

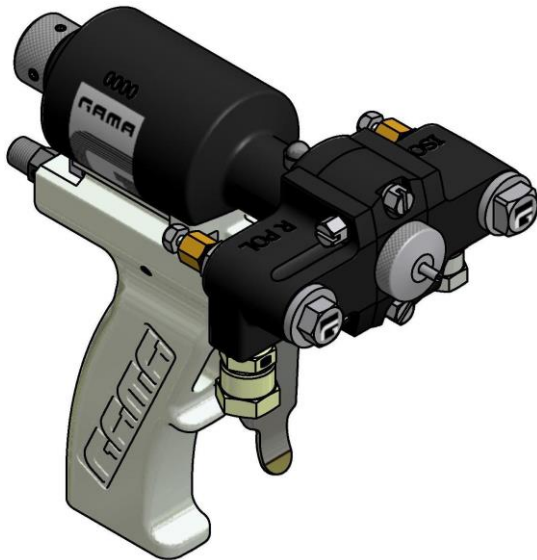


Service Manual

Spray Gun

Series Master

2.1 Issue 1/24/2022
Ref. NR-00008-ENG



Before installing the Master Gun and starting it up, carefully read all the technical and safety documentation included in this manual. Pay special attention to the information to know and understand the operation and the conditions of use of the gun. All of the information is aimed at enhancing User Safety and avoiding possible breakdowns derived from the incorrect use of the Gun.



WARRANTY

HI-TECH SPRAY EQUIPMENT, S. A. (hereinafter "HI-TECH") grants this Limited Guarantee to the original buyer (hereinafter the "Client") for the unit and the original accessories given with the unit (hereinafter the "Product") against any fault in the design, materials or manufacture of the Product at the time of the first purchase by the user and for a duration of two (2) years thereafter.

If during the guarantee period and under normal conditions of use, the Product should fail to work correctly due to defects of design, material or manufacture, the authorised distributor of the country where the HI-TECH Product or technical assistance service has been purchased shall repair or replace the Product in accordance with what is established in the following:

CONDITIONS

- a) The validity of this guarantee will be subject to the presentation of the original invoice issued by the HI-TECH authorised distributor for the sale of the Product along with the Product handed over for repair or replacement, which must show the date of purchase and the serial number. HI-TECH reserves the right to refuse to give the guarantee service when the indicated data fail to appear on the invoice or have been modified after the purchase of the Product.
- b) The repaired or replaced Product will continue to maintain the original guarantee for the time remaining until the end of the guarantee or for three (3) months from the repair date, if the remaining period of the original guarantee were shorter.
- c) This guarantee will not be applied to the faults in the Product caused by its faulty installation, the natural wear and tear of the components, any use other than that considered normal for this Product or which should fail to strictly comply with the instructions of use provided by HI-TECH; due to accident, carelessness, adjustments, alterations or modifications of the Product not authorised by HI-TECH or due to the use of accessories, heating devices, pumping equipment and/or dispensers that have not been approved or manufactured by HI-TECH.
- d) The guarantee applicable to the components and accessories forming part of the Product and which have not been made by HI-TECH will be limited to the guarantee offered by the original manufacturer thereof.

HI-TECH WILL NOT RECOGNISE ANY EXPRESS ORAL OR WRITTEN GUARANTEES OTHER THAN THIS PRINTED LIMITED GUARANTEE. ALL IMPLICIT GUARANTEES, INCLUDING, WITHOUT LIMIT, ADAPTATION FOR A SPECIFIC USE, ARE SUBJECT TO THE DURATION OF THIS WRITTEN GUARANTEE. HI-TECH DOES NOT ASSUME ANY KIND OF COMMITMENT OR RESPONSIBILITY FOR ALL POSSIBLE DAMAGE OR EXPENSE CAUSED BY FAULTS IN THE OUTPUT OF THE PRODUCT, ITS WORKING OR THE DISPENSING OF MATERIAL THROUGH THE PRODUCT, INCLUDING, WITHOUT LIMITATION, ALL EXPENSES CAUSED BY DAMAGE TO PEOPLE OR PROPERTY. EQUALLY, HI-TECH WILL IN NO CASE ACCEPT LIABILITY FOR THE LOSS OF SPECULATIVE PROFITS OR COMMERCIAL LOSSES. ALL REPAIRS OR REPLACEMENT OF FAULTY PRODUCTS WILL CONSTITUTE THE COMPREHENSIVE FULFILMENT OF HI-TECH'S OBLIGATIONS WITH RESPECT TO THE CLIENT. HI-TECH DOES NOT IN ANY WAY GUARANTEE THE SUITABILITY OR APTITUDE OF ITS PRODUCT FOR ANY PARTICULAR PURPOSE OR APPLICATION.

All information provided on components which have not been manufactured by HI-TECH and which is based on reports received from the original manufacturer, though considered precise and reliable, is provided without any guarantee or responsibility of any explicit or implicit kind.

All concession, sale or financial leasing of the Product by HI-TECH in no case explicitly or implicitly constitutes any authorisation, acceptance or concession for the use of any rights or patents, nor does it encourage, nurture or back their infringement.

The restrictions on the guarantee suppose no limitation on the legal rights of the consumer established in applicable national legislation, nor do they affect any rights derived from the bargain and sale agreement between the consumer and supplier.

All information provided in this manual has been included in the confidence that it is true, although it does not constitute any responsibility or implicit or explicit guarantee. HI-TECH reserves the right at any time and without prior warning to make all improvements and modifications necessary to this manual, in order to rectify any possible typographical errors, increase the information contained or insert the changes caused to the characteristics and performance of the unit.



