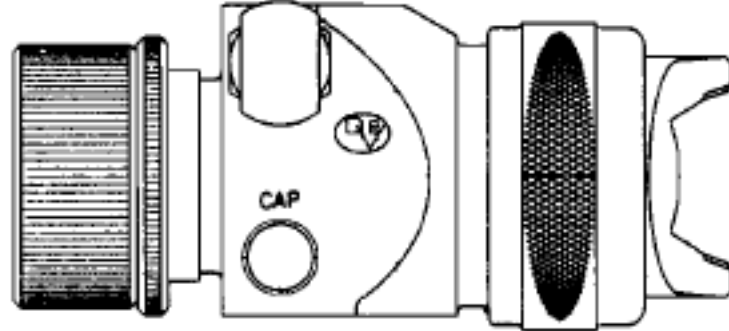


T-AGB

COMPACT AUTO GUN Operation Manual

DEVILBISS

Important: Read and follow all instructions and SAFETY PRECAUTIONS before using this equipment.



DESCRIPTION

T-AGB gun is a small, light-weight Automatic Compact gun and suitable for robots and automatic machines. Models and application information follows.

MODELS

Example: T-AGB-872 704 - FX

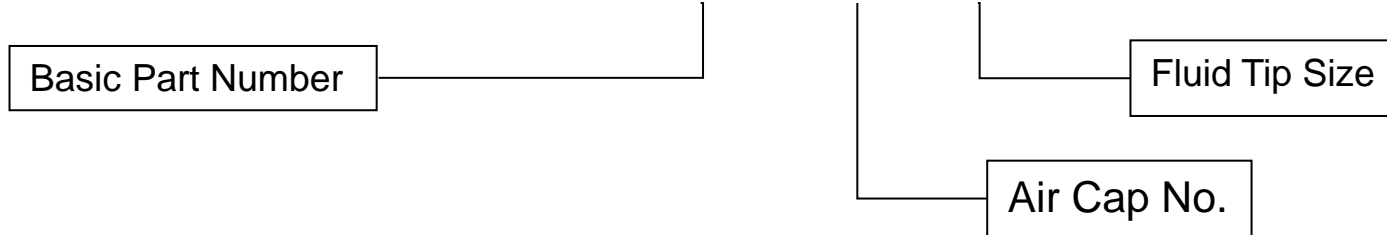


Chart 1

Model No. (Available Tip Sizes)	Gun body Material	Fluid Tip/Needle Material	Typical Applications	Weight
T-AGB-862 AC(2.8), D(2.2), E(1.8), FF(1.4), FX(1.1), G(0.7)	Aluminum	303Gr/ 400Gr Stainless	Most conventional materials	270g
T-AGB-872 AC(2.8), D(2.2), E(1.8) FF(1.4), FX(1.1), G(0.7)	303Gr Stainless	303Gr/ 400Gr Stainless	Most conventional Materials & most waterbornes & chlorinated solvents.	550g
T-AGB-873 AC(2.8), D(2.2), EE(1.8) FF(1.4)	303Gr Stainless	Niteralloy	Abrasive materials	550g
T-AGB-874 D(2.2), EE(1.8), FF(1.4)	303Gr Stainless	Tungsten Carbide	Porcelain Enamels	550g
T-AGB-879 FF(1.4), FX(1.1), G(0.7)	303Gr Stainless	303Gr Stainless	Waterbornes	550g
T-AGB-882 FF(1.4), FX(1.1), G(0.7)	316Gr Stainless	303Gr Stainless	Foods, Medicines	550g

NOTE: Stainless Steel body gun may be used with chlorinated solvents. Aluminum is not used in fluid passages. If using chlorinated solvents, make sure all other fluid handling components are also compatible.

SAFETY PRECAUTIONS




This manual contains important information that ALL users should know and understand BEFORE using this equipment. This information relates to USER SAFETY and PREVENTING EQUIPMENT PROBLEMS.

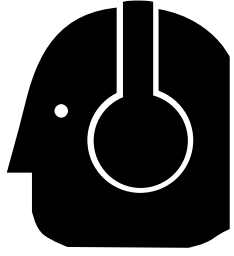
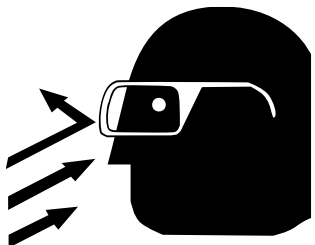
To help you recognize this information, we use the following terms to draw your attention to certain equipment labels and portions of this manual. Pay special attention to any label or information that is highlighted by one of these terms:

WARNING	Important information to alert you to a situation that might cause serious injury or loss of life if instructions are not followed.
CAUTION	Important information that tells how to prevent damage to equipment.
NOTE	Information that you should pay special attention to.

