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INTRODUCTION

The LP400/410E delivers the durability of an Airlessco, with the simplicity of a mechanical pressure control system. It's built on a compact, well balanced triple chrome plated carry frame sturdy enough to stand on.

It's powered by a dependable fan cooled, totally enclosed DC motor - no troublesome electronic controls! The heart of any contractor sprayer is the pump, and the durability of the LP pump is legendary amongst pro painters. It features the oversized "Slow-Stroking" stainless steel piston, and Airlessco's patented externally adjustable packing system. It's the only packing system that has external adjustment of upper and lower packings. No getting stuck on the job with blown packings and a sprayer full of paint!

The LP400 comes standard with our 008 Silver Contractor spray gun with built in swivel, and 50' of 1/4" high pressure airless hose.

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WARNING

HANDLE THIS UNIT AS YOU WOULD A LOADED FIREARM!
High pressure spray can cause extremely serious injury.
OBSERVE ALL WARNINGS!

Before operating this unit, read and follow all safety warnings and instructions related to the usage of this equipment on pages 2, 3 & 4. READ, LEARN, and FOLLOW the Pressure Relief Procedure on Page 10 of this manual.

All Service Procedures to be performed by an Authorized Airlessco Service Center ONLY.

NO MODIFICATIONS or alterations of any AIRLESCCO Equipment or part is allowed.

MANUAL NOTATIONS

**WARNING** - Alerts user to avoid or correct conditions that could cause bodily injury.
**CAUTION** - Alerts user to avoid or correct conditions that could cause damage to or destruction of equipment.
**IMPORTANT** - Alerts users to steps or procedures that are essential to proper equipment repair and maintenance.
**NOTE** - Identifies essential procedures or extra information.
SAFETY WARNINGS

HIGH PRESSURE SPRAY CAN CAUSE EXTREMELY SERIOUS INJURY. 
Handle as you would a loaded firearm. 
Follow the PRESSURE RELIEF PROCEDURE.

DO NOT USE HALOGENATED SOLVENTS IN THIS SYSTEM.
The prime valve, and most airless guns have aluminum parts and may explode. Cleaning agents, coatings, paints or adhesives may contain halogenated hydrocarbon solvents. DON'T TAKE CHANCES! Consult your material suppliers to be sure. Some of the most common of these solvents are: Carbon tetra chloride, Chlorobenzene, Dichloroethane, Dichloroethyl Ether, Ethylbromide, Ethylchloride, Tetrachloethane. Alternate valves and guns are available if you need to use these solvents.

MEDICAL ALERT - Airless Spray Wounds
If any fluid appears to penetrate your skin, get EMERGENCY MEDICAL CARE AT ONCE. DO NOT TREAT AS A SIMPLE CUT. Tell the doctor exactly what fluid was injected.

INJECTION HAZARD
• Fluids under high pressure from spray or leaks can penetrate the skin and cause extremely serious injury, including the need for amputation.
• NEVER point the spray gun at anyone or any part of the body.
• NEVER put your hand or fingers over the spray tip. Do not use a rag or any other materials over your fingers. Paint will penetrate through these materials & into the hand.
• NEVER try to stop or deflect leaks with your hand or body.
• ALWAYS have the tip guard in place when spraying.
• ALWAYS lock the gun trigger when you stop spraying.
• ALWAYS remove tip from the gun to clean it.
• NEVER try to "blow back" paint, this is not an air spray sprayer.
• ALWAYS follow the PRESSURE RELIEF PROCEDURE before cleaning or removing the spray tip or servicing any system equipment.
• Be sure the equipment safety devices are operating properly before each use.
• Tighten all of the fluid connections before each use.

MEDICAL TREATMENT
• If any fluid appears to penetrate your skin, get EMERGENCY CARE AT ONCE! DON'T TREAT AS A SIMPLE CUT.
• Go to an emergency room immediately.
• Tell the doctor you suspect an injection injury.
• Tell him what kind of material you were spraying with and have him read NOTE TO PHYSICIAN above.

NOTE TO PHYSICIAN: Injection in the skin is a traumatic injury. It is important to treat the injury surgically as soon as possible. DO NOT DELAY treatment to research toxicity. Toxicity is a concern with some exotic coatings injected directly into the blood stream. Consultation with a plastic surgeon or reconstructive hand surgeon may be advisable.

GENERAL PRECAUTIONS
• NEVER alter equipment in any manner.
• NEVER smoke while in spraying area.
• NEVER spray highly flammable materials.
• NEVER use around children.
• NEVER allow another person to use sprayer unless he is thoroughly instructed on its safe use and given this operators manual to read.
• ALWAYS wear a spray mask, gloves and protective eye wear while spraying.
• ALWAYS ensure fire extinguishing equipment is readily available and properly maintained.

NEVER LEAVE SPRAYER UNATTENDED WITH PRESSURE IN THE SYSTEM.

FOLLOW PRESSURE RELIEF PROCEDURES.

NOTE: United States Government safety standards have been adopted under the Occupational Safety & Health Act. These standards, particularly the General Standards, Part 1910 & Construction Standards, Part 1926 should be consulted.
SAFETY WARNINGS

ALWAYS INSPECT SPRAYING AREA
- Keep the spraying area free from obstructions.
- Make sure the spraying area has good ventilation to safely remove vapors and mists.
- NEVER keep flammable material in spraying area.
- NEVER spray in vicinity of open flame or other sources of ignition.
- The spraying area must be at least 20 ft. away from spray unit.

SPRAY GUN SAFETY
- ALWAYS set gun safety lock in the "LOCKED" position when not in use & before servicing or cleaning.
- NEVER remove or modify any part of the gun.
- ALWAYS REMOVE THE SPRAY TIP when cleaning. Flush unit at the LOWEST POSSIBLE PRESSURE.
- ALWAYS check operation of all gun safety devices before each use.
- Be very careful when removing the spray tip or hose from the gun. A plugged line will contain fluid under pressure. If the tip or line is plugged, follow the PRESSURE RELIEF PROCEDURE.

TIP GUARD
- ALWAYS have the tip guard in place on the spray gun while spraying. The tip guard alerts you to the injection hazard and helps prevent accidentally placing your fingers or any part of your body close to the spray tip.

SPRAY TIP SAFETY
- Use extreme caution when cleaning or changing spray tips. If the spray tip clogs while spraying, engage the gun safety latch immediately. ALWAYS follow the PRESSURE RELIEF PROCEDURE and then remove the spray tip to clean it.
- NEVER wipe off build up around the spray tip.

TOXIC FLUID HAZARD
- ALWAYS remove tip guard & tip to clean AFTER pump is turned off and the pressure is relieved by following the PRESSURE RELIEF PROCEDURE.
- Hazardous fluid or toxic fumes can cause serious injury or death if splashed in eyes or on skin, inhaled or swallowed. Know the hazards of the fluid you are using. Store & dispose of hazardous fluid according to manufacturer, local, state & national guidelines.
- ALWAYS wear protective eyewear, gloves, clothing and respirator as recommended by fluid manufacturer.