SAFETY AND HANDLING

The equipment described in this manual has been designed and manufactured in compliance with the following European Directives, following as application guide the harmonized standards detailed and in conformity with the relevant UK Statutory Instruments (and their amendments):

Directive 2006/42/EC on machinery (UK Supply of Machinery (Safety) Regulations 2008)

UNE EN 12100:2012 (BS EN ISO 12100:2010)

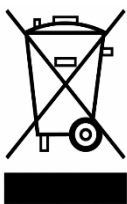
UNE EN 1953:2013 (BS EN 1953:2013)

Directive 2014/68/EU on pressure equipment (UK Pressure Equipment (Safety) Regulations 2016)

UNE EN 809:1999 +A1 (BS EN 809:1998 +A1:2009)

Directive 2011/65/EU on the restriction of the use of certain hazardous substances in electrical and electronic equipment with amendment 2015/863/EU (UK The Restriction of the Use of Certain Hazardous Substances in Electrical and Electronic Equipment Regulations 2012)

Directive 2012/19/EU on waste electrical and electronic equipment (UK The Waste Electrical and Electronic Equipment Regulations 2013)



Electrical products cannot be thrown out with the rubbish. They must be taken to a dedicated collection point for an environmentally sound disposal in accordance with local regulations. You must contact your local collective or retailer for information about recycling. Before leaving WEEE at appropriate collection facilities, batteries must be removed and disposed of separately for proper recycling. The packaging materials are recyclable. Dispose of packaging materials in an environmentally sound manner and place them at the disposal of recycling sectors.

TRANSPORT AND STORAGE

Proper precautions must be taken so that the equipment can withstand the effects of transport and storage temperatures between -25°C and +55°C or up to +70°C for short periods that do not exceed 24 hours. Also, appropriate means to prevent damage from moisture, vibrations or shocks must be foreseen.



This chapter contains important information on the safety, handling and use of your **GAMA MASTER** series gun.



Before installing the Master gun and starting it up, carefully read all the technical and safety documentation included in this manual. Pay special attention to the information to know and understand the operation and the conditions of use of the unit. All of the information is aimed at enhancing User Safety and avoiding possible breakdowns derived from the incorrect use of the gun

WARNING! establishes information to alert on a situation that might cause serious injuries if the instructions are not followed.

PRECAUTION! establishes information that indicates how to avoid damage to the gun or how to avoid a situation that could cause minor injuries.

NB: is relevant information on a procedure being carried out.

Careful study of this manual will enable the operator to know the characteristics of the gun and the operating procedures. By following the instructions and recommendations contained herein, you will reduce the potential risk of accidents in the installation, use or maintenance of the gun; you will provide a better opportunity for incident-free operation for a longer time, greater output and the possibility of detecting and resolving problems fast and simply.

Keep this Service Manual for future consultation of useful information at all times. If you lose this manual, ask for a new copy from your **HI-TECH** local distributor or directly contact **HI-TECH SPRAY EQUIPMENT, S.A.**

Important Safety Information

The master gun has been designed and built for the application of polyurea chemical systems, polyurethane foam chemical systems and some two-component epoxy systems.

WARNING: *The design and configuration of the gun do not allow its use in potentially explosive atmospheres or the pressure and temperature limits described in the technical specifications of this manual to be exceeded.*

Always use liquids and solvents that are compatible with the unit. In the event of doubt, consult the **HI-TECH** technical service.



When working with the gun, it is recommended that the operator wear suitable clothing and elements of personal protection, including, without limitation, gloves, protective goggles, safety footwear and face masks. Use breathing equipment when working with the gun in enclosed spaces or in areas with insufficient ventilation. The introduction and follow-up of safety measures must not be limited to those described in this manual. Before starting up the gun, a comprehensive analysis must be made of the risks derived from the products to be dispensed, the type of application and the working environment.



To prevent possible injury caused by incorrect handling of the raw materials and solvents used in the process, carefully read the safety data sheet provided by your supplier.



Deal with the waste caused according to current regulations.

To avoid damage caused by the impact of pressurized fluids, do not open any connection or perform maintenance work on components subject to pressure until the pressure has been completely eliminated.



Use suitable protection when operating, maintaining or being present in the area where the equipment is functioning. This includes, but is not limited to, the use of protective goggles, gloves, shoes and safety clothing and breathing equipment.

The equipment includes components that reach high temperatures and can cause burns. Hot parts of the equipment must not be handled or touched until they have cooled completely.



To prevent serious injury through crushing or amputation, do not work with the equipment without the safety guards installed on the moving parts. Make sure that all the safety guards are correctly reinstalled at the end of the repair or maintenance work of the equipment



CHARACTERISTICS

- * Internal mixture due to high pressure
- * Automatic cleaning with pressurized air
- * No solvents needed
- * Mechanical spraying
- * Exterior lubrication of the mix chamber

Approximate weight: 1 Kg

Dimensions: H 19 cm / W 10 cm / L 19 cm

TECHNICAL SPECIFICATIONS

Maximum working pressure:	210 bar (21 MPa)
Air pressure required:	6-8 bar (0,6-0,8 MPa)
Maximum production ratio 1:1:	18 Kg/min
Minimum production ratio 1:1:	1,5 Kg/min
Opening force @ 6 bar:	90 Kg
Closing force @ 6 bar:	93 Kg
Approximate air consumption @ 6 bar (50 cycles/min):	307 litres/minute

