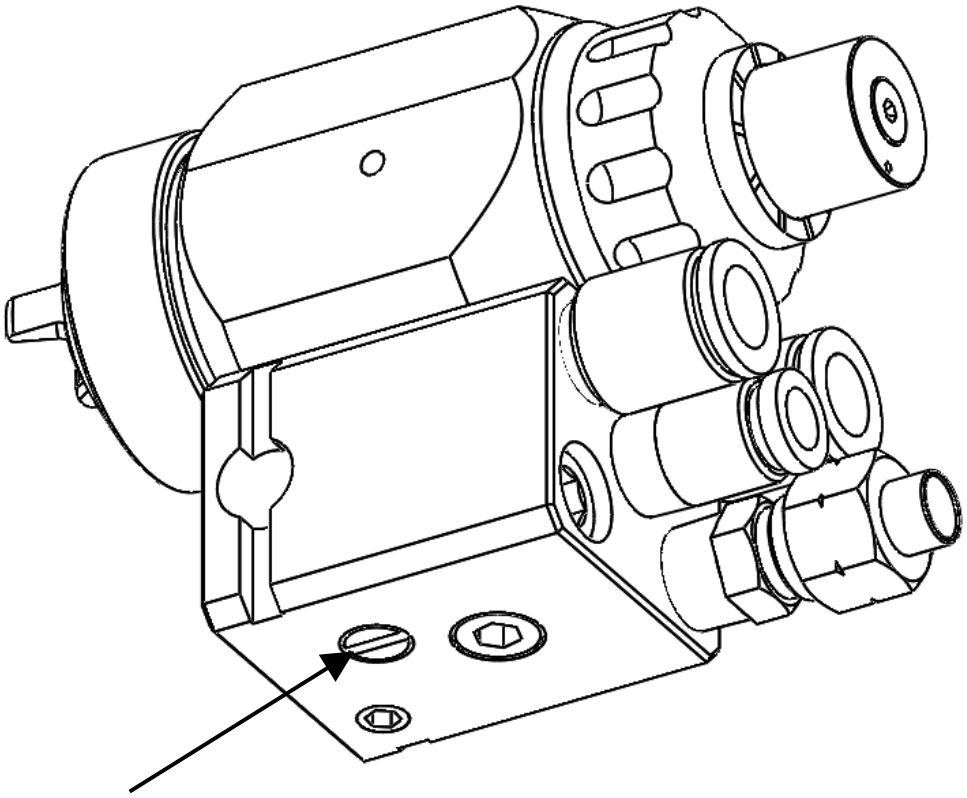
(7) Attaching the core unit
Loosen the plug (No. 2-3, 1782-003), and attach the hexagon socket head cap bolt (No. 3, 03-70530) into the core unit.