HOSES
- Tighten all of the fluid connections securely before each use. High pressure fluid can dislodge a loose coupling or allow high pressure spray to be emitted from the coupling and result in an injection injury or serious bodily injury.
- Only use hoses with a spring guard. The spring guard helps protect the hose from kinks or other damage which could result in hose rupture and cause an injection injury.
- NEVER use a damaged hose, which can result in hose failure or rupture and cause an injection injury or other serious bodily injury or property damage. Before each use, check entire hose for cuts, leaks, abrasions, bulging of the cover, or damage or movement of couplings. If any of these conditions exist, replace the hose immediately.
- NEVER use tape or any device to try to mend the hose as it cannot contain the high pressure fluid. NEVER ATTEMPT TO RECOUPLE THE HOSE. A high pressure hose is not recoupleable.

GROUNDING
- Ground the sprayer & other components in the system to reduce the risk of static sparking, fire or explosion which can result in serious bodily injury and property damage. For detailed instructions on how to ground, check your local electrical code.
- ALWAYS ensure switch is in OFF position before plugging unit in.

Always Ground All of These Components:
1. Sprayer: plug the power supply cord, or extension cord, each equipped with an undamaged three-prong plug, into a properly grounded outlet. DO NOT USE AN ADAPTER. Use only a 3 wire extension cord that has a 3 blade grounding plug, and a 3 slot receptacle that will accept the plug on the product. Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. (Note: The table on the top of the next page shows the correct size to use depending on cord length and name plate ampere rating. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.)
2. Fluid hose: use only grounded hoses.
3. Spray gun or dispensing valve: grounding is obtained through connection to a properly grounded fluid hose and pump.
4. Object being sprayed: according to your local code.
5. All solvent pails used when flushing:
   - Once each week, check electrical resistance of hose (when using multiple hose assemblies, check overall resistance.) Overall (end to end) resistance of unpressurized hose must not exceed 29 megohms (max.) for any coupled length or combination of hose lengths. If hose exceeds these limits, replace it immediately.
   - Never exceed 500 ft. (150 m) overall combined cord length to assure electrical continuity.
SAFETY WARNINGS

ALWAYS USE APPROVED HIGH PRESSURE FITTINGS AND REPLACEMENT PARTS.

ALWAYS ENSURE FIRE EXTINGUISHING EQUIPMENT IS READILY AVAILABLE AND PROPERLY MAINTAINED.

KEEP CLEAR OF MOVING PARTS

Keep clear of moving parts when starting or operating the sprayer. Do not put your fingers into any openings to avoid amputation by moving parts or burns on hot parts. Precaution is the best insurance against an accident. When starting the motor, maintain a safe distance from moving parts of the equipment. Before adjusting or servicing any mechanical part of the sprayer, follow the PRESSURE RELIEF PROCEDURE.

AVOID COMPONENT RUPTURE

• This sprayer operates at 3000 psi (205 bar). Always be sure that all components and accessories have a maximum working pressure of at least 3000 psi to avoid rupture which can result in serious bodily injury including injection and property damage.
• NEVER leave a pressurized sprayer unattended to avoid accidental operation of it, which could result in serious bodily injury.
• ALWAYS follow the PRESSURE RELIEF PROCEDURE whenever you stop spraying and before adjusting, removing or repairing any part of the sprayer.
• NEVER alter or modify any part of the equipment to avoid possible component rupture which could result in serious bodily injury and property damage.
• NEVER use weak, damaged, or non-conductive paint hose. Do not allow kinking or crushing of hoses or allow it to vibrate against rough, sharp or hot surfaces. Before each use, check your hoses for damage and wear and ensure all of the fluid connections are secure.
• ALWAYS replace any damaged hose. NEVER use tape or any device to mend the hose.
• NEVER attempt to stop any leakage in the line or fittings with your hand or any part of the body. Turn off the unit and release pressure by following PRESSURE RELIEF PROCEDURE.

PREVENT STATIC SPARKING FIRE/EXPLOSIONS

• ALWAYS be sure all of the equipment & objects being sprayed are properly grounded. Always ground sprayer, paint bucket and object being sprayed. See the grounding section of this manual for grounding information.
• Vapors created when spraying can be ignited by sparks. To reduce the risk of fire, always locate the sprayer at least 20 feet (6 m.) away from spray area. Do not plug in or unplug any electrical cords in the spray area. Doing so can cause sparks which can ignite any vapors still in the air. Follow the coating & solvent manufacturers safety warnings and precautions.
• Use only conductive fluid hoses for airless applications. Be sure the gun is grounded through the hose connections. Check ground continuity in hose & equipment. Overall (end to end) resistance of unpressurized hose must not exceed 29 megohms for any coupled length or combination of hose length. Use only high pressure airless hoses with static wire approved for 3000 psi.

FLUSHING

• Reduce the risk of injection injury, static sparking or splashing by following the specific cleaning process.
• ALWAYS follow the PRESSURE RELIEF PROCEDURE.
• ALWAYS remove the spray tip before flushing. Hold the metal part of the gun firmly to the side of a metal pail & use the lowest possible fluid pressure during flushing.
• NEVER use cleaning solvents with flash points below 140 degrees F. Some of these are: acetone, benzene, ether, gasoline, naphtha. Consult your supplier to be sure.
• NEVER SMOKE in the spraying/cleaning area.

WHEN SPRAYING & CLEANING WITH FLAMMABLE PAINTS AND THINNERS

1. When spraying with flammable liquids, the unit must be located a minimum of 25 feet away from the spraying area in a well ventilated area. Ventilation must be sufficient enough to prevent the accumulation of vapors.
2. To eliminate electrostatic discharge, ground the spray unit, paint bucket & spraying object. See GROUNDING. Use only high pressure airless hoses approved for 3000 psi which is conductive.
3. Remove the spray tip before flushing. Hold the metal part of the gun firmly to the side of a metal pail & use the lowest possible fluid pressure during flushing.
4. Never use high pressure in the cleaning process. USE MINIMUM PRESSURE.
5. Do not smoke in spraying/cleaning area.
**1. New Sprayer**
Your sprayer was factory tested in an oil solution which was left in the pump. **Before using oil-base paint**, flush with mineral spirits only. **Before using water-base paint** flush with mineral spirits, followed by soapy water, then a clean water flush.

**2. Changing Colors**
Flush with a compatible solvent such as mineral spirits or water.

**3. Changing from water-base to oil-base paint.**
Flush with soapy water, then mineral spirits.

**4. Changing from oil-base to water-base paint.**
Flush with mineral spirits, followed by soapy water, then a clean water flush.

**5. Storage**
*Always relieve pressure (See pressure relief procedure on page 10) prior to storage or when machine is unattended.*

Oil-base Paint: Flush with mineral spirits. Ensure that there is no pressure in the unit, then close the prime/pressure relief valve.

Water-base Paint: Flush with water, then mineral spirits. For longer term storage use a 50/50 mixture of mineral spirits and motor oil. Always ensure that there is no pressure in the unit, and close the prime/pressure relief valve for storage.

**6. Start-up after storage**
*Before using water-base paint*, flush with soapy water and then a clean water flush.

*When using oil-base paint*, flush out the mineral spirits with the material to be sprayed.

