INSTRUCTIONS-PARTS LIST



307614

Rev. R



This manual contains important warnings and information.
READ AND KEEP FOR REFERENCE.

GRACO
First choice when quality counts.™

Contractor Airless Spray Gun

3600 psi (252 bar, 25.2 MPa) MAXIMUM WORKING PRESSURE

Model 220955, Series D

Includes RAC[®] DripLess[™] Guard, 517 size SwitchTip[™], and 2 finger trigger. Four finger trigger is optional; see parts list.

Model 235990, Series C

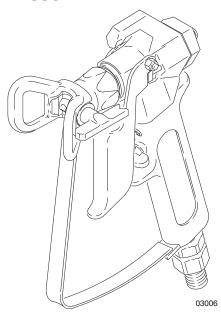
Includes the Standard (non-reversing) DripLess™ Tip Guard and 4-finger trigger.
Spray tip not included. Order separately.

Model 217593, Series E

Includes the Standard (non-reversing) DripLess™ Tip Guard. Spray tip not included. Order separately.

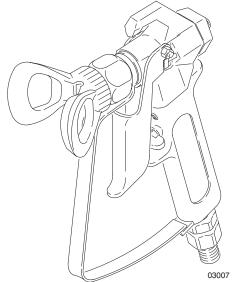
Model 820165, Series D

Includes RAC[®] DripLess[™] Guard, 517 size SwitchTip[™], and 2 finger trigger. Four finger trigger is optional; see parts list.



Models 220955, 820165





Model 217593

Table of Contents

Varnings	How to Clean the Filter
nstallation/Operation5	Service 9
	Parts Drawing
How to Use the Trigger Safety Latch 5	Parts List
How to Use the Gun6	Technical Data
How to Adjust the Spray Pattern 6	Graco Phone Number
How to Clean the Spray Tip	Graco Warranty
and Clear a Spray Tip Obstruction	-

Symbols

Warning Symbol

A WARNING

This symbol alerts you to the possibility of serious injury or death if you do not follow the instructions.

Caution Symbol

A CAUTION

This symbol alerts you to the possibility of damage to or destruction of equipment if you do not follow the instructions.

WARNING



FIRE AND EXPLOSION HAZARD

Improper grounding, poor ventilation, open flames or sparks can cause a hazardous condition and result in a fire or explosion and serious injury.

- If there is any static sparking or you feel an electric shock while using this equipment, **stop spraying immediately.** Do not use the equipment until you identify and correct the problem.
- Provide fresh air ventilation to avoid the buildup of flammable fumes from solvents or the fluid being sprayed.
- Keep the spray area free of debris, including solvent, rags, and gasoline.
- Electrically disconnect all equipment in the spray area.
- Extinguish all open flames or pilot lights in the spray area.
- Do not smoke in the spray area.
- Do not turn on or off any light switch in the spray area while operating or if fumes are present.
- Do not operate a gasoline engine in the spray area.
- Ground the equipment and the object being sprayed. See **Grounding** on page 5.

⚠ WARNING



INJECTION HAZARD

Spray from the gun, leaks or ruptured components can inject fluid into your body and cause extremely serious injury, including the need for amputation. Fluid splashed in the eyes or on the skin can also cause serious injury.

- Fluid injected into the skin is a serious injury. The injury may look like just a cut, but it is a serious
 injury. Get immediate medical attention.
- Do not point the gun at anyone or at any part of the body.
- Do not put your hand or fingers over the spray tip.
- Do not stop or deflect leaks with your hand, body, glove or rag.
- Do not "blow back" fluid; this is not an air spray system.
- Always have the tip guard and the trigger guard on the gun when spraying.
- Check the gun diffuser operation weekly. Refer to the gun manual.
- · Be sure the gun trigger safety operates before spraying.
- Lock the gun trigger safety when you stop spraying.
- Follow the **Pressure Relief Procedure** on page 5 if the spray tip clogs and before cleaning, checking or servicing the equipment.
- Tighten all fluid connections before operating the equipment.
- Check the hoses, tubes, and couplings daily. Replace worn or damaged parts immediately. Do not repair high pressure couplings; you must replace the entire hose.
- Fluid hoses must have spring guards on both ends, to help protect them from rupture caused by kinks or bends near the couplings.



TOXIC FLUID HAZARD

Hazardous fluid or toxic fumes can cause serious injury or death if splashed in the eyes or on the skin, inhaled, or swallowed.