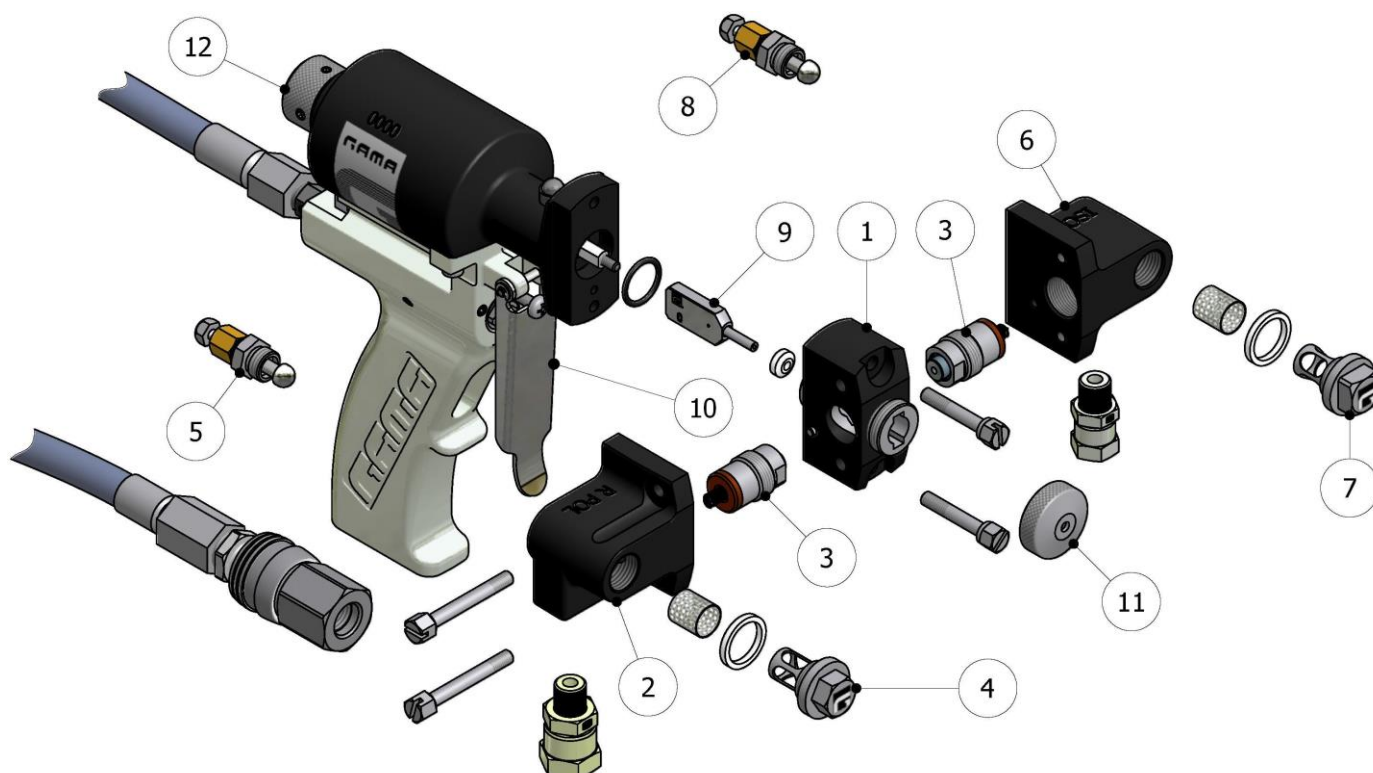
A-weighted sound pressure level: 77,2 dB (A)

A-weighted sound power level: 87,9 dB (A)

Values obtained according to UNE-EN ISO 3746:1995 standard.



GENERAL DESCRIPTION



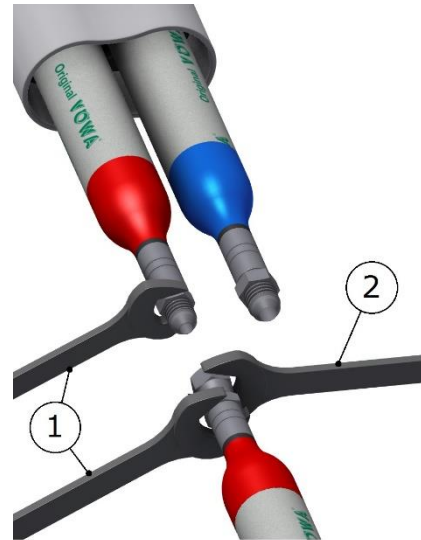
For better knowledge of the elements forming the **MASTER** series gun, the main components and their description are shown. For more precise identification, see the Components Manual ref. NR-00004-ENG

1. Gun block unit
2. Polyol input block unit
3. Metal sealing kit
4. Polyol filter body
5. Polyol manual valve
6. Isocyanate input block unit
7. Isocyanate filter body
8. Isocyanate manual valve
9. Mix chamber
10. Trigger
11. Diffuser
12. Blocking device

METHOD OF THREADED UNION OF THE HOSES

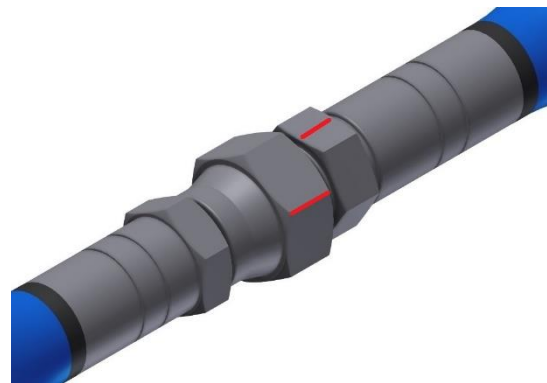
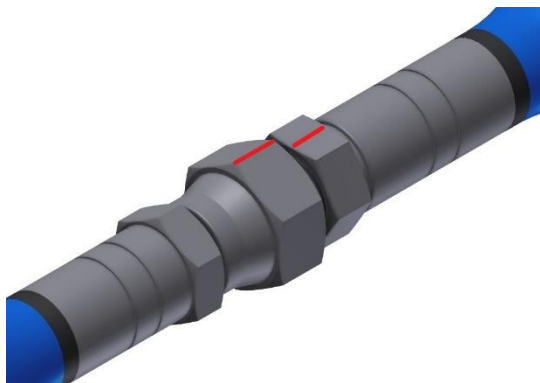
Follow the torques for threaded joints listed in **Table 1** according to thread sizes of hose fittings to ensure their proper assembly.