---

**NEVER leave pump unattended while under pressure!**

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**HOW TO FLUSH**

**FIGURE 1**

Prime/Pressure Relief Valve (Prime/PR Valve)
Used to relieve pressure from gun, hose & tip and to prime the unit when in OPEN position.  
(It is in open position when there is a wider gap between valve handle and cam body).
When valve is in the CLOSED position, there is only a very slight gap between handle & body.  
When closed the system is pressurized.

Handle as a Loaded Firearm!

**FIGURE 2**

PRESSURE CONTROL KNOB. (FIG. 2)
Used to adjust pressure. Turn clockwise (CW) to increase pressure and counterclockwise (CCW) to decrease pressure.

**FIGURE 3**

TOGGLE SWITCH

Continued on next page...........
1. Be sure the gun safety latch is engaged and there is no spray tip in the gun. Refer to page 14 on how to lock the safety latch and the gun's safety features.

**FIGURE 4**

**REMOVE SPRAY TIP, ENGAGE GUN SAFETY LATCH.**

2. Pour enough clean, compatible solvent into a large, empty metal pail to fill the pump and hoses.

3. Place the suction tube into the pail.

4. Turn the Prime/Pressure Relief (PR) Valve to the "OPEN", priming position. Refer to Figure 1.

5. Point the gun into the metal pail and hold a metal part of the gun firmly against the pail. Refer to Figure 5.

6. Disengage the gun safety latch and squeeze the gun trigger. Turn the ON-OFF Toggle Switch to the "ON" position (Figure 3) and turn Pressure Control Knob (Figure 2) clockwise to increase pressure just enough to start the pump.

7. Turn the Prime/PR Valve to the PRESSURE "CLOSED" position. This will allow solvent to be flushed through the pump, hoses and gun. Allow the unit to operate until clean solvent comes from the gun.

8. Release the trigger and engage the gun safety latch.

9. Whenever you shut off the sprayer, follow the "PRESSURE RELIEF PROCEDURE".

---

**WARNING**

To reduce the risk of static sparking which can cause fire or explosion, always hold a metal part of the gun firmly against the metal pail when flushing. This also reduces splashing.

**FIGURE 5**

MAINTAIN FIRM METAL TO METAL CONTACT BETWEEN GUN AND CONTAINER
CERTIFYING UP

1. Connect the hose and gun.
   a. Remove the plastic cap plug from the outlet tee and screw a conductive or grounded 3000 psi airless spray hose onto fluid outlet.
   b. Connect an airless spray gun to the other end of the hose.
   c. Do not use steel braided airless hose. Use nylon braided airless hose only.

   **NOTE:** Do not use thread sealer on swivel unions as they are made to self-seal. Use thread seal on tapered male threads only.

2. Fill the packing nut/wet cup with 5 drops of Airlessco Throat Seal Oil (TSO). See (Figure 6).

3. Check the electrical service.
   Be sure the electrical service is 120 VAC, 15 amp minimum, and that the outlet you use is properly grounded.

4. Grounding

   **WARNING**
   To reduce the risk of static sparking, fire or explosion which can result in serious bodily injury and property damage, always ground the sprayer and system components and the object being sprayed, as instructed in the safety warning section of this manual.

5. Flush the sprayer
   As per "Flushing Procedure" in this manual.
1. Learn the functions of the controls.

**PRIME/PRESSURE (PR) RELIEF VALVE** is used to prime pump and to relieve pressure from gun, hose and tip.

**FIGURE 7**
Prime/Pressure Relief Valve (Prime/PR Valve)
Used to relieve pressure from gun, hose & tip and to prime the unit when in OPEN position. (It is in open position when there is a wider gap between valve handle and cam body)
When in CLOSED position, there is only a very slight gap between handle & body. When closed the system is pressurized. Handle as a loaded firearm!

**FIGURE 8**
TOGGLE SWITCH
PRESSURE CONTROL KNOB is used to adjust pressure. Turn clockwise (CW) to increase pressure and counterclockwise (CCW) to decrease pressure.

**FIGURE 9**

2. Prepare the material

a. Prepare the material according to the material manufacturer’s recommendations.

b. Place the suction tube into the material container.

3. Starting the sprayer

(See Figure 7, 8 & 9)

a. Prime/PR Valve must be "OPEN" in the priming position.

b. When you have ensured that the gun safety latch is engaged, attach tip and safety guard.

c. Turn the ON-OFF Toggle Switch to the "ON" position.

d. After the pump is primed, turn Prime/PR Valve to the "Closed" position.

e. Turn Pressure Control Knob to the desired spray pressure.

f. Disengage the gun safety latch and you are ready to spray.
4. Adjusting the pressure

a. Turn the Pressure Control Knob Clockwise to increase pressure and counterclockwise to decrease pressure.

b. Always use the lowest pressure necessary to completely atomize the material.

Note: Operating the sprayer at higher pressure than needed, wastes material, causes early tip wear, and shortens sprayer life.

c. If more coverage is needed, use a larger tip rather than increasing the pressure.

d. Check the spray pattern. The tip size and angle determines the pattern width and flow rate.

Avoiding Tip Clogs

There is an easy way to keep the outside of the tip clean from material build up:

Every time you stop spraying, for even a minute, lock the gun and submerge it into a small bucket of thinner suitable for the material sprayed. Thinner will dissolve the buildup of paint on the outside of tip, tip guard and gun much more effectively if the paint doesn’t have time to dry out completely.

5. When Shutting off the Sprayer

a. Whenever you stop spraying, even for a short break, follow the "Pressure Relief Procedure".

b. Clean the tip & gun as recommended on page 11 for Airlessco 008 gun or separate gun instruction manual for all others.

c. Flush the sprayer at the end of each work day, if the material you are spraying is water-based, or if it could harden in the sprayer overnight. See "Flushing". Use a compatible solvent to flush, then fill the pump and hoses with an oil based solvent such as mineral spirits.

d. For long term shutdown or storage, refer to the "Flushing" section of this manual.
**PRESSURE RELIEF PROCEDURE**

⚠️ **IMPORTANT!**

To avoid possible serious body injury, always follow this procedure whenever the sprayer is shut off, when checking it, when installing, changing or cleaning tips, whenever you stop spraying, or when you are instructed to relieve the pressure.

1. Engage the gun safety latch. Refer to the separate instruction manual provided with your gun on its safety features and how to engage safety latch.

2. Turn the unit off & unplug it from the electrical outlet.

3. Disengage the gun safety latch and trigger the gun to relieve residual fluid pressure.

   *Hold metal part of the gun in contact with grounded metal pail. USE MINIMUM PRESSURE!*

4. Turn Prime/Pressure Relief Valve (PR Valve) to the open (priming) position to relieve residual fluid pressure.

   *There will be a wider gap between valve handle and cam body when in open position. In the closed position there is only a very slight gap.*

   *Note: The valve handle can move both clockwise and counter clockwise and can face different directions.*

5. Re-engage gun safety latch and close Prime/Pressure Relief Valve.

If the SPRAY TIP OR HOSE IS CLOGGED, follow Step 1 through 5 above. Expect paint splashing into the bucket while relieving pressure during Step 4.

