

XHF™ Spray Gun

3A2799D

EN

For spraying viscous materials at high flow rates. For professional use only.

262854, Series A

Includes an XHD™ RAC® Guard and XHD429 SwitchTip™

7250 psi (50 MPa, 500 bar) Maximum Working Pressure

26C793, Series A

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Important Safety Instructions

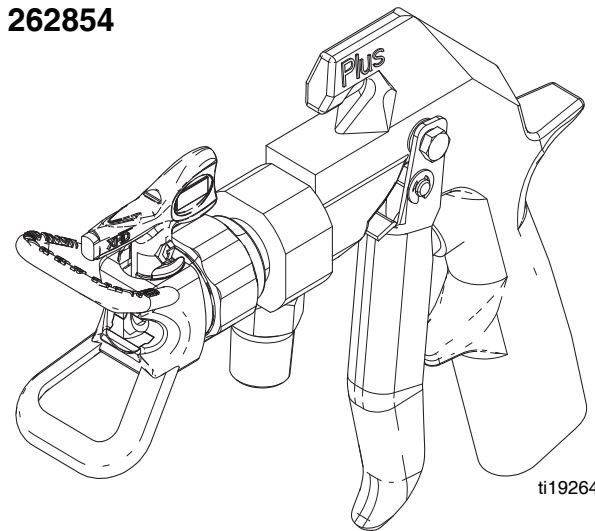
Read all warnings and instructions in this manual before using the equipment. Save these instructions.



Important Medical Information

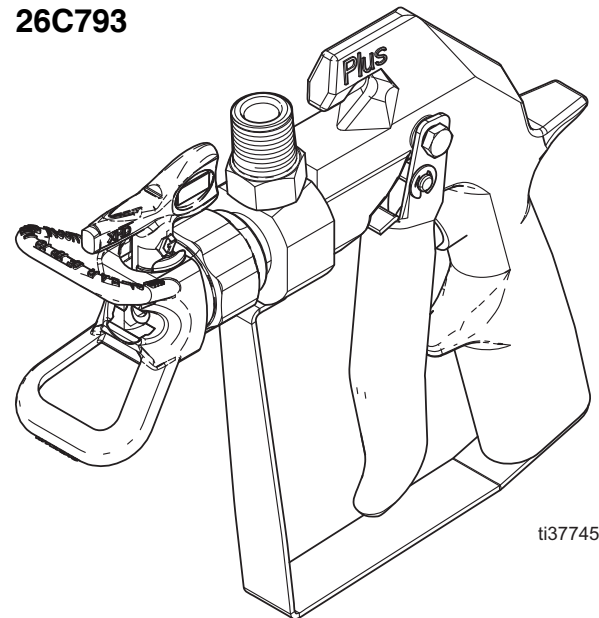
Read the medical alert card provided with the gun. It contains injection injury treatment information for a doctor. Keep it with you when operating the equipment.

262854



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Warnings

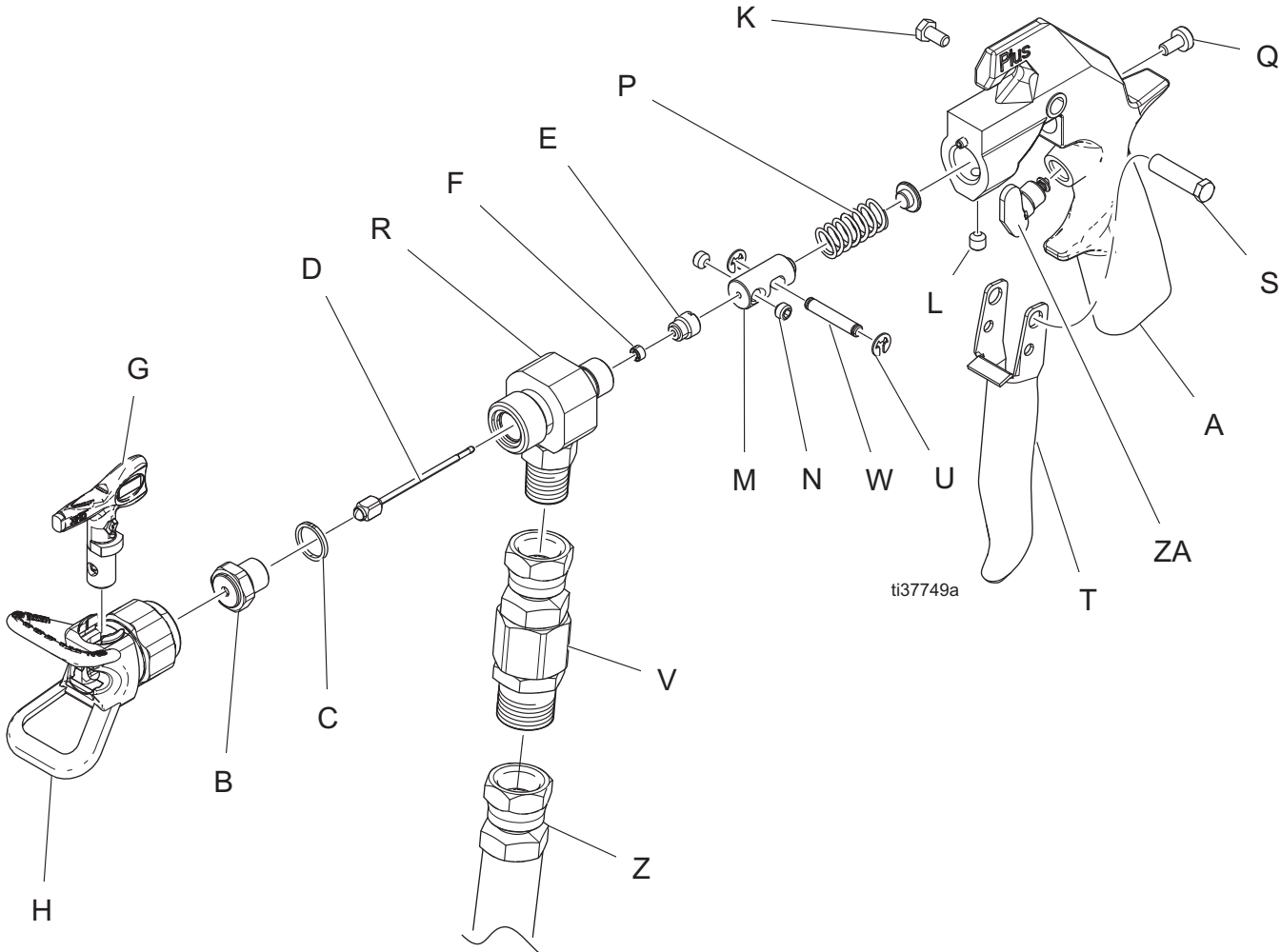
The following warnings are for the setup, use, grounding, maintenance, and repair of this equipment. The exclamation point symbol alerts you to a general warning and the hazard symbols refer to procedure-specific risks. When these symbols appear in the body of this manual or on warning labels, refer back to these Warnings. Product-specific hazard symbols and warnings not covered in this section may appear throughout the body of this manual where applicable.

