

P.A.T. SPRAYER OPERATION

INSTRUCTIONS

**This tank is intended for use with water-based adhesives only!
Do not put solvent-based adhesives in this tank!**



1. Follow the filling and pressuring instructions for the P.A.T. that follows on page 4. Pressurize to 50 psi. Never use over 90 psi!
2. Fluid Adjustment Knob (#1 on P.A.T. Sprayer schematic) controls the trigger pull and adjusts the amount of adhesive through the fluid tip (#11). Turning the fluid adjustment knob clockwise will decrease the amount of adhesive applied.
3. The Pattern Control Needle (#5) controls the size and shape of the adhesive pattern to be sprayed. Turning the pattern control knob clockwise will give you a smaller spray pattern. Moving the spray gun closer to the item being glued also decreases the pattern size.
4. The Air Regulator Assembly (#26) controls the amount of atomizing air. Turn clockwise until the screw is all the way in. This turns off the atomizing air.
5. Once tank is pressurized with glue (see instructions on page 4) adjust the Fluid Adjustment Knob (#4) so that one or two drops of glue emerge per second when pulling the trigger (#27).
6. Open the Pattern Control Needle (#5) to allow atomizing air to flow which will spray the glue.
7. Hold the spray gun 6 to 8 inches from the item being glued.
8. Loosening the lock ring on the air cap (#12) and rotating the air cap 90 degrees will change the adhesive pattern from horizontal to vertical and vice versa.
9. The adhesive film being applied can be varied by the operator's speed, distance from the glued surface, and the fluid adjustment knob.

MAINTENANCE

It is generally not necessary to clean the spray gun on a daily basis. When starting the next day it may be necessary to peel away dried adhesive from the fluid tip. Attaching a damp towel to the air cap assembly overnight is helpful, or you can apply some petroleum jelly or food grade grease onto the tip where the adhesive emerges.

Do not immerse the spray gun in a bucket of water!

It may be necessary to disassemble part of the spray gun for routine cleaning and/or troubleshooting. Remove items 1-4 and 10-12 and clean with soap and water or a solvent if required. Be careful not to bend any parts!

TROUBLESHOOTING THE SPRAY GUN

SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Spray pattern too small	<ol style="list-style-type: none"> 1. Dried adhesive in openings of air cap (#12) 2. Lumpy adhesive 3. Not enough adhesive 4. Pattern control needle not open enough 	<ol style="list-style-type: none"> 1. Clean air cap 2. Thin and/or strain adhesive 3. Open fluid adjustment knob more or increase incoming tank air pressure (up to 75 psi)
Unsatisfactory spray pattern	<ol style="list-style-type: none"> 1. Adhesive too viscous 2. Dirty Air Cap (#12) 3. Too much adhesive being applied 	<ol style="list-style-type: none"> 1. Thin adhesive 2. Clean Air Cap 3. Close fluid adjustment knob to reduce adhesive.
Too much spray mist	Too much air pressure	Reduce air pressure to spray gun
Leakage around fluid packing nut	<ol style="list-style-type: none"> 1. Packing nut (#13) loose 2. Worn packing (#19) 	<ol style="list-style-type: none"> 1. Tighten packing nut. Replace if leakage continues. 2. Replace packing.