- Know the specific hazards of the fluid you are using.
- Store hazardous fluid in an approved container. Dispose of hazardous fluid according to all local, state and national guidelines.
- Always wear protective eyewear, gloves, clothing and respirator as recommended by the fluid and solvent manufacturer.



RECOIL HAZARD

Due to the high pressure fluid emitted, a strong recoil action may occur when you trigger this gun. If you are unprepared, your hand could be forced back toward your body or you could lose your balance and fall, resulting in serious injury.

WARNING



EQUIPMENT MISUSE HAZARD

Equipment misuse can cause the equipment to rupture or malfunction and result in serious injury.

- This equipment is for professional use only.
- Read all instruction manuals, tags, and labels before operating the equipment.
- Use the equipment only for its intended purpose. If you are uncertain about usage, call your Graco distributor.
- Do not alter or modify this equipment.
- Check equipment daily. Repair or replace worn or damaged parts immediately.
- Do not exceed the maximum working pressure of the lowest rated system component. Refer to the **Technical Data** on page 15 for the maximum working pressure of this equipment.
- Use fluids and solvents which are compatible with the equipment wetted parts. Refer to the Technical Data section of all equipment manuals. Read the fluid and solvent manufacturer's warnings.
- Do not use 1,1,1–trichloroethane, methylene chloride, other halogenated hydrocarbon solvents or fluids containing such solvents in pressurized aluminum equipment. Such use could result in a chemical reaction, with the possibility of explosion.
- Do not use hoses to pull equipment.
- Route hoses away from traffic areas, sharp edges, moving parts, and hot surfaces. Do not expose Graco hoses to temperatures above 82°C (180°F) or below –40°C (–40°F).
- Do not lift pressurized equipment.
- Comply with all applicable local, state, and national fire, electrical, and safety regulations.
- Wear ear protection when operating this equipment.

System Requirements

⚠ WARNING

Keep the wallet-sized warning card provided with this gun with the operator at all times. The card contains important treatment information should an injection injury occur. Additional cards are available at no charge from Graco Inc.

A WARNING

Be sure your system has a bleed-type master air valve (pneumatic pumps only) and a pressure drain valve. These accessories help reduce the risk of serious bodily injury, including fluid injection, splashing in the eyes or on the skin, or injury from moving parts, if you are adjusting or repairing the pump or gun.

- The <u>bleed-type master air valve</u> (air-powered pumps only) relieves air trapped between this valve and the pump after the air regulator is shut off. Trapped air can cause the pump to cycle unexpectedly.
- The <u>pressure drain valve</u> assists in relieving fluid pressure in the displacement pump, hose and gun: triggering the gun to relieve pressure may not be sufficient.
- 3. Strain the fluid you are spraying if it contains particles which could clog the spray tip.

Grounding

To reduce the risk of static sparking, ground the sprayer and all other spray equipment used or located in the spray area. Check your local electrical code for detailed grounding instructions for your area and type of equipment.

▲ WARNING

INJECTION HAZARD

The system pressure must be manually relieved to prevent the system from starting or spraying accidentally. Fluid

under high pressure can be injected through the skin and cause serious injury. To reduce the risk of an injury from injection, splashing fluid, or moving parts, follow the **Pressure Relief Procedure** whenever you:

- are instructed to relieve the pressure,
- stop spraying,
- check or service any of the system equipment,
- or install or clean the spray tip.

Pressure Relief Procedure

- 1. Engage the gun safety latch.
- 2. Turn the ON/OFF switch to OFF.
- 3. Unplug the power supply cord.
- Disengage the gun safety latch. Hold a metal part of the gun firmly to a grounded metal pail. Trigger the gun to relieve pressure.
- 5. Engage the gun safety latch.
- Open the system pressure drain valve. Leave the pressure drain valve open until you are ready to spray again.

If you suspect that the spray tip or hose is completely clogged, or that pressure has not been fully relieved after following the steps above, VERY SLOWLY loosen the tip guard retaining nut or hose end coupling to relieve pressure gradually, then loosen completely. Now clear the tip or hose obstruction.

How to Use the Gun Trigger Safety

- 1. To engage the gun trigger safety, turn the latch to a right angle with the gun body. See Fig. 1.
- 2. To disengage the gun trigger safety, push the latch out and turn it parallel with the gun body.

