

# PRODUCT DATA

## 6613, 6614, 6617, 6618 HVLP Spray Guns

### DESCRIPTION:

Transtar HVLP professional spray guns are designed to produce high quality finishes in all applications...high production, spot and panel refinishing and vehicle restoration. FOR PROFESSIONAL TOP QUALITY FINISHES.

#### Clearcoat & Color Gun HVLP (1.3 mm) Part #6613

- This is perfect for applying basecoats, clearcoats and single stage top coats.

#### Clearcoat & Color Gun HVLP (1.4 mm) Part #6614

- Provides excellent atomization of color and clearcoats for optimum coverage and leveling capabilities.

#### Primer Gun HVLP (1.7 mm) Part #6617

- Excellent for solvent and waterborne primers, finishing fillers, self-etching primers and other fill and build coatings.

#### Touch Up Gun HVLP (1.0 mm) Part #6618

- Designed to produce high quality finishes in touch-up, jambing, and detail refinishing.

*Note: Note 6618 is not recommended for use with waterborne products.*

### TECHNICAL DATA:

	<b>6613</b>	<b>6614</b>	<b>6617</b>	<b>6618</b>
GUN WEIGHT	17 oz (482 g)	17 oz (482 g)	17 oz (482 g)	11.3 oz (320 g)
AIR INTAKE	1/4" BSP	1/4" BSP	1/4" BSP	1/4" BSP
MAX PRESSURE @ AIRCAP	10 PSI	10 PSI	10 PSI	8.5 PSI
MAX PRESSURE @ GUN	20 PSI	20 PSI	20 PSI	32 PSI
AIR CONSUMPTION	4-8 cfm	4-8 cfm	4-8 cfm	4 cfm
CUP TYPE	Aluminum	Aluminum	Aluminum	Aluminum
GUN SET-UP (NEEDLE/NOZZLE)	1.3 mm	1.4 mm	1.7 mm	1.0 mm
SPRAY WIDTH	12"	12"	12"	8-10"
CUP CAPACITY	600 CC	600 CC	600 CC	125 CC
TRANSFER EFFICIENCY	>65%	>65%	>65%	65%

### GUN FEATURES:

- Superb atomization with reduced paint overspray
- Increased transfer efficiency means less wasted material
- Light weight and ergonomic design make the guns easy to handle
- Low air cap pressure helps reduce bounce back effect of material on surface being coated
- Easy adjustments, cleaning and maintenance
- Professional quality at affordable pricing
- Higher application rate and excellent leveling properties
- Touch up gun allows for refinishing in areas inaccessible with a standard size gun

**SEE REVERSE SIDE FOR APPLICATION INSTRUCTIONS**

*(Refer to Material Safety Data Sheet for proper handling of products listed in this bulletin.)*

### PRODUCT AVAILABILITY:

- 6613 HVLP Spray Gun 1.3 (pearl black), 1/case
- 6614 HVLP Spray Gun 1.4 (blue), 1/case
- 6617 HVLP Spray Gun 1.7 (green), 1/case
- 6618 Touch Up HVLP Spray Gun 1.8 (gray), 1/case



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## SET UP & ADJUSTMENT

### 1. Starting

- a. Use the spanner wrench to tighten the fluid nozzle.
- b. Tighten the air cap and paint cup.
- c. Before connecting to gun, check air lines and fittings to ensure that they are clean and damage free.
- d. Soak gun thoroughly with cleaning solvent. Clean using approved cleaning materials according to local & federal regulations.

### 2. Fan adjustment

Use the fan adjustment control on the left side of the gun to obtain the desired pattern.

### 3. Air adjustment

Adjust the air pressure using the air adjustment knob at the bottom of the gun or the #6621 Air Regulator.

### 4. Fluid adjustment

Use the fluid control knob to obtain the desired fluid flow volume.

## MAINTENANCE

To assure proper fit and performance, always change air cap, fluid nozzle and needle as a matched set.