If you suspect that pressure hasn't been relieved due to damaged Prime/Pressure Relief Valve or other reason, engage the gun safety latch and take your unit to an authorized Airlessco Service Center.

---

**DAILY MAINTENANCE**

1. Keep the displacement pump packing nut/wet cup lubricated with Airlessco TSO (Throat Seal Oil) at all times. The TSO helps protect the rod and the packings.

2. Inspect the packing nut daily. Your pump has a patented Triple Life Packing System. *Packing life will be extended a minimum of three times if the following "Packing Adjustment" procedure is followed:*

   *If seepage of paint into the packing nut and/or movement of the piston upward is found (while not spraying), the packing nut should be tightened enough to stop leakage only, but not any tighter. Over tightening will damage the packings and reduce the packing life.*
SPRAY GUN OPERATION

SPRAY GUN
Attach spray gun to airless unit and tighten fittings securely. Set the gun safety latch. (Also may be called gun safety lock, or trigger lock)

* The gun safety latch should always be set when the gun is not being triggered.

Read all warnings and safety precautions supplied with the spray gun and in product manual.

MAJOR COMPONENTS OF SPRAY GUN AND REVERSIBLE SPRAY TIP

SPRAY TIP ASSEMBLY
1. Be sure pressure relief procedure is followed before assembling tip and housing to the gun.
2. Lock gun safety latch.
3. Insert REV-TIP™ cylinder into the REV-GUARD™ (guard housing assembly).
4. Guide metal seat into REV-GUARD™ (guard housing assembly) through retaining nut & turn until it seats against the cylinder.
5. Insert O-Ring gasket on metal seat so it fits in the grooves.
6. Finger tighten REV-GUARD™ retaining nut onto the gun.
7. Turn guard in the desired position.
8. Completely tighten the retaining nut.

TO REMOVE CLOGS FROM SPRAY TIP
1. Lock gun safety latch.
2. Turn REV-TIP™ handle 180 degrees.
3. Disengage trigger lock & trigger gun into pail.
4. If the REV-TIP™ handle appears locked (resists turning), loosen the retaining nut. The handle will now turn easily.
5. Engage gun safety latch & return handle to the spray position.

CLEANING SPRAY GUN
Immediately after the work is finished, flush the gun out with a solvent. Brush pins with solvent and oil them lightly so they will not collect dried paint.

CLEANING FILTER IN GUN HANDLE
To clean the filter, use a brush dipped in an appropriate solvent. Change or clean filters at least once a day. Some types of latex may require a filter change after four hours of operation.

CLOGGED FLAT TIP
Should the spray tip become clogged, relieve pressure from hose by following the "Pressure Relief Procedure." Secure gun with the safety latch, take off guard, take out the tip, soak in appropriate solvent & clean with a brush. (Do not use a needle or sharp pointed instrument to clean the tip. The tungsten carbide is brittle and can chip.)
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<tr>
<td></td>
<td>Tip damaged</td>
<td>Replace with new tip*</td>
</tr>
<tr>
<td>Excess Paint Builds on Tip Guard</td>
<td>Spray gun excessively close to surface</td>
<td>Hold gun further from surface sprayed</td>
</tr>
<tr>
<td></td>
<td>Pressure setting high</td>
<td>Reduce pressure setting</td>
</tr>
<tr>
<td>Drips, Spits From Tip</td>
<td>Valve seat and/or ball in gun head</td>
<td>Service spray gun, replace valve assembly</td>
</tr>
<tr>
<td></td>
<td>damaged or worn</td>
<td></td>
</tr>
<tr>
<td>Tip Clogs Continually</td>
<td>Debris in paint</td>
<td>Thoroughly strain paint before use</td>
</tr>
<tr>
<td></td>
<td>Gun filter missing</td>
<td>Insure gun filter is in handle</td>
</tr>
<tr>
<td></td>
<td>Coarse filter mesh</td>
<td>Use fine mesh filter in gun handle</td>
</tr>
<tr>
<td>Gun Filter Clogs Quickly</td>
<td>Debris in paint</td>
<td>Thoroughly strain paint before use</td>
</tr>
<tr>
<td></td>
<td>Pump inlet strainer missing</td>
<td>Do not operate without inlet strainer</td>
</tr>
</tbody>
</table>

*See “Tip Selection Guide” in this manual
Spray tip selection is based on paint viscosity, paint type, and job needs. For light viscosities (thin paints), use a smaller tip; for heavier viscosities (thicker paints), use a larger tip size.

Spray tip size is based on how many gallons of paint per minute can be sprayed through the tip. Do not use a tip larger than the maximum pump flow rate or capacity the sprayer can accommodate. Pump flow rate is measured in gallons per minute (GPM).

**PATTERN WIDTH**
Thickness of the paint coat per stroke is determined by spray tip "fan width", rate of the spray gun movement, and distance to surface.

**SPRAY TIP SELECTION**
Two tips having the same tip size, but different pattern widths will deliver the same amount of paint over a different area (wider or narrower strip). A spray tip with a narrow pattern width makes it easy to spray in tight places.

**SPRAY TIP REPLACEMENT**
During use, especially with latex paint, high pressure will cause the orifice to grow larger. This destroys the pattern.

Replace tips before they become excessively worn. Worn tips waste paint, cause overspray, make cutting-in difficult, and decreases sprayer performance.
### REV-TIP® SPRAY TIP SIZE CHART

**For sizes not shown, call factory for availability.**

#### REV-TIP® for Painting

<table>
<thead>
<tr>
<th>Fan Width (12” from surface)</th>
<th>SPRAY TIP - ORIFICE SIZE (Inches)</th>
</tr>
</thead>
<tbody>
<tr>
<td>in.</td>
<td>(mm)</td>
</tr>
<tr>
<td>4-6</td>
<td>102-152</td>
</tr>
<tr>
<td>6-8</td>
<td>152-203</td>
</tr>
<tr>
<td>8-10</td>
<td>203-254</td>
</tr>
<tr>
<td>10-12</td>
<td>254-305</td>
</tr>
<tr>
<td>12-14</td>
<td>305-356</td>
</tr>
<tr>
<td>14-16</td>
<td>356-406</td>
</tr>
<tr>
<td>16-18</td>
<td>406-457</td>
</tr>
<tr>
<td>20-24</td>
<td>508-610</td>
</tr>
</tbody>
</table>

**Gun Filter**

C = Coarse - 60 mesh  
F = Fine - 100 mesh

**Wood Interior**

Lacquer, Varnish, Stain, Sealer, Enamel

**Wood Exterior**

Exterior Stain  
Vinyl, Acrylic, Latex

**Masonry**

Vinyl, Oil Base Alkyd, Latex, Acrylic, Block Filler, Elastomer

**Ceiling**

Hi Build, Mill White

**Structural Steel**

Heavy Coatings

**Water Flow Rate** (water @ 2000psi, 138 bar)

<table>
<thead>
<tr>
<th>(gpm)</th>
<th>.12</th>
<th>.18</th>
<th>.24</th>
<th>.31</th>
<th>.38</th>
<th>.47</th>
<th>.57</th>
<th>.67</th>
<th>.77</th>
<th>1.03</th>
<th>1.31</th>
<th>1.63</th>
<th>1.80</th>
</tr>
</thead>
<tbody>
<tr>
<td>(lpm)</td>
<td>.49</td>
<td>.69</td>
<td>.91</td>
<td>1.17</td>
<td>1.47</td>
<td>1.79</td>
<td>2.15</td>
<td>2.54</td>
<td>2.96</td>
<td>3.90</td>
<td>4.98</td>
<td>6.17</td>
<td>6.81</td>
</tr>
</tbody>
</table>