 <h1 style="margin: 0;">WARNING</h1>	
	<p>SKIN INJECTION HAZARD</p> <p>High-pressure fluid from gun, hose leaks, or ruptured components will pierce skin. This may look like just a cut, but it is a serious injury that can result in amputation. Get immediate surgical treatment.</p> <ul style="list-style-type: none"> • Do not spray without tip guard and trigger guard installed. • Engage trigger lock when not spraying. • Do not point gun at anyone or at any part of the body. • Do not put your hand over the spray tip. • Do not stop or deflect leaks with your hand, body, glove, or rag. • Follow the Pressure Relief Procedure when you stop spraying and before cleaning, checking, or servicing equipment. • Tighten all fluid connections before operating the equipment. • Check hoses and couplings daily. Replace worn or damaged parts immediately.
	<p>FIRE AND EXPLOSION HAZARD</p> <p>Flammable fumes, such as solvent and paint fumes, in work area can ignite or explode. Paint or solvent flowing through the equipment can cause static sparking. To help prevent fire and explosion:</p> <ul style="list-style-type: none"> • Use equipment only in well-ventilated area. • Eliminate all ignition sources; such as pilot lights, cigarettes, portable electric lamps, and plastic drop cloths (potential static sparking). • Ground all equipment in the work area. See Grounding instructions. • Never spray or flush solvent at high pressure. • Keep work area free of debris, including solvent, rags and gasoline. • Do not plug or unplug power cords, or turn power or light switches on or off when flammable fumes are present. • Use only grounded hoses. • Hold gun firmly to side of grounded pail when triggering into pail. Do not use pail liners unless they are anti-static or conductive. • Stop operation immediately if static sparking occurs or you feel a shock. Do not use equipment until you identify and correct the problem. • Keep a working fire extinguisher in the work area.

WARNING

 	<p>EQUIPMENT MISUSE HAZARD</p> <p>Misuse can cause death or serious injury.</p> <ul style="list-style-type: none"> • Do not operate the unit when fatigued or under the influence of drugs or alcohol. • Do not exceed the maximum working pressure or temperature rating of the lowest rated system component. See Technical Specifications in all equipment manuals. • Use fluids and solvents that are compatible with equipment wetted parts. See Technical Specifications in all equipment manuals. Read fluid and solvent manufacturer's warnings. For complete information about your material, request Safety Data Sheets (SDSs) from distributor or retailer. • Do not leave the work area while equipment is energized or under pressure. • Turn off all equipment and follow the Pressure Relief Procedure when equipment is not in use. • Check equipment daily. Repair or replace worn or damaged parts immediately with genuine manufacturer's replacement parts only. • Do not alter or modify equipment. Alterations or modifications may void agency approvals and create safety hazards. • Make sure all equipment is rated and approved for the environment in which you are using it. • Use equipment only for its intended purpose. Call your distributor for information. • Route hoses and cables away from traffic areas, sharp edges, moving parts, and hot surfaces. • Do not kink or over bend hoses or use hoses to pull equipment. • Keep children and animals away from work area. • Comply with all applicable safety regulations.
	<p>RECOIL HAZARD</p> <p>Gun may recoil when triggered. If you are not standing securely, you could fall and be seriously injured.</p>
	<p>TOXIC FLUID OR FUMES HAZARD</p> <p>Toxic fluids or fumes can cause serious injury or death if splashed in the eyes or on skin, inhaled, or swallowed.</p> <ul style="list-style-type: none"> • Read Safety Data Sheets (SDSs) to know the specific hazards of the fluids you are using. • Store hazardous fluid in approved containers, and dispose of it according to applicable guidelines.
	<p>PERSONAL PROTECTIVE EQUIPMENT</p> <p>Wear appropriate protective equipment when in the work area to help prevent serious injury, including eye injury, hearing loss, inhalation of toxic fumes, and burns. Protective equipment includes but is not limited to:</p> <ul style="list-style-type: none"> • Protective eyewear, and hearing protection. • Respirators, protective clothing, and gloves as recommended by the fluid and solvent manufacturer.

Component Identification



- Key**
- A Gun Body
 - B Valve Seat
 - C Gasket
 - D Needle
 - E Seal Retainer
 - F Seal
 - G SwitchTip
 - H Tip Guard
 - K Hex Screw
 - L Set screw
 - M Spring Guide

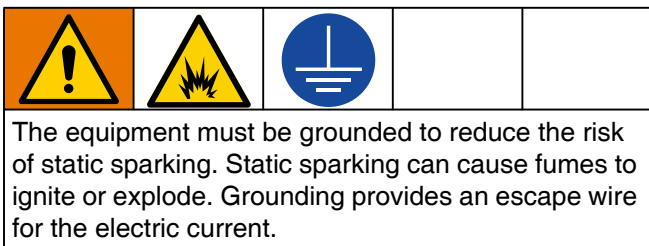
- Key**
- N Socket Head Set screw
 - P Spring
 - Q Adjusting Screw
 - R Fluid Housing
 - S Pivot Pin
 - T Gun Trigger
 - U E-Clip
 - V Swivel
 - W Trigger Pin
 - Z Fluid Hose
 - ZA Trigger Lock

Setup

System Requirements

Pressure drain valves are recommended in the system. Pressure drain valves assist in relieving fluid pressure in the displacement pump, hose and gun in the event that the gun is clogged and triggering the gun does not relieve all pressure.