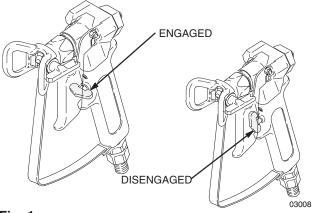


Fig. 1

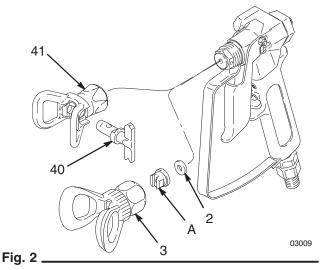
How to Use the Gun

- Connect a grounded fluid hose to the gun inlet. See Fig. 2
- 2. With no tip installed, start the pump. Flush the pump according to the instructions supplied with it. Prime the system with the fluid.
- Follow the Pressure Relief Procedure on page 5. Be sure the gun trigger safety is locked. See Fig. 1.
- Models 217593 & 235990: unscrew the tip guard

 (3) and install the tip (A) and the gasket (2) in the nut of the tip guard. Screw the assembly firmly onto the gun. Tighten the assembly with a wrench. See Fig. 2.

NOTE: If the gasket (2) is not installed, the gun will leak.

 Models 220955 and 820165: install the SwitchTip (40) and the tip guard (41). See manual 308644, supplied. See Fig. 2.



6. Start the pump. Adjust the fluid pressure until the spray is completely atomized. Use the lowest pressure necessary to get the desired results. Higher pressure may not improve the spray pattern and will cause premature tip wear and pump wear.

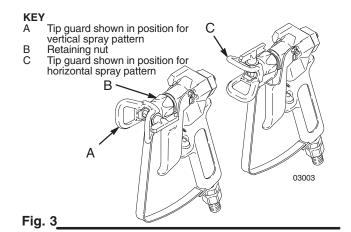
- 7. If adjusting the pressure does not give a good spray pattern, follow the **Pressure Relief Procedure** on page 5 and then try another tip size.
- 8. Use a full-open, full-close triggering action. Hold the gun about 14 in. (350 mm) from and at right angles to the work surface. Don't swing the gun in an arc. Practice to find the best length and speed of stroke.

How to Adjust the Spray Pattern

- To adjust the spray pattern direction, follow the Pressure Relief Procedure on page 5. Loosen the tip guard retaining nut (B). Turn the tip guard/ tip groove horizontally (C) for a horizontal pattern and vertically (A) for a vertical pattern. Tighten the nut.
- 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.

A CAUTION

The openings in the tip guard reduce paint buildup on the tip guard while spraying. Any damage to the sharp edges of the openings causes paint to collect at that area. Never hang the gun by the tip guard.



How to Clean the Spray Tip and Clear a Spray Tip Obstruction

WARNING

To reduce the risk of fluid injection or splashing in the eyes or on the skin, **do not** hold a hand, body or rag in front of the spray tip 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" paint; this is NOT an air spray gun.

DO NOT wipe fluid buildup off the gun or spray tip until pressure is relieved.

Cleaning during the day.

- 1. Follow Pressure Relief Procedure on page 5.
- Clean the front of the tip frequently during the day to help reduce buildup. Also clean the tip and tip guard at the end of each work day. Use a solventsoaked brush to clean the spray tip.

Clearing an obstruction.

If the spray tip clogs while spraying, immediately stop spraying, then:

Gun 217593 & 235990 - with standard tip guard

 Lock the gun trigger safety, open the pressure drain valve.

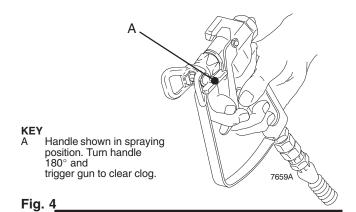
A CAUTION

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

2. Remove the spray tip and blow out the obstruction by applying air to the front of the spray tip. Or, let the spray tip and gun nozzle soak to dissolve the obstruction. If it won't dissolve, jar it out by tapping the back of the spray tip against a flat surface.

Gun 220955 & 820165 - with RAC guard

- 1. Lock the gun trigger safety. Rotate the RAC guard handle 180°. See Fig. 4.
- 2. Unlock the gun trigger safety. Trigger the gun into a pail or onto the ground to remove the clog.
- 3. Lock the gun trigger safety. Rotate the tip handle to the spraying position.
- 4. If the tip is still clogged, lock the gun trigger safety, shut off the sprayer and disconnect the power source, and open the pressure drain valve to relieve pressure. Clean the spray tip as shown in manual 308644, supplied with the RAC guard.