WARNING

The following hazards may occur during the normal use of this equipment. Please read the following chart.

HAZARD	CAUSE	SAFEGUARDS
<p>Fire</p> 	<p>Solvents and coatings can be highly flammable or combustible, especially when sprayed.</p>	<ol style="list-style-type: none"> 1. Adequate exhaust must be provided to keep the air free of accumulations of flammable vapors. 2. Smoking must never be allowed in the spray area. 3. Fire extinguishing equipment must be present in the spray area. 4. Static discharges must be prevented. Ground(earth) all conductive objects in the spray area, such as a cleaning solvent bucket, fire extinguisher, etc. 5. When using solvents for cleaning: <ul style="list-style-type: none"> · Those used for equipment flushing must have a flash point equal to or greater than that of the coating. · Those used for general cleaning must have flash points above 100°F (37.8°C).
<p>Inhaling Toxic Substances</p> 	<p>Certain materials may be harmful if inhaled or if there is contact with the skin.</p>	<ol style="list-style-type: none"> 1. Follow the requirements of the Material Safety Data Sheet supplied by coating material manufacturer. 2. Adequate exhaust must be provided to keep the air free of accumulations of toxic materials. 3. Use a mask or respirator whenever there is a chance of inhaling sprayed materials. The mask must be compatible with the material being sprayed and its concentration. Equipment must be as prescribed by an industrial hygienist or safety expert, and be NIOSH approved.
<p>Explosion Hazard – Incompatible Materials</p> 	<p>Halogenated hydrocarbon Solvents- for example: methylene chloride and 1,1,1,-Trichloroethane are not chemically compatible with the aluminum that might be used in many system components. The chemical reaction caused by these solvents reacting with aluminum can become violent and lead to an equipment explosion.</p>	<p>The T-AGB spray gun can be used with these solvents. However, aluminum is widely used in other spray application equipment – such as material pumps, cups, regulators, valves, etc. Check all other equipment items before use of these solvents. Read the label or data sheet for the material you intend to spray. If in doubt as to where or not a coating or cleaning material is compatible, contact your material supplier.</p>

HAZARD	CAUSE	SAFEGUARDS
General Safety	Improper operation or maintenance may create a hazard.	Operators should be given adequate training in the safe use and maintenance of the equipment (in accordance with the requirements of NFPA-33, Chapter 15 in U.S.). Users must comply with all local and national codes of practice and insurance company requirements governing ventilation, fire precautions, operation, maintenance and housekeeping (in the U.S., these are OSHA Sections 1910.94 and 1910.107 and NFPA-33).
Noise Levels 	The continuous A-weighted sound pressure level of this spray gun may exceed 85dB(A) depending on the air cap/nozzle set-up being used. Sound levels are measured using an impulse sound level meter and analyzer, when the gun is being used in a normal spraying application. Details of actual noise levels produced by the various air cap/nozzle set-ups are available on request.	Wear earplugs when using the spray gun.
Spraying solvent 	Pressured air/fluid passage may be broken when cleaning or flashing with solvent. The solvent may be harmful if contacted with eyes.	Always wear eye protection when spraying or cleaning the equipment.
<p>Misuse:</p> <ul style="list-style-type: none"> · All spray guns project particles at high velocity and must never be aimed t any part of body. · Never exceed the recommended safe working pressure for any of the equipment used. · The fitting of non-recommended or non-original accessories or spare parts may create hazardous conditions. · Before dismantling the equipment for cleaning or maintenance, all pressures, air and material, must be isolated and released. <p>Disposal of non-metallic materials must be carried out in an approved manner. Burning may generate toxic fumes. The removal of waste solvents and coating materials should be carried out by an authorized local waste disposal service.</p>		

SPECIFICATIONS

Max. Air Pressure	0.9MPa (9.0 bar)
Max. Fluid Pressure	1.4MPa (14.0 bar)
Cylinder Air Pressure	Min. 0.34MPa (3.5 bar) Max. 0.49MPa (5.0 bar)
Weight	270g (T-AGB-862) 550g (Stainless Body Type)
Gun Stud Diameter	10.5mm
Fluid Thread	R1/8 (F)
CAP Thread	R1/8 (F)
FAN Thread	R1/8 (F)
CYL Thread:	R1/8 (F)