Grounding



Check your local electrical code and pump or sprayer manual for detailed grounding instructions.

Spray gun: ground through connection to a properly grounded fluid hose and pump.

Pump: follow manufacturer's recommendations.

Fluid hose: use only electrically conductive hoses with a maximum of 500 ft. (150 m) combined hose length to ensure grounding continuity. Check electrical resistance of hoses. If total resistance to ground exceeds 29 megohms, replace hose immediately.

Fluid supply container: follow local code.


Object being sprayed: follow local code.

Solvent pails used when flushing: follow local code. Use only conductive metal pails, placed on a grounded surface. Do not place the pail on a nonconductive surface, such as paper or cardboard, which interrupts grounding continuity.

To maintain grounding continuity when flushing or relieving pressure: hold metal part of the spray gun firmly to the side of a grounded metal pail, then trigger the gun.

Operation

Pressure Relief Procedure

 Follow the Pressure Relief Procedure whenever you see this symbol.

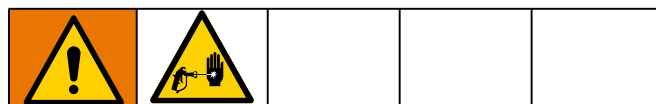


This equipment stays pressurized until pressure is manually relieved. To help prevent serious injury from pressurized fluid, such as skin injection, and splashing fluid, follow the Pressure Relief Procedure when you stop spraying and before cleaning, checking, or servicing the equipment.

1. Engage the gun trigger lock.
2. Shut off power to the pump.
3. Disengage the gun trigger lock.
4. Hold a metal part of the gun firmly to a grounded metal pail. Trigger the gun to relieve pressure.
5. Engage the gun trigger lock.
6. Open the system drain valve, having a container ready to catch the drainage. Observe the pressure gauge. The gauge reads 0 psi/bar when fully drained. Close the system drain valve.
7. If you suspect that the spray tip or hose is completely clogged or that pressure has not been fully relieved after following the previous steps, very slowly loosen the tip guard retaining nut or hose end coupling to relieve pressure gradually. Clean the tip or hose obstruction.

Gun Trigger Lock

1. To engage the gun trigger lock, rotate the lock so it is perpendicular to the gun body. See FIG. 1.
2. To disengage the gun trigger lock, push the lock out and rotate it so it is parallel with the gun body. See FIG. 1.



To prevent injury when the gun is not in use, always engage the gun's trigger lock if unit is being shut down or left unattended. A wallet-sized medical alert card with important injection treatment information is included with the gun. Additional cards are available at no charge. Provide a card to all operators.

The trigger lock must move freely, and easily snap into the locked position. If the trigger lock is damaged or movement is restricted, replace with new trigger kit immediately.

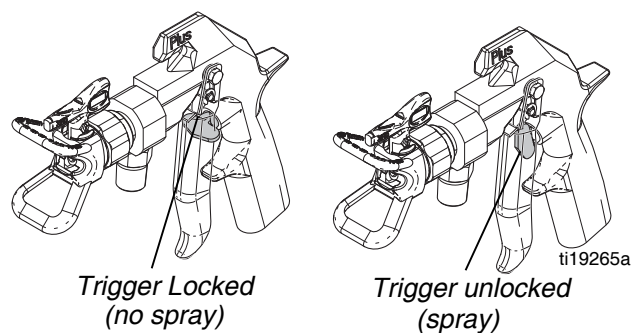


FIG. 1: Trigger Lock Positions

Tip Guard Installation and Removal

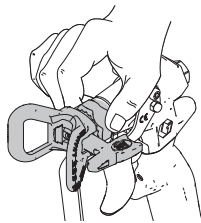


To avoid serious injury from skin injection, do not put your hand in front of the spray tip when installing or removing the spray tip and tip guard.

NO



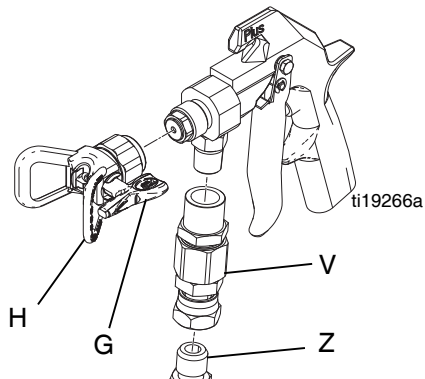
YES



Spray



1. Connect a fluid hose (Z) to the gun inlet. Use swivel 17G980 or 17G981 if desired (order separately).
2. With SwitchTip (G) and tip guard (H) removed, start the pump. Flush the pump according to the instructions supplied with it. Use the lowest pressure possible.
3. Prime the system with the material.
4. Follow the **Pressure Relief Procedure**, page 7.
5. Install the SwitchTip (G) and tip guard (H). See **Tip Guard Installation and Removal**.



6. Start the pump. Trigger the gun onto test paper. Adjust the fluid pressure until the spray is completely atomized.

NOTE: Use the lowest pressure necessary to get the desired results. Higher pressure may not improve the spray pattern and will cause premature tip and pump wear.

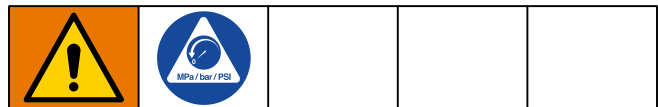
7. If adjusting the pressure does not give a good spray pattern, relieve pressure and try another tip size.
8. When spraying, use a full-open, full-close trigger action to get uniform coverage of applied media. Hold the gun about 14 in. (350 mm) from and at right angles to the work surface. Do not swing the gun in an arc. Practice to find the best length and speed of stroke.

NOTICE

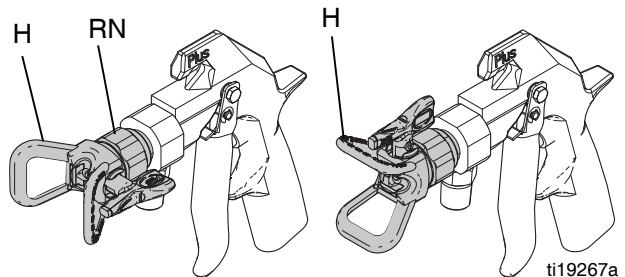
Pulling hoses with the gun can cause the fluid housing to loosen. This could result in the gun not shutting off when the trigger is released.