**Paint Flow Rate** (latex paint @ 2000psi, 138 bar, 36 spec. gr.)

<table>
<thead>
<tr>
<th>(gpm)</th>
<th>.10</th>
<th>.15</th>
<th>.21</th>
<th>.27</th>
<th>.33</th>
<th>.40</th>
<th>.49</th>
<th>.58</th>
<th>.66</th>
<th>.88</th>
<th>1.12</th>
<th>1.39</th>
<th>1.54</th>
</tr>
</thead>
<tbody>
<tr>
<td>(lpm)</td>
<td>.38</td>
<td>.57</td>
<td>.79</td>
<td>1.02</td>
<td>1.25</td>
<td>1.51</td>
<td>1.85</td>
<td>2.20</td>
<td>2.50</td>
<td>3.33</td>
<td>4.24</td>
<td>5.26</td>
<td>5.83</td>
</tr>
</tbody>
</table>

**Pump Minimum Output**

<table>
<thead>
<tr>
<th>(gpm)</th>
<th>.25</th>
<th>.25</th>
<th>.33</th>
<th>.40</th>
<th>.50</th>
<th>.60</th>
<th>.75</th>
<th>.88</th>
<th>1.0</th>
<th>1.25</th>
<th>1.5</th>
<th>2.0</th>
<th>2.2</th>
</tr>
</thead>
<tbody>
<tr>
<td>(lpm)</td>
<td>1.0</td>
<td>1.0</td>
<td>1.25</td>
<td>1.5</td>
<td>1.9</td>
<td>2.3</td>
<td>2.8</td>
<td>3.3</td>
<td>3.8</td>
<td>4.7</td>
<td>5.7</td>
<td>7.5</td>
<td>8.2</td>
</tr>
</tbody>
</table>

*Pump will support tip worn to next larger size.

#### STRIPING TIP - ORIFICE SIZE (Inches)

<table>
<thead>
<tr>
<th>Fan Width (5” from surface)</th>
<th>STRIPING TIP - ORIFICE SIZE (Inches)</th>
</tr>
</thead>
<tbody>
<tr>
<td>in.</td>
<td>(mm)</td>
</tr>
<tr>
<td>1-2</td>
<td>25-51</td>
</tr>
<tr>
<td>2-4</td>
<td>51-102</td>
</tr>
<tr>
<td>4-6</td>
<td>102-152</td>
</tr>
<tr>
<td>6-8</td>
<td>152-203</td>
</tr>
<tr>
<td>Striping Paint</td>
<td>Oil Base</td>
</tr>
</tbody>
</table>

**New Wide Tips**

NEW Wide Tips

- W21
- W23
- W25

**Fine Finish**

NEW Double orifice design for lower pressure spraying when you need a smoother finish on interior trim, cabinet, shutters, and doors.

<table>
<thead>
<tr>
<th>Fan Width</th>
<th>Orifice Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>4-6</td>
<td>.012</td>
</tr>
<tr>
<td>6-8</td>
<td>.014</td>
</tr>
<tr>
<td>8-10</td>
<td>.012</td>
</tr>
</tbody>
</table>

**For Paint Spraying**

P.N. 560-xxx  
Includes Rev-Tip® TM, Metal Seal & O-Ring Seal.

**For Striping Pavement & Turf**

P.N. 562-xxxST  
Includes Rev-Tip® TM, Metal Seal & O-Ring Seal.
1. **LUBRICATION** - This motor is supplied with prelubricated ball bearings, lubricated for life of bearing.

2. **MOTOR BRUSHES** - These need periodic inspection and replacement as wear indicates. Brush wear is greatly influenced by individual application. It is recommended that brush wear be checked at early intervals of operation in order to determine future required inspections. The standard brushes for this motor have an initial length of 13/16". When the brushes are worn to a length of 1/4", they should be replaced.

3. **TO CHANGE THE BRUSHES**, follow the procedures below:
   a. Unplug the machine.
   b. Open the two covers at the rear of the motor.
   c. Loosen the screw holding the brush terminal and remove the brush lead.
   d. Push the brush retainer clip in and remove.
   e. Remove the worn brushes (one on each side of motor).
   f. Install new brushes in reverse order and replace covers.

**NOTE**: For longer life, new brushes (Part No. 331-778) need to have a run in period. After changing brushes, set up the machine for spraying. Use a bucket of water and Airlessco Pump Conditioner mixture, a 50 foot x 1/4" airless hose, airless gun with 0.017 tip on unit, turn the Prime/PR Control Valve to the Prime position and turn the unit on. Turn the Pressure Control Knob to maximum pressure (fully CW position) and let the pump cycle at high speed in the prime position for 20 minutes. This will allow the brushes to "run in" properly giving a longer life.
# FIELD TROUBLESHOOTING

<table>
<thead>
<tr>
<th>PROBLEM</th>
<th>CAUSE</th>
<th>SOLUTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>Unit doesn't prime</td>
<td>Airleak due to:</td>
<td>• Tighten Suction Nut</td>
</tr>
<tr>
<td></td>
<td>• Loose Suction Nut</td>
<td>• Replace O-Ring (106-011) on suction seat, &amp; O-Ring (106-020) below suction seat</td>
</tr>
<tr>
<td></td>
<td>• Worn O-Rings</td>
<td>• Replace Suction Hose (331-290)</td>
</tr>
<tr>
<td></td>
<td>• Hole in Suction Hose</td>
<td></td>
</tr>
<tr>
<td></td>
<td>• Stuck or Fouled Balls</td>
<td>• Service outlet valve suction assembly</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Unit primes but has no</td>
<td>Pressure set too low</td>
<td>• Turn up pressure</td>
</tr>
<tr>
<td>or poor pressure</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Filter(s) are clogged</td>
<td>• Clean or replace gun filter, inlet filter and/or manifold filter</td>
</tr>
<tr>
<td></td>
<td>Outlet Valve fouled/worn</td>
<td>• Service outlet valve</td>
</tr>
<tr>
<td></td>
<td>Prime/Pressure Relief valve</td>
<td>• Clean or replace primve valve</td>
</tr>
<tr>
<td></td>
<td>bypassing</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Packings and/or piston worn</td>
<td>• Tighten packing nut</td>
</tr>
<tr>
<td></td>
<td></td>
<td>• Repack unit</td>
</tr>
<tr>
<td>Unit does not maintain</td>
<td>Blown spray tip</td>
<td>• Replace spray tip</td>
</tr>
<tr>
<td>good spraying pressure</td>
<td></td>
<td>• Repack unit</td>
</tr>
<tr>
<td></td>
<td>Packings and/or piston worn</td>
<td>• Replace upper seat</td>
</tr>
<tr>
<td></td>
<td>Upper Seat worn</td>
<td></td>
</tr>
<tr>
<td>Unit does not run</td>
<td>Blown fuse</td>
<td>• Replace fuse</td>
</tr>
<tr>
<td></td>
<td></td>
<td>• 15A SlowBlow (pn. 331-256)</td>
</tr>
<tr>
<td></td>
<td>Electrical failure</td>
<td>• See electrical troubleshooting</td>
</tr>
</tbody>
</table>
GEAR AND PUMP ASSEMBLY

- Do not operate machine without cover guard in place.

