



# DEMI GUN Operation Manual

SB-JE-DEMI-C

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

## MODELS

DEMI- Air Cap No. - Fluid Tip Size – Type of Feed G: Gravity

(Ex.) : DEMI-DM1 -1.1-G ← (DM1 Air Cap – Size 1.1 mm – Gravity)

## SPECIFICATIONS

**Maximum Working Air Pressure: 0.69 MPa, Maximum Working Fluid Pressure: 0.69 MPa**

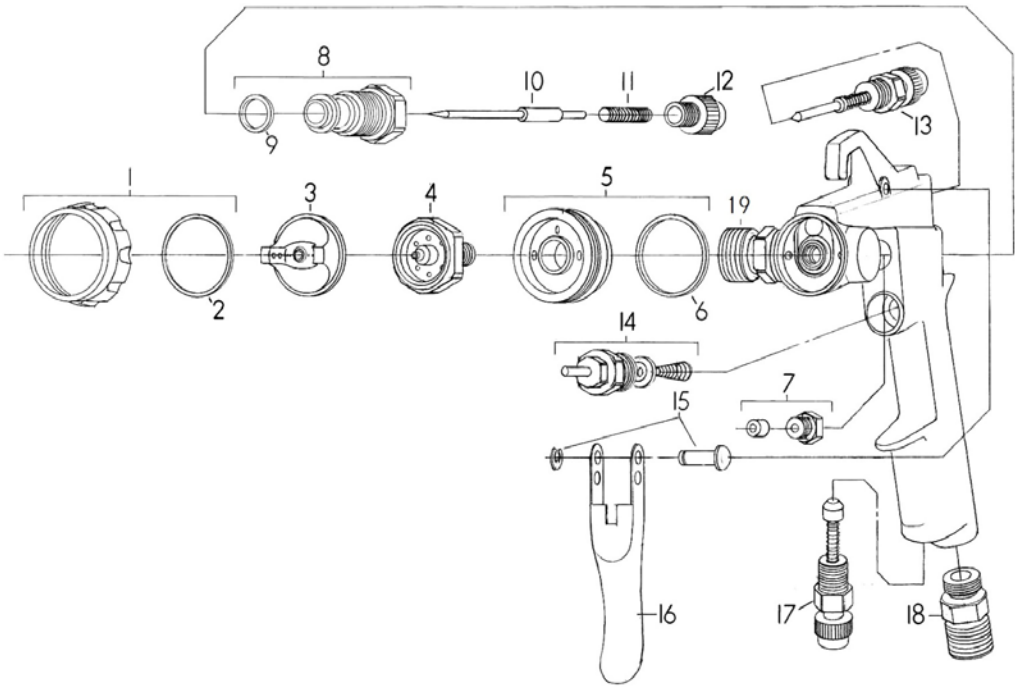
Chart. 1

| Air Cap No.<br>Part Number | Tip size (mm) | Feed | Air consumption<br>Gun inlet pressure | Pattern width<br>(mm) | Application | Fluid inlet | Air inlet | Weight<br>(g) |
|----------------------------|---------------|------|---------------------------------------|-----------------------|-------------|-------------|-----------|---------------|
| DM1                        | 1.1           | G    | 95L/min<br>0.15MPa                    | 150                   |             | G1/4        | G1/4      | 228           |
| DM2                        | 1.1           | G    | 95L/min<br>0.15MPa                    | 130                   |             |             |           |               |

## PARTS LIST

Chart.2

| Ref. No. | Part Number | Description              | Qty |
|----------|-------------|--------------------------|-----|
| 1        | DM-3        | Retaining Ring Assy.     | 1   |
| 2        | DM-20-K5    | Seat Kit of 5            | 1   |
| 3        | DM-1        | Air Cap (For Base Coat)  | 1   |
|          | DM-2        | Air Cap (For Clear Coat) | 1   |
| 4        | DM-4-1.1    | Fluid Tip                | 1   |
| 5        | DM-5        | Baffle with Gasket       | 1   |
| 6        | DM-6-K5     | Gasket kit of 5          | 1   |
| 7        | DM-7        | Needle Packing Kit       | 1   |
| 8        | DM-8        | Bushing                  | 1   |
| 9        | DM-9-K5     | Gasket kit of 5          | 1   |
| 10       | DM-10       | Needle                   | 1   |
| 11       | DM-11-K5    | Needle Spring Kit of 5   | 1   |
| 12       | DM-12       | Adjusting Screw (Gold)   | 1   |
|          | DM-12-1     | Adjusting Screw (Green)  | 1   |
| 13       | DM-13       | Pattern Valve            | 1   |
| 14       | DM-14       | Air Valve                | 1   |
| 15       | DM-15       | E-Ring/Stud kit          | 1   |
| 16       | DM-16       | Trigger                  | 1   |
| 17       | DM-17       | Cheater Valve            | 1   |
| 18       | DM-18       | Air Connector            | 1   |
| 19       | DM-19       | Fluid Inlet              | 1   |
| 20       | LUNA-34     | Spanner (standard acc.)  | 1   |



