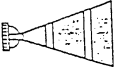




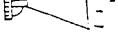


# TROUBLESHOOTING

Spray Pattern	Problems	Remedies
 Fluttering	<ol style="list-style-type: none"> <li>Air enters between fluid nozzle and tapered seat of gun body.</li> <li>Air is suctioned from fluid needle packing.</li> </ol>	<ol style="list-style-type: none"> <li>Remove fluid nozzle to clean seat. If it is damaged, replace nozzle.</li> <li>Tighten fluid needle packing.</li> </ol>
 Crescent	<ol style="list-style-type: none"> <li>Paint buildup on air cap, partially clogs horn holes. Air pressure from both horns differs.</li> </ol>	<ol style="list-style-type: none"> <li>Remove obstructions from horn holes. But do not use metal objects to clean horn holes.</li> </ol>
 Inclined	<ol style="list-style-type: none"> <li>Paint buildup on the periphery of the fluid nozzle hole or air cap center hole or damage.</li> <li>Loose fluid nozzle.</li> </ol>	<ol style="list-style-type: none"> <li>Remove obstructions. Replace if damaged.</li> <li>Remove fluid nozzle, clean seated section.</li> </ol>
 Split	<ol style="list-style-type: none"> <li>Paint viscosity too low.</li> <li>Fluid output too high.</li> </ol>	<ol style="list-style-type: none"> <li>Add paint to increase viscosity.</li> <li>Adjust fluid adj. knob or pattern adj. knob.</li> </ol>
 Heavy Center	<ol style="list-style-type: none"> <li>Paint viscosity too high.</li> <li>Fluid output too low.</li> </ol>	<ol style="list-style-type: none"> <li>Reduce viscosity.</li> <li>Increase fluid output.</li> </ol>
 Spit	<ol style="list-style-type: none"> <li>Fluid nozzle and fluid needle set are not seating properly.</li> <li>The first-stage travel of trigger (when only air discharges) decreases.</li> <li>Paint buildup inside air cap set</li> </ol>	<ol style="list-style-type: none"> <li>Clean or replace fluid nozzle and fluid needle set.</li> <li>Replace fluid nozzle and fluid needle set.</li> <li>Clean air cap set.</li> </ol>

## PROBLEMS AND REMEDIES

Problem	Where it occurred	Parts to be checked	Cause	Remedy			
				Tighten	Adjust	Replace	
Air leaks (from tip of air cap)	Air valve set	Air valve	*Dirt or damage on seat			x	x
		Air valve seat set	*Dirt or damage on seat			x	x
			*Wear on air valve spring				
		O ring	*Damaged or deteriorated				
Paint leaks	Fluid nozzle	Fluid nozzle - fluid needle set	*Dirt, damage, wear on seat			x	x
			*Loose fluid needle adj. knob		x		
			*Wear on needle spring				x
		Fluid nozzle - gun body	*Insufficient tightening	x			
			*Dirt or damage on seat			x	x
			Fluid needle - packing set	*Needle does not return due to packing set too tight		x	
	*Needle does not return due to paint buildup on fluid needle			x	x		
	Fluid needle	Needle packing set	*Wear	x		x	
Packing seat		*Insufficient tightening	x				
Paint does not flow	Tip of gun	Fluid adj. knob	*Insufficient opening		x		
		Tip hole of nozzle	*Clogged			x	
		Paint filter	*Clogged			x	x

## Instruction Manual



# AZ10 HTE / AV / SE SPRAY GUN

**CE** **GB** Before use, adjustment or maintenance, it is important to read this instruction manual very carefully. This manual must be stored in a safe place for any future reference that may be necessary.

## IMPORTANT

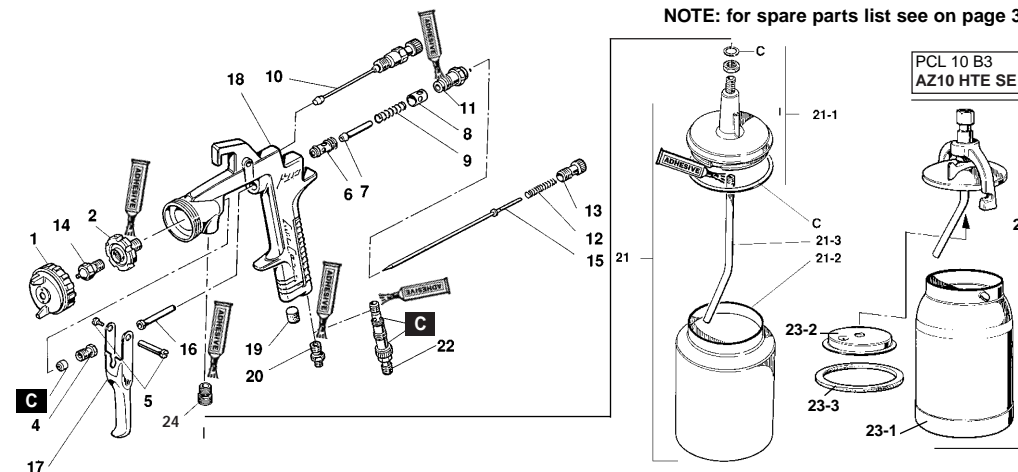
This spray gun should be operated only by an adequately trained operator, for safe use and maintenance of the equipment. Any misuse or handling other than those indicated in this Instruction Manual is not covered by guarantee. AIR GUNSA disclaims all responsibility for any accident or damage caused by failure to observe the operational and safety procedures as from this manual. In the interest of user friendliness, this manual contains information in a brief and concise form. For any additional information you may require regarding spray guns operations, or if any missing parts or any damage during transportation is found, please contact your nearest ANEST IWATA Company (see last cover page).