INSTALLATION

Figure 1. Dimensions

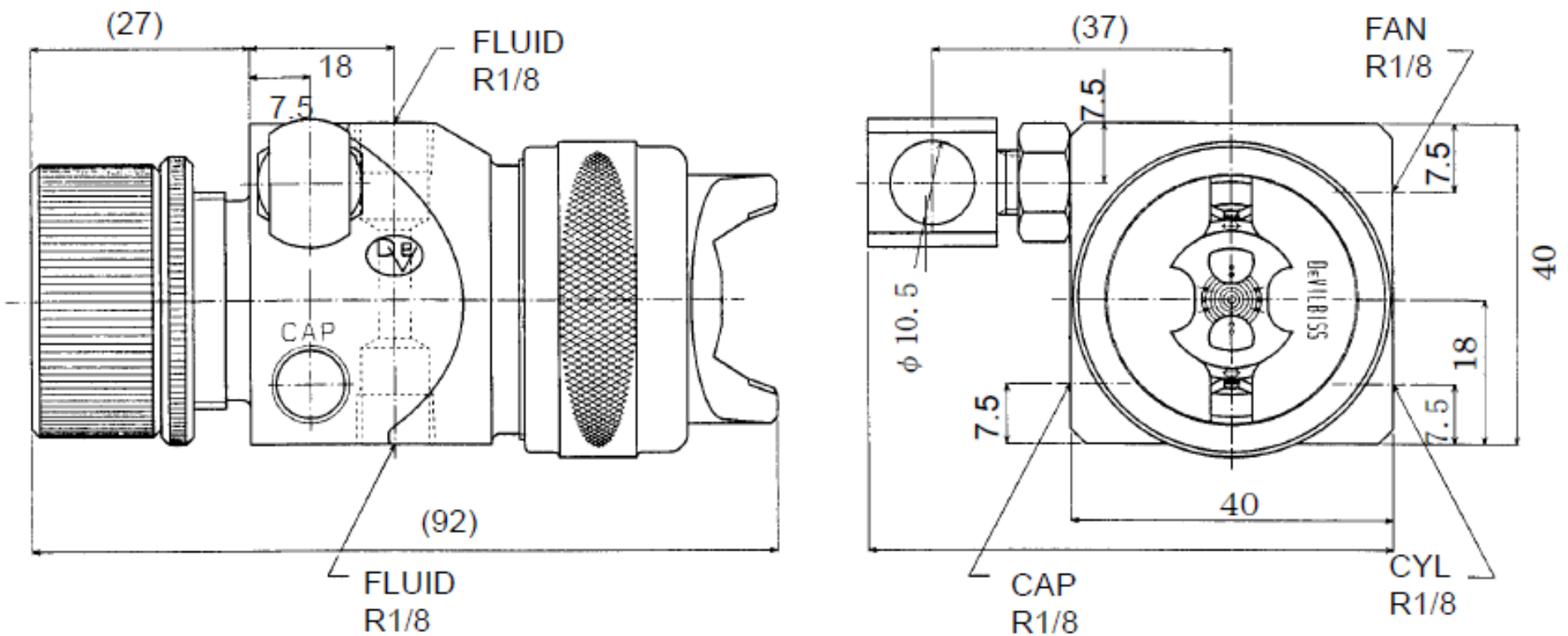
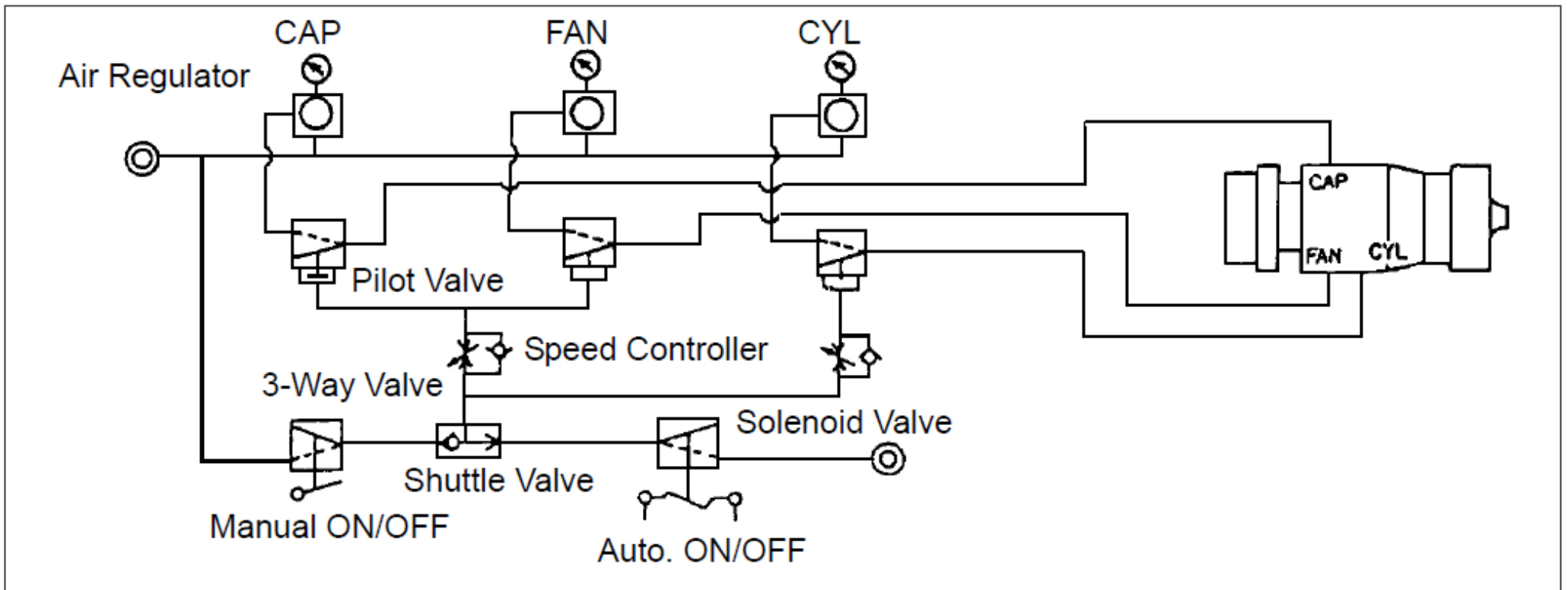