How to Check the Gun Diffuser Operation

Check the diffuser operation weekly. The gun diffuser/ seat (A) breaks up spray and reduces the risk of fluid injection when the tip is not installed. Perform the test below. If it fails, replace the entire Needle Kit, Part No. 218070, as instructed on page 7. Diffuser/seats are not sold separately since the gun will leak if an old needle is used with a new diffuser/seat.

- Follow Pressure Relief Procedure on page 5.
- Remove the tip guard and spray tip.
- Start the sprayer and adjust it to the lowest pressure.
- 4. Aim the gun into a grounded metal pail while holding it firmly to the pail. Trigger the gun. If the fluid emitted is not diffused into an irregular stream, replace the entire needle kit immediately. See Fig. 5.

How to Clean the Filter (See Fig. 6.)

Normal daily system flushing removes most buildup on the filter (17). For a weekly cleaning:

- Follow Pressure Relief Procedure on page 5.
- Remove the screw (14).
- Push up on the trigger guard (12) and swing it away from the trigger (5).
- 4. Unscrew the gun handle from the housing (26). Remove the filter and clean it in compatible solvent.

5. Apply lithium-base grease to the threads of the fluid tube (19) and reassemble the gun.

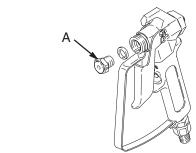
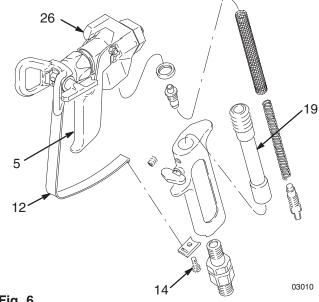


Fig. 5 -



How to Flush the Gun

WARNING



To reduce the risk of serious bodily injury, including splashing fluid in the eyes or on the skin, or static electric

discharge when flushing:

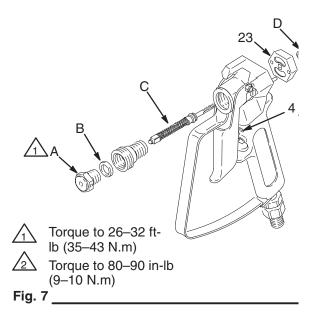
- Be sure the entire system, including flushing pails, are properly grounded.
- Remove the tip guard and spray tip.
- Maintain metal to metal contact between the gun and the flushing pail.
- Use the lowest possible pressure.

Always flush the pump and the gun before the fluid being sprayed can dry in it.

NOTE: If it is available, the flushing procedure provided in your pump or sprayer manual should be used instead of this procedure.

- 1. Follow Pressure Relief Procedure on page 5.
- 2. Remove the tip guard and spray tip. Soak and clean the parts.
- 3. Put the pump intake in a grounded pail of water or solvent.
- 4. Start the pump at its lowest pressure.
- 5. Trigger the gun into the original pail. When solvent appears, release the trigger.
- 6. Now trigger the gun into the solvent pail. Circulate the fluid until the system is thoroughly flushed.
- 7. Follow Pressure Relief Procedure on page 5.

Service



NOTE: The needle (C), diffuser/seat (A), gasket (B) and locknut (D) must be replaced together. They are included in Kit 218070.

Disassembly (See Fig 7)

- Follow the Pressure Relief Procedure on page
 5.
- 2. Remove the tip guard assembly. See Fig 2.
- 3. Squeeze the trigger while unscrewing the diffuser/ seat (A) and gasket (B).
- 4. Remove the locknut (D) and end cap (23).
- 5. Tap the rear of the gun with a plastic mallet to push the needle assembly out the front.

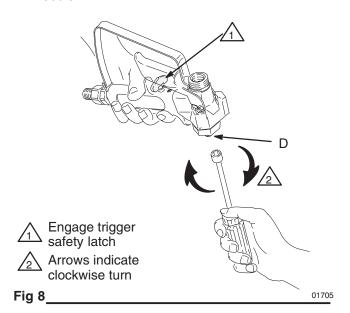
Reassembly (See Fig 7)

- 1. Guide the threaded end of the needle assembly into the front of the gun.
- Install the end cap, aligning its guides with the holes in the rear of the gun. Install the locknut (D) loosely.
- 3. Squeeze the trigger while installing the gasket (B) and diffuser/seat (A). Torque the diffuser seat to 26–32 ft-lb (35–43 N.m).