⚠ CAUTION

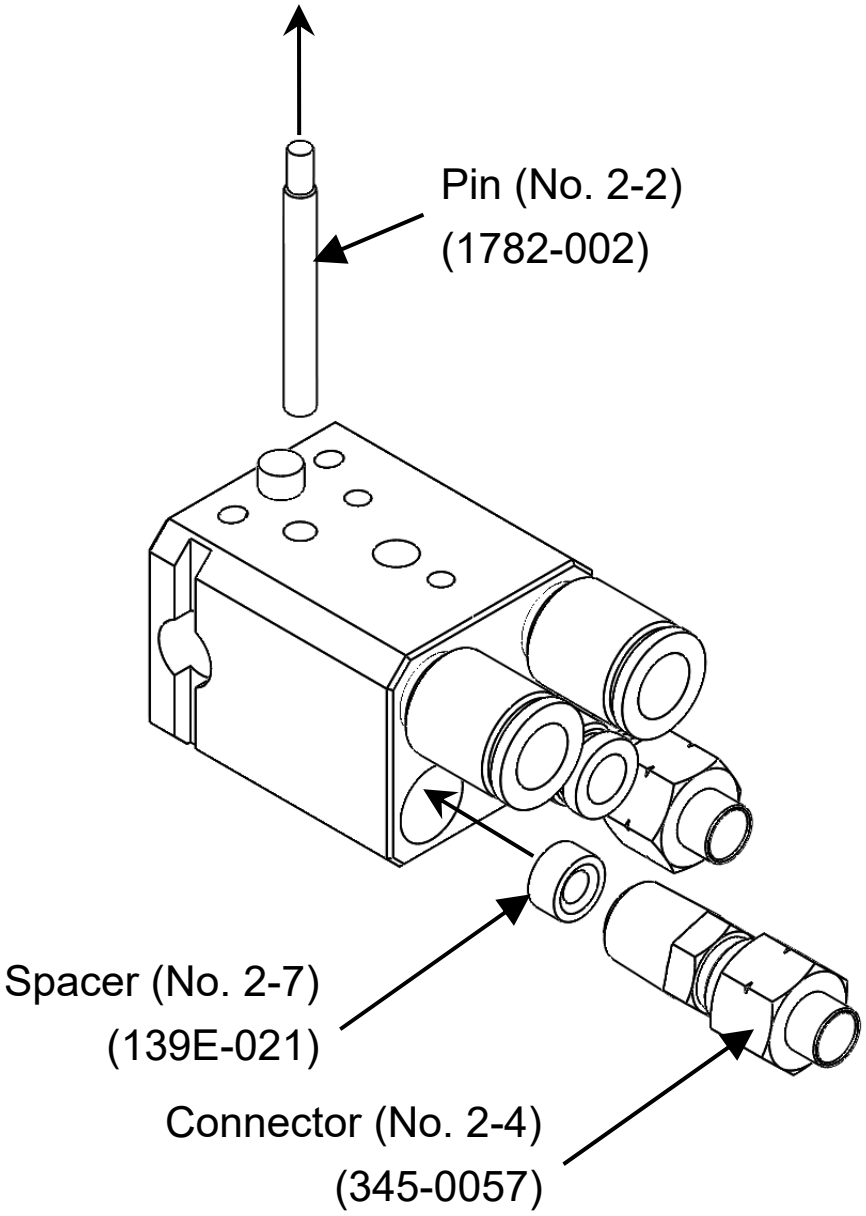
Before attaching the gun bracket, loosen the plug once.
Otherwise, the core unit and the gun bracket may become unable to seal.

(8) Attaching the core unit
Tighten the plug (No. 2-3, 1782-003).



Plug (No. 2-3)
(1782-003)

(9) When changing the gun to a paint circulation mode
Detach the pin (No. 2-2, 1782-002) and the hexagon socket head cap screw (No. 2-9, 244-4001).
Attach the spacer (No. 2-7, 139E-021) and the connector (No. 2-4, 345-0057).