Figure 2. Installation



Mount the gun with the stud (21) or tighten with M8(F) of the gun body.

CAUTION:

The air supplied to the gun should be clean air that removed any impurities. Also, the air hose should have enough inner diameter depending on the length to supply necessary air.

As CYL air is not consumption air, large diameter of the tube is not necessary.

When circulating the paint, remove the plug and install the fluid nipple.

OPERATION

1. Mix, prepare and strain the coating material to be sprayed according to paint manufacturer's instructions.
2. Adjust the CYL air at 0.34~0.49Mpa.
3. Turn the Adjusting Screw (20) counter-clockwise 3.5 turns from fully closed position and fixed with Lock Nut (19). This makes the Needle fully opened.
4. Adjust the CAP/FAN air at about 0.35Mpa.
5. Adjust fluid air at about 0.07Mpa~0.1Mpa.
6. Turn on CYL air and test spray. Adjust fluid and air pressure until desired pattern is obtained. Control fluid pressure at source supply. Always attempt to keep CAP pressure as low as possible to minimize overspray.

WARNING

Risk of injury. Equipment and fluid may be under pressure. Pressure in the system must be relieved before beginning the cleaning procedure and before replacing any parts. Follow the procedures in the literature provided with the system.

CLEANING

1. Relieve air pressure from pressure tank. Carefully follow instructions in bulletin sent with tank.
2. Replace material in container with a suitable solvent.
3. Re-pressurize system.
4. Trigger gun and repeat procedure until gun and hose are thoroughly clean. A SolventSaver™ type hose and gun cleaner which supplies a mixture of air and solvent can be used to most effectively clean gun and hose internal passages. See "Accessories" for SolventSaver™. Wipe exterior of gun with a solvent dampened cloth.
5. If a recirculating system is used, it may be necessary to fit a shut off valve in return line to ensure fluid tip and forward portion of sprayhead passage are properly cleaned when flushed with solvent.

CAUTION

Do not totally submerge gun in solvent. It is possible to wash solids into air operating sections of gun which could seriously damage piston "O" Ring seals.

CAUTION

The air cap can be immersed in solvent for cleaning. If orifices are clogged, use a broom straw or toothpick to remove obstruction. Never use a steel wire or hard instrument. This will damage air cap and result in a distorted spray pattern.