- 4. If the gun handle (6) was removed, hand tighten it into the fluid housing (26); it should fit easily. Only if necessary, loosen the setscrew (4), align the handle with the fluid housing and torque the setscrew to 80–90 in-lb (9–10 N.m).
- Adjust the needle before using the gun. Procedure below.
- 6. Be sure the trigger guard and tip guard are installed before using the gun.

Adjusting the needle (See Fig 8)

- 1. Engage the gun safety latch.
- 2. Hold the gun with the nozzle straight up so the trigger falls onto the safety latch.
- 3. With light pressure, hold the trigger against the latch. Turn the locknut (D) clockwise until there is enough tension for you to **feel** *and* **see** the trigger raise slightly off the latch.
- 4. Turn the adjusting nut 3/4 turn counterclockwise.
- 5. Connect the fluid hose. Install the tip guard and prime the system. Trigger the gun and release it. The fluid flow should stop immediately. Engage the safety latch and try to trigger the gun. No fluid should flow. If the gun fails either test, relieve pressure, disconnect the hose and readjust the needle.



Notes

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Parts Drawing

Model 220955, Series D Includes items 1 and 4 to 41 Model 235990, Series C Includes items 1 to 39 Model 217593, Series E Includes items 1 to 39 Included with 1 23, Model 820165, Series D 32 Includes items 1 to 39 - 18 19 **1**∕40 20 16 37 Purchase separately 15 03013

Parts List

Model 220955, Series D; Model 235990, Series C; Model 217593, Series E; Model 820165, Series D

Ref. No.	Part No.	Description	Qty.	Ref. No.	Part No.	Description	Qty.
1	218070	NEEDLE-DIFFUSER/SEAT KIT	1	19	179721	FLUID TUBE	1
2/	166969	GASKET, tip (used with flat tips only)	1	20	179763	SPRING	1
3	220251	TIP GUARD	1	21	179722	SPRING RETAINER (color coded blue	ue)
4	100421	SETSCREW, soc hd, 5/16-18 x 3/8"	1			(for standard 50 mesh filter)	1
5	179734	2 FINGER TRIGGER (standard)	1	21a	179957	SPRING RETAINER (color coded ora	ange)
5a	179943	4 FINGER TRIGGER				(for optional 100 mesh filter)	1
		(Model 235990 only)	1	221	179733	GASKET	1
6	218643	GUN HANDLE ASSEMBLY		23	191244	END CAP	1
		includes replaceable items 4, 13, 14	1	26	179718	FLUID HOUSING	1
10▲	172479	INSTRUCTION TAG	1	31	105334	LOCKNUT; M4 x 0.7 thread	1
11 🛦	179761	WARNING TAG	1	32	177538	TRIGGER STUD	1
12	195495	TRIGGER GUARD	1	33	179737	ACTUATOR PIN	2
13	179730	GUARD RETAINER	1	37	195419	NEEDLE HOUSING	1
14	109575	SCREW, 8-32 x 5/16"	1	39▲	222385	WARNING CARD (not shown)	1
15	218021	SWIVEL	1	401	221517	SWITCHTIP SPRAY TIP, SZ 517	1
16	179750	SPRING RETAINER	1	41/	237859	RAC DripLess GUARD	
17/	218131	FLUID FILTER ASSEMBLY (standard 50 mesh) includes				See manual 308644 for parts	1
17a	218133	replaceable items 16, 18, 20, 21 FLUID FILTER ASSEMBLY (optional 100 mesh) includes	1	Replacement Danger and Warning labels, tags and cards are available at no cost.			
18	179731	replaceable items 16, 18a, 20, 21a STRAINER ELEMENT	1			pare parts on hand to reduce dov	vn
		(standard 50 mesh)	1	tin	ne.		
18a	179732	STRAINER ELEMENT (optional 100 mesh)	1				

Accessories

FILTERS

3000 psi (210 bar, 21 MPa) Maximum Working Pressure.

Adequate filtering is important for a good surface finish and to minimize tip clogging. These filters provide secondary filtering. Elements are available in various mesh sizes.

Mounts in hose

213068 Includes filter body, spring and one

100 mesh screen.

213069 Includes filter spring and one

60 mesh screen.

Use with above filter body.

210742 Includes filter spring and one

100 mesh screen.

Use with above filter body.