P.A.T. Spray Gun Schematic Diagram

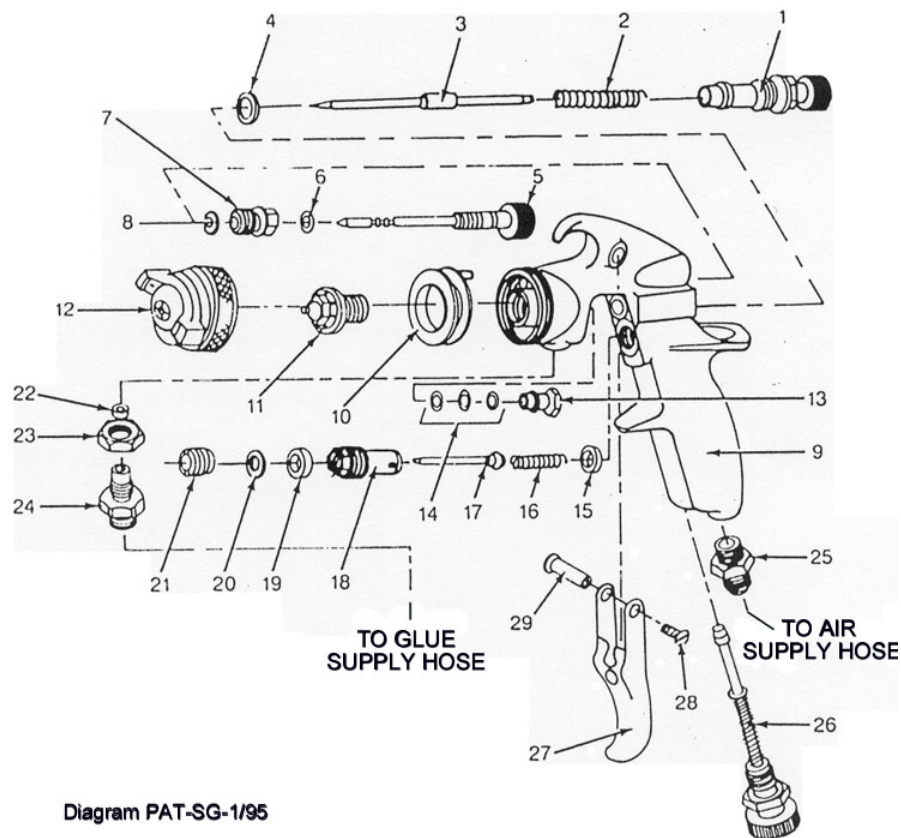


Diagram PAT-SG-1/95

P.A.T. SPRAY GUN PARTS LIST

Reference No.	Part Number	Description
A	SPRKITA	GASKET KIT, INCLUDES REF #4, 6, 8, 10, 14, 15, 19, 20, 22, 28 & 29
B	SPRKITB	AIR VALVE KIT, INCLUDES REF #15, 16, 17, 18, 19, 20 & 21
C	SPRKITC	FLUID CONTROL KIT, INCLUDES REF #2, 3, 4, 10, 11, 13 & 14
D	SPRKITD	PATTERN CONTROL KIT, INCLUDES REF #5, 6, 7, & 8
1	SPR01	FLUID ADJUSTMENT KNOB
2	SPR02	FLUID NEEDLE SPRING (C)
3	SPR03	FLUID NEEDLE (C)
4	SPR04	FLUID NEEDLE GASKET (A,C)
5	SPR05	PATTERN CONTROL NEEDLE (D)
6	SPR06	O-RING (A,D)
7	SPR07	PATTERN CONTROL NUT (D)
8	SPR08	SNAP RING (A,D)
9	SPR09	GUN BODY ASSEMBLY
10	SPR10	FLUID TIP INSERT (A,C)
11	SPR11	FLUID TIP (C)
12	SPR12	AIR CAP
13	SPR13	PACKING NUT (C)
14	SPR14	PACKING (PKG OF 6) (A,C)
15	SPR15	AIR VALVE GASKET (A,B)
16	SPR16	AIR VALVE SPRING (B)
17	SPR17	AIR VALVE (B)
18	SPR18	VALVE BODY (B)
19	SPR19	PACKING (A,B)
20	SPR20	PACKING WASHER (A,B)
21	SPR21	AIR VALVE NUT (B)
22	SPR22	CANISTER PACKING (A)
23	SPR23	JAM NUT
24	SPR24	GLUE HOSE CONNECTOR
25	SPR25	AIR HOSE CONNECTOR
26	SPR26	AIR REGULATOR ASSEMBLY
27	SPR27	TRIGGER
28	SPR28	SCREW (A)
29	SPR29	TRIGGER PIN (A)
233	SPR233	"T", 1 MALE, 2 FEMALE
234	SPR234	AIR HOSE ASSEMBLY, 15 FEET

PNEUMATIC ADHESIVE TANK (P.A.T.)

INSTRUCTIONS

**This tank is intended for use with water-based adhesives only!
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Pressurizing the tank

1. Be sure all connections are secure. Check to see that the tank lid (part #8) is locked in position and the safety relief valve is closed (down position).
2. Turn gauge control (part #3) fully counter clockwise to the closed position.
3. Open the on-off air valve (part #2).
4. Turn the gauge control slowly clockwise. Pressurize to normal operating pressure which will vary depending on your application. Never operate the tank above 90 psi.

Depressurizing the tank

1. Turn the gauge control fully counter clockwise to the closed position.
2. Close the on-off air valve.
3. Open the safety relief valve on the tank (up position) reducing the pressure in the tank to zero. You will not be able to remove the tank lid until the pressure is zero.

Maintenance

1. If you are using an extrusion glue head or the SKID-LOCK SPRAY HEAD, remove the head from the applicator at the end of the day. Place it in a cup of water. Place the female cap plug with coupler (part #25) onto the male nipple (part #21). The system is now fully closed, and there is no need for further maintenance. During lunch hour or long work stoppages, we recommend that you wrap the glue head in a damp towel.
2. If you are using the P.A.T. with PISTOL GRIP SPRAYER apply some petroleum jelly to the tip at the end of the day. If the glue tip becomes clogged remove and clean with water. Do not lose any of the parts at the tip.
3. If you are using the P.A.T. SPRAYER (with the air atomizing gun) apply some petroleum jelly to the tip at the end of the day. If the glue tip becomes clogged remove and clean with water. Do not lose any of the parts at the tip.
4. We recommend that you clean and flush the system on a monthly basis.