# SAFETY PRECAUTIONS

**This manual contains information that is important for you to know and understand.  
This information relates to USER SAFETY and PREVENTING EQUIPMENT PROBLEMS.  
Read and follow SAFETY PRECAUTIONS before using this equipment.**

## FIRE OR EXPLOSION HAZARD

1. When spraying, adequate exhaust must be provided to keep air free of accumulations of flammable vapors which may cause fire or explosion.
2. Smoking must never be allowed in the spray area.
3. Static electricity is generated and a static spark could be produced in the spray area. To prevent the risk of fire or explosion, ground without fail all conductive objects in the spray area.
4. Make it sure to use and ground hoses with static wire for spray gun operation. If improperly grounded, a static spark possibly produced may cause fire or explosion.
5. Fire extinguishing equipment must be provided in the spray area.
6. Solvents used for cleaning must have a flash point equal to or higher than that of the coating. Those for general cleaning must have flash points above 37.8°C(100° F) to prevent the risk of fire.

## INHALING TOXIC SUBSTANCES

1. Toxic vapors and liquids are harmful to health. When spraying, adequate exhaust must be provided to keep the air free of accumulations of toxic materials and the use at all times of respiratory protective equipment must be set compulsory.
2. Always wear eye protection when spraying or cleaning the equipment.
3. Certain materials may be harmful if there is contact with the skin. Read carefully all the labels and safety performance data of the materials and solvents to be used. Appropriate clothes and gloves must be worn for spraying or cleaning the equipment.

## MISUSE

1. Operators should be given adequate and appropriate training in the safe use and maintenance of this equipment.
2. Pressured liquids may injure eyes. Do not point the spray gun to any person.
3. Gravity or suction feed gun must not be used for pressure feed gun.
4. Parts with compressed air may damage the human body. Connect air hoses tightly by using a spanner so that air never leaks. If tightened loosely, hoses can be removed which may result in damaging the human body, objects to be coated and other equipment used together.
5. Parts with compressed air or under spring pressure may injure the human body. When replacing such parts, clean the spray gun by discharging the materials, discharge the air, remove air hose and fluid cup and then replace such parts by placing the gun flat. Eye protection must be worn when repairing the spray gun.
6. Do not use the gun at no more than maximum working pressure (0.69MPa).

# INSTALLATION

1. The air supplied to spray gun must be cleaned air which any water, oil and solid material removed. To set up the Mist Separator and Air Transformer near the gun is recommended. The use of air not cleaned may cause coating troubles.
2. Connect fluid cup and air hoses tightly. If tightened loosely, hoses can be removed which may result in damaging the human body, objects to be coated and other equipment used together.

# OPERATION

1. The recommended pressure of air supplied to gun is in a range of 0.15MPa~0.20Mpa. Do not supply to gun the air pressure in excess of the gun's maximum working pressure (0.69MPa).
2. Try with the pressure starting from 0.1MPa~0.2Mpa or around as the spraying pressure varies depending upon the inner diameter of gun, triggering distance, materials etc.
3. The recommended spray distance is 180mm. If the spray distance is too far, good result does not appear.
4. In order to get uniform finishing the spray gun should be hold vertically toward the painting surface.

# PREVENTIVE MAINTENANCE

1. Daily lubrication and cleaning is necessary to maintain the best condition of the gun.
2. To clean the gun body, wipe exterior with solvent dampened cloth. Do not submerge the gun body in solvent as any solids may get into the air passage and cause troubles.
3. Do not leave the gun with solvent in fluid cup. Clean the spray gun after used with clean solvent and empty the cup. To clean the fluid cup, after removing extra paint, through the appropriate solvent and flush down the residual paint.
4. The Air Cap can be immersed in solvent and brushed down for cleaning. If orifices are clogged, use a toothpick to remove obstruction. Never use a steel wire or hard instrument. This will damage air cap and result in a distorted spray pattern.
5. Do not immerse any plastic parts in solvent for long time.
6. Certain portions of gun should be lubricated. Do not lubricate to any portion where not instructed. For lubrication, SSL-10 Gun Lube\* is recommended (\*sold separately, vegetable not repelling materials).
7. The following portions should be lubricated regularly; Trigger Stud (15), Pattern Valve (13), threads of cheater Valve (17) and Adjusting Screw (12), Air Valve (14) stem, portion of Packing Gland (7) here Needle (10) comes in and out.
8. When installing Air Cap (3), make sure no foreign materials adhered on Retaining Ring (1) and thread of Baffle (5) and then oil one drop of Gun Lube SSL-10.
9. Apply non-silicone grease lightly on Needle Spring (11) and Air Valve Spring (14). Do not apply too much grease as it may clog the air passage.