There is also an alternative procedure to obtain an equivalent torque without using special tools: joint both ends of the hoses to be connected, tighten a swivel nut by hand (without using spanner) until there is resistance on the nut. Fit two spanners (1) on the fixed ends of the hoses and turn the swivel nut with a third spanner (2) as many flats from wrench resistance (FFWR) as indicated in **Table 1**.



THREAD SIZE	TORQUE Nm	FFWR
1/2"-20	23	2 (or 120°)
9/16"-18	30	1-1/2 (or 90°)

NOTE: 1 FFWR corresponds to one complete shear of a flat marked with red between swivel and fitting or else 60°.





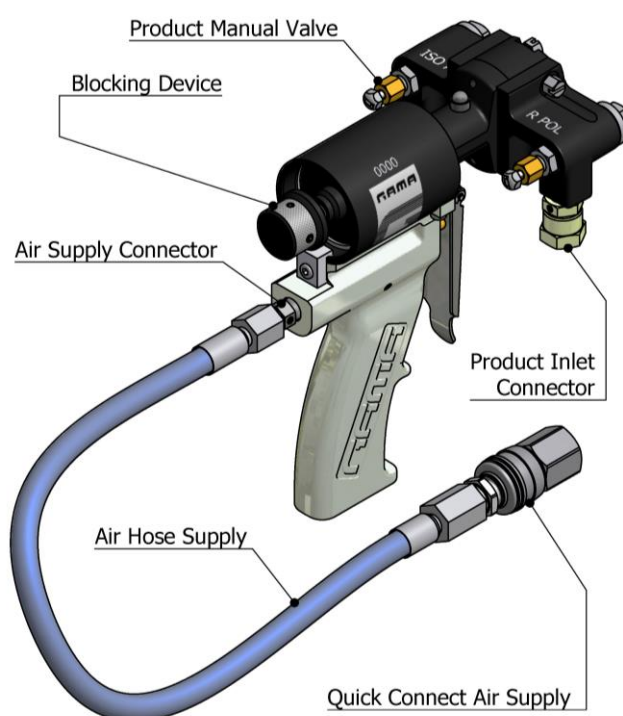
INSTALLATION AND START-UP

PRECAUTION: When working with the gun or performing maintenance work on it, wear suitable protection in accordance with the recommendations and specifications provided by the product suppliers.

HI-TECH provides a series of tools and accessories (**KT-00013**) that are necessary for assembling the gun. The tool kit is made up of the following elements:

49gr. Tube of grease	BI-00009	1x
5/16" Tube spanner	HT-00054	1x
Bits for cleaning	HT-00060	1x
Air hose supply	MA-00027	1x
Quick connect	RA-00109	1x
Adapter	RA-00110	1x
Service Manual	NR-00008	1x
Parts Identification Manual	NR-00004	1x

1. Close the manual valves by turning them to the full clockwise position. The manual valves control the flow of each product to the chamber and are located on the Isocyanate input block and the Polyol input block.
2. Press the safety stop and turn it clockwise to set it to the blocking position.
3. Fit the air supply pipe and connect it to the connector on the rear of the gun.
4. Connect the Isocyanate hose (red terminal) to the connection on the Isocyanate input block (letter A).
5. Connect the Polyol hose (blue terminal) to the connection on the Polyol input block. (letter R).



NB.: The product hoses are identified in red and blue, allowing the user to rapidly recognise them. The red corresponds to the Isocyanate hose and the blue to the Polyol hose. To avoid connection errors, the coupling connections of the Isocyanate and Polyol hoses are different sizes, which makes it impossible to swap connections.



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6. Connect the air supply to the gun.
7. Pressurise the gun and make sure there are no leaks.
8. Pull the trigger several times to check the correct movement of the mixing chamber.
9. Check that the pressure in the machine and the temperature of the heaters and the hoses is correct (see the Machine Service Manual).
10. Open the manual valves of each product by turning them to the full counter clockwise position.
11. Press the safety stop and turn it counter clockwise to set it to the spray position
12. Perform a test projection in a vessel.

WARNING: Before performing maintenance, repair or cleaning work, press the safety stop and turn it clockwise to set it to the blocking position, close the manual valves completely and disconnect the air supply to avoid possible accidents.

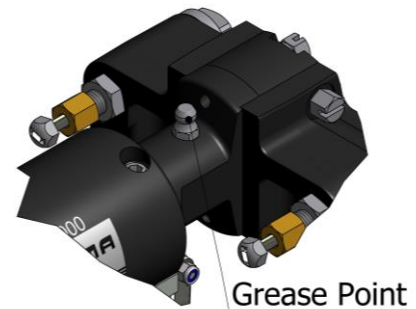


SHUTDOWN PROCEDURES

1. Perform the Unit Shutdown Procedures, following the method indicated in the Machine Service Manual.
2. Close the manual valves of each product by turning them to the full clockwise position.
3. To eliminate the pressure from the gun, pull the trigger and project the gun until the projection fan starts to reduce.
4. Press the safety stop and turn it clockwise to set it to the blocking position
5. Disconnect the air supply from the gun.
6. Lubricate the mixing chamber with a grease gun; this action will prevent the cleaning air of the gun from reacting with the ISOCYANATE product and avoiding crystallization which may damage the chamber and cap.

NB.: *The use of injecting lubrication into the gun at the end of the day will avoid maintenance time, as it will not be necessary to remove the chamber each day to clean it.*

PRECAUTION: *To avoid possible contamination by the product remains deposited in the components of the gun, do not exchange the Isocyanate parts with the Polyol parts. The gun has the Isocyanate side identified with the letter A.*



If the product hoses maintain the pressure, follow the Standstill Method indicated in the Machine Service Manual.

