

Operation and Maintenance Manual

Pipe Inside Spray Equipment

PIP100·250·300



PIP250



This manual contains important information on warnings and cautions. Read the manual thoroughly before starting to operate this equipment, and follow the instructions. Always keep the manual handy until such time as the equipment 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 the Asahi Sunac Corporation, directly, and ask us to send you a new one.

Thank you for buying our product.

Dear Valued Customer,

Thank you for buying our product, Pipe Inside Spray Gun (PIP100·250·300).

Please read this manual carefully before starting to operate the equipment. Please pay particular attention to major specifications, warnings and precautions, including prohibited items. Use the equipment appropriately and with care, following the instructions. We hope that by doing so you win benefit from use of the product over a long period of time.

The equipment is geared to industrial painting. It is for use only by those who are familiar with its workings and have undergone proper training; persons without such knowledge should not be allowed to operate the equipment.

Should you have any questions with regard to the manual, please give us the “Model Name” and “Serial Number” of your equipment, so that we may be able help you with your questions. You can reach us at any of the addresses, phone numbers and fax numbers shown on the back cover.

Thank you,
Asahi Sunac Corporation

Contents

| | | |
|----------|--|----|
| 1 | For Your Safety..... | 1 |
| 2 | Specification | 1 |
| 3 | General Instructions Before the Start of Operation | 4 |
| 4 | Operating Procedure and Safety Instructions | 5 |
| | Unpackaging and Connection | 5 |
| | Operating Procedure | 6 |
| | After the Completion of Operation..... | 6 |
| | Maintenance of the Equipment..... | 6 |
| | Other Precautionary Notes..... | 7 |
| 5 | Exploded Diagram and Names of Parts..... | 8 |
| 6 | Maintenance Log | 16 |
| 7 | Warranty | 16 |

The PIP100/250/300 <pipe inside spray gun> can be used with an airless pump to most efficiently and neatly coat the insides of pipes.

The PIP is an easy-to-use spray gun focusing on the functionality and safety. If used in a wrong manner, however, it may cause a malfunction or another inconvenience, possibly resulting in a equipment disorder or accident. The following instructions shall be fully observed.

The following descriptions are mostly related with the PIP250.

1

For Your Safety



Please carefully read this manual and get yourself acquainted with the equipment.

Please observe the operating procedures in the manual. Failure to do so may result in **personal injury and/or damage to property**.

This manual covers only minimum safety precautions and it does not suggest or imply that no other precautions are required. Of course, each enterprise must observe its own rules as well as the laws and regulations of the country or region in which it operates, in addition to the safety precautions in the manual.

Again, shown on the pages that follow are basic and minimum safety precautions for use of our products.

- As shown below, safety precautions are classified into three categories based on the severity of hazards involved.

| | |
|--|---|
|  WARNING | Alerts a hazardous situation which may result in personal injury, with instructions on how to avoid it. |
|  CAUTION | Alerts a hazardous situation which may result in damage or breakage to equipment, with instructions on how to avoid it. |
| NOTICE | Indicates important methods and practical information. |

※ A hazardous situation classified into the CAUTION category could cause a serious accident depending on how things develop. All the precautions in the manual convey significant information that you must observe such precautions in order to ensure your own safety and prevent equipment from failure.

2

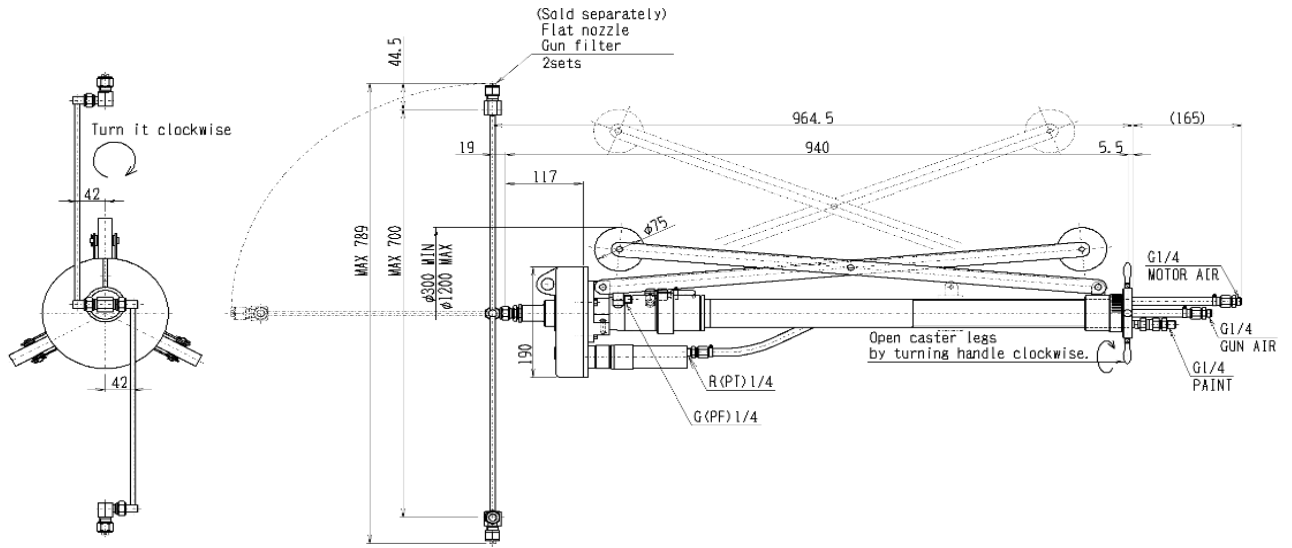
Specification

| Model | PIP100 | PIP250 | PIP300 |
|----------------------|---|---|---|
| Pipe inside diameter | φ125-250 mm | φ250-700 mm | φ300-1200 mm |
| Rotation speed | - | 90-125rpm | |
| Air pressure | 0.3-0.5MPa | | |
| Air flow rate | 100 L/min | 440 L/min | |
| Length | 547 mm | 660 mm | 965 mm |
| Weight | 3.4 kg | 12.5 kg | 18 kg |
| Air inlet diameter | G1/4 (PF1/4) 1 place | G 1/4 (PF1/4) 2 places | |
| Remarks | No rotation. Use the round nozzle (CN). | Use the nozzle extension (for PIP250). | Use the nozzle extension (for PIP300). |