## MAIN SPECIFICATIONS

Model	Max. Temperature range	Max. Working pressure	Air inlet pressure	Air nipple	Fluid nipple	Noise Level (LAeqT)
AZ10 HTE	5-40°C	7.0 bar	2.5 bar	G 1/4" M	G 1/4" F	75.2 dB (A)
AZ10 HTE AV	5-40°C	7.0 bar	2.5 bar	G 1/4" M	G 1/4" F	75.2 dB (A)
AZ10 HTE SE	5-40°C	7.0 bar	2.5 bar	G 1/4" M	G 3/8" M	75.2 dB (A)

Model	Type of feed	Nozzle Orifice ø mm	Air Cap code	Fluid Output ml/min	Pattern width mm	Air Consumption Nl/min	Total Weight (incl. container) g
AZ10 HTE	Suction	1.0	W2SUB000110	90	150	210	790
		1.3	W2SUB000113	150	190	210	
		1.5	W2SUB000115	200	200	210	
		1.8	W2SUB000118	230	230	280	
		2.0	W2SUB000120	260	260	280	
		2.5	W2SUB000125	290	290	290	
		3.0	W2SUB000130	300	300	300	
AZ10 HTE AV AZ10 HTE SE		1.0	W2SUB000110	80	140	190	800 AZ10 HTE AV 910 AZ10 HTE SE
		1.3	W2SUB000113	140	180	190	
		1.5	W2SUB000115	190	190	190	
		1.8	W2SUB000118	220	220	260	
		2.0	W2SUB000120	250	250	260	
		2.5	W2SUB000125	270	280	260	
		3.0	W2SUB000130	290	290	280	

NOTE: for spare parts list see on page 3.



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MA0012EREV.2

## SAFETY WARNINGS



### FIRE OR EXPLOSION HAZARD

- Fluid and solvents can be highly flammable or combustible.
  - Use in well-ventilated spray booth.
  - Avoid any ignition sources such as smoking, open flames, electrical hazard, etc.

- NEVER use HALOGENATED HYDROCARBON SOLVENTS (1.1.1 TRICHLORINE, ETHYL CHLORIDE, etc.), which can chemically react with aluminium and zinc parts and cause an explosion. Be sure that all fluids and solvents used are chemically compatible with aluminium and zinc parts. If in doubt, consult your fluid or solvent supplier to ensure compatibility. Details of materials used in the gun are available on request.

- To reduce the risk of static sparking, grounding continuity to the spray equipment and object being sprayed must be maintained.



### MISUSE HAZARD

- NEVER point gun in the direction of human body.
- NEVER exceed the maximum safe working pressure of the equipment.
- ALWAYS release air and fluid pressures before cleaning, disassembling or servicing. For emergency stop and prevention of unintended operation, a ball valve installation near the gun to stop air supply is recommended.



### HAZARD CREATED WHILE COATING MATERIALS ARE ATOMIZED AND SPRAYED

- Toxic vapours produced by spraying certain materials can create intoxication and serious damage to health.
  - Use the gun in well-ventilated areas.
  - Always wear protective eyewear, gloves, respirator, etc., to prevent the toxic vapour hazard, solvents and paint from coming into contact with your eyes or skin.
- Noise level mentioned in main specifications was measured at 1.0 m behind the tip of the gun, 1.6 m height from floor.
  - Wear earplugs if required.



### OTHER HAZARDS

- NEVER enter working areas of robots, reciprocators, conveyors, etc., unless machines are switched off.
- NEVER spray foods or chemicals through the spray gun.
- NEVER modify this product for any applications.

## INSTALLATION

### IMPORTANT:

- This gun should be operated by adequately trained operators only.
- Ensure that the gun has not been damaged during transportation.
- Clean dry air should be supplied to the gun.