- Do not pull hose with gun. Always pull hose with a separate hand.
- Periodically verify that the set screw in the fluid housing remains tight.

Adjust the Spray Pattern



1. Follow the **Pressure Relief Procedure**, page 7.
2. Loosen the tip guard retaining nut (RN).
3. Rotate the tip guard (H) as necessary to achieve a vertical or horizontal spray pattern. Tighten the nut (RN).



Vertical Spray Pattern

Horizontal Spray Pattern

- The spray tip orifice and spray angle determines the coverage and size of pattern. When more coverage is needed, use a larger spray tip rather than increasing fluid pressure.

NOTICE

Openings in the tip guard reduce material buildup on the guard while spraying. Damage to the sharp edges of the openings causes material to collect in the damaged area. To prevent this, never hang the gun by the tip guard.

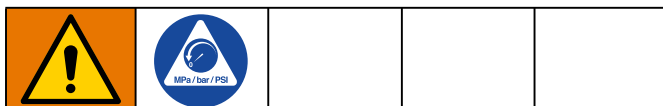
Gun Care



To reduce the risk of fluid injection or splashing in the eyes or on the skin, do not point gun at anyone or at any part of the body when cleaning or checking a clogged tip. Point the gun toward the ground or into a waste container when checking to see if the spray tip is cleared.

- Do not try to “blow back” material; this is not an air spray gun.
- Do not wipe fluid buildup off the gun or spray tip until pressure is relieved.

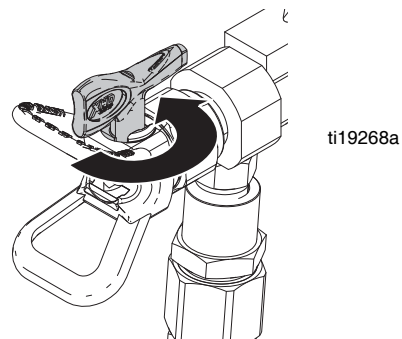
Clean the Gun



- Follow the **Pressure Relief Procedure**, page 7.
- Use a solvent-soaked brush to clean the spray tip. Clean the front of the tip frequently during the day to help reduce buildup.
- Clean the tip and tip guard at the end of each work day.

Clean the Spray Tip / Clear Clogs

- Engage the gun trigger lock.
- Rotate the RAC SwitchTip handle 180° (see FIG. 2).



Spraying position shown. Rotate tip handle 180° and trigger gun to clear clog.







FIG. 2: Rotate RAC tip handle for cleaning

- Disengage the gun trigger lock.
- Trigger the gun into a pail or onto the ground to remove the clog.
- Engage the gun trigger lock.
- Rotate the tip handle back to the spraying position.
- Disengage the gun trigger lock and continue spraying.
- If the tip is still clogged:
 - Engage the gun trigger lock.
 - Follow the **Pressure Relief Procedure**, page 7.
 - Remove the RAC SwitchTip and clean. See **Tip Guard Installation and Removal**, page 8.

NOTICE

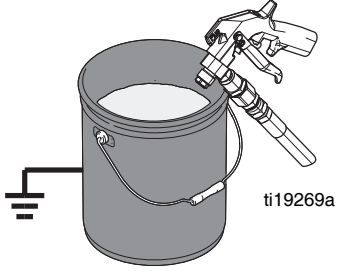
Never soak the entire gun in solvent. Prolonged exposure to solvent can damage the packings.

Flushing

To reduce the risk of serious injury, including splashing fluid in the eyes or on the skin, or static electric discharge when flushing:

- Be sure the entire system, including flushing pails, is properly grounded.
- Remove the tip guard and SwitchTip.
- Maintain metal to metal contact between the gun and the flushing pail.
- Use the lowest possible pressure.



NOTICE

Always flush the pump and gun before the sprayed fluid cures.

NOTE: This procedure requires a grounded pail of compatible flushing fluid.

1. Follow the **Pressure Relief Procedure**, page 7.
2. Remove the tip guard (H) and SwitchTip (G). Soak and clean the parts.
3. **Single component systems only:** Remove the pump intake from the original pail. Put the pump intake in a grounded pail of compatible solvent.
4. Start the pump at its lowest pressure.
5. **Single component systems only:** Trigger the gun into the original pail. When flushing fluid appears, release the trigger.
Two-component systems only: Trigger the gun into a waste container. When flushing fluid appears release the trigger.
6. Trigger the gun into the flushing fluid supply pail. Circulate the fluid until the system is thoroughly flushed.
7. After gun is thoroughly flushed, follow the **Pressure Relief Procedure**, page 7.

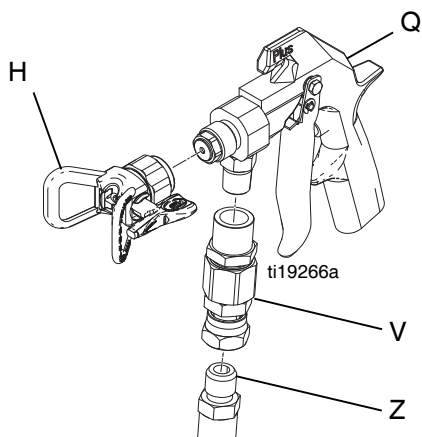
Maintenance



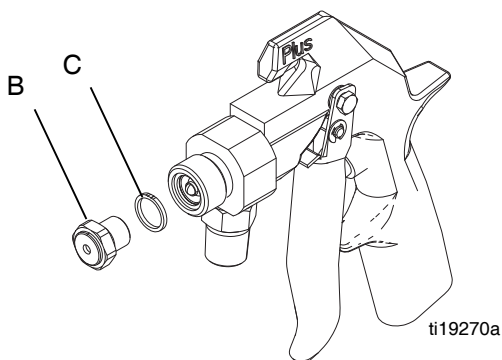
Disassemble the Gun

NOTE: If replacing needle and seat only, steps 4 and 5 are optional.