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>331-234</td>
<td>Cover</td>
</tr>
<tr>
<td>331-046</td>
<td>Bearing</td>
</tr>
<tr>
<td>331-038</td>
<td>Crosshead Assembly</td>
</tr>
<tr>
<td>331-406</td>
<td>Gear Crank</td>
</tr>
<tr>
<td>331-047</td>
<td>Bearing</td>
</tr>
<tr>
<td>331-040</td>
<td>Gearbox Casting *</td>
</tr>
<tr>
<td>100-381</td>
<td>Bolt Soc Hd (2)</td>
</tr>
<tr>
<td>100-380</td>
<td>Shoulder Bolt (2)</td>
</tr>
<tr>
<td>331-088</td>
<td>Retaining Ring</td>
</tr>
<tr>
<td>331-065</td>
<td>Pin</td>
</tr>
<tr>
<td>331-117</td>
<td>Sleeve</td>
</tr>
<tr>
<td>331-062</td>
<td>Retaining Spring</td>
</tr>
<tr>
<td>331-209</td>
<td>Fluid Pump Ass’y</td>
</tr>
<tr>
<td>100-318</td>
<td>Screw (2)</td>
</tr>
<tr>
<td>331-074</td>
<td>Tube Spacer (2)</td>
</tr>
<tr>
<td>331-111</td>
<td>Cover Guard</td>
</tr>
<tr>
<td>331-061</td>
<td>Sleeve Bearing</td>
</tr>
<tr>
<td>115-019</td>
<td>Hose Connector (1/4 NPSXNPT)</td>
</tr>
</tbody>
</table>

**PART NUMBER DESCRIPTION**

- **PART #**
- **DESCRIPTION**

**GEARBOX SLEEVE BEARING REPLACEMENT**

1. Remove fluid pump as per "Fluid Pump Disconnect" procedures.
2. Remove frame from the gearbox by loosening the four mounting screws.
3. Refer to Figure 12. Separate cover assembly from box by removing bolts from front of cover & back of box & shoulder bolts from front of cover & back of box.
4. Lay unit on its back and disassemble gearbox.
5. Inspect bearings, Crosshead Assembly, Gearcrank & sleeve bearing inside cover assembly for wear/damage. Replace worn/damaged parts.
6. If gear grease needs replacing, replace with gear grease (Part No. 331-132).
7. Clean mating surfaces of cover and box thoroughly. Use Part No. 105-331 BLUE XS™ ADVANCED RTV SILICONE INSTANT GASKET.
8. Reassemble in reverse order.

**SERVICING GEAR BOX ASSEMBLY**

**NOTE:** When replacing item (1), cover outside of sleeve with clear silicone prior to inserting into cover assembly.

**FIGURE 10 PARTS LIST**

<table>
<thead>
<tr>
<th>ITEM #</th>
<th>PART #</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>331-061</td>
<td>Sleeve Bearing</td>
</tr>
<tr>
<td>2</td>
<td>331-103</td>
<td>Washers (2)</td>
</tr>
<tr>
<td>3</td>
<td>331-197</td>
<td>Screws (2)</td>
</tr>
</tbody>
</table>
SERVICING THE FLUID PUMP

NOTE: Check everything in the Troubleshooting Chart before disassembling the Fluid Pump.

Fluid Pump Removal - Refer to Figure 11

1. Follow the Pressure Relief Procedure page 10.
2. Flush the material you are spraying out of the machine.
3. Remove the connecting rod shield (331-111).
4. Move the piston rod (331-093) to its lowest position by cycling pump slowly or by rotating the motor fan.
5. Remove the grey wire from the Pressure Control Switch.
6. Remove the retaining ring (331-062) from the connecting rod (331-038) and slide the sleeve (331-117) down revealing the connecting rod pin (331-065).
7. Remove the suction assembly from the fluid pump body (331-011) by unscrewing the suction nut (331-034) with the packing adjustment tool.
8. Using a 1/2” wrench unscrew the two bolts (100-318) from the cover assembly 331-234). The fluid pump will be hanging loosely at this point.
9. Remove the connecting rod pin (331-065) out of the connecting rod (331-038), allowing the removal of the fluid pump (331-209) from the machine.

FIGURE 11
Fluid Pump Reinstallation -
Refer to Figure 11 & 14

1. Loosen the packing nut and ensure that the piston rod (331-093) is in its upper position in the fluid pump body (331-011). Slip the sleeve (331-117) & the retaining ring (331-062) over the piston rod.

2. Push the piston rod up into the connecting rod (331-038) & align the holes. Insert the connecting rod pin (331-065) through the connecting rod & piston. Slip the sleeve over the connecting rod pin and insert the retaining ring into the groove on the connecting rod.

3. Push the two bolts (100-318) through the tube spacers (331-074) & screw them into the cover assembly (331-234). Using a 1/2” wrench, tighten the two bolts evenly (alternating between them) until you reach 20 ft-lbs.

4. Reassemble the lower suction valve assembly by placing the suction seat assembly: O-ring (106-011), suction ball (331-030) and suction ball guide (331-029) in the suction nut (331-034) and screw onto the fluid pump body.

5. Reconnect the grey wire to the Pressure Control Switch.

6. Start the machine and operate slowly to check the piston rod for binding. Adjust the two bolts, holding the fluid pump body to the cover assembly, if necessary. This will eliminate any binding.

7. Tighten the packing nut counter clockwise until resistance is felt against the Belleville Springs, then go 3/4 of a turn more. Put five drops of Airlessco Throat Seal Oil into the packing nut.

8. Run the machine at full pressure for several minutes. Release the pressure by following the Pressure Relief Procedure & readjust the packing nut per step 7 above.

9. Install the connecting rod shield (331-111) so that the small hole is in the upper right hand corner.
**Servicing the Piston Rod - Outlet Valve**

**DISASSEMBLY OF THE OUTLET VALVE**

REFER TO FIGURE 13

1. Disconnect the Fluid Pump.
2. Place piston holder (Item 1) in a vise. Slide piston into the holder & lock in place with a 3/8” dowel (Item 2).
3. Use a 1/4” allen wrench to unscrew the outlet seat retainer (Item 7) from the piston.
4. Remove the outlet seat (Item 5), O-ring (Item 6) and outlet ball (Item 4).
5. Inspect outlet ball & seat for wear. Replace as necessary.
6. While piston is still locked in the holder, install parts back into the piston in the following order:

   **ball, outlet seat and O-ring**

   Before reinstalling the outlet seat retainer, apply two drops of Loctite No. 242 (blue) on the threads & torque to 20 ft-lbs.