REPLACEMENT

Tools Required

- Crescent Wrench
- 1/2 Box Wrench (for Item No. 3)
- Pliers (for Needle Assy)
- 3, 6, 13, 14mm Open Wrench (for Item No. 12, 17, 21, 15)
- 1.5mm Hex Wrench (for Item No. 16)
- T-AGB-GRT-1 (for Item No. 7)
- T-AGB-HW-1 (for Item No. 11)

Fluid Tip (3)

1. Relieve all air and fluid pressure in system.
2. Remove Adjusting Screw (20), Lock Nut (19) and Needle Spring (18) and Needle Assy with Pliers from gun body.
3. Remove Retaining Ring (1) and Air Cap (2).
4. Remove Fluid Tip (3) with 1/2 Box Wrench and also remove Nozzle Gasket (22).
5. Reassemble in reverse order. The taper side of inside of Nozzle Gasket (22) should be faced to Fluid Tip side when assembling. Recommended torque of Fluid Tip: 24~27N.m. (for T-AGB-862, the recommended torque is 16~20 N.m.).

NOTE

It is recommended that Fluid Tip (3), Nozzle Gasket (22), Needle (12), Needle Seal Kit (7), and Piston Cup (14) be replaced at the same time.

Replacing Needle (12), Piston Cup (14)

1. Remove Adjusting Screw (20), Lock Nut (19), Needle Spring (18). Pull Needle Assy out from gun body with Pliers.
2. Loosen Set Screw (16) of Retainer (15) by turning 1~2 times with 1.5mm Hex Wrench.
3. Loosen Piston Flange (13) and Retainer (15) a little by turning clockwise with 14mm Spanner for Retainer (15) and 6mm Spanner for Lock Nut (17).
4. Fix this position with Set Screw (16). Remove Retainer (15) with 14mm Spanner and Lock Nut with 6mm Spanner.
5. Using 14mm Spanner for Retainer (15) and 3mm Spanner for Needle (12), remove Needle (12) from Piston Flange (13).
6. Loosen Set Screw (16) with Hex Wrench and remove Piston Flange (13) and Retainer (15), then remove Piston (14).

CAUTION

Do not try to remove Needle (12) with Lock Nut (17) installed as it may cause the damage.

Reassembling Needle Assy

1. Apply small amount of liquid gasket on thread of Needle (12) and screw into Piston Flange (13). Then insert Piston Cup (14) and screw into Retainer (15) fully by finger.
2. Using 14mm Spanner on Retainer (15), tighten it approximately 150~180 degree clockwise from the position where maximally screwed in with finger with 3mm Spanner on Needle (12).(when exchanging to new Piston Cup)

CAUTION

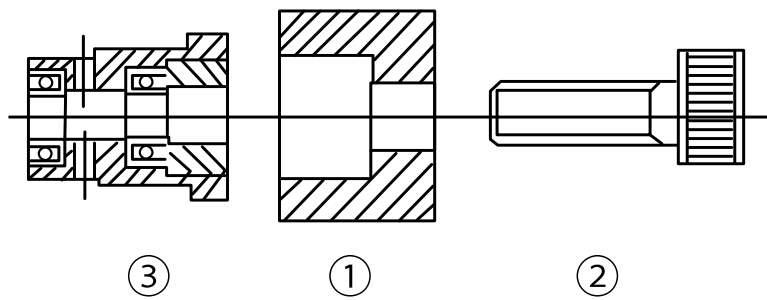
If Piston Cup is not brand-new, tighten at 60~90 degree. (Recommended torque: 0.8~1.0N·m)

3. Tighten Set Screw (16) with 1.5mm Hex Wrench.
4. Using 14mm Spanner on Retainer (15) and then tighten Lock Nut (17) with 6mm Spanner. (Recommended torque: 0.8~1.0N·m)

Replacing Needle Seal Kit (7), Seal (9)