210729 Includes assembly 213068 plus a

3 ft (0.9 m) whip hose for more

flexible gun movement.

Standard filter elements

224455 Two, 50 mesh filters (179731)

224456 Two, 100 mesh filters (179732)

Mounts between hose and gun

210500 Includes swivel, adapter and one

60 mesh screen

Replacement elements for above filters

210731 Three 60 mesh (250 micron) screens
 210732 Three 100 mesh (149 micron) screens
 210733 Three 200 mesh (74 micron) screens

TOOLS

Nylon Brushes

Use to thoroughly clean the gun's fluid passages.

101891 0.375" (9 mm) dia. **101892** 0.625" (16 mm) dia.

Wrench 171147
Fits all hexes on the gun.



SWIVELS and WHIP HOSES

Swivels and whip hoses provide more flexible gun movement for easier handling and less fatigue. Working pressures are listed in the descriptions.

214925 Swivel, 1/4 npsm x 3/8 npt(f)

5000 psi (350 bar, 35 MPa) Max. Working Pressure

207946 Swivel, 1/2 npsm x 3/8 npt(f)

5000 psi (350 bar, 35 MPa) Max. Working Pressure

204940 Swivel, 1/4 npt x 1/4 npsm

3000 psi (210 bar, 21 MPa) Max. Working Pressure

214701 Whip hose, nylon, coupled 1/4 npsm(f)

x 3/8 npt(m), spring guards both ends.

3000 psi (210 bar, 21 MPa) Max. Working Pressure

TIP GUARDS

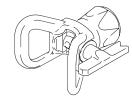
These tip guards fit all Graco airless spray guns. Choose the one that's right for your application. One of these tip guards is included with every Graco airless gun.

237859 Performance Series Reverse–A–Clean

DripLess[™] Guard.

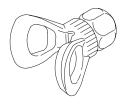
Order SwitchTip separately.

See your distributor for available sizes.



220251 Standard DripLess™ Tip Guard. Order

flat tip separately. See your distributor for available sizes.



Heavy Duty RAC[®] DripLess[™] Tip Guard.

Order SwitchTip separately. See your

distributor for available sizes.

Technical Data

Maximum Working Pressure	
Fluid Orifice Size 0.125 in. (3.18 m	m)
Wetted Parts Stainless steel, Polyethyler	
Polyurethane, Nylon, PTFE	Ξ
Weight	g)
Inlet 1/4 npsm(m)swi	vel
Maximum Material Temperature 120°F(50°	
Sound Data	
Sound Pressure Level 78 dB(/	4)*
Sound Power Level 87 dB(/	4)*
* Measured while spraying waterbase paint - gravity	/
1.36 through a 517 tip at 3,000 psi (207 bar).	
Per ISO 3744	

Graco Phone Number

TO PLACE AN ORDER, contact your Graco distributor, or call this number to identify the distributor closest to you: **1–800–690–2894 Toll Free.**

Manual Change Summary

Changed Revision level of manual from P to R per ECO Z000496.

Graco Warranty

Graco warrants all equipment listed in this manual which is manufactured by Graco and bearing its name to be free from defects in material and workmanship on the date of sale by an authorized Graco distributor 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 or 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

Graco's sole obligation and buyer's sole remedy for any breach of warranty shall be as set forth above. The buyer agrees that no other remedy (including, but not limited to, incidental or consequential damages for lost profits, lost sales, injury to person or property, or any other incidental or consequential loss) shall be available. Any action for breach of warranty must be brought within two (2) years of the date of sale.

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, gas engines, 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.

FOR GRACO CANADA CUSTOMERS

The parties acknowledge that they have required that the present document, as well as all documents, notices and legal proceedings entered into, given or instituted pursuant hereto or relating directly or indirectly hereto, be drawn up in English. Les parties reconnaissent avoir convenu que la rédaction du présente document sera en Anglais, ainsi que tous documents, avis et procédures judiciaires exécutés, donnés ou intentés à la suite de ou en rapport, directement ou indirectement, avec les procédures concernées.

ADDITIONAL WARRANTY COVERAGE

Graco does provide extended warranty and wear warranty for products described in the "Graco Contractor Equipment Warranty Program".

All information, illustrations and specifications in this document are based on the latest product information available at the time of publication. The right is reserved to make changes at any time without notice.

> Sales Offices: Minneapolis, Detroit Foreign Offices: Belgium, Korea, Hong Kong, Japan

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