To eliminate the pressure from the hoses with the gun removed, fit the product input blocks in a suitable container, keep a reasonable distance away and very carefully and very slowly open the manual valves. Under pressure, the product will come out of the side of the blocks.

MAINTENANCE

To obtain maximum output from your **MASTER** gun, it is necessary to periodically perform certain maintenance operations.



To prevent possible injury caused by incorrect handling of the raw materials and solvents used in the process, carefully read the safety data sheet provided by your supplier.

Deal with the waste caused according to current regulations.



To prevent serious damage caused by the impact of pressurised fluids, never open a connection or perform maintenance work on components subject to pressure until all pressure has been eliminated.

Use suitable protection when operating, maintaining or being present in the area where the equipment is functioning. This includes, but is not limited to, the use of protective goggles, gloves, shoes and safety clothing and breathing equipment.



The equipment includes components that reach high temperatures and can cause burns. Hot parts of the equipment must not be handled or touched until they have cooled completely.

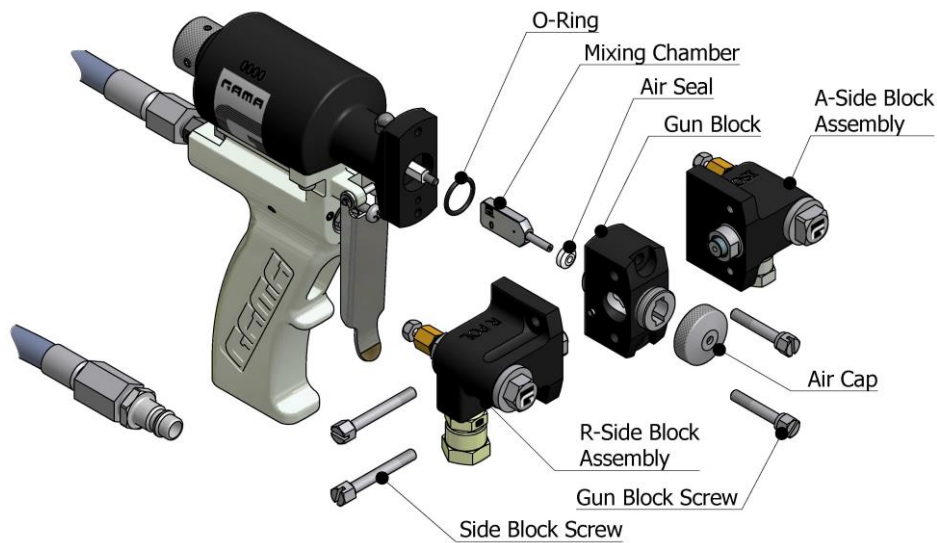


To prevent serious injury through crushing or amputation, do not work with the equipment without the safety guards installed on the moving parts. Make sure that all the safety guards are correctly reinstalled at the end of the repair or maintenance work of the equipment.



Gun block unit and mix chamber

WARNING: Before proceeding to carry out maintenance work on the gun, make sure that the unit is at a complete standstill, that all the buttons and the general switch are turned off and that the unit is disconnected from the main power supply. The gun is a component that works under pressure; no connection must be opened and maintenance work must not be performed on components subject to pressure until the pressure has been totally eliminated.



Unscrew the diffuser. Remove the bolts fixing the product input blocks to the gun block and carefully separate both blocks from the gun. Clean the contact surface using a cloth dampened in gun-cleaning solvent.

PRECAUTION: Use wooden or plastic utensils or a brass brush for cleaning. Do not use metal utensils that can scratch the contact surfaces.

Remove the gun block mounting bolts and separate the gun block by sliding it over the chamber. To eliminate the residual product, clean the gun block unit using a cloth dampened with gun cleaning solvent and a brass brush. Remove the o-ring.

Use a spanner to lock the end of the pneumatic cylinder shaft and unthread the mixing chamber. Clean the mix chamber and, if necessary, use a brush to go over the product passage holes. Make sure that the chamber is not scratched or marked.

Replace the chamber if there are any small faults.

Screw the chamber back onto the end of the pneumatic cylinder shaft.

Fit the gun block unit by sliding it over the chamber and fix it to the gun with the bolts. Make sure to fit the o-ring between the block and the fixing plate. Replace the o-ring if it is damaged. Tighten alternately to avoid possible leaks.

Fit the side blocks to the gun block with the corresponding bolts. Tighten alternately to avoid possible leaks. Screw on the Air Cap. The gun is now ready for service.

NOTE: If any of the manual valves must be replaced due to breakage or deterioration, make sure that before mounting them on the side blocks, they are fully open (that the ball is housed inside the body of the valve). If not, you could damage the manual valves when mounting them.

Side block unit

WARNING: Before performing maintenance work on the gun, make sure that the unit is at a complete standstill, that all of the buttons and the main switch are turned off and that the unit is disconnected from the main power supply. The gun is a component that works under pressure; no connection must be opened and no maintenance work must be done on components subject to pressure until the pressure has been completely eliminated.

Remove the side block mounting bolts on the Polyol side and carefully separate it from the gun block. Clean the contact surfaces using a cloth dampened in gun-cleaning solvent.