To change the needle packing, remove the fluid needle, fluid nozzle and the packing nut. A narrow, flat head screw-driver is required to remove the packing nut.

Cleaning and gun care:

- a. Immediately soak with solvent to remove all coatings after using.
- b. Clean the air cap with the brush provided.
- c. Lightly lube all moving parts with a non-petroleum based lubricant.

**Note:** Never use improper cleaning instruments as they may damage the part and adversely affect gun performance. Never immerse the gun in solvent.

## TROUBLESHOOTING

**Problem:** Gun is leaking from fluid nozzle.

**Causes:** Fluid nozzle is loose, foreign particle or dried paint is keeping needle from seating.

**Remedy:** Tighten nozzle or remove and clean nozzle.

**Problem:** Gun is leaking from needle sealing area.

**Causes:** Teflon® packing is damaged or missing.

**Remedy:** Replace Teflon® packing.

**Problem:** Gun sprays sickle-shaped to the left or right ) (.

**Causes:** Air holes are clogged on air cap or air cap is damaged.

**Remedy:** Clean air holes or replace air cap.

**Problem:** Tear drop or oval-shaped spray pattern ◆.

**Causes:** Air cap is clogged at fluid needle orifice.

**Remedy:** Remove and clean air cap and fluid nozzle.

**Problem:** Paint sputters from gun.

**Causes:** Insufficient material in cup, material not filtered, fluid nozzle loose, needle Teflon® packing damaged, needle & nozzle are dirty.

**Remedy:** Refill cup, filter material, tighten loose parts, replace Teflon® packing, clean needle & nozzle.

**Problem:** Incorrect atomization.

**Causes:** Inlet air pressure is too low or material is too thick; pressure is too high or material is too thin.

**Remedy:** Adjust air pressure and/or product viscosity.

*Teflon® is a registered trademark of DuPont.*

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## **ACCESSORIES AVAILABLE FOR HVLP SPRAY GUNS:**

### **Rebuild Kit**

- 6600 Rebuild Kit for 6613/6614/6617, 1/case
- 6601 Rebuild Kit for 6618, 1/case

### **Needle Nozzle Kit**

- 6602 Touch Up HVLP Needle Nozzle Kit 1.2 mm, 1/case
- 6603 HVLP Needle Nozzle Kit 1.3 mm, 1/case
- 6604 HVLP Needle Nozzle Kit 1.4 mm, 1/case
- 6607 HVLP Needle Nozzle Kit 1.7 mm, 1/case
- 6608 Touch Up HVLP Needle Nozzle Kit 1.0 mm, 1/case

### **Air Cap Test Gauge**

- 6615 HVLP Air Cap Test Gauge, 1/case
- 6625 HVLP Touch Up Air Cap Test Gauge, 1/case

### **HVLP and LVLP Air Regulator**

- 6621 Air Regulator 1/4", 1/case

### **Medium Mesh Filters**

- 6635 Medium Mesh Filters for ALL Transtar HVLP spray guns, 6/package, 1 package/case

### **Spray Gun Cups**

Select the size (125 cc, 600 cc or 1000 cc) and type of cup (aluminum or plastic) you prefer. All spray gun cups & lids will fit on the 6613, 6614, 6617, and 6618 HVLP spray guns.

- 6630 1000 cc Aluminum Spray Cup with Lid, 1/case
- 6631 600 cc Aluminum Spray Cup with Lid, 1/case
- 6632 125 cc Aluminum Spray Cup with Lid, 1/case
- 6633 600 cc Plastic Spray Gun with Lid, 1/case.
- 6640 Aluminum Spray Cup Lid for 6630 & 6631, 1/case

### **17 Piece Spray Gun Brush Cleaning Kit**

17 piece brush kit for the cleaning of Transtar's spray guns.

- 6636 Spray Brush Gun Cleaning Kit, 1/case

### **Replacement Seals**

- 6643 Cup Lid Seal for 6618, 1/case
- 6644 Cup Lid Seal for 6613/6614/6617, 1/case
- 6645 Plastic Air Baffle, 1/case