9 Components

PGB1S

1853

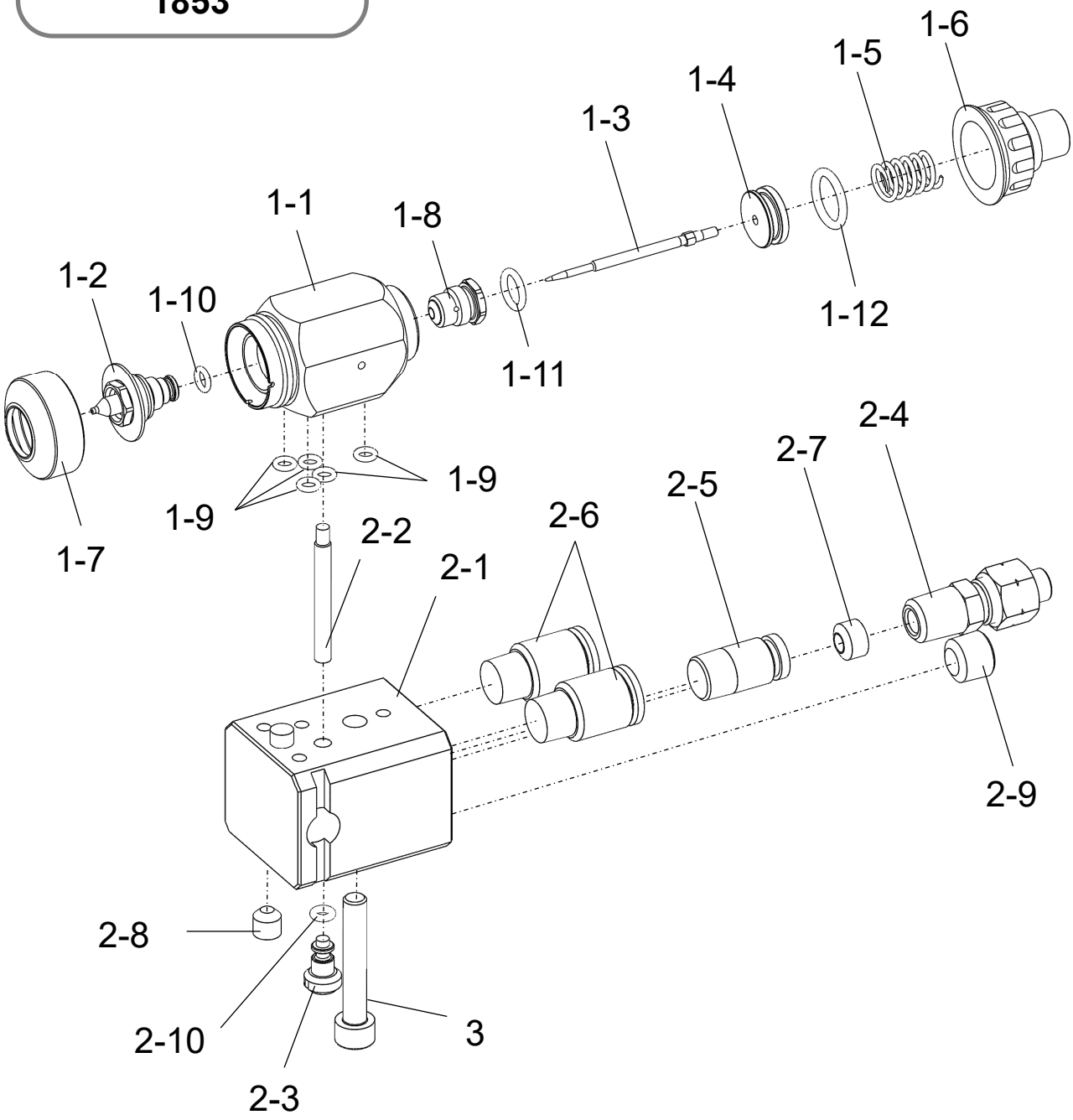


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Table 1 Parts list of PGB1S (1853)

No.	Part No.	Part name	Qty	Remarks
1	1781	Core unit	1	
1-1	1781-001	Body	1	
*1-2	1781-002	Paint nozzle	1	
*1-3	1781-003	Needle	1	
1-4	1781-004	Piston	1	
1-5	1781-005	Spring	1	
1-6	1781-006	Dial	1	
1-7	1781-007	Retainer	1	
*1-8	1826-004	Packing case set	1	
*1-9	130-9005	O-ring	5	
*1-10	130-9006	O-ring	1	
*1-11	101-6010	O-ring	1	
*1-12	101-6015	O-ring	1	
2	1782	Gun bracket	1	
2-1	1782-001	Bracket	1	Straight type
2-2	1782-002	Pin	1	Unavailable for the paint circulation mode
2-3	1782-003	Plug	1	
2-4	345-0057	Connector	1	
2-5	378-0601	Straight with hexagon socket	1	Trigger air
2-6	378-0801	Straight with hexagon socket	2	
2-7	139E-021	Spacer	1	
2-8	86-70608	Hexagon socket head cap screw	1	
2-9	244-4001	Plug with hexagon socket	1	Change to No. 2-4 and No. 2-7 in the case of the paint circulation mode.
2-10	130-9003	O-ring	1	
3	03-70530	Hexagon socket head cap bolt	1	
4	Nil			
5	Nil			
6	332-0130	Box spanner	1	See page 41.
-	15E8-001	Air cap	1	To be separately arranged

It is recommended to keep the parts marked with an asterisk (*) at hand as spare parts.