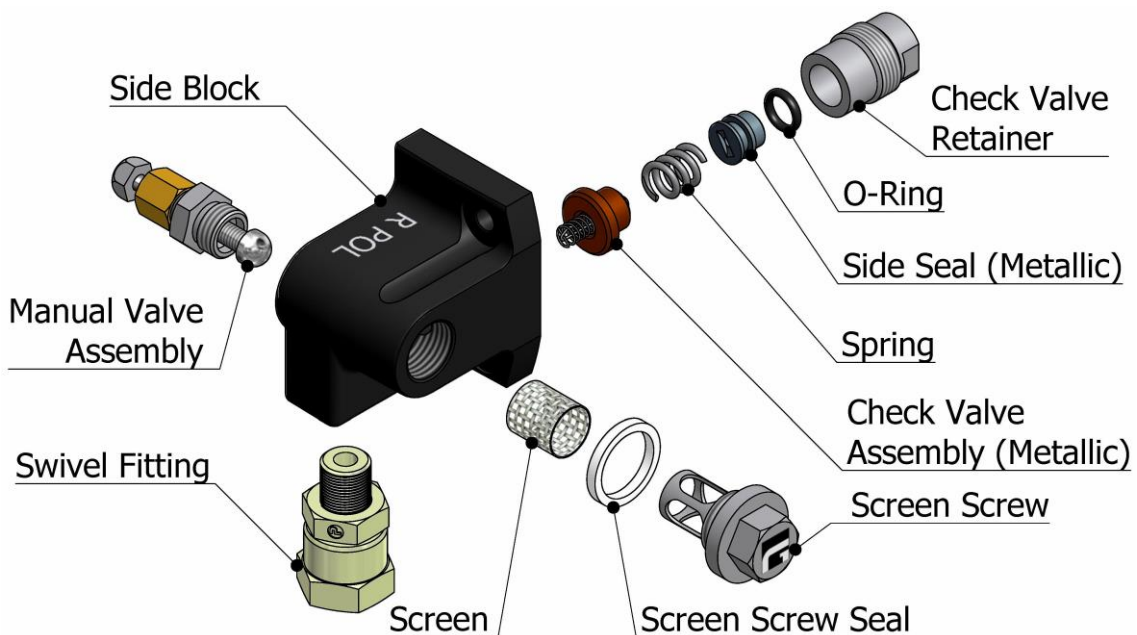
Unscrew the filter housing and remove the seal and the filter screen. Carefully clean the filter with gun cleaning solvent and check that the mesh is completely free from contaminants. Replace the filter screen as required.

Remove the check valve retainer from the side block.

Remove the plastic/metal non-return unit and clean it with gun-cleaning solvent. Replace it if damaged.

Remove the parts and clean with gun cleaning solvent or replace them as required.

Clean all of the components meticulously to eliminate the remains of product using a cloth dampened with gun cleaning solvent and a brass brush.



PRECAUTION: Use wooden or plastic utensils or a brass brush for cleaning. Do not use metal utensils that can scratch the contact surfaces.



Reassemble the check valve and side seal assembly.

In the model with a metal seal, you must fit the spring and the check valve into the retainer. To facilitate assembly, use a little grease to fit the o-ring in the metal seal cap; make sure that it is not damaged and replace it if necessary. Press the metal seal cap into the retainer until the o-ring is fitted in its groove.

Hand-tighten the metal seal and retainer into the side block. If you use a spanner, do not over-tighten the retainer more than 1/4 of a turn.

PRECAUTION: Do not tighten the check valve retainer excessively. Tightening more than 1/4 of a turn can damage the plastic/metal check valve and cause leaks.

Check the wear on the metal seal, by measuring the distance that it stands out from the cap housing. If the seal is worn, knocked or scratched, it can cause leaks. Replace the seal if it stands out less than 1.65 mm / 1/16 inch.

To check whether the metal check valve is damaged as a result of excessive tightening, make sure the separation between the support face of the side block and the bottom of the cap housing, once fitted, is 0.46 mm / 1/64 inch. If the separation is smaller, the check valve must be replaced.

Assemble the screen screw and screw it into the side block.

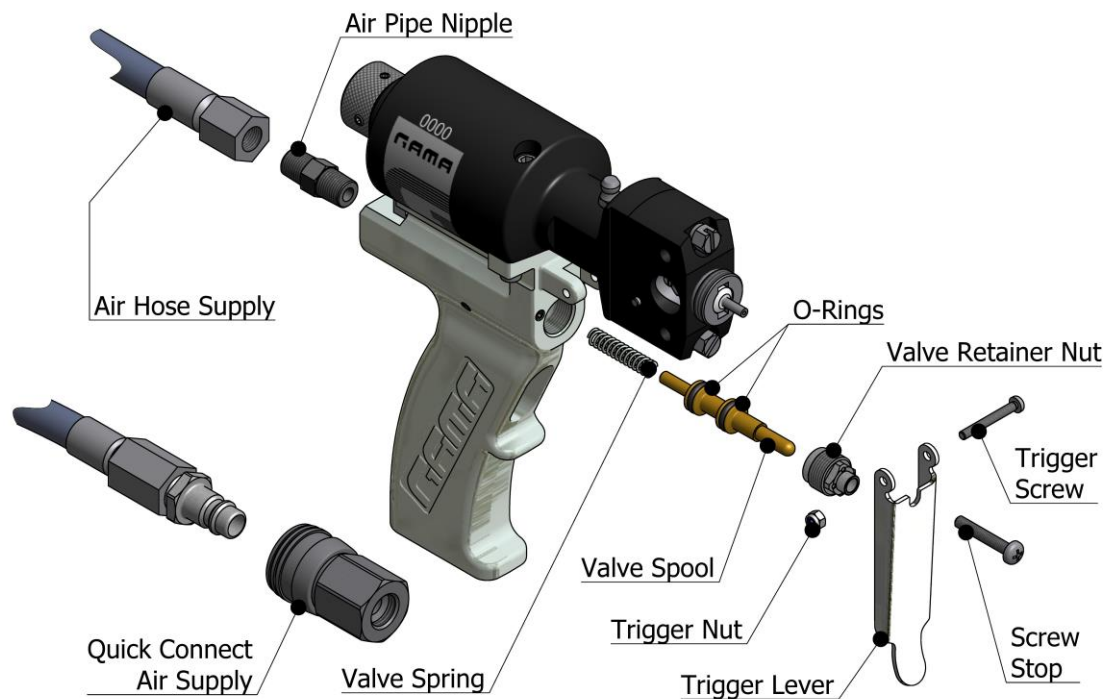
Fix the Polyol side block onto to the gun block with the corresponding bolts. Tighten alternately to avoid possible leaks.