<table>
<thead>
<tr>
<th>Item</th>
<th>Part Number</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>331-195</td>
<td>Piston Holder</td>
</tr>
<tr>
<td>2</td>
<td>331-196</td>
<td>3/8” Dowel</td>
</tr>
<tr>
<td>3</td>
<td>331-708</td>
<td>Piston</td>
</tr>
<tr>
<td>4</td>
<td>331-027</td>
<td>Outlet Ball</td>
</tr>
<tr>
<td>5</td>
<td>331-026</td>
<td>Outlet Seat</td>
</tr>
<tr>
<td>6</td>
<td>331-100</td>
<td>O-ring</td>
</tr>
<tr>
<td>7</td>
<td>331-314</td>
<td>Outlet Seat Retainer</td>
</tr>
</tbody>
</table>

**Servicing the Suction Assembly**

Refer to Figure 14

1. Unthread and remove suction nut from the fluid pump body.
2. Remove suction seat (Item 5), O-ring (Item 4), suction ball (Item 3) and suction retainer (Item 2).
3. Clean all parts and inspect them for wear or damage, replacing parts as needed.
4. Clean inside of the fluid pump body.
5. Reassemble lower suction valve assembly by placing the suction seat (Item 5), O-ring (Item 4), suction ball (Item 3) & suction ball guide (Item 2) in the suction nut (Item 6) & screw onto fluid pump body.

<table>
<thead>
<tr>
<th>Item</th>
<th>Part Number</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>331-011</td>
<td>Fluid Pump Body</td>
</tr>
<tr>
<td>2</td>
<td>331-029</td>
<td>Suction Ball Guide</td>
</tr>
<tr>
<td>3</td>
<td>331-030</td>
<td>Suction Ball</td>
</tr>
<tr>
<td>4</td>
<td>106-011</td>
<td>O-ring</td>
</tr>
<tr>
<td>5</td>
<td>331-409</td>
<td>Suction Seat</td>
</tr>
<tr>
<td>6</td>
<td>331-034</td>
<td>Suction Nut</td>
</tr>
</tbody>
</table>
**Packing Replacement Procedures**

**Replacement Instructions:**

**Fluid Pump Removal - Refer to Figure 11**

1. Follow steps 1-9 on page 16 under Removal procedures.

**Disassembly of the Fluid Pump - Figure 16**

1. Unscrew & remove the packing nut (331-037).
2. Push the piston rod (331-708) down through the packings & out of the pump.
3. Now push the packing removal tool (187-249) up through the pump & remove from the top bringing packings, spacer & springs along with it, leaving fluid body (331-011) empty.

   *Make sure all old packings & glands have been removed from fluid pump.*

5. Disassemble all parts & clean for reassembly. Discard any old packings.
6. Lubricate leather packing in lightweight oil for 10 minutes prior to reassembly.

**Disassembly of the Outlet Valve - Figure 13**

1. Follow steps 2-6 on page 19 under Disassembly of the Outlet Valve.

**REASSEMBLY - Figure 15 & 16**

1. Take lower male gland (331-014) & place it down on the flat side.
2. Take three of the lower polyethylene packings (331-016) & two of the leather packings (331-306) & place onto the male gland in the following order with the inverted side down: polyethylene, leather, polyethylene, leather, polyethylene.
3. Take the female adaptor (331-305), which is inverted on both sides, & place it on top of your assembled lower packings.
4. Follow step 2 above with your packings inverted side up.
5. Take the second lower male gland and place it on top of your assembled packings with the rounded side down.
6. Take assembled glands & packings (13 pieces) & slide on to the lower half of the piston.
7. Take the spacer (331-018) & slide over the top of the piston (it doesn’t matter which direction it sits), falling onto lower packings.
8. Take three Belleville Springs (331-025) & slide over the top of the piston in the following order:
   * First spring, curve facing down
   * Second spring, curve facing up
   * Third spring, curve facing down
9. Take upper male gland (331-022) & place it rounded side up.
10. Take three upper polyethylene packings (331-023) & two leather packings (331-307) & assemble with inverted side down, on to the male gland in the following order:
    polyethylene, leather, polyethylene, leather, polyethylene.
11. Take upper female gland (331-021) & place on top of the assembled upper packings with the inverted side down.
12. Take assembled upper glands & packings (7 pieces) & slide on over the top of the piston, making sure inverted sides are down.
13. Take the packing holder (331-019) & replace the white O-ring (106-009) & the black O-ring (106-010) with new ones from the packing kit.
14. Slide the packing holder over the top of the upper packings so they fit inside.
15. Lubricate inside of the fluid pump body & the outside of the packings with a light weight oil.

   *To keep packings secured in correct position, hold the pump body upside down & push the completed assembly upwards into the pump body. Once placed inside, tilt pump body back up to keep all pieces in.*
17. Tighten packing nut (331-037) onto the top of the fluid pump body & tighten until you feel slight resistance against the Belleville Springs (331-025). Using the Packing Adjustment Tool (189-211), tighten another 3/4 of a turn.

**Fluid Pump Reinstallation - Figure 11 & 14**

1. Follow steps 1-9 on page 16 under reinstallation procedures.
Packing Replacement Procedures (Continued)

FIGURE 15

FIGURE 16
## FRAME ASSEMBLY Part Number 331-401

### FIGURE 17

<table>
<thead>
<tr>
<th>Item</th>
<th>Part #</th>
<th>Description</th>
<th>Item</th>
<th>Part #</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>331-234</td>
<td>Cover</td>
<td>12</td>
<td>111-037</td>
<td>Screw (4)</td>
</tr>
<tr>
<td>2</td>
<td>331-143</td>
<td>Frame</td>
<td>13</td>
<td>100-382</td>
<td>Screw (2)</td>
</tr>
<tr>
<td>3</td>
<td>119-048</td>
<td>Screw (4)</td>
<td>14</td>
<td>100-028</td>
<td>Plug 1/4 NPT</td>
</tr>
<tr>
<td>4</td>
<td>331-490</td>
<td>.6 HPDC Motor</td>
<td>15</td>
<td>331-048</td>
<td>Rubber Boot (2)</td>
</tr>
<tr>
<td>5</td>
<td>331-212</td>
<td>Fan</td>
<td>16</td>
<td>100-180</td>
<td>Prime P/R Valve</td>
</tr>
<tr>
<td>6</td>
<td>331-213</td>
<td>Fan Cover</td>
<td>17</td>
<td>100-318</td>
<td>Screw (2)</td>
</tr>
<tr>
<td>7</td>
<td>117-090</td>
<td>Fan Cover Screws (3)</td>
<td>18</td>
<td>115-019</td>
<td>Hose Connector (1/4 NPSXNPT)</td>
</tr>
<tr>
<td>8</td>
<td>301-191</td>
<td>Fan Retaining Clip</td>
<td>19</td>
<td>331-725</td>
<td>Pressure Valve</td>
</tr>
<tr>
<td>9</td>
<td>331-398</td>
<td>Motor Brush (2)</td>
<td>20</td>
<td>331-111</td>
<td>Shield</td>
</tr>
<tr>
<td>10</td>
<td>301-405</td>
<td>Blank Plate</td>
<td>21</td>
<td>331-074</td>
<td>Tube Spacer (2)</td>
</tr>
<tr>
<td>11</td>
<td>331-838</td>
<td>Terminal Box</td>
<td>22</td>
<td>100-638</td>
<td>Terminal Box Gasket</td>
</tr>
</tbody>
</table>
SUCTION ASSEMBLIES  Part Number 331-238