- Connect the air hose to air nipple tightly.(ref. 20 for AZ10 HTE/ref. 22 for AZ10 HTE AV / SE).
- Connect suction cup to the fluid nipple (ref. 24) tightly.
- Flush the gun fluid passage with a compatible solvent.
- Pour paint into container, test spray, and adjust fluid output as well as pattern width.

*Air-Gunsa*

## HOW TO OPERATE

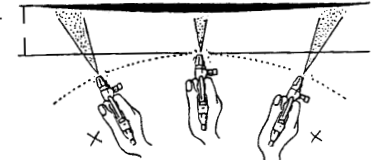
Suggest air pressure is 2.5 bar in order to obtain the best transfer efficiency.

Set the spray distance from the gun to the workpiece as near as possible within the range of 250 mm.

Keep fluid output as small as possible to the extent that the job will not be hindered. It will lead to better finishing with fine atomization.

The gun should be held so that gun is perpendicular to the surface of the workpiece at all times. And the gun should move in a straight and horizontal line. Arcing the gun causes uneven painting.

Recommended paint viscosity is 21 sec./ Ford #4 and differs according to paint property and painting conditions.



## MAINTENANCE AFTER PAINTING



### WARNING

TURN OFF AIR AND COATING MATERIALS TO THE GUN AND RELEASE PRESSURE BY TRIGGERING THE GUN BEFORE DISASSEMBLING, CLEANING OR SERVICING. PAY ATTENTION WHEN DISASSEMBLING SPRAY GUN SINCE YOU MUST TOUCH SHARP PARTS. BEFORE DISASSEMBLING READ CAREFULLY THIS INSTRUCTION MANUAL.

- Pour remaining paint into another container and then clean paint passages and air cap. Spray a small amount of thinner to clean paint passages. Incomplete cleaning will cause adverse pattern shape and particles. Clean fully and promptly two-component paint after use.
- Clean other sections with attached brush soaked with thinner and waste cloth.
- Clean paint passages fully before disassembly.
- Remove fluid nozzle after removing fluid needle set or while keeping fluid needle pulled, in order to protect seat section.
- While keeping fluid needle set inserted, tighten fluid needle packing set by hand. Then tighten gradually by spanner. Adjust packing set while pulling trigger and watching movement of fluid needle set since too much tightening will slow down movement of fluid needle and result in leakage from tip of nozzle.
- Turn pattern adj. knob counterclockwise to full opening, and then tighten pattern adj. guide into gun body.



### WARNING

NEVER USE COMMERCIAL OR OTHER PARTS INSTEAD OF AIR GUNSA ORIGINAL SPARE PARTS  
NEVER IMMERSE THE WHOLE GUN INTO LIQUID SUCH AS THINNER  
NEVER DAMAGE HOLES OF AIR CAP, FLUID NOZZLE OR FLUID NEEDLE

## SPARE PARTS LIST

DESCRIZIONE	Ref.part	DESCRIZIONE	Ref.part	DESCRIPTION	Ref.part
AIR CAP	Ref.part 1	FLUID NEEDLE SET	Ref.part 15	COMPLETE CUP SET PCL 10 B3	Ref.part 23
NOZZLE HOLDER	Ref.part 2	AIR VALVE SHAFT	Ref.part 16	CONTAINER (1 Liter )	Ref.part 23-1
NEEDLE PACKING NUT	Ref.part 4	TRIGGER	Ref.part 17	NON DRIP SET	Ref.part 23-2
TRIGGER STUD	Ref.part 5	GUN BODY	Ref.part 18	PACKING	Ref.part 23-3
AIR VALVE SEAT SET	Ref.part 6	PLUG	Ref.part 19	FLUID NIPPLE G 3/8" M AZ10 HTE SE	Ref.part 24
AIR VALVE	Ref.part 7	AIR NIPPLE G 1/4" M AZ10 HTE	Ref.part 20	PACKING SET	Ref.part C
BUSHING	Ref.part 8	COMPLETE CUP SET	Ref.part 21		
AIR VALVE SPRING	Ref.part 9	LID SET	Ref.part 21-1		
PATTERN ADJUSTMENT	Ref.part 10	CONTAINER (1 Liter )	Ref.part 21-2		
FLUID NEEDLE GUIDE SET	Ref.part 11	SUCTION TUBE	Ref.part 21-3		
FLUID NEEDLE SPRING	Ref.part 12	AIR FLOW CONTROL VALVE			
FLUID NEEDLE ADJ. KNOB	Ref.part 13	AZ10 HTE AV/AZ10 HTE SE	Ref.part 22		
FLUID NOZZLE	Ref.part 14				

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