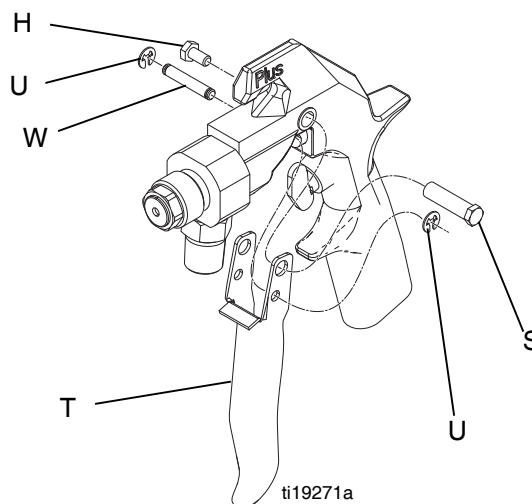
1. Follow the **Pressure Relief Procedure**, page 7.
2. Disconnect the fluid hose (Z) and swivel (V, if used). Remove the tip guard (H). Unscrew the spring screw (Q) about 1/4 in. (7 mm) to release spring tension.



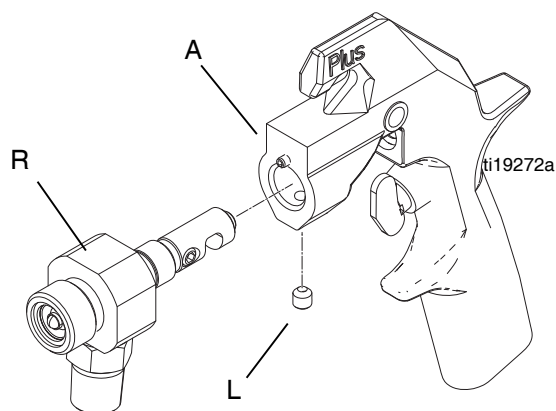
3. Unscrew the valve seat (B). Remove the gasket (C).



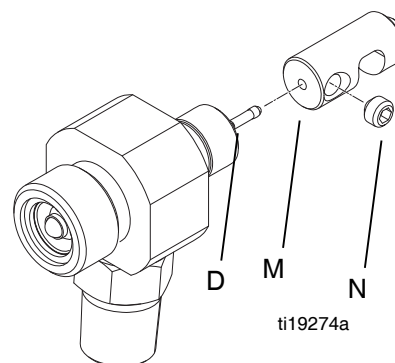
4. Remove one e-clip (U) then push the pin (W) out of the gun. Remove the screw (H), pivot pin (S), and trigger (T).



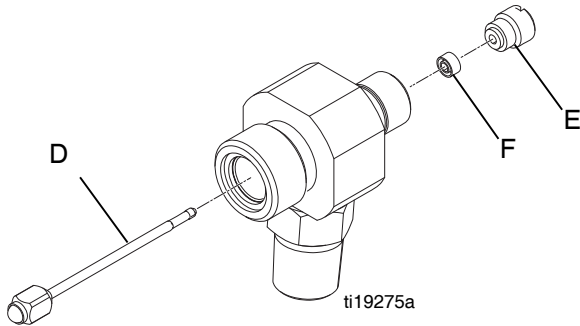
5. Loosen the set screw (L) then remove the fluid housing (R) from the gun body (A).



6. While supporting the spring guide (M) to prevent bending the needle (D), loosen the set screws (N) then remove the spring guide (M).



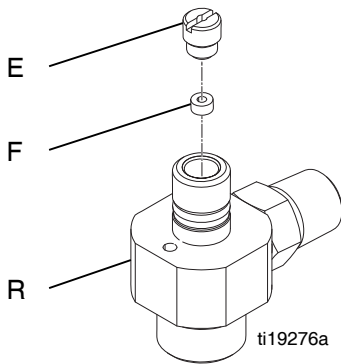
- Remove the needle (D). Unscrew the seal retainer (E) then remove the seal (F).



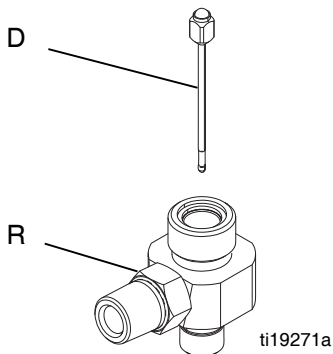
- Clean all parts and cavities thoroughly with a compatible flushing fluid. Dry with a rag or compressed air. Replace any parts that are worn or damaged.

Reassemble the Gun

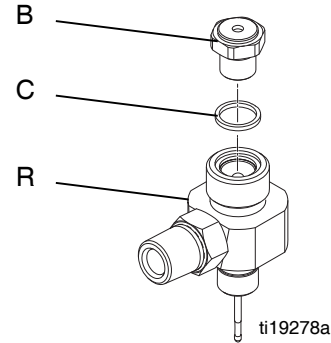
- Lightly grease the inner cavities of the fluid housing (R). Install the small seal (F) so the lips face into the fluid housing cavity. Install the seal retainer (E) and torque to 30-40 in-lb (3.4-4.5 N•m).



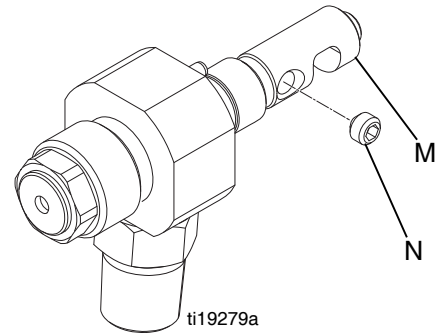
- Lightly grease the small end of the needle (D) then guide it into the large end of the fluid housing (R).



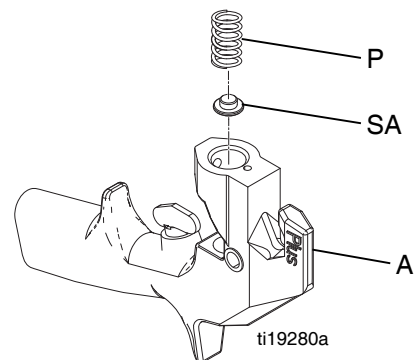
- Place the gasket (C) on the valve seat (B). Grease the threads of the valve seat (B) then install into the fluid housing (R). Torque to 20-25 ft-lb (27-34 N•m).