FIGURE 18

<table>
<thead>
<tr>
<th>Item</th>
<th>Part Number</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>331-217</td>
<td>Inlet Strainer</td>
</tr>
<tr>
<td>2</td>
<td>331-135</td>
<td>Spring Clip</td>
</tr>
<tr>
<td>3</td>
<td>331-290</td>
<td>Suction Hose Ass’y (Inc. strainer)</td>
</tr>
<tr>
<td>4</td>
<td>331-425</td>
<td>Bypass Hose</td>
</tr>
<tr>
<td>5</td>
<td>111-016</td>
<td>Nylon Tie</td>
</tr>
<tr>
<td>6</td>
<td>331-231</td>
<td>Bypass Hose Ass’y</td>
</tr>
<tr>
<td>7</td>
<td>331-090R</td>
<td>Fitting</td>
</tr>
<tr>
<td>8</td>
<td>331-035</td>
<td>Suction Elbow</td>
</tr>
<tr>
<td>9</td>
<td>331-034</td>
<td>Suction Nut</td>
</tr>
<tr>
<td>10</td>
<td>106-020</td>
<td>O-Ring PTFE</td>
</tr>
</tbody>
</table>
## TROUBLESHOOTING - Machine does not start

Refer to Figure 19

<table>
<thead>
<tr>
<th>CAUSE</th>
<th>STEPS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Control Settings</td>
<td><strong>STEP 1:</strong> After making sure that the machine is plugged into the wall, verify that the on-off switch is in the ON position and that the pressure control knob is turned all the way to the right (clockwise for maximum pressure).</td>
</tr>
<tr>
<td>Fuse</td>
<td><strong>STEP 2:</strong> Using your multi-meter, test the fuse for continuity or replace with a new fuse. If the fuse reads good, move on to step three.</td>
</tr>
<tr>
<td>Power Source</td>
<td><strong>STEP 3:</strong> Locate the L1 and L2 terminals on the board, and then using your multi-meter check to make sure you have 110 volts AC across the two terminals (the cord wires will still be attached). If there is no voltage at these leads, there is no power getting to the machine. Check your power source (outlet, circuit breaker, extension cord, and power cord). If you have AC voltage at the L1 and L2 terminals, go to step 4.</td>
</tr>
<tr>
<td>Thermal Overload</td>
<td><strong>STEP 4:</strong> Disconnect the two red motor leads (S1 &amp; S2) and test for continuity between them. No continuity means that the thermal coupler has opened due to excessive motor heat. If the motor is still hot to the touch, allow it to cool and then retest. If the motor is cool and there is not continuity on the red leads, contact your local electric motor repair facility to repair/replace the thermal coupler. Continuity shows that the motor's thermal coupler has not tripped. Proceed to step 5.</td>
</tr>
<tr>
<td>Pressure Control Assembly</td>
<td><strong>STEP 5:</strong> If everything checks out in steps one through four and the power indicating light is still out, replace the pressure control assembly.</td>
</tr>
<tr>
<td>(Board)</td>
<td></td>
</tr>
</tbody>
</table>
**ELECTRICAL BOARD CALIBRATION**

*Note: Anytime a sensor, pressure control assembly (board) or both are replaced, the following calibrations must be performed.*

**PRESSURE CALIBRATION**

1. Attach a 50’, 1/4” airless hose, airless gun with 0.017 tip and a 5000 psi glycerin filled pressure gauge to the pump.
2. Place the suction tube into a bucket of Airlessco Pump Conditioner and water.
3. Turn prime/pressure relief valve to the prime (open) position and prime fluid pump.
4. Place the prime/pressure relief valve in the pressure (closed) position.
5. Slowly increase pressure using the control knob, while watching the glycerin gauge. Maximum pressure is to be 3000 psi. Adjust pressure using the set screw under label on top of pressure control knob. Clockwise to increase pressure and counter-clockwise to decrease pressure. Trigger the gun a few times to ensure maximum pressure is correct.
6. If pressure exceeds 3000 psi, use adjusting set screw under the label on the knob top. Turning the set screw counter-clockwise will decrease the unit pressure.

**ELECTRICAL BOARD CALIBRATION**

1. Unplug machine’s power cord.
2. Remove four screws (Fig. 17, Item 12) from pressure control assembly.
3. Disconnect all leads from pressure control assembly.
4. Reassemble in reverse order.

**PRESSURE CONTROL KNOB**

1. Unplug machine's power cord.
2. Remove four screws (Fig. 17, Item 12) from pressure control assembly.
3. Disconnect Pressure Control Knob wire from pressure control assembly.
4. Unscrew Knob from Fluid Body fitting
5. Reassemble in reverse order, use liquid pipe thread sealer (PST) on threads, tighten to snug, then rotate 90 deg so wire is tucked next to fluid body. Do Not Overtighten.

**ON-OFF TOGGLE SWITCH**

1. Lower the pressure control assembly as described above.
2. Disconnect the two wires on the switch.
3. Use a 9/16” wrench to loosen the nut on the toggle switch shaft.
4. Reassemble in reverse order.

**FUSE HOLDER**

1. Lower pressure control assembly as described above.
2. Disconnect the two wires on the holder.
3. Remove holder cover and fuse.
4. Use 11/16” wrench to remove the nut from the holder shaft.
5. Reassemble in reverse order.

---

*WARNING*

Always unplug the electrical cord before servicing machine.

*NOTE: Anytime the pressure control assembly, sensor or both are replaced, perform the calibrations.*
ELECTRICAL SYSTEM

FIGURE 19

<table>
<thead>
<tr>
<th>Item</th>
<th>Part #</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>331-168</td>
<td>Electrical Power Cord</td>
</tr>
<tr>
<td>2</td>
<td>331-185</td>
<td>Strain Relief</td>
</tr>
<tr>
<td>3</td>
<td>331-138</td>
<td>Screw</td>
</tr>
<tr>
<td>4</td>
<td>331-312</td>
<td>Fuse Holder</td>
</tr>
<tr>
<td>5</td>
<td>331-256</td>
<td>Fuse 15A Slow Blow</td>
</tr>
<tr>
<td>6</td>
<td>331-311</td>
<td>Toggle Switch</td>
</tr>
<tr>
<td>7</td>
<td>331-490</td>
<td>Motor .6HP 90VCD</td>
</tr>
<tr>
<td>8</td>
<td>331-749</td>
<td>Pressure Control Assembly</td>
</tr>
<tr>
<td>9</td>
<td>331-725</td>
<td>Pressure Control Switch</td>
</tr>
</tbody>
</table>