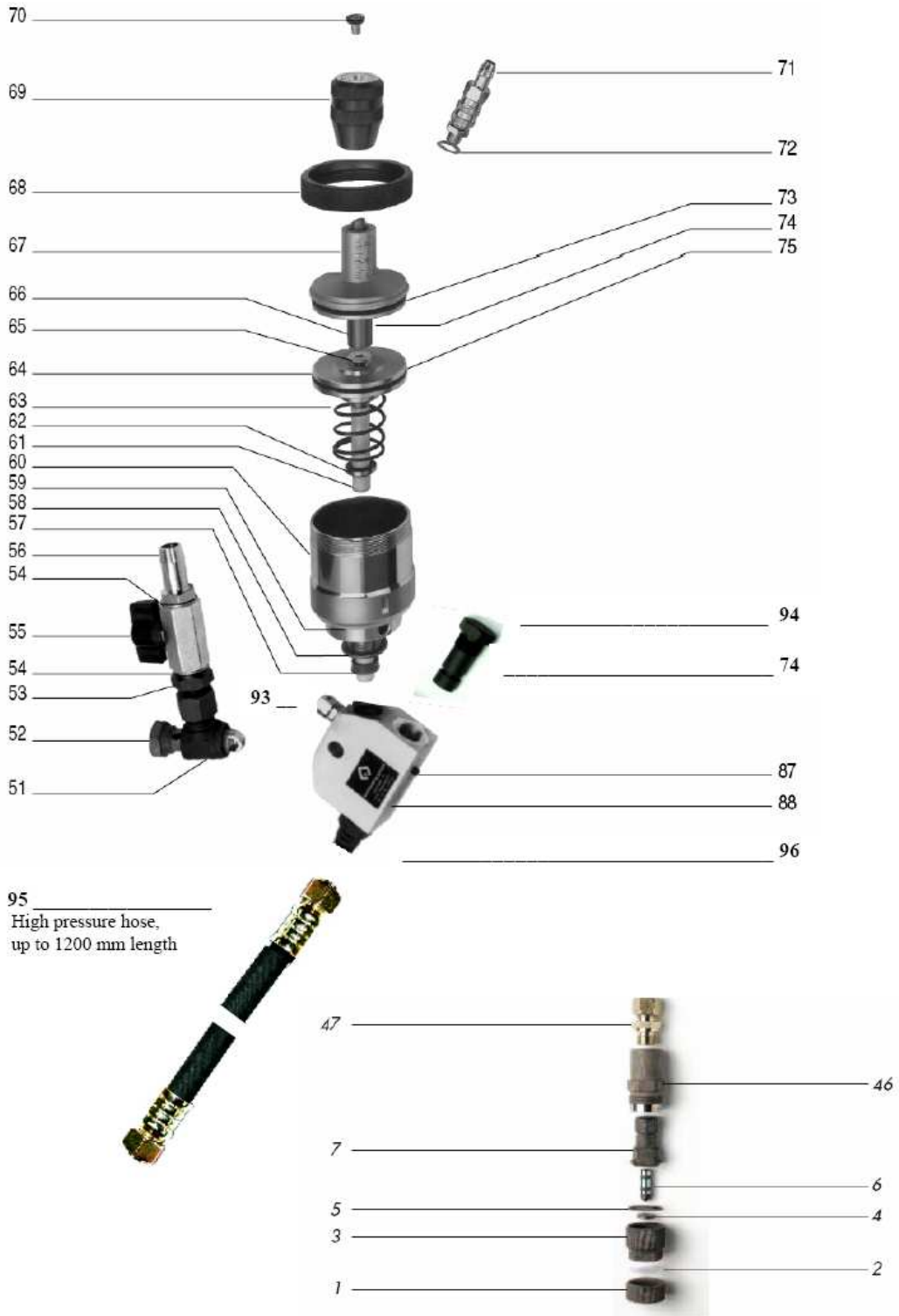


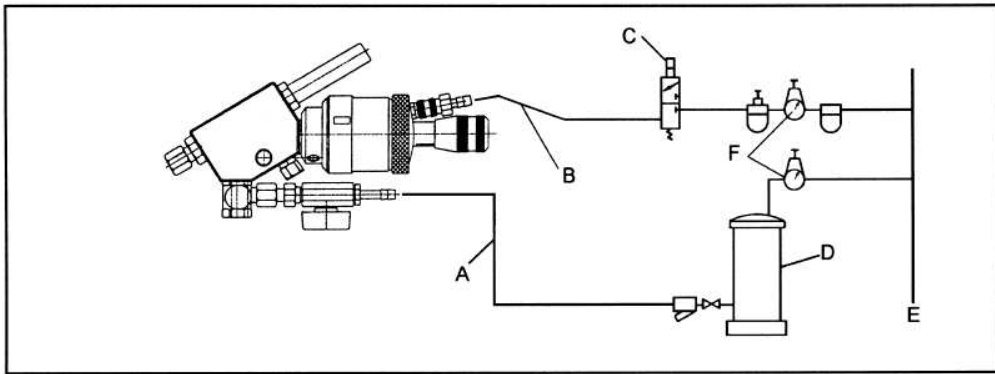


High Velocity Spray Gun type HDP-II Special





widoberg



Technical Data

Air pressure/spray gun	75–90 p.s.i.
Material (compound) pressure	50–90 p.s.i.
Hose ID; air	3/8"
Hose ID; material (compound)	1/2"
3-way valve - normally closed – port size	3/8" NPT
Minimum flow Ø	1/4"
Spray amount per shot (adjustable)	0.2–3 cm ³
Air consumption/spray gun	approx. 0.75 m ³ /h