1311-1

Coating unit inside the pipe

PIP300

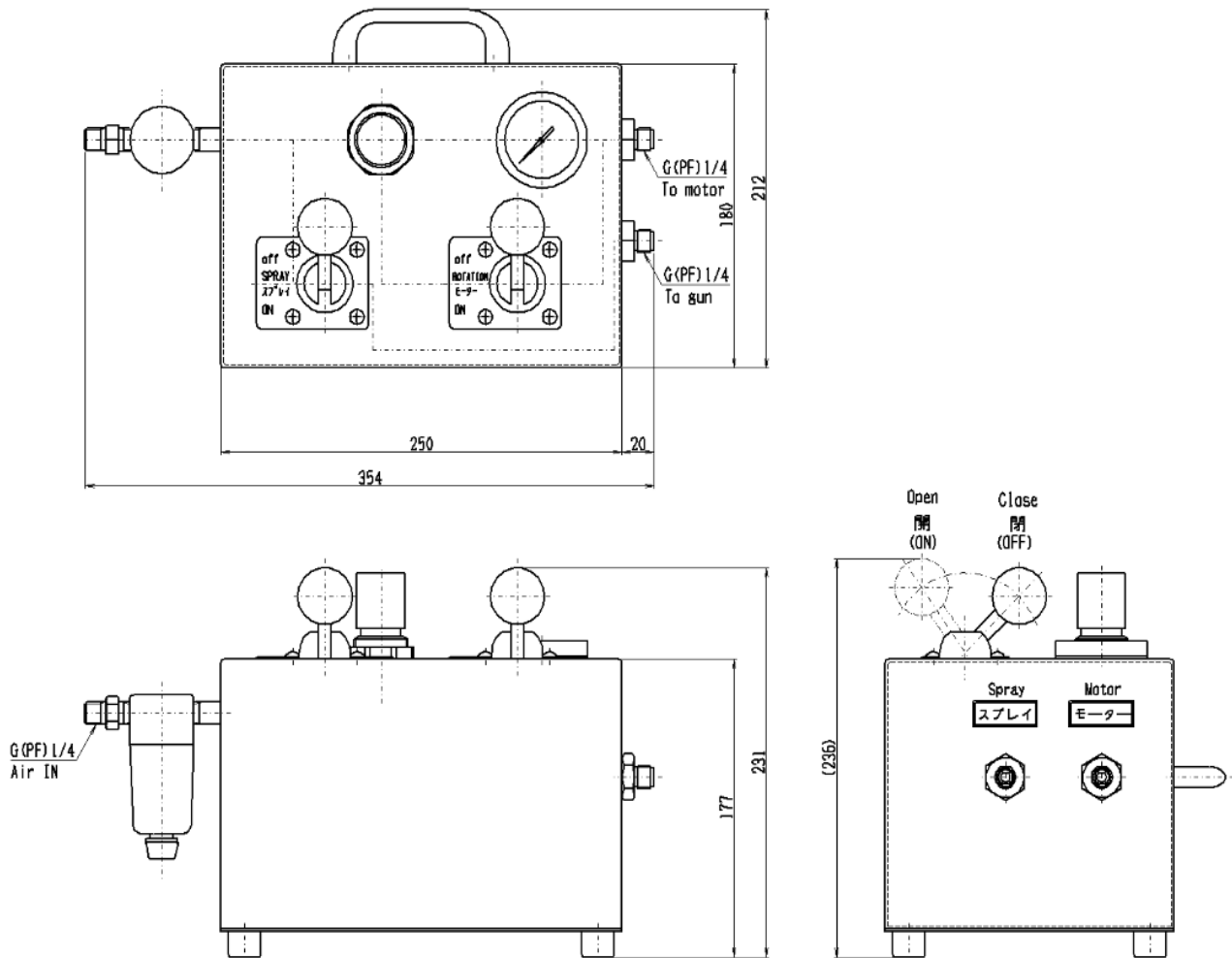


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Control box

APCB

Use with PIP250, 300.



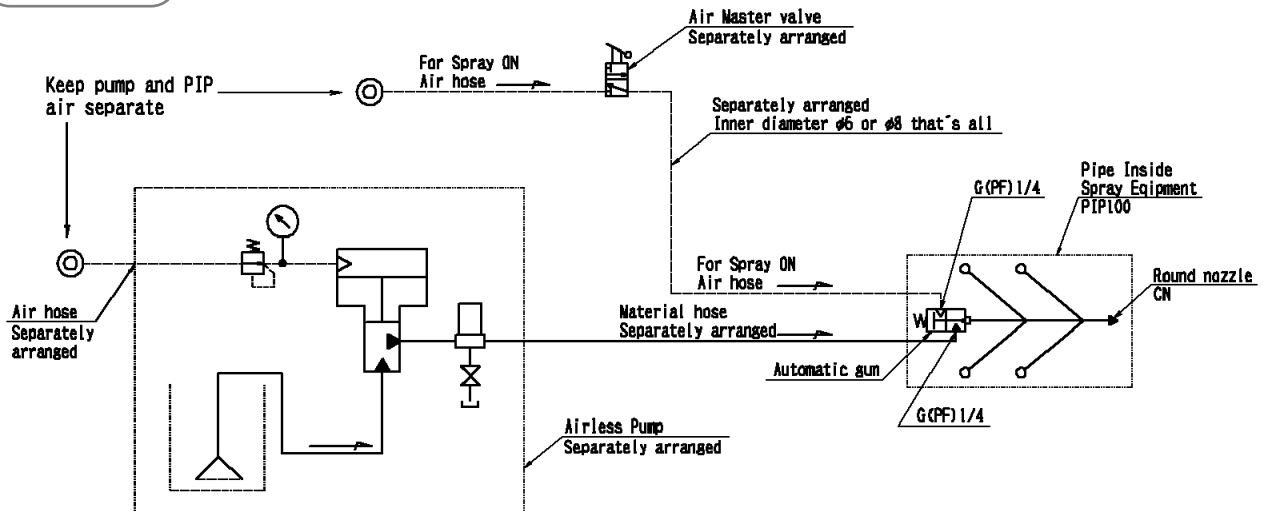
3

General Instructions Before The Start of Operation

- ① An airless pump needs to be provided separately to compress the paint used for the pipe inside coating equipment.
- ② Compressed air is used to rotate the spray nozzle and operate the spray gun. Use dry and clean air for compressor.
- ③ Use the hose (two air hoses [or one for the PIP100] and a paint hose) that is longer than the pipe considering movable range.

PIP100

1309-1

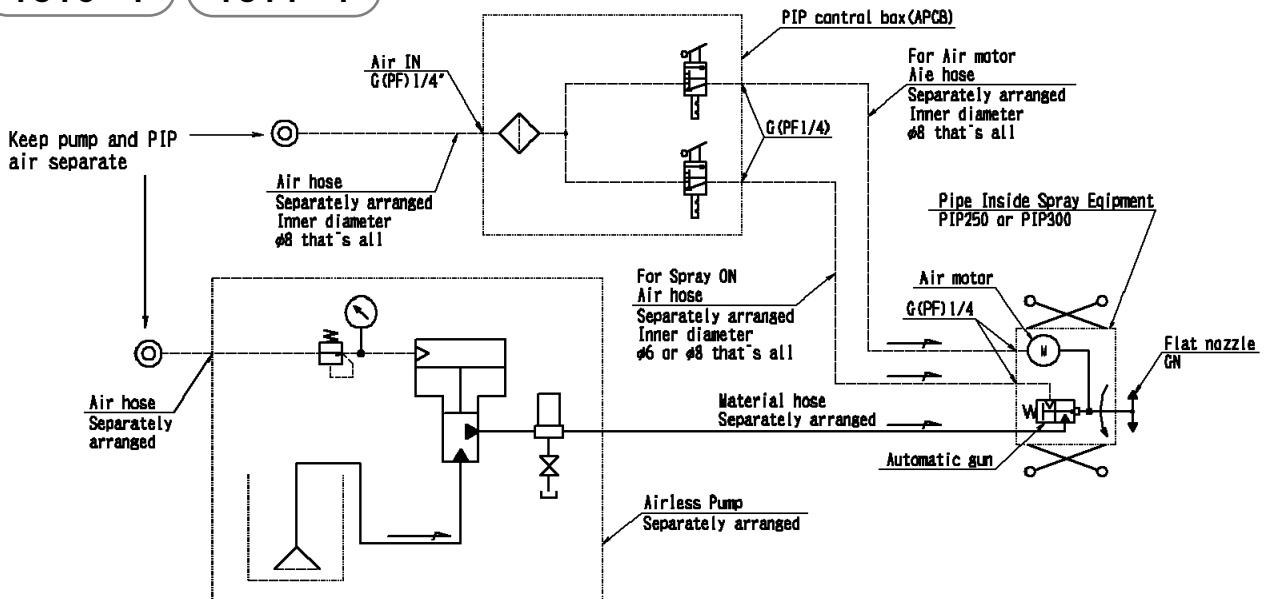


PIP250

1310-1

PIP300

1311-1



- ④ Before starting the airless pump, read safety instructions for the pump.
- ⑤ The applicable pipe inside diameter range for the PIP100 is: $\phi 125$ mm to $\phi 250$ mm
 The applicable pipe inside diameter range for the PIP250 is: $\phi 250$ mm to $\phi 700$ mm
 The applicable pipe inside diameter range for the PIP300 is: $\phi 300$ mm to $\phi 1200$ mm

4

Operating Procedure and Safety Instructions

① Unpackaging and connection

Although the equipment is 100% checked at the factory so that it can be directly used after connected with the pump, hoses and gun, some parts of the equipment may have been damaged or lost during transportation or for another reason. Fully check for missing or damaged parts after unpackaging and, if any, please contact us or one of our distributors.

● Preparation for coating

(1) Connect the material and air hoses.

Coating equipment body : Material hose 1

Coating equipment body : Air hose Spray ON/OFF air hose 1

Air hose Spray nozzle rotating air hose 1

(unnecessary for the PIP100, which has a non-rotating spray nozzle)

Control box : 2 air hoses identical to the ones specified above and an air supply hose

Before starting, close (rotate counterclockwise) the air regulator on the control box and set the spray ON/OFF and spray nozzle rotation switch valves set to "OFF."