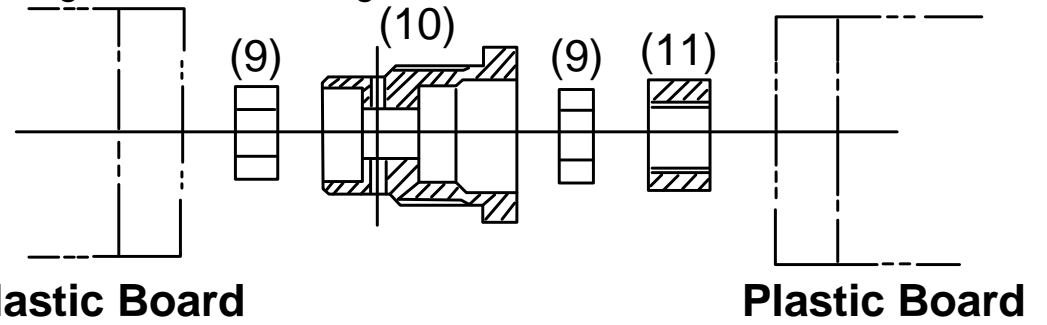
1. Remove Adjusting Screw (20), Lock Nut (19), Needle Spring (18) and Needle Assy with Pliers from gun body.
2. Remove Fluid Seal Kit (7) with T-AGB-HW-1 Housing Wrench (Optional).
3. To remove Seal (9) inside of Needle Seal Kit (7), remove Gland (11) with T-AGB-GRT-1 Grand Removal Tool (Optional). (Refer to Figure 3)

Figure 3. Removing Gland (11)



Holding ③ with 13mm Spanner,
 ① place the Spacer, ② tighten the bolt and extract Gland (11).

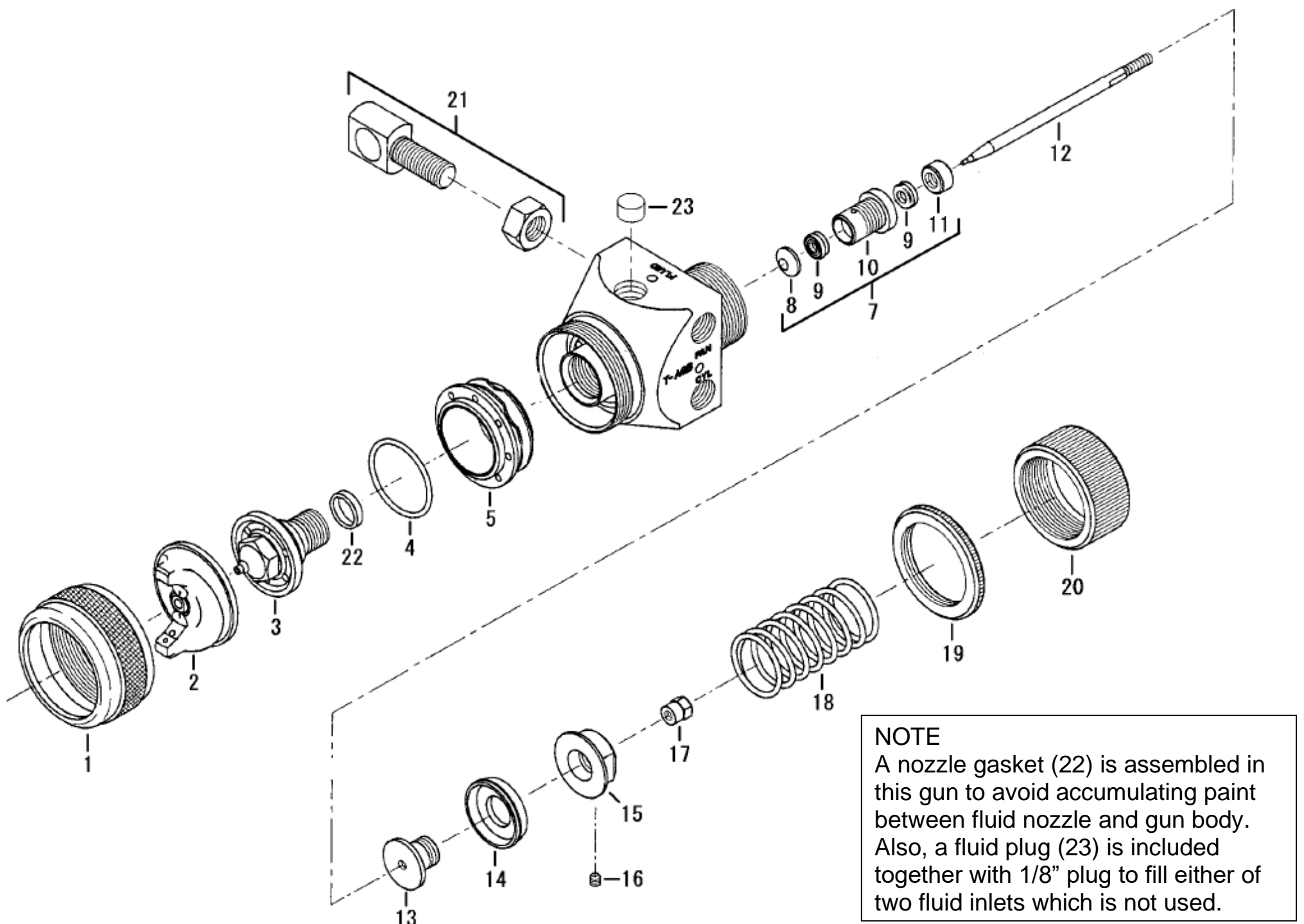
Figure 4. Assembling Needle Seal Kit



Place Seals (9) and Gland (11) as shown the above.
 Press them in with plastic board from both side.