# REPLACEMENT OF PARTS

**Before replacing gun parts, remove materials from the gun for cleaning. Then release the air pressure in the gun and disconnect air hoses. All repairs should be made on a clean flat surface. Use only appropriate tools indicated for replacement of parts.**

## Fluid Tip (4) and Needle (10)

1. It is recommended to replace Fluid Tip (4) and Needle (10) as a set.
2. Loosen completely Pattern Valve (13) by turning the knob counterclockwise.
3. Remove Adjusting Screw (12) and Needle Spring (11) and then withdraw Needle (10) from the gun body.
4. Remove Retaining Ring (1) and Air Cap (3).
5. Remove Fluid Tip (4) by using socket wrench, offset wrench or the spanner / wrench (20) included in the box.
6. Recommended torque of Fluid tip (4) is 6N·m when you re-assemble.

## Fluid Inlet (19) and Air Connector (18)

Fluid Inlet (19) and Air Connector (18) are fixed together by sealing material. Do not disassemble these connectors if it is not necessary. It may become a cause of problem.

## Pattern Valve (13) and Cheater Valve (17)

When disassembling and reassembling Pattern Valve (13) and Cheater Valve (17), turn the knobs completely counterclockwise and then disassemble or reassemble them.

## Air Valve Assembly (14)

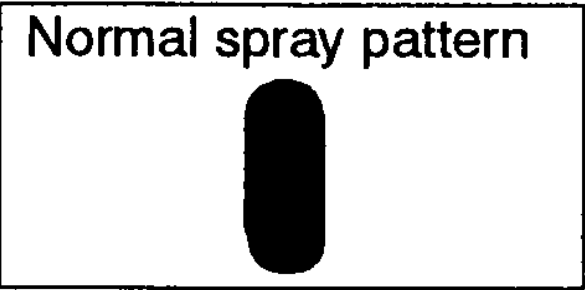
**When replacing Air Valve Assembly (14), be careful not to damage the surface of seals of Gun Body, and Air Valve (14) to prevent from air leakage.**

1. Remove the E-Ring (15) by using flat head screwdriver and then remove Trigger (16)
2. Remove Air Valve Assembly (14) by using 12 mm offset wrench or the spanner included in the box (20).
3. Insert new Air Valve Assembly (14) into gun.
4. Tighten air valve assembly using fingers first and then tighten with 12 mm offset wrench.
5. Replace trigger (16) by using E-Ring (15).

## Needle Packing (7)

1. Remove fluid adjusting knob (12) and needle spring (11) from gun, and then remove fluid needle (10).
2. Loosen and remove packing nut using 8 mm offset wrench or the spanner included in the box (20).
3. Re-assembling the packing (7). Assemble into gun body by hand and then tighten using the wrench.
4. Insert fluid needle (10), and then needle spring (11), and needle adjusting knob (12). Reinstall trigger.
5. Trigger the gun several times to verify correct operation and adjust the packing by using the wrench.

SERVICE CHECKS



| problem                                   | Cause   | Correction  |
|---|---|---|
| Will not spray                            | No pressure to gun.<br>Adjust ing Screw (12) not properly adjusted.   | Check air and material lines.<br>Adjust.  |
| Inproper spray pattern<br>                | A,B.Material build up on the Air Cap or Fluid Tip.<br><br>C,D Incorrect fluid delivery or viscosity.  | A,B Clean the Air Cap or Fluid Tip.<br><br>C,D Adjust.                                      |
| Jerky or fluttering spray<br>             | Insufficient material in the cup or Loose connector.<br><br>Gun material passage plugged.<br><br>Worn Needle Packing (7).<br><br>Loose or damaged Fluid Tip (4).                            | Fill cup or tighten the Connector.<br><br>Clean.<br><br>Replace.<br><br>Tighten or replace. |
| Fluid leaking from needle packing nut (7) | Loose of Needle Packing (7)<br>Worn or damaged Needle Packing (7).  | Tighten<br>Replace.   |
| Dripping from fluid tip                   | 1. Worn or damaged Fluid Tip (4) or Needle(10).<br><br>2. Stuck Needle Packing (7) or Needle(10).<br><br>3. Incorrect adjustment of Needle Packing (7)<br><br>4. Loose Adjusting Screw (12) | 1. Replace.<br><br>2. Lubricate.<br><br>3. Adjust.<br><br>4. Adjust.                        |

ACCESSORIES

| Part No.     | Description  | Part No.  | Description                          |
|--------------|--|-----------|--------------------------------------|
| KG-250DEMI   | Stainless Steel Gravity Cup with Stand for DEMI gun(250ml) | SSL-10    | Gun Lube (60ml)                      |
| SHIM-3       | SHIM MASK  | HAV-502-B | Light Air Adjusting Valve with Gauge |
| DAH-10/20/30 | Air Hose Set (10/20/30m)                                   | HAV-501-B | Air Adjusting Valve with Gauge       |
| HAF-507      | Disposable Air Filter                                      |           |                                      |
|              |  |           |                                      |
|              |  |           |                                      |

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