(2) Open PIP legs to fit the caster in with inner diameter of straight pipe. To open legs, turn the gun body counterclockwise for PIP100 and turn the handle clockwise for PIP250 / 300.

(3) Mix the paint in a container and insert a suction filter into the container.

(4) Open (rotate clockwise) the air regulator for airless pump to run the airless pump and feed the paint under pressure to the pipe inside coating equipment. Set the paint pressure around 4 to 5MPa at this time.

(5) Supply the compressed air into the control box.

(6) Put a can at the tip of the spray nozzle to perform a spray test.

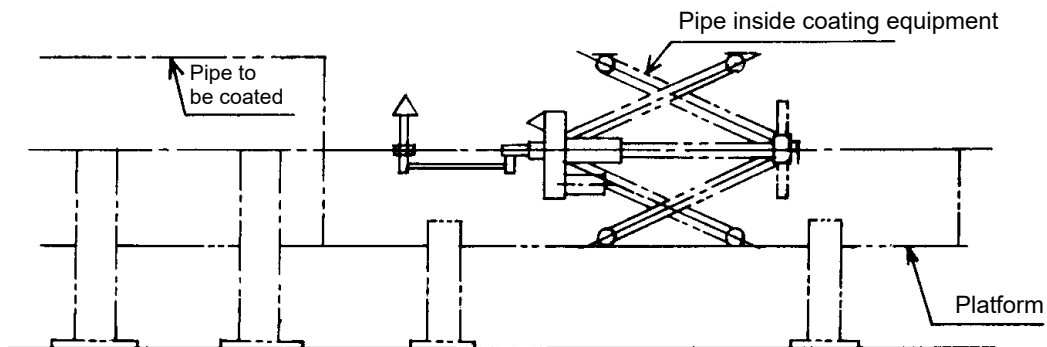
Set the spray switch valve on the control box to "ON." The washing fluid and air come out first and, after a while, the paint comes out. (Do not install the spray nozzle at this time.) Next, install the spray nozzle and adjust the paint pressure to a level that permits atomization. Perform a spray test. If the paint is not properly atomized in this test, adjust the paint pressure, spray nozzle, paint viscosity, etc. to obtain better atomization results.

Set the paint pressure to the lowest possible level that ensures good atomization results. Too high pressure may cause damage to the coating equipment, material hose, spray nozzle, etc. and/or accelerate the wear.

- (7) Insert the coating equipment into the pipe to be coated and adjust it to the inside diameter of the pipe. Insert it until it reaches the end opposite from the draw-out port.
- (8) Adjust the spraying distance.
The optimum distance between the spray nozzle tip and the inside surface of the pipe (spraying distance) is 50 to 125mm for the PIP100, 150 to 200mm for the PIP250 or 150 to 500mm for the PIP300 although it depends on the paint type, coat thickness and pipe inside diameter.
- (9) Set the spray nozzle rotation switch valve to "ON" and slowly open (rotate clockwise) the air regulator to rotate the spray nozzle.
The rotating speed shall be set to an adequate level according to the paint discharge rate, pattern width, specified coat thickness, pipe inside diameter and other conditions. Once an adequate rotating speed is obtained, stop the spray nozzle using the switch valve without changing the air regulator setting.

② Operating procedure

- (1) Set the spray nozzle rotation switch valve to "ON" to rotate the spray nozzle.
- (2) Set the spray switch valve to "ON" and draw the coating equipment toward you.
The speed at which the coating equipment is drawn toward you shall be predetermined according to the paint type, paint discharge rate, pattern width, specified coat thickness, pipe inside diameter and other conditions.
- (3) Once the coating equipment comes near the draw-out port, set the spray switch valve to "OFF." Also set the spray nozzle rotation switch valve to "OFF."
Then, the coating process has been completed.
Although the surface in the vicinity of the draw-out port cannot be coated with the coating equipment, it is still possible to coat the whole inside surface by installing a semi-circular pipe with a slightly larger diameter than the inside diameter of the pipe to be coated (and longer than the coating equipment) at the same height with the pipe to be coated.



③ After the completion of operation

Before a noon recess or break or at the end of a day's work, only remove the spray nozzle and immerse it in a washing fluid. When withdrawing the equipment from service for two or three days, take the following action.

(When using a two-component paint, wash the spray nozzle every day.)

- (1) Remove the spray nozzle and immerse it in a washing fluid.
- (2) Drain the paint from the system. Place a can below the spray nozzle of the coating equipment. Remove the suction filter for airless pump from the paint can and open (rotate clockwise) the air regulator for driving the airless pump to run the airless pump at a lower pressure. Then, set the spray switch valve to "ON" to drain the paint from the system.
- (3) Flush throughout the system using a washing fluid. This operation shall be performed in the same manner as for "pressure feeding" or "draining" except that a lower pressure shall be used.
- (4) Overhaul and wash the material filter.
- (5) Close the compressed air supply valve. Washing shall be completely performed. Insufficient washing causes the gelled paint to clog the spray nozzle, resulting in poor coating results. Wash the spray nozzle after immersing in the washing fluid for a while or remove it from the washing fluid for washing directly before use.

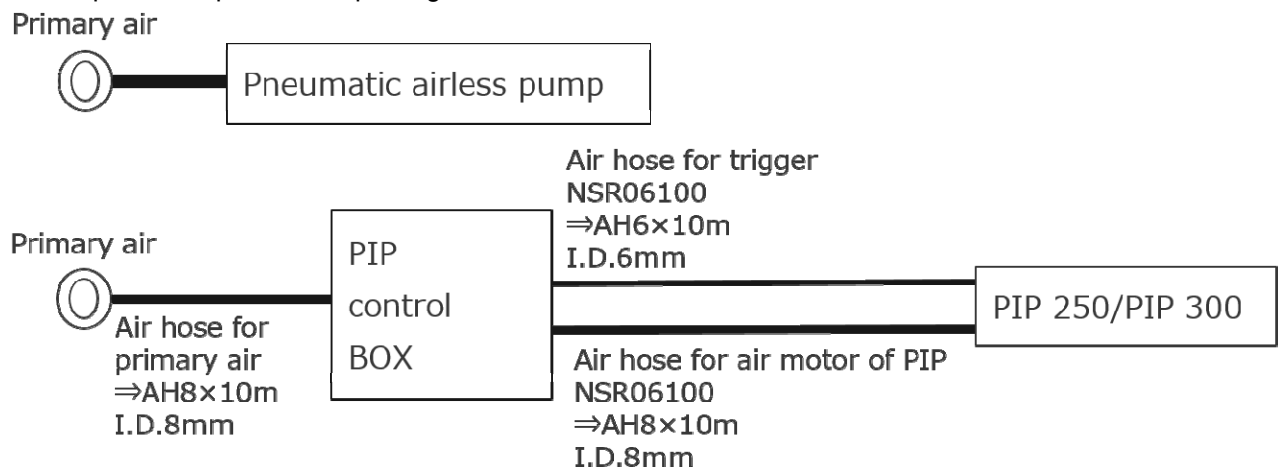
④ Maintenance of the equipment

- (1) Re-grease the gears in the gear case regularly (usually every 500 hours).
 - (2) If the paint starts leaking from the adapter, replace the V-packings.
The replacement procedure is described below.
Remove the nozzle extension and nipple. Then, remove the packings one by one using a needle-like pin. Assemble in the reverse order of disassembly. Take care to install the V-packings in the correct direction.
 - (3) If the dried paint clogs up, overhaul and clean.
 - (4) The paint leakage from the packing retainer in the PIP automatic gun can be stopped by tightening the retainer. If it persists, replace the V-packings with new ones.
The replacement procedure is described below.
 - 1) Set the 1/4B ball cock to "OFF" and loosen the flareless joint.
 - 2) Loosen the hexagon socket screws and remove the PIP automatic gun.
 - 3) The automatic gun overhauling procedure is described below.
Loosen the hexagon socket screws and slightly pull out the air cylinder section. Remove the packing retainer from the gun head and further pull out the air cylinder section. The needle shaft is then removed together.
 - 4) Remove the V-packings using a needle-like pin. Assemble in the reverse order of disassembly. Take care to install the V-packings in the correct direction. Also check the O-ring at this time and replace if damaged.
- ※ In case of the PIP100, loosen the lock nut and remove the V-packings using a wrench on the opposing edges (17) of the extension at the nozzle mounted side and the opposing edges (19) of the seal housing for automatic gun.