4. Bind seal tape 1.5 laps on thread of Housing (10). Careful not to cover the hole in front of the thread.
5. Set Needle Seal Kit (7) on the shaft of T-AGB-HW-1 Housing Wrench and assemble on Gun Body (6). Tighten as follows.
 - ① Screw Needle Seal Kit (7) with T-AGB-HW-1 Housing Wrench from the backside of the Gun Body (6).
 - ② Pressure 0.1Mpa on fluid inlet. (For circulating system, close the one side.)
 - ③ Press the point of Fluid Tip (3) to stop the air and tighten until the air stops leaking from 3mm hole.
6. Apply petroleum jelly on Piston Cup (14) of Needle Assy and insert into gun.
7. Insert Needle Spring (18), Lock Nut (19) and assemble Adjusting Screw (20) at the position of 3.5 counter-clockwise turns from fully closed position.
8. Pressure 0.34Mpa on CYL and check the movement of needle.

Figure 5. Gun Exploded View



NOTE
 A nozzle gasket (22) is assembled in this gun to avoid accumulating paint between fluid nozzle and gun body. Also, a fluid plug (23) is included together with 1/8" plug to fill either of two fluid inlets which is not used.

Item No.	Part Number	Description	Q'ty
872, 873, 874 Stainless Steel Body			
1	MBC-368	Retaining Ring	1
2	see chart	Air Cap	1
3	see chart	Fluid Tip	1
5	MBC-142-1	Plastic Baffle	1
6	T-AGB-71	Gun Body (303Gr Stainless)	1
7	T-AGB-10-1	Needle Seal Kit	1
8	T-AGB-11-3	Seat Washer	2
9	T-AGB-12	Seal	1
10	T-AGB-13-2	Housing	1
11	T-AGB-14	Grand	1
12	see chart	Needle	1
13	T-AGB-101	Piston Flange	1
14	T-AGB-102	Piston Cup	1
15	T-AGB-103	Retainer	1
16	T-AGB-104-K5	Set Screw Kit of (5)	1
17	T-AGB-105	Lock Nut	1
18	T-AGB-106	Needle Spring	1
19	T-AGB-127	Lock Nut (SUS)	1
20	T-AGB-128	Adjusting Screw (SUS)	1
21	T-AGB-109	Gun Stud	1
22	T-AGB-120-K5	Nozzle Gasket Kit of (5)	1
23	T-AGB-121-K5	Fluid Plug Kit of (5)	1
■Tools			
	T-AGB-GRT-1	Grand Removal Tool	1
	T-AGB-HW-1	Housing Wrench	1
862 Aluminum Body			
19	T-AGB-117	Lock Nut (Aluminum)	1
20	T-AGB-118	Adjusting Screw (Aluminum)	1
879 All Stainless Body			
1	T-MBC-368-SUS	Retaining Ring	1
7	T-AGB-10-1-SUS	Needle Seal Kit	1
10	T-AGB-13-2-SUS	Housing	1
11	T-AGB-14-SUS	Grand	1
13	T-AGB-101-SUS	Piston Flange	1
15	T-AGB-103-SUS	Retainer	1
17	T-AGB-105-SUS	Lock Nut	1
21	T-AGB-109-SUS	Gun Stud	1
882 High Grade (SUS-316) Stainless Steel Body			
1	T-MBC-368-SUS	T-AGB-109-SUS	1
7	T-AGB-10-1-SUS	Needle Seal Kit	1
10	T-AGB-13-2-SUS	Housing	1
11	T-AGB-14-SUS	Grand	1
13	T-AGB-101-SUS	Piston Flange	1
15	T-AGB-103-SUS	Retainer	1
17	T-AGB-105-SUS	Lock Nut	1
21	T-AGB-109-SUS	Gun Stud	1