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Helpful hints for using the P.A.T.

1. The natural tendency with this applicator is
 - A. Press the trigger mechanism
 - B. Begin moving your hand to apply the adhesive
 - C. Stop at the end of the item you are gluing
 - D. Then release the trigger mechanism.THIS IS WRONG! You will end up with a pool of adhesive at the beginning and the end of the procedure. The correct way to use the P.A.T. is:
 - A. Be sure that your hand is moving in the direction you want to apply the product.
 - B. Press the trigger mechanism.
 - C. Release the trigger mechanism when you want to stop applying product.
 - D. Your hand must still be moving before you release the trigger mechanism.
2. Do not tamper with the fittings when the tank is pressurized!

Using the P.A.T. when not directly connected to an air supply

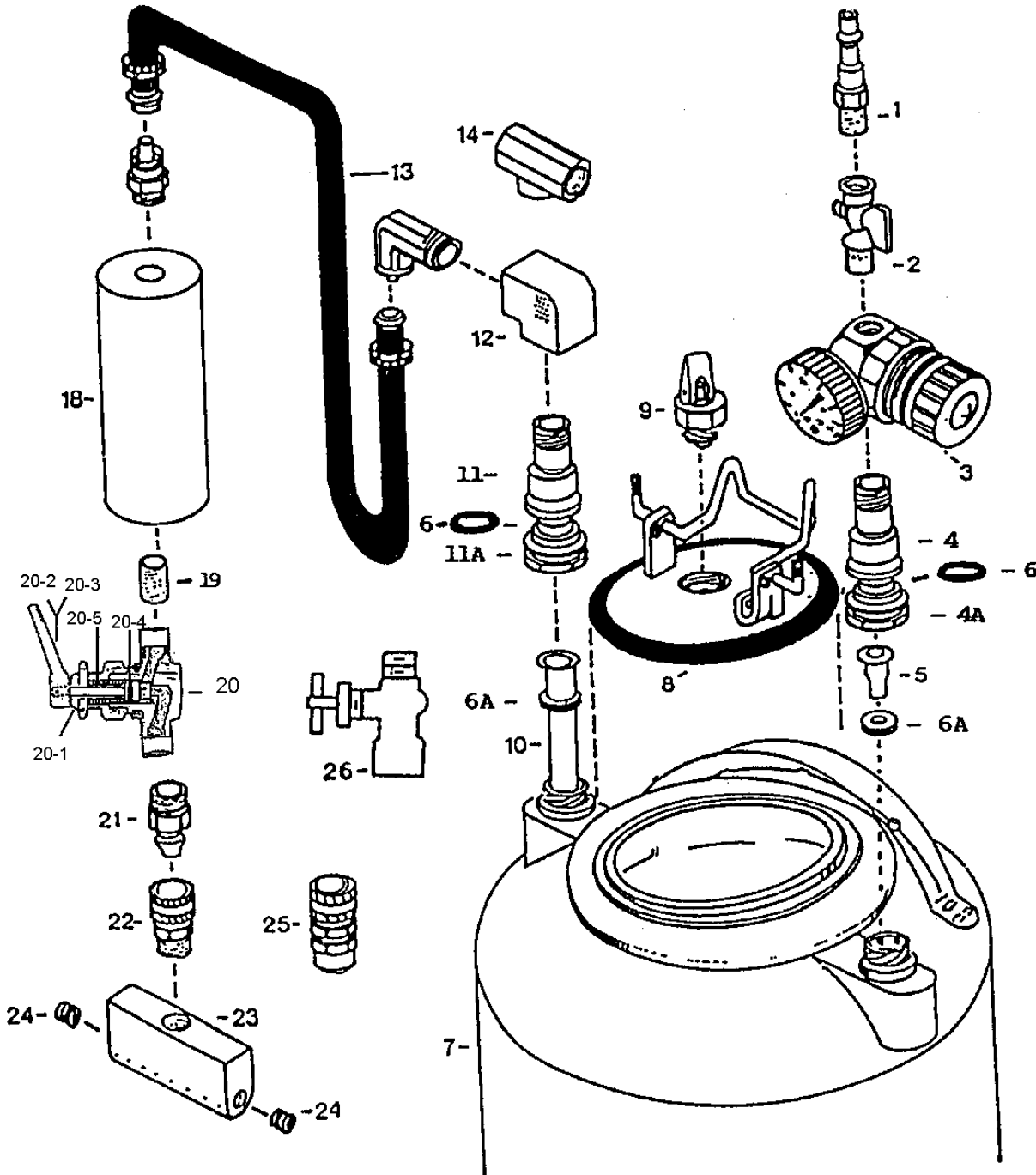
1. Fill the tank no more than half full with adhesive. Charge it to a pressure which is higher than you need to properly apply the adhesive. If the pressure drops too