PGB1RA

1854

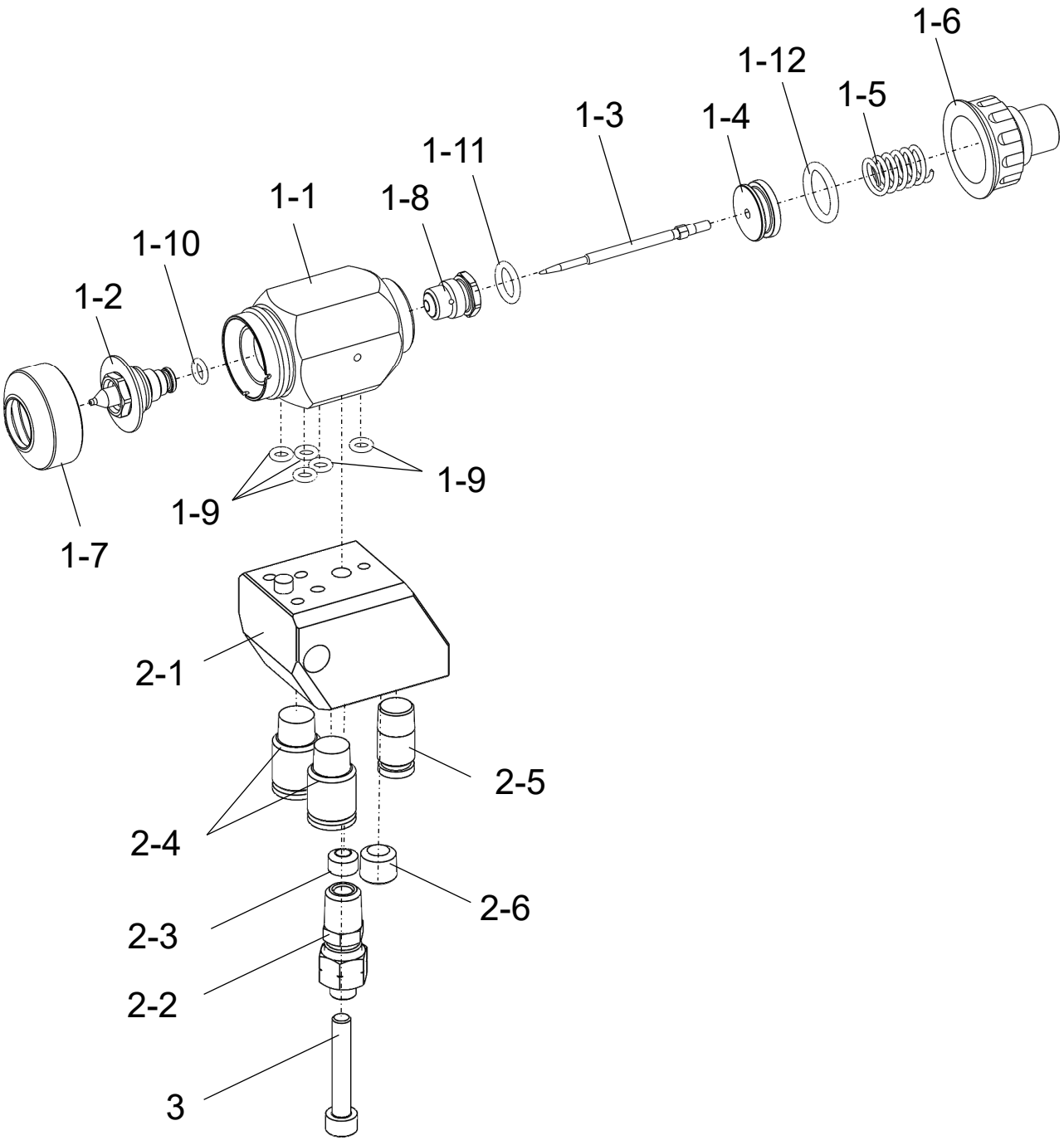

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Table 2 Parts list of PGB1RA (1854)

No.	Part No.	Part name	Qty	Remarks
1	1781	Core unit	1	
1-1	1781-001	Body	1	
*1-2	1781-002	Paint nozzle	1	
*1-3	1781-003	Needle	1	
1-4	1781-004	Piston	1	
1-5	1781-005	Spring	1	
1-6	1781-006	Dial	1	
1-7	1781-007	Retainer	1	
*1-8	1826-004	Packing case set	1	
*1-9	130-9005	O-ring	5	
*1-10	130-9006	O-ring	1	
*1-11	101-6010	O-ring	1	
*1-12	101-6015	O-ring	1	
2	1782-1	Bottom pull-out gun	1	
2-1	1782-101	Bottom pull-out gun	1	Rectangular type
2-2	345-0057	Connector	1	
2-3	139E-021	Spacer	1	
2-4	378-0801	Straight with hexagon socket	2	
2-5	378-0601	Straight with hexagon socket	1	Trigger air
2-6	244-4001	Plug with hexagon socket	1	Change to No. 2-2 and No. 2-3 in the case of the paint circulation mode.
3	03-70530	Hexagon socket head	1	
4	Nil			
5	Nil			
6	332-0130	Box spanner	1	See page 41.

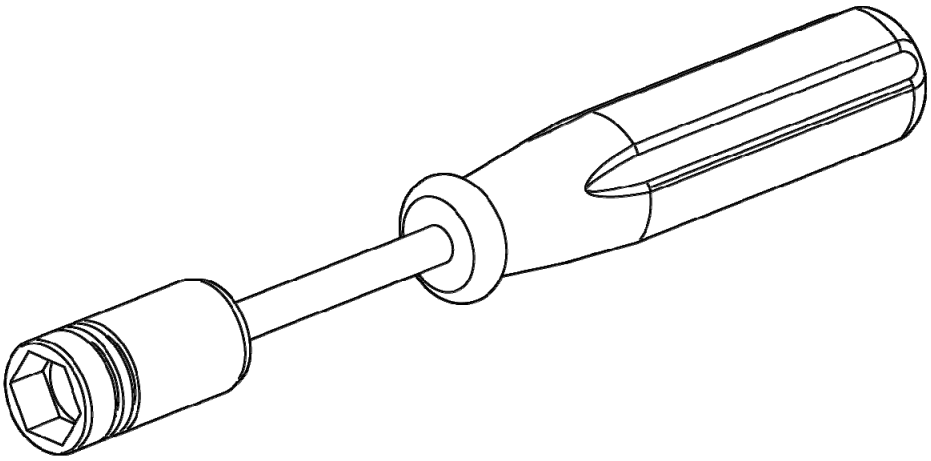
-	15E8-001	Air cap	1	To be separately arranged

It is recommended to keep the parts marked with an asterisk (*) at hand as spare parts.

Accessory

332-0130

Box spanner (HEX13)



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10 Maintenance Log

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			Proximity air spray automatic gun dedicated to rotary coating <PGB1S/PGB1RA>		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
						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

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

11 Warranty

ASAHI SUNAC CORPORATION (the “Company”) shall provide the original purchaser (the “Purchaser”) with warranty service for a period of 6months 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 to 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 lightening.
  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.

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[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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