- Install the spring guide (M) and seat it against the needle. Loosely thread both set screws (N) into the spring guide then alternately and evenly tighten the set screws to 10-15 in-lb (1.1-1.6 N•m). Fill the set screw cavities with petroleum jelly.

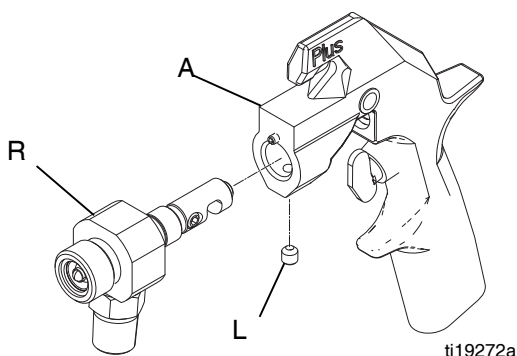


- If the spring (P) was removed, grease the spring adjuster (SA) and place the spring on the adjuster then drop into the gun body (A).

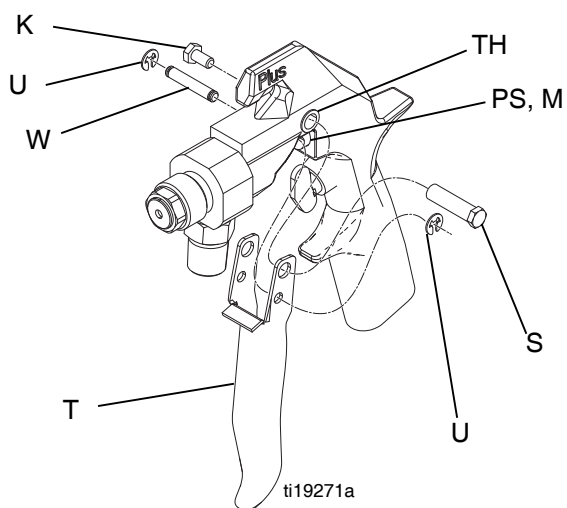


- Push the fluid housing (R) onto the gun body (A) until fully seated. Apply medium strength thread locking compound to set screw (L). Tighten the set screw to 60-75 in-lb (6.8-8.5 N•m). Fill the set screw cavity with petroleum jelly.

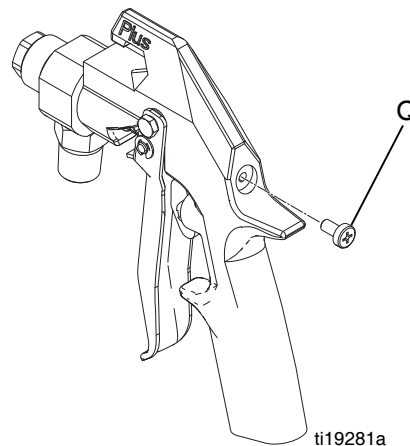
NOTE: If rebuilding from a needle and set kit, discard the old set screw and use the new set screw in the kit.



- Position the trigger (T) on the gun body. Insert the pivot pin (S) into the top hole (TH) and secure with the screw (K) on the other side. Ensure there is an e-clip (U) on one end of the trigger pin (W). Slide the pin through lower trigger holes and through the slot (PS) in the spring guide (M) -- turn the spring guide to align, as needed. Install the other e-clip (U) onto the pin.

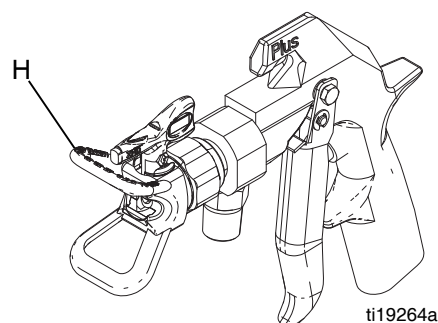


- If it was removed, install the spring tension screw (Q) at the rear of the gun. Then turn the screw in until it stops.