Perform the same steps with the side block on the Isocyanate side.

The gun is now ready for service.

Trigger and valve

WARNING: Before performing maintenance work on the gun, make sure that the unit is at a complete standstill, that all of the buttons and the main switch are turned off and that the unit is disconnected from the main power supply. The gun is a component that works under pressure; no connection must be opened or maintenance work done on components subject to pressure until the pressure has been completely eliminated.



Remove the side blocks and carefully separate them from the gun block. Clean the contact surfaces using a cloth dampened in gun cleaning solvent.

Disconnect the air hose supply with the quick connect.

Unscrew the trigger stop bolt.

Remove the retention nut and extract the screw holding the trigger.

Unscrew the nut of the trigger valve.

Remove the trigger shaft and hold it carefully for the end with a few pliers to extract it from the hole. The trigger shaft has a spring in the base. Make sure you do not lose it.

Check the o-rings of the trigger shaft. Replace them if they are damaged. Apply a little grease to make assembly easier.



Verify that the accommodation of the trigger shaft is free of dirt and wall light a small fat layer in his interior.

Mount the air hose in the rear part of the gun using sealing paste in the thread to avoid air escapes.

Insert the trigger shaft in to the spring and insert it inside the handle taking special care not to damage the o-rings. You will note a certain resistance caused by the interference of the seals with the housing wall.

Screw down the trigger valve nut until it does ceiling in the fund.

Fit the trigger with the screw and hold it with the retention nut.

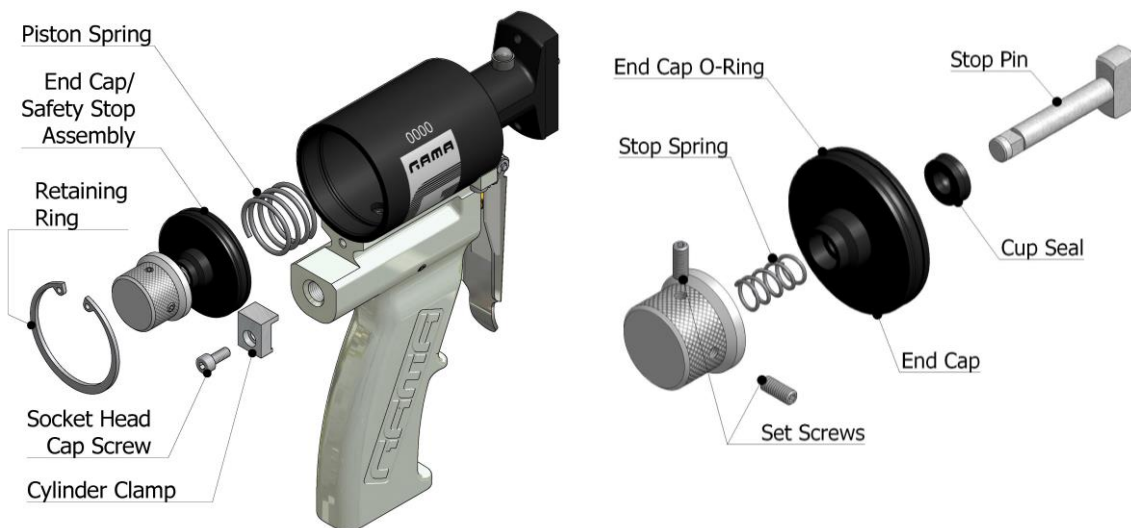
Place the trigger stop bolt. It must be tight up to eliminating the roominess of the trigger shaft (without to displace the shaft).

Fix the product input blocks to the gun block with the corresponding bolts. Tighten alternately to avoid possible leaks.

The gun is now ready for service.

Cylinder block and safety stop

WARNING: Before performing maintenance work on the gun, make sure that the unit is at a complete standstill, that all of the buttons and the main switch are turned off and that the unit is disconnected from the main power supply. The gun is a component that works under pressure; no connection or maintenance work done on components subject to pressure until the pressure has been completely eliminated.



- Remove the side blocks and carefully separate them from the gun block.
- Clean the contact surfaces with a cloth dampened in gun cleaning solvent.
- Unscrew the bolt fixing the clamp on the rear of the gun.
- Remove the retaining ring from the cylinder using the snap ring pliers.
- Pull hard on the safety stop to remove the whole unit from the cylinder. Also remove the plunger spring.
- Check the state of the o-ring seal on the end cap. Replace it if it is damaged.
- Apply a little grease to facilitate the placement of the o-ring.
- Loosen the two set screws on the safety stop. Remove the stop pin and the stop spring from the device.
- Remove the end cap from the stop pin.
- Remove the lip seal from the end cap and replace it if it is damaged. Apply a little grease to facilitate the fitting.
- Pay attention to the correct installation of the lip seal: **The seal lips must face forward.**
- Fit the end cap onto the stop pin. Slide the spring and the safety stop onto the stop pin. Tighten the two set screws making sure that they are perfectly aligned with the flats on the end of the stop pin. Make sure that the blocking device is well-fitted.
- Insert the spring in the rear housing of the plunger. Insert the end cap into the cylinder bore by pressing until it passes the insertion groove of the retention ring.
- Fit the retention ring using snap ring pliers.