Installation diagram

- A Compo connection
- B Air connection
- C Solenoid valve
- D Pressure vessel or pump
- E Main line (air)
- F Pressure control

Spare parts list

Item no.	Description	Part no.	Item no.	Description	Part no.
	Original WIDOBORG High Velocity Spray Gun Type HDP-II - Special	109991	87	Grub screw	101605
			88	Body	101010
			93	Bleed valve assembly	101346
			94	Screw plug	102034
51	Banjo connection	101818	95	High pressure hose	107070
52	* Check valve assembly	101249	96	Insert assembly, conical	102108
53	Connection piece	101354	47	Screw connection	101834
54	Sealing ring	101850	46	Cartridge body, part 2	111872
55	Stop cock	101826	7	* Piston guide, compl.	110124
56	Hose connection	111724	6	* Valve piston	110043
57	* Cup seal	101664	5	O-Ring	110035
58	* Usit sealing ring	101672	4	* Valve seat	101290
59	Cylinder flange	103128	3	Retaining nut	110027
60	Cylinder	111481	2	Teflon seal	111759
61	* Plunger	101150	1	Nozzle nut	110019
62	Strip ring	103136			
63	* Compression spring	111457			
64	* Flat seal for piston assembly	101648			
65	Countersunk screw	101699	91	Standard Nozzle 0°	103004
66	Spindle	111511	91	Standard Nozzle 20°	103209
67	Cylinder cover	111503	91	Standard Nozzle 40°	103403
68	Retaining nut	111554	91	Standard Nozzle 65°	103659
69	Knurled knob	111538	91	Standard Nozzle 90°	103900
70	Flat head screw	111546	91	Standard Nozzle 120°	104000
71	Quick connection	111562	91	Barrel Nozzle 40°	105406
72	Sealing ring	111570	91	Barrel Nozzle 65°	105651
73	* O-ring	101702	91	Barrel Nozzle 90°	105902
74	O-ring	101613	91	Barrel Nozzle 120°	106011
75	* Piston assembly	111473			

Parts marked with * should be kept in stock.



Installation

1. Mount gun on a support. Use 12 mm (15/32") Ø hole in gun body.
2. Connect compressed air to quick connection no. 71.
Please use clean lubricated air.
3. Install 3-way control valve (minimum flow Ø, 1/4") as close as possible to the gun.
When using a 3-way solenoid valve, valve is "normally closed" when de-energized. Actuation of valve can be made through an automatic timer or manually.
4. Connect material feed (compound hose) to connection no. 56. A dirt trap (strainer) in feed line is recommended. Strainer mesh size: 30.

Start-up

1. Open material shut-off valve no. 55.
2. Open bleed valve nut no. 93 slightly until material emerges.
Or put the blade of a screwdriver to the groove of the nozzle nut no. 1 and press down the nozzle until no air will come out. After the screwdriver has been removed, the system is closed automatically.
Please check that the position of the nozzle has not changed.
3. Actuate control valve to vent gun and then close bleed valve nut no. 93.
4. Adjust quantity of spray by means of knurled knob no. 69.

Care and maintenance

To avoid damaging seals, never immerse spray gun in hot water or aggressive cleaning fluids.
Clean dismantled nozzle with compressed air. Keep all moving parts clean and oil lightly when servicing.

Exchange of valve piston no. 6

Remove retaining nut no. 3. Extract valve piston no. 6 with a pincer and press in the new valve piston by hand.

Replacement of plunger no. 61

Unscrew retaining nut no. 68 (at air connection end) and remove complete cylinder cover no. 67. Pull out complete piston assembly no. 75 including plunger no. 61.

Unscrew countersunk screw no. 65 and push out plunger no. 61 from piston assembly no. 75. When reassembling, tighten screw firmly and secure threads with a locking fluid.

Changing of nozzle

Unscrew retaining nut No. 92 and remove nozzle and valve seat no. 90.



Tips for trouble shooting

No compound emerges from nozzle

Insufficient air pressure: increase to 75 – 90 p.s.i

Gun not properly vented

Open bleed valve assembly no. 93 to vent, or put the blade of a screwdriver to the groove of the nozzle nut no. 1 and press down the nozzle until no air will come out.

Nozzle blocked

Remove nozzle and clean.

Check valve no. 52 binds or leaks

Clean or replace.

Strainer in dirt trap blocked

Remove and clean.

Material hardened in feed line

Clean line and stop cock no. 55.

Plunger no. 61 binds, does not retract

Replace compression spring no. 63 or piston assembly no. 75 and/or cup seal no. 57.

Gun dribbles

Valve piston no. 6, valve seat no. 4 or complete piston guide no. 7 could get worn out. Replace these parts.

When using buffing compound

To obtain trouble free operation and minimum rate of wear, use airless compositions suitable for high pressure applications.

We reserve the right to make changes for the purposes of improvements and technical progress.