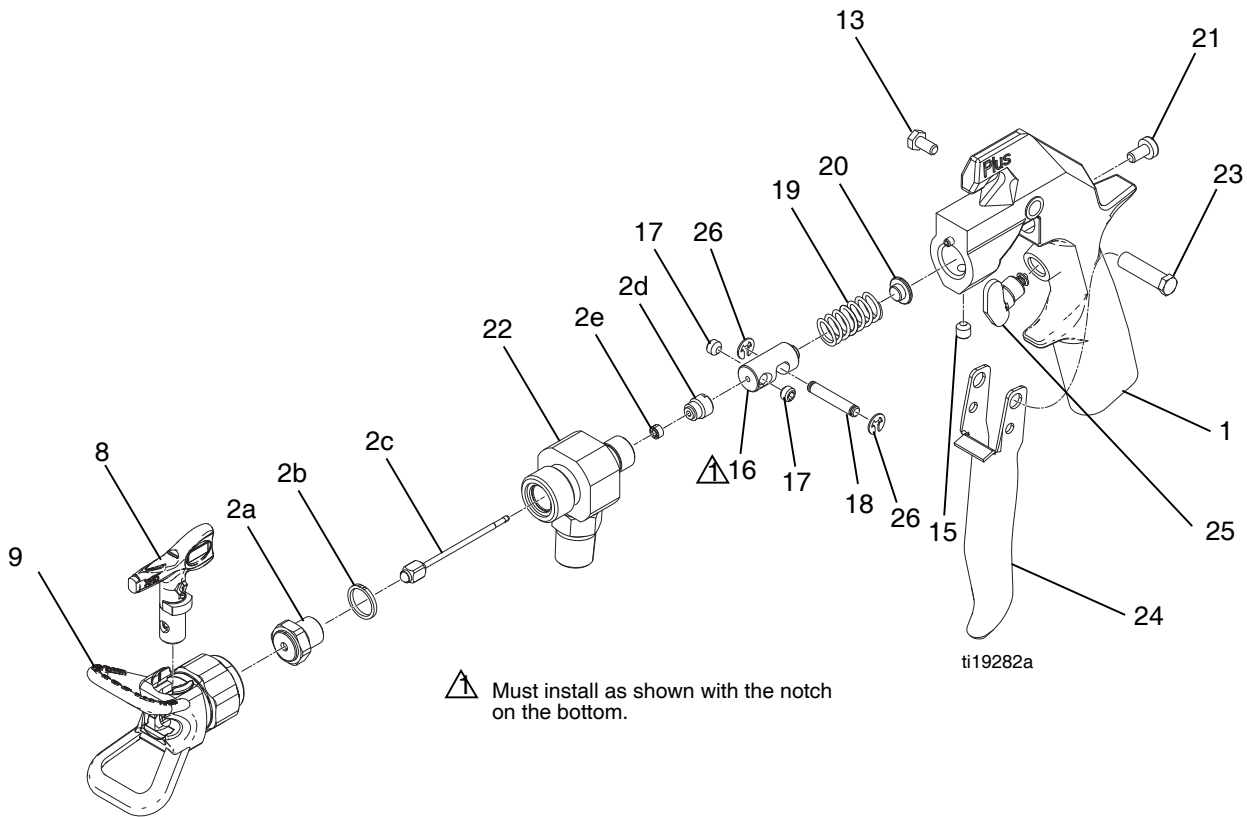
Test the Gun After Service

- Engage the gun trigger lock.
- Connect a hose to the gun. Start and prime the pump.
- Disengage the gun trigger lock.
- Trigger the gun into a waste container until fluid dispenses.
- Release the trigger to be sure the gun immediately stops spraying and that there are no leaks in any gun connections.
- Engage the gun trigger lock.
- Install the tip guard (H) before regular use. See **Tip Guard Installation and Removal**, page 8.



Parts

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Ref	Part	Description	Qty
1	---	BODY, gun	1
2	237260	KIT, needle and seat	1
2a	---	SEAT, valve	1
2b	---	GASKET	1
2c	---	NEEDLE	1
2d	---	RETAINER, seal	1
2e	---	SEAL	1
8	XHD429	SwitchTip, size 429	1
9	XHD001	KIT, RAC Guard	1
13	203953	SCREW, hex head, 10-24	1
15	126943	SET SCREW, 1/4-20	1
16	189960	GUIDE, spring	1
17	112729	SET SCREW, socket head	2
18	189958	PIN, trigger	1
19	112727	SPRING	1

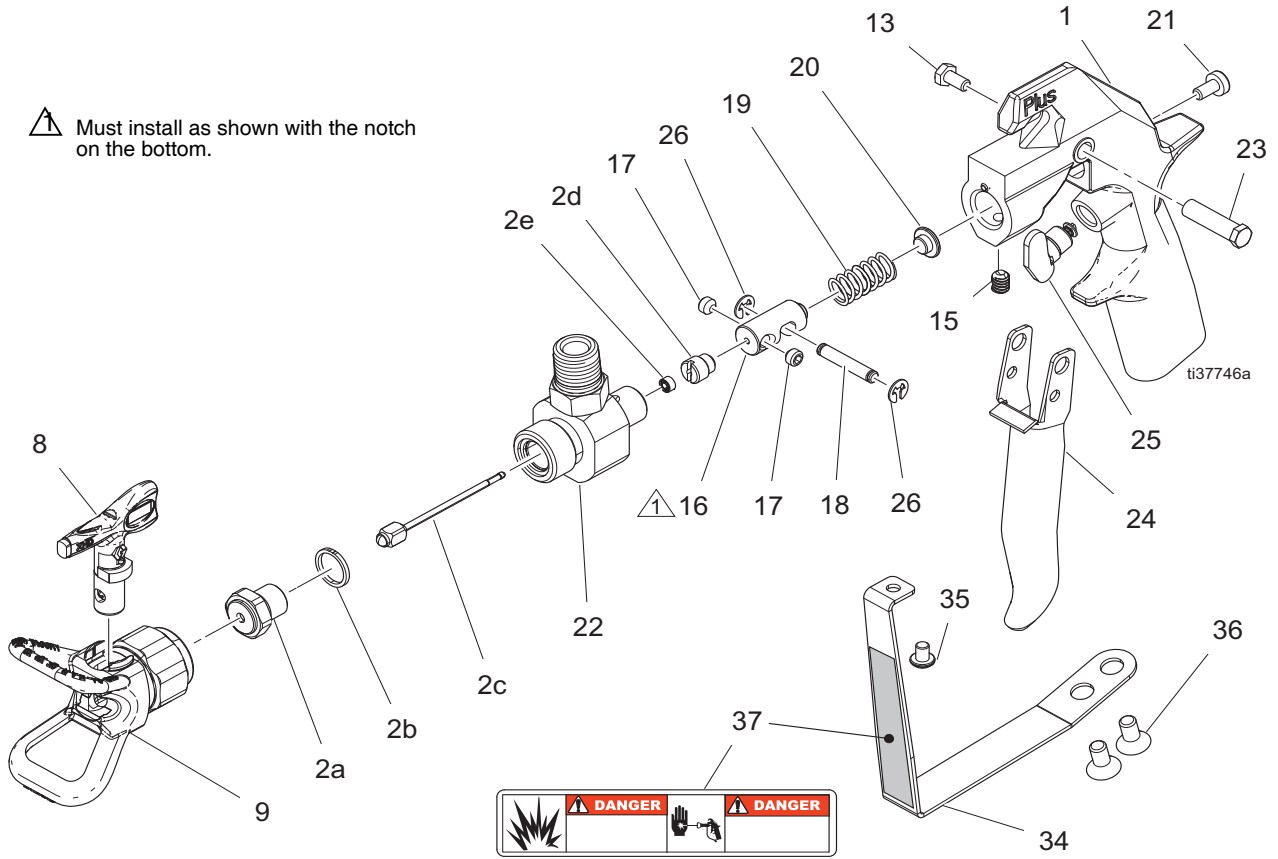
Ref	Part	Description	Qty
20	189990	ADJUSTER, spring	1
21	110637	SCREW, adjusting	1
22	16P780	HOUSING, fluid	1
23	187965	PIN, pivot	1
24	189974	TRIGGER, gun	1
25	235468	STOP, trigger	1
26	112410	E-CLIP	2
28▲	222385	CARD, medical alert (not shown)	1

--- Not for sale.