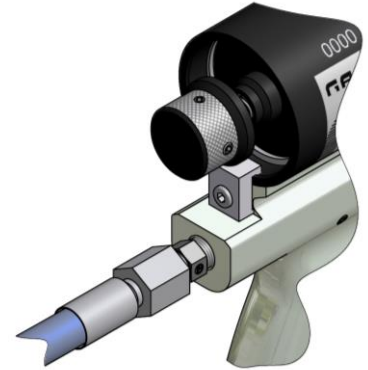
WARNING: *To assure that the end cap is well-fitted, make sure that the retention ring is perfectly fitted in the fixing groove. To avoid possible errors in assembly, avoid approaching the cylinder block when applying pressure to the gun after cleaning, repair or maintenance operations.*

Fit the clamp and fix it with the bolt to the rear of the gun.

Fix the side blocks to the gun block with the corresponding bolts.

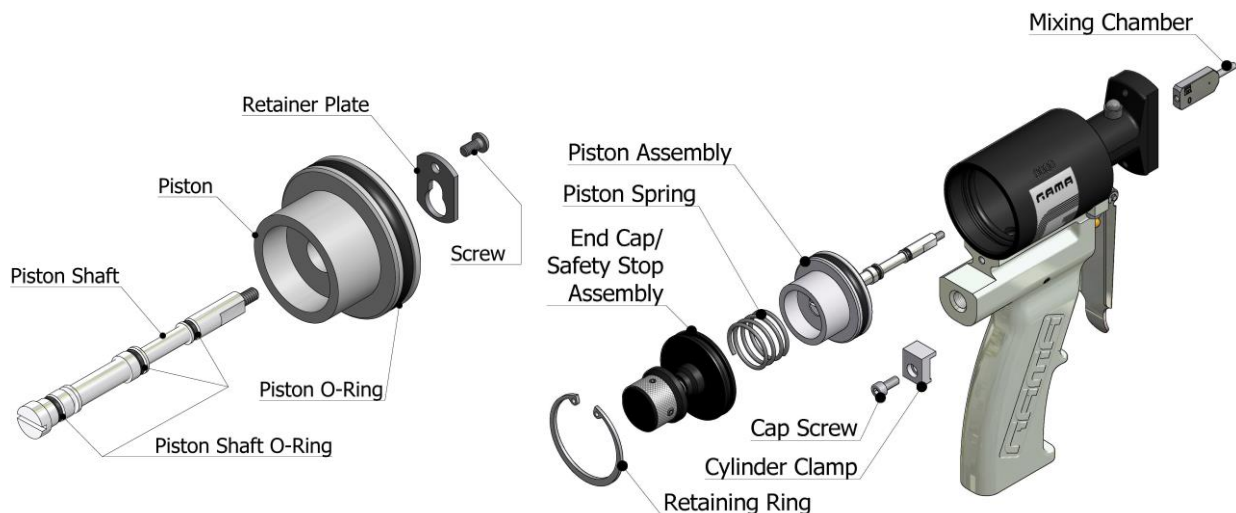
Tighten alternately to avoid possible leaks.

The gun is now ready for service.



Pneumatic cylinder

WARNING: Before performing maintenance work on the gun, make sure that the unit is at a complete standstill, that all of the buttons and the main switch are turned off and that the unit is disconnected from the main power supply. The gun is a component that works under pressure; no connection must be opened or maintenance work done on components subject to pressure until the pressure has been completely eliminated.



Unscrew the air cap. Remove the side blocks from the gun block. Clean the contact surfaces using a cloth dampened with gun cleaning solvent.

Remove the gun block from the gun by sliding it over the chamber. To eliminate the remains of product, clean the gun block unit using a cloth dampened with gun cleaning solvent. Remove the o-ring.

Use a spanner to lock the end of the pneumatic cylinder shaft and unthread the mixing chamber. Clean the mixing chamber and, if you consider it necessary, use a brush to go over the passage holes.

Remove the cylinder clamp.

Using the snap ring pliers, remove the retaining ring holding the end cap.

Pull hard on the blocking device to remove the whole unit from the cylinder bore. Also remove the spring and the piston assembly from inside the cylinder.

Remove the screw and the retainer plate from the piston shaft and separate it from the piston.

Check the state of the o-rings of the shaft and piston. Replace them if they are damaged. Apply a little grease to facilitate the fitting.

Fit the piston by sliding it onto the shaft taking special care not to damage the o-rings. Fit the retainer plate and the screw..

Fit the piston assembly into the cylinder bore.

Insert safety stop assembly into the cylinder bore until it passes the insertion groove of the retention ring.

Fit the retention ring using the snap ring pliers.



WARNING: *To Warranty that the cylinder block is well-fitted, make sure that the retention ring is perfectly fitted in the fixing groove. To avoid possible errors in assembly, avoid approaching the end cap when applying pressure to the gun after cleaning, repair or maintenance operations.*

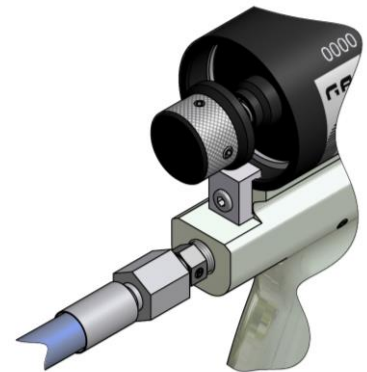
Install the cylinder clamp.

Hand-tighten the mix chamber while holding the end of the pneumatic cylinder with a spanner.

Assemble the gun block by sliding it over the chamber and fix it to the gun with the bolts. Make sure to fit the o-ring between the block and the fixing plate and replace it if it is damaged. Tighten alternately to avoid possible leaks.

Assemble the side blocks to the gun block with the corresponding bolts. Tighten alternately to avoid possible leaks. Screw on the diffuser.

The gun is now ready for service.





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