⑤ Other precautionary notes

- (1) The equipment body is contaminated with paint, etc. when inside the pipe and shall be covered with a vinyl chloride sheet or such. The sheet shall be occasionally replaced.
- (2) The compressed air to be supplied to the air cylinder for PIP automatic gun and the spray nozzle rotating air motor shall be free from moisture and foreign matter.
- (3) Do not raise the paint pressure exceeding the required value. The maximum operating pressure for the coating equipment is 20MPa.
- (4) The compressed air to be supplied to the spray switch valve shall be adjusted between 0.5 and 0.7MPa.
- (5) The spray nozzle discharge rate and pattern width shall be appropriately selected from the spray nozzle table in connection with the pipe to be coated.
- (6) When using the PIP250 or PIP300, the control box air source should be independent of the pneumatic airless pump or other air source.
If you supply the air by branching from the same air hose, the rotation of the air motor will become unstable or stop, and uniform coating will not be possible. (The following figure shows an example of air piping.)

<Example of compressed air passage>



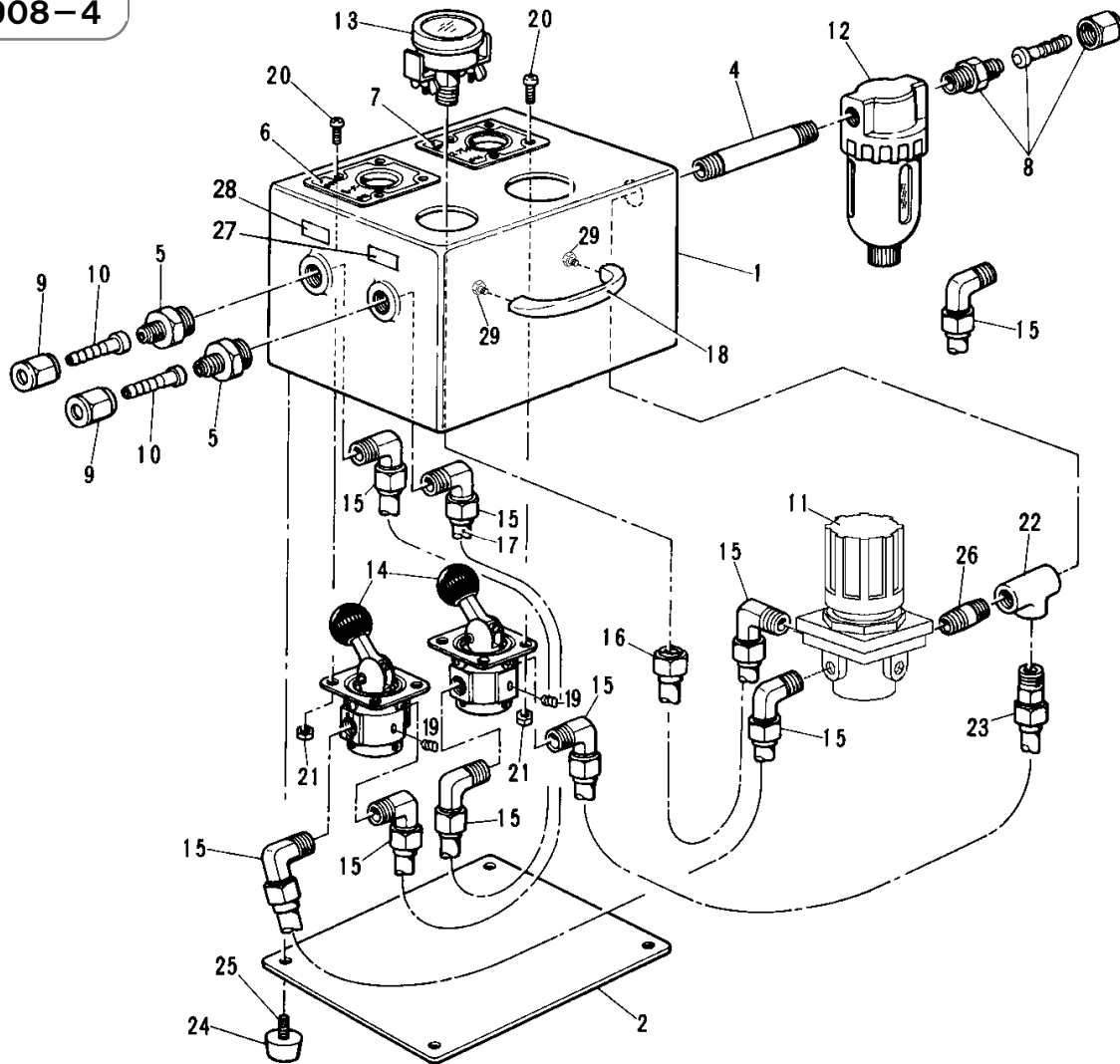
- (7) By using embedded plug, you can stop paint to the nozzle tip.

5

Exploded Diagram and Names of Parts

APCB1

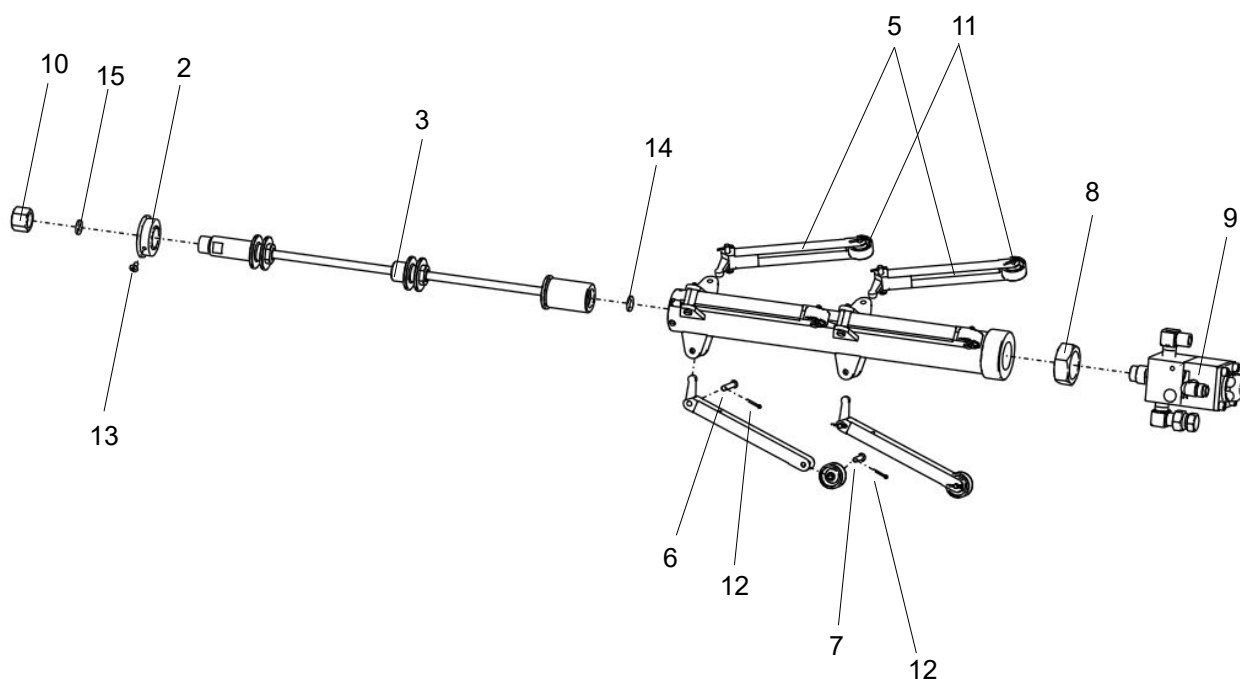
3908-4



PIP control box APCB1

| No. | Part No. | Part name | Qty | Remarks |
|-----|----------|-----------------------------|-------|---------|
| 1 | 3908-401 | Box | 1 | |
| 2 | 3908-002 | Plate | 1 | |
| 3 | Nil | | | |
| 4 | 3908-004 | Long nipple | 1 | |
| 5 | 3908-005 | Nipple | 2 | |
| 6 | 3908-206 | Nameplate | 1 | |
| 7 | 3908-207 | Nameplate | 1 | |
| 8 | 2801 | Rubber hose universal joint | 1 set | |
| 9 | 2801-002 | Nut | 2 | |
| 10 | 2801-003 | Joint | 2 | |
| 11 | 301-0025 | Air regulator | 1 | |
| 12 | 303-0029 | Air filter | 1 | |
| 13 | 305-0004 | Pressure gauge | 1 | |
| 14 | 3908-414 | Switch valve | 2 | |