▲ Replacement Danger and Warning labels, tags and cards are available at no cost.

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 Must install as shown with the notch on the bottom.



Ref.	Part	Description	Qty.	Ref.	Part	Description	Qty.
1	---	BODY, gun	1	21	110637	SCREW, adjusting	1
2	237260	KIT, needle and seat	1	22	26C792	HOUSING, fluid	1
2a	---	SEAT, valve	1	23	187965	PIN, pivot	1
2b	---	GASKET	1	24	189974	TRIGGER, gun	1
2c	---	NEEDLE	1	25	235468	STOP, trigger	1
2d	---	RETAINER, seal	1	26	112410	E-CLIP	2
2e	---	SEAL	1	28▲	222385	CARD, medical alert (not shown)	1
8	XHD429	SwitchTip, size 429	1	34	18B903	GUARD, trigger, xhf-180	1
9	XHD001	KIT, RAC Guard	1	35	16P338	SCREW, mach., phillips rnd hd	1
13	203953	SCREW, hex head, 10-24	1	36	107091	SCREW, mach., flat hd	2
15	126943	SET SCREW, 1/4-20	1	37▲	290230	LABEL, warning	1
16	189960	GUIDE, spring	1				
17	112729	SET SCREW, socket head	2				
18	189958	PIN, trigger	1				
19	112727	SPRING	1				
20	189990	ADJUSTER, spring	1				

--- Not for sale.
 ▲ Replacement Danger and Warning labels, tags and cards are available at no cost.




Needle and Seat Kits

The needle and seat are available only in kits that include items 2a through 2e.

The standard non-diffused needle and seat kit, 237260, includes all OEM parts and has the number 125 stamped on the needle and seat. It is recommended for use with mastics, sealers and other high viscosity materials which have fillers that cannot easily pass through a diffuser.

The optional needle and seat kit, 237398, has the number 090 stamped on the needle and seat. This kit will decrease the maximum flow rate of the gun.

Accessories

				
<p>To reduce the risk of component rupture, and serious injury, including fluid injection, do not exceed the gun's 7250 psi (500 bar, 50 MPa) maximum working pressure or the maximum working pressure of lowest rated component in the system.</p>				

17G981 Swivel

7250 psi (50 MPa, 500 bar) Maximum Working Pressure

Connects the gun inlet to the fluid supply hose and allows easier gun movement and twisting.

17G980 Swivel

7250 psi (50 MPa, 500 bar) Maximum Working Pressure

Connects the gun inlet to the fluid supply hose and allows easier gun movement and twisting. This swivel has a PTFE seal for improved chemical resistance.

Technical Specifications

XHF Spray Gun		
	US	Metric
Maximum working pressure	7250 psi	50 MPa, 500 bar
Length	8.25 in.	21 cm
Height	7 in.	17.8 cm
Fluid orifice size	0.125 in.	0.3 cm
Noise (dBa)		
Maximum sound pressure	84 dB(A) @ 6000 psi (41 MPa, 414 bar)	
Maximum sound power	93 dB(A) @ 6000 psi (41 MPa, 414 bar)	
<i>Sound pressure measured 3.3 feet (1 meter) from equipment.</i>		
<i>Sound power measured per ISO-9614-2.</i>		
Inlet/Outlet Sizes		
Air inlet size	3/8 npt(m)	
Materials of Construction		
Wetted materials on all models	Tungsten carbide, 17-4PH passivated stainless steel, polypropylene, polyethylene	
Weight		
All models	1.45 lb.	7.2 kg
Notes		
All trademarks or registered trademarks are the property of their respective owners.		

California Proposition 65

CALIFORNIA RESIDENTS

 **WARNING:** Cancer and reproductive harm – www.P65warnings.ca.gov.

Graco Standard Warranty

Graco warrants all equipment referenced in this document which is manufactured by Graco and bearing its name to be free from defects in material and workmanship on the date of sale to the original purchaser for use. With the exception of any special, extended, or limited warranty published by Graco, Graco will, for a period of twelve months from the date of sale, repair or replace any part of the equipment determined by Graco to be defective. This warranty applies only when the equipment is installed, operated and maintained in accordance with Graco's written recommendations.

This warranty does not cover, and Graco shall not be liable for general wear and tear, or any malfunction, damage or wear caused by faulty installation, misapplication, abrasion, corrosion, inadequate or improper maintenance, negligence, accident, tampering, or substitution of non-Graco component parts. Nor shall Graco be liable for malfunction, damage or wear caused by the incompatibility of Graco equipment with structures, accessories, equipment or materials not supplied by Graco, or the improper design, manufacture, installation, operation or maintenance of structures, accessories, equipment or materials not supplied by Graco.

This warranty is conditioned upon the prepaid return of the equipment claimed to be defective to an authorized Graco distributor for verification of the claimed defect. If the claimed defect is verified, Graco will repair or replace free of charge any defective parts. The equipment will be returned to the original purchaser transportation prepaid. If inspection of the equipment does not disclose any defect in material or workmanship, repairs will be made at a reasonable charge, which charges may include the costs of parts, labor, and transportation.

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GRACO MAKES NO WARRANTY, AND DISCLAIMS ALL IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, IN CONNECTION WITH ACCESSORIES, EQUIPMENT, MATERIALS OR COMPONENTS SOLD BUT NOT MANUFACTURED BY GRACO. These items sold, but not manufactured by Graco (such as electric motors, switches, hose, etc.), are subject to the warranty, if any, of their manufacturer. Graco will provide purchaser with reasonable assistance in making any claim for breach of these warranties.

In no event will Graco be liable for indirect, incidental, special or consequential damages resulting from Graco supplying equipment hereunder, or the furnishing, performance, or use of any products or other goods sold hereto, whether due to a breach of contract, breach of warranty, the negligence of Graco, or otherwise.

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Graco Information

For the latest information about Graco products, visit www.graco.com.

For patent information, see www.graco.com/patents.

TO PLACE AN ORDER, contact your Graco distributor or call to identify the nearest distributor.

Phone: 612-623-6921 or Toll Free: 1-800-328-0211 Fax: 612-378-3505