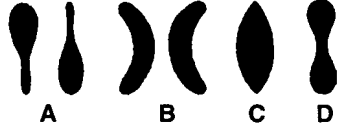

Item No.	Part Number	Description	Q' ty
Air caps			
2	■Air Cap with Ring 1 pce.		
	MB-4039-62	AC(2.8mm)	
	MB-4039-64	D(2.2mm)	
	MB-4039-67	E, EE (1.8mm)	
2	■Air Cap without Ring 1 pce.		
	AV-1239-265R-1	Resin	
	AV-1239-704		
	AV-1239-705		
	AV-1239-765		
	31767-777		
	AV-1239-797		
Fluid Tip & Needle for 872, 862, 879, 882			
3	■Fluid Tip (300Gr Stainless, with soft-seat) Stamped No.: AV-4915 1 pce.		
	AV-651-D	2.2mm	
	AV-651-E	1.8mm	
	AV-651-FF	1.4mm	
	AV-651-FX	1.1mm	
	AV-651-G	0.7mm	
	AV-645-AC	2.8mm	
12	Needle (300Gr Stainless for 872, 862)		
	T-JGA-402-DEX	(for AV-651-D)	
	T-JGA-402-E	(for AV-651-E)	
	T-JGA-402-FZ	(for AV-651-FF, FX)	
	T-JGA-402-G	(AV-651-G)	
Fluid Tip & Needle for 874 (Tungsten)			
3&12	■Lapped Set (Tungsten Fluid Tip & Needle)		
	T-AGB-440-FF-TC	1.4mm (AV-617-FF,T-JGA-409-FF)	
	T-AGB-440-EE-TC	1.8mm (AV-617-EE,T-JGA-409-EE)	
	T-AGB-440-D-TC	2.2mm (AV-617-D,T-JGA-409-D)	
Fluid Tip & Needle for 873 (Nitalloy)			
3&12	■Lapped Set (Nitalloy Fluid Tip & Needle)		
	T-AGB-440-FF-TF	1.4mm (AV-611-FF,T-JGA-402-FF-TF)	
	T-AGB-440-EE-TF	1.8mm (AV-611-EE,T-JGA-402-NADEEE)	
	T-AGB-440-D-TF	2.2mm (AV-611-D,T-JGA-402-NADEX)	
	T-AGB-440-AC-TF	2.8mm (AV-611-AC,T-JGA-402-AC-TF)	

SERVICE CHECK

Normal spray pattern



The proper combination of fluid pressure, fan and atomization air pressure, and fluid tip size should result in a pattern of this shape.

problem	Cause	Correction
Will not spray.	No pressure to gun. Piston stops moving.	Check air and material lines. Check CYL air pressure.
Improper spray pattern. 	A. Gun not adjusted properly. A, B. Material build up on the air cap (2) or fluid tip (3). Note To determine where the material build up is, rotate the air cap 180° and test spray. If the pattern stays in the same position, the condition is caused by material build up on the fluid tip. If the pattern changes with air cap movement, the buildup is in the air cap. C, D. Wrong material or material too thick. D. Insufficient material or atomizing air pressure too high.	A. Re-adjust. See "Operation Section". A, B. Clean the air cap or fluid tip. See "Preventive Maintenance". C, D. Adjust material pressure or thin material. D. Increase material or reduce atomizing air pressure.
Jerky or fluttering spray 	1. Insufficient material in the tank or an obstruction in the line. 2. Gun material passage plugged. 3. Worn Needle Seal Kit (7). 4. Loose or damaged Fluid Tip.	1. Fill tank or clear obstruction. 2. Clean. 3. Replace. 4. Tighten or replace.
Air leaking from Adjusting Screw (20).	1. Damaged or worn Piston Cup (14). 2. Damaged cylinder of Gun Body (6).	1. Replace. 2. Replace.
Dripping from Fluid Tip.	1. Worn or damaged Fluid Tip (2) or Needle (12). 2. Needle Spring (18) damaged or deformed.	1. Replace. 2. Replace.
Air or fluid leaking from Gun Body (6).	Damaged or worn Needle Seal Kit (7)	Replace.

ACCESSORIES

Code No.	Part No.	Description
805153	SSL-10-K12	Gun Lube Kit of (12)
806472	42884-214-K5	Cleaning Brush Kit of 5
800163	GC-100-K48	Gun Cover Kit of (48)
HD-505-W		Quick Cleaner
800279	QMGZ-5200	Solvent Saver (10ℓ)

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2017-08- T-AGB