| No. | Part No. | Part name | Qty | Remarks |
|-----|----------|-----------------------------|-------|---------|
| 15 | 379-0802 | Quick Joint | 8 | |
| 16 | 377-0802 | Quick Joint | 1 | |
| 17 | 593-0015 | Air tube | 1 set | |
| 18 | 322-0009 | Handle | 1 | |
| 19 | 86-70404 | Hex socket hd set screw | 2 | |
| 20 | 68-10512 | Cross recessed pan hd screw | 8 | |
| 21 | 15-10500 | Hex. nut | 8 | |
| 22 | 205-3002 | Tee | 1 | |
| 23 | 376-0802 | Quick Joint | 1 | |
| 24 | 3908-024 | Leg | 4 | |
| 25 | 03-50615 | Hex socket hd cap screw | 4 | |
| 26 | 232-2002 | Thick nipple | 1 | |
| 27 | 3908-008 | Nameplate | 1 | |
| 28 | 3908-009 | Nameplate | 1 | |
| 29 | 01-10610 | Hex bolt | 2 | |



Pipe Inside Spray Gun PIP100

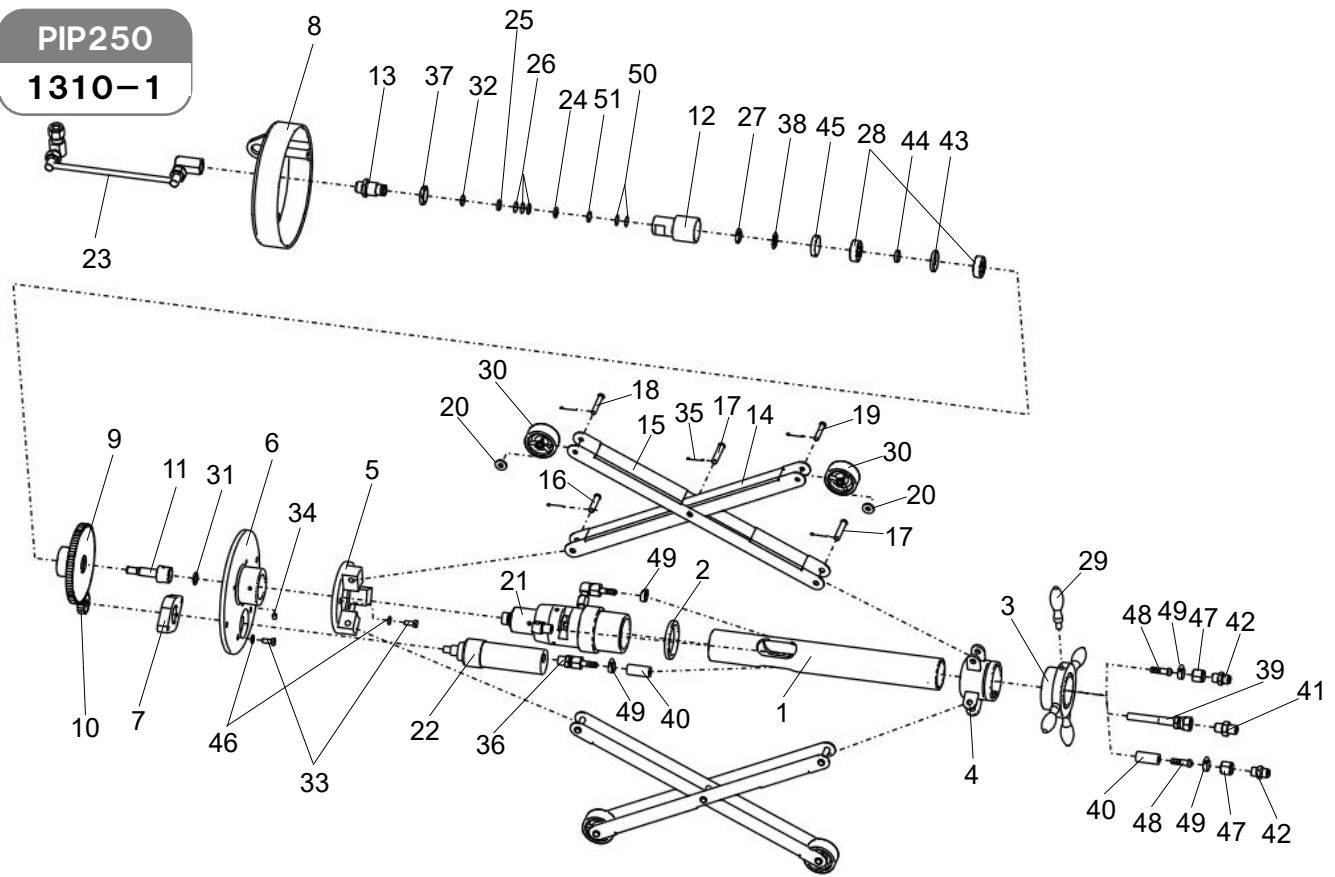
| No. | Part No. | Part name | Qty | Remarks |
|-----|----------|------------|--------|---------|
| 1 | 1309-001 | Housing | 1 set | |
| 2 | 1309-002 | Head plate | 1 | |
| 3 | 1309-103 | Extension | 1 set | |
| 4 | Nil | | | |
| 5 | 1309-005 | Caster arm | 6 sets | |
| 6 | 1309-006 | Pin | 6 | |
| 7 | 1309-007 | Pin | 6 | |
| 8 | 1309-008 | Lock nut | 1 | |

| No. | Part No. | Part name | Qty | Remarks |
|-----|----------|-------------------------------|-------|---------|
| 9 | 1383-1 | Automatic gun | 1 set | |
| 10 | 1201-103 | Retaining nut | 1 | |
| 11 | 309-0019 | Caster | 6 | |
| 12 | 49-10210 | Split pin | 12 | |
| 13 | 70-10408 | Raised countersunk head screw | 3 | |
| ※14 | 146-3002 | Gasket | 1 | |
| ※15 | 146-3003 | Gasket | 1 | |

Items marked with ※ are the parts we recommend you to carry in stock.

CAUTION: For No.9 1383-1 automatic gun, see the separate Operation and Maintenance Manual for 「Airless Automatic Gun<AG series>」.

PIP250
1310-1



Pipe Inside Spray Gun PIP250

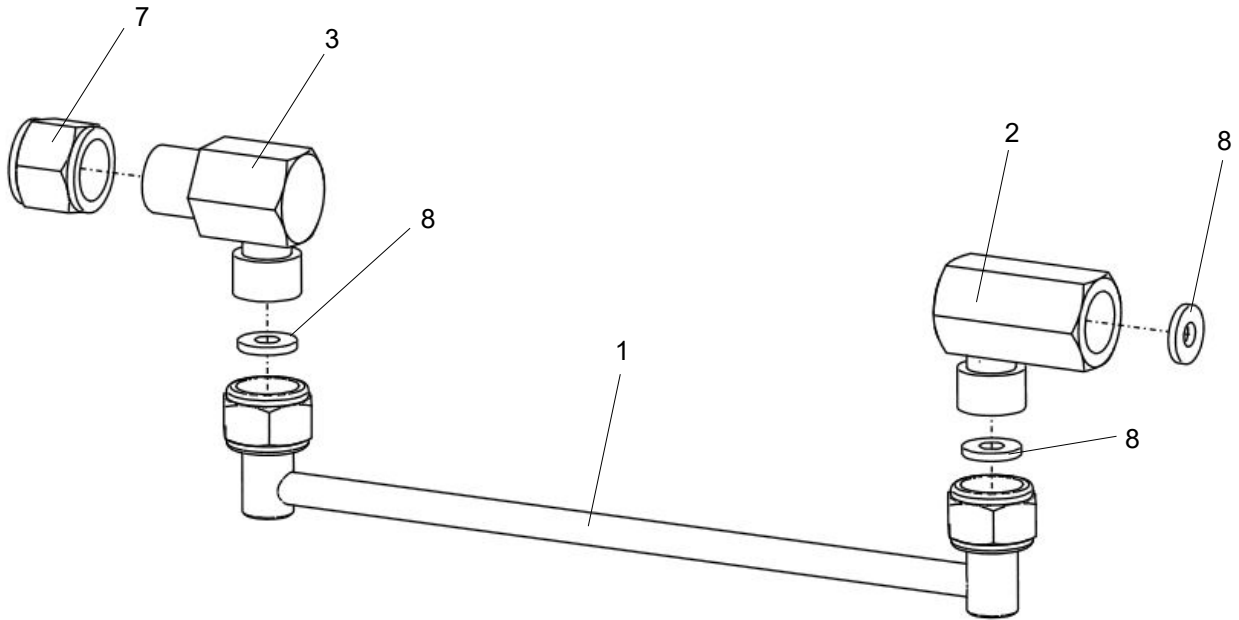
| No. | Part No. | Part name | Qty | Remarks |
|-----|------------|-------------------|-------|---------|
| 1 | 1310-001 | Pole | 1 | |
| 2 | 1310-002 | Lock nut | 1 | |
| 3 | 1310-003 | Adjuster | 1 set | |
| 4 | 1310-104 | Slide support | 1 set | |
| 5 | 1310-105 | Arm support | 1 | |
| 6 | 1310-006 | Bracket | 1 | |
| 7 | 1310-007 | Motor support | 1 | |
| 8 | 1310-008 | Gear case | 1 | |
| 9 | 1310-009 | Gear | 1 | |
| 10 | 1310-010 | Pinion gear | 1 | |
| 11 | 1310-211 | Socket | 1 | |
| 12 | 1310-012 | Adaptor | 1 | |
| 13 | 1310-113 | Nipple | 1 | |
| 14 | 1310-014 | Arm A | 3 | |
| 15 | 1310-115 | Arm B | 3 | |
| 16 | 1310-016 | Pin A | 3 | |
| 17 | 1310-017 | Pin B | 6 | |
| 18 | 1310-018 | Pin C | 3 | |
| 19 | 1310-019 | Pin D | 3 | |
| 20 | 1310-020 | Collar | 6 | |
| 21 | 1334 | PIP automatic gun | 1 set | |
| 22 | 1310-022 | Air motor | 1 set | |
| 23 | 1601 | Nozzle extension | 1 set | |
| 24 | 2905-006 | Packing gland | 1 | |
| 25 | 2905-005 | Packing gland | 1 | |
| ※26 | V851000160 | V-packing | 3 | |

| No. | Part No. | Part name | Qty | Remarks |
|-----|-----------|-----------------------------|-------|---------|
| 27 | 361-0007 | Bearing nut | 1 | |
| 28 | 1310-028 | Bearing | 2 | |
| 29 | 322-0002 | Handle | 4 | |
| 30 | 309-0018 | Caster | 6 | |
| ※31 | 103-6011 | O-RING | 1 | |
| ※32 | 101-6012 | O-RING | 1 | |
| 33 | 01-10615 | Hex. bolt | 7 | |
| 34 | 85-50610 | Hex. socket screw | 3 | |
| 35 | 49-10220 | Split pin | 15 | |
| 36 | 2801 | Rubber hose universal joint | 1 set | |
| 37 | 1310-037 | Lock nut | 1 | |
| 38 | 362-0007 | Bearing washer | 1 | |
| 39 | 503-10057 | Material hose | 1 | |
| 40 | 547-10057 | Air hose | 2 | |
| 41 | 248-2202 | Interim nipple | 1 | |
| 42 | 2817-001 | Rubber hose interim nipple | 2 | |
| 43 | 1310-043 | Spacer | 1 | |
| 44 | 1310-044 | Spacer | 1 | |
| 45 | 1310-045 | Ring | 1 | |
| 46 | 41-50600 | Spring washer | 7 | |
| 47 | 2801-002 | Nut | 2 | |
| 48 | 2801-003 | Joint | 2 | |
| 49 | 307-0006 | Jack band | 4 | |
| 50 | 2922-009 | Spacer | 2 | |
| 51 | 1310-051 | Spacer | 1 | |

Items marked with ※ are the parts we recommend you to carry in stock.

Nozzle extension (PIP250)

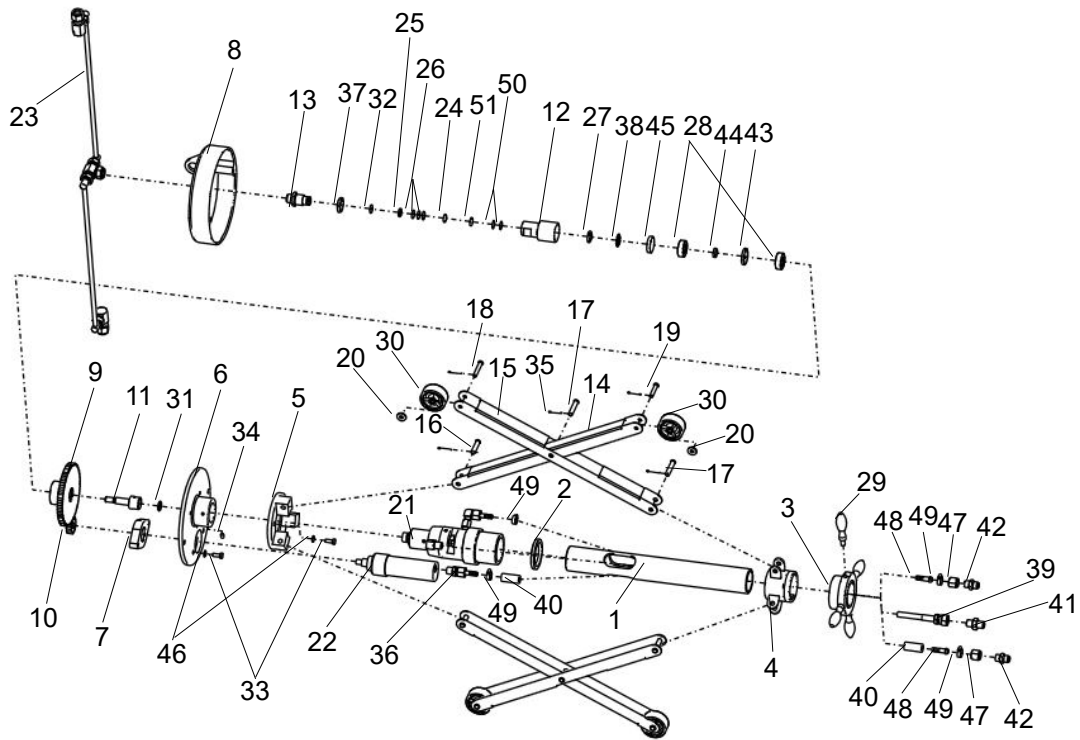
Nozzle extension
1601



| No. | Part No. | Part name | Qty | Remarks |
|-----|----------|---------------|-----|----------|
| 1 | 1601-101 | Pipe | 1 | |
| 2 | 1601-102 | Joint | 1 | |
| 3 | 1601-103 | Head | 1 | |
| 4 | Nil | | | |
| 5 | Nil | | | |
| 6 | Nil | | | |
| 7 | 1203-019 | Retaining nut | 1 | G(PF)3/8 |
| 8 | 146-3003 | Gasket | 3 | |

PIP300

1311-1



Pipe Inside Spray Gun PIP300

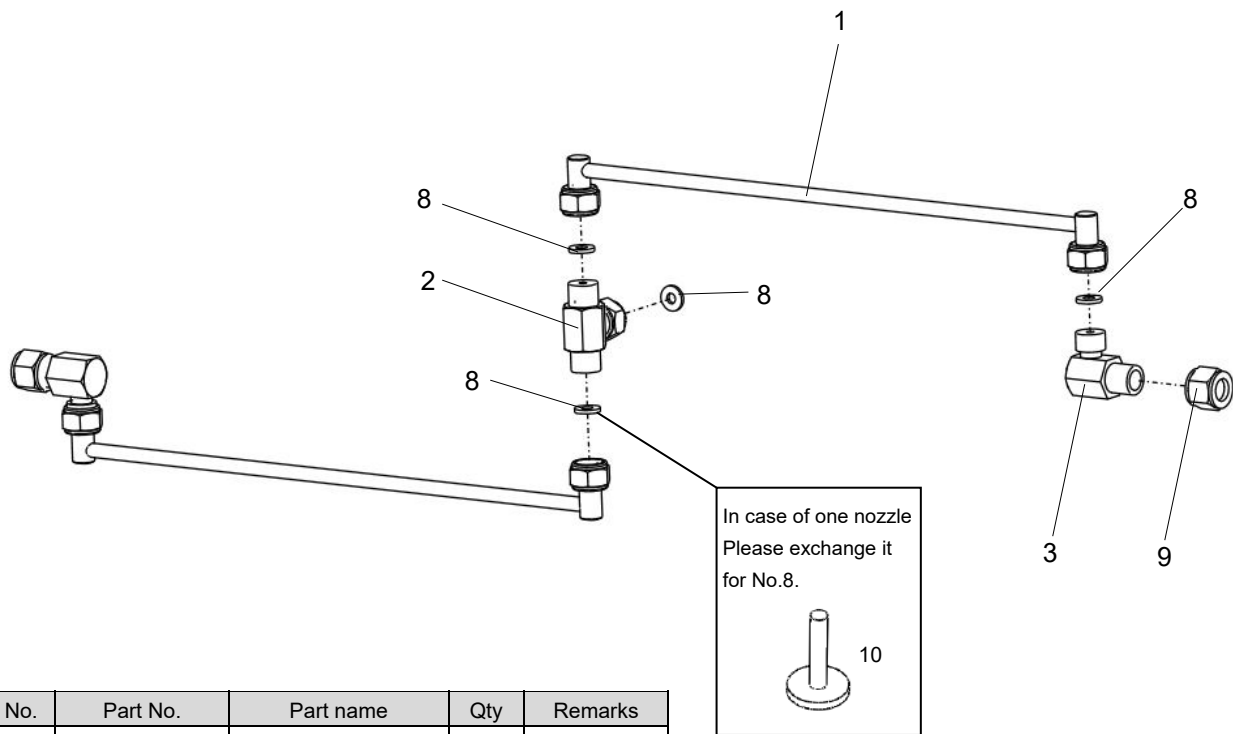
| No. | Part No. | Part name | Qty | Remarks |
|-----|------------|-------------------|-------|---------|
| 1 | 1311-001 | Pole | 1 | |
| 2 | 1310-002 | Lock nut | 1 | |
| 3 | 1310-003 | Adjuster | 1 set | |
| 4 | 1310-104 | Slide support | 1 set | |
| 5 | 1310-105 | Arm support | 1 | |
| 6 | 1310-006 | Bracket | 1 | |
| 7 | 1310-007 | Motor support | 1 | |
| 8 | 1310-008 | Gear case | 1 | |
| 9 | 1310-009 | Gear | 1 | |
| 10 | 1310-010 | Pinion gear | 1 | |
| 11 | 1310-211 | Socket | 1 | |
| 12 | 1310-012 | Adaptor | 1 | |
| 13 | 1310-113 | Nipple | 1 | |
| 14 | 1311-014 | Arm A | 3 | |
| 15 | 1311-115 | Arm B | 3 | |
| 16 | 1310-016 | Pin A | 3 | |
| 17 | 1310-017 | Pin B | 6 | |
| 18 | 1310-018 | Pin C | 3 | |
| 19 | 1310-019 | Pin D | 3 | |
| 20 | 1310-020 | Collar | 6 | |
| 21 | 1334 | PIP automatic gun | 1 set | |
| 22 | 1310-022 | Air motor | 1 set | |
| 23 | 1602 | Nozzle extension | 1 set | |
| 24 | 2905-006 | Packing gland | 1 | |
| 25 | 2905-005 | Packing gland | 1 | |
| ※26 | V851000160 | V-packing | 3 | |

| No. | Part No. | Part name | Qty | Remarks |
|-----|----------|-----------------------------|-------|---------|
| 27 | 361-0007 | Bearing nut | 1 | |
| 28 | 1310-028 | Bearing | 2 | |
| 29 | 322-0002 | Handle | 4 | |
| 30 | 309-0030 | Caster | 6 | |
| ※31 | 103-6011 | O-ring | 1 | |
| ※32 | 101-6012 | O-ring | 1 | |
| 33 | 01-10615 | Hex. bolt | 7 | |
| 34 | 85-50610 | Hex. socket screw | 3 | |
| 35 | 49-10220 | Split pin | 15 | |
| 36 | 2801 | Rubber hose universal joint | 1 set | |
| 37 | 1310-037 | Lock nut | 1 | |
| 38 | 362-0007 | Bearing washer | 1 | |
| 39 | 503-1008 | Material hose | 1 | |
| 40 | 547-1008 | Air hose | 2 | |
| 41 | 248-2202 | Interim nipple | 1 | |
| 42 | 2817-001 | Rubber hose interim nipple | 2 | |
| 43 | 1310-043 | Spacer | 1 | |
| 44 | 1310-044 | Spacer | 1 | |
| 45 | 1310-045 | Ring | 1 | |
| 46 | 41-50600 | Spring washer | 7 | |
| 47 | 2801-002 | Nut | 2 | |
| 48 | 2801-003 | Joint | 2 | |
| 49 | 307-0006 | Jack band | 4 | |
| 50 | 2922-009 | Spacer | 2 | |
| 51 | 1310-051 | Spacer | 1 | |

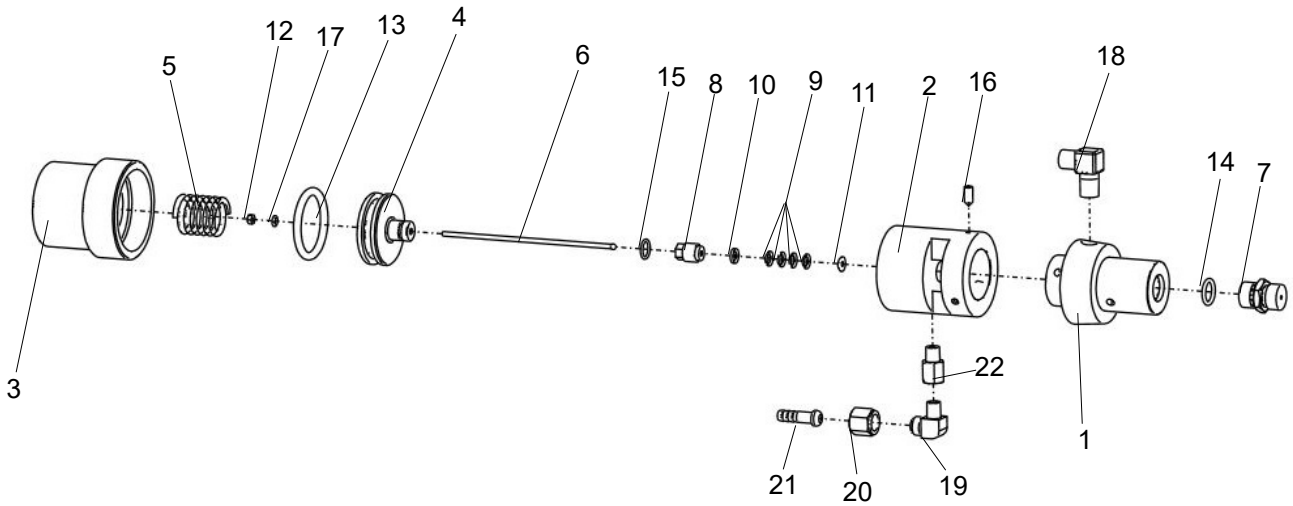
Items marked with ※ are the parts we recommend you to carry in stock.

Nozzle extension (PIP300)

Nozzle extension
1602



| No. | Part No. | Part name | Qty | Remarks |
|-----|----------|---------------|-----|----------|
| 1 | 1602-101 | Pipe | 2 | |
| 2 | 1602-102 | Joint | 1 | |
| 3 | 1601-103 | Head | 2 | |
| 4 | Nil | | | |
| 5 | Nil | | | |
| 6 | Nil | | | |
| 7 | Nil | | | |
| 8 | 146-3003 | Gasket | 5 | |
| 9 | 1203-019 | Retaining nut | 2 | G(PF)3/8 |
| 10 | 1602-010 | Embedded plug | 1 | |



PIP automatic gun (PIP 250-300) APAG-P

| No. | Part No. | Part name | Qty | Remarks |
|-----|------------|------------------|-------|---------|
| 1 | 1334-001 | Gun head | 1 | |
| 2 | 1334-002 | Air cylinder | 1 | |
| 3 | 1334-003 | Cap | 1 | |
| 4 | 1334-004 | Piston | 1 | |
| 5 | 1334-005 | Spring | 1 | |
| 6 | 1334-006 | Needle shaft | 1 set | |
| 7 | 1309-009 | Seat housing | 1 set | |
| 8 | 1203-113 | Packing retainer | 1 | |
| ※9 | V850320105 | V-packing | 4 | |
| 10 | 1203-124 | Packing gland | 1 | |
| 11 | 1203-125 | Packing gland | 1 | |

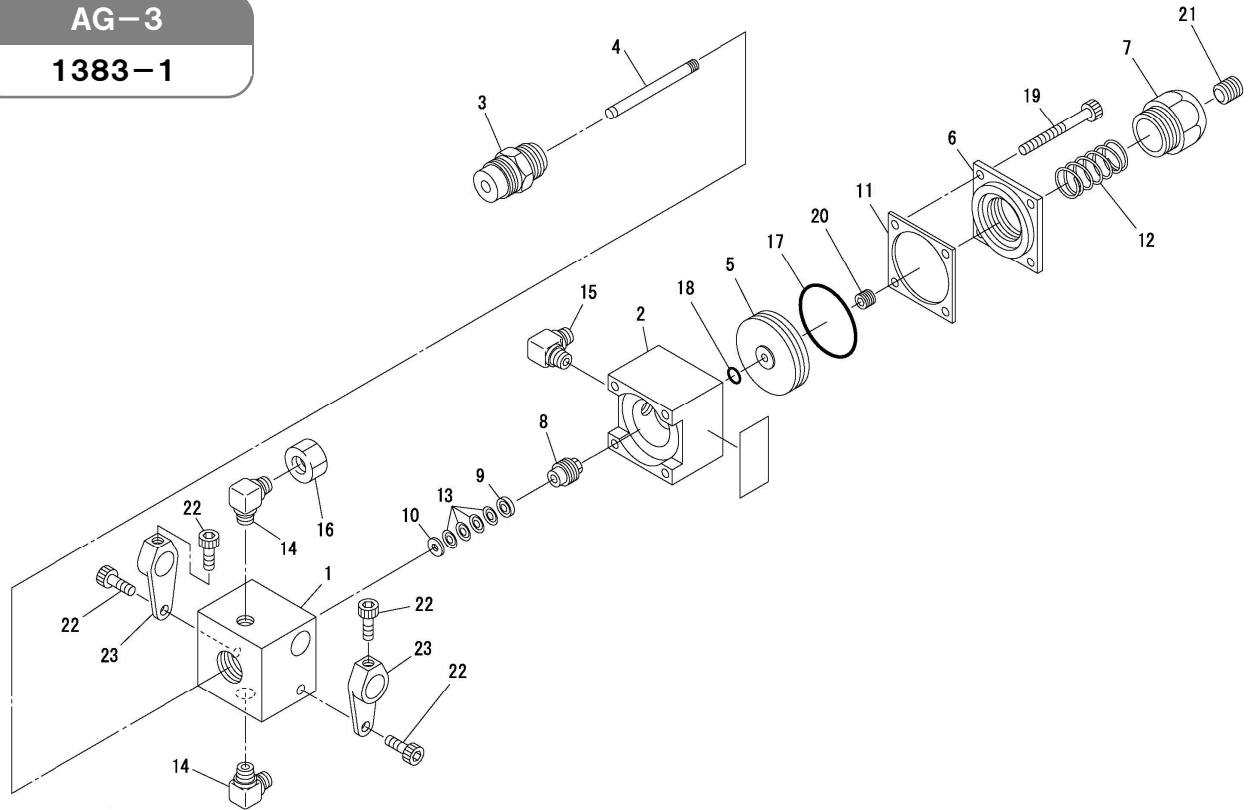
| No. | Part No. | Part name | Qty | Remarks |
|-----|----------|----------------------------------|-----|---------|
| 12 | 1302-110 | Hex. nut | 1 | |
| ※13 | 103-6029 | O-ring | 1 | |
| ※14 | 103-6011 | O-ring | 1 | |
| ※15 | 105-6013 | O-ring | 1 | |
| 16 | 85-50614 | Hex. socket screw | 3 | |
| 17 | 41-50400 | Spring washer | 1 | |
| 18 | 249-2202 | L type hose joint | 1 | |
| 19 | 3210-001 | L type nipple | 1 | |
| 20 | 2801-002 | Nut | 1 | |
| 21 | 2801-003 | Joint | 1 | |
| 22 | 280-2101 | High pressure male/female nipple | 1 | |

Items marked with ※ are the parts we recommend you to carry in stock.

Note: The configurations and specifications of the equipment are subject to change without prior notice due to continuous improvements which we incorporate into equipment as they are made.

AG-3

1383-1



PIP automatic gun (PIP 100 AG-3)

| No. | Part No. | Part name | Qty | Remarks |
|-----|----------|------------------|-----|---------|
| 1 | 1383-001 | Body | 1 | |
| 2 | 1381-002 | Cylinder | 1 | |
| *3 | 1381-003 | Seat | 1 | |
| *4 | 1381-004 | Needle | 1 | |
| 5 | 1381-005 | Piston | 1 | |
| 6 | 1381-006 | End plate | 1 | |
| 7 | 1381-007 | End cap | 1 | |
| 8 | 1381-009 | Packing adjuster | 1 | |
| 9 | 1203-124 | Packing retainer | 1 | |
| 10 | 1203-125 | Packing retainer | 1 | |
| 11 | 1381-013 | Gasket | 1 | |

| No. | Part No. | Part name | Qty | Remarks |
|-----|------------|-----------------------|-----|---------|
| 12 | 1381-014 | Spring | 1 | |
| *13 | V850320105 | V-packing | 4 | |
| 14 | 249-2202 | L-shaped hose joint | 2 | |
| 15 | 3210-101 | Elbow nipple | 1 | |
| 16 | 278-2002 | Plug | 1 | |
| *17 | 101-6034 | O-ring | 1 | |
| *18 | 101-6003 | O-ring | 1 | |
| 19 | 03-80545 | Hex. socket bolt | 4 | |
| 20 | 86-50506 | Hex. socket set screw | 1 | |
| 21 | 1381-030 | Leak plug | 1 | |

* As for the parts marked with an asterisk (*), it is recommended to purchase enough amount as spare parts.

Optional parts

| No. | Part No. | Part name | Qty | Remarks |
|-----|----------|------------------|-----|---------|
| 1 | 03-80510 | Hex. socket bolt | 4 | |
| 2 | 1381-028 | Gun holder | 2 | |

Accessory tool

| No. | Part No. | Part Name | Qty | Remarks |
|-----|----------|------------------|-----|---------|
| 1 | 3511-201 | Dedicated wrench | 1 | |

Note: Because of possible modifications, such as improvements, changes may be made without advance notice, to both the configuration and the specifications of this equipment.

6

Maintenance Log

Shown below is a maintenance log format of a kind we recommend you to keep. Each time that you conduct a maintenance service, such as replacement of a part, tear-down cleaning, post-failure repair, etc., record the details. In the long run, you will find that such a log is very valuable in keeping your equipment in a consistently good operating condition.

| Equipment name | PIP automatic gun<PIP100·250·300> | | | Date of acquisition: YYYY/MM/DD | |
|-----------------|-----------------------------------|-------------|---------|---------------------------------|--|
| Date of service | Portion worked on | Description | Results | Who serviced | |
| | | | | In-house / Agency / Asahi Sunac | |
| | | | | In-house / Agency / Asahi Sunac | |
| | | | | In-house / Agency / Asahi Sunac | |
| | | | | In-house / Agency / Asahi Sunac | |
| | | | | In-house / Agency / Asahi Sunac | |

7

Warranty

ASAHI SUNAC CORPORATION (the "Company") shall provide the original purchaser (the "Purchaser") with warranty service for a period of one (1) year 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】

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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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17th Edition: July 11, 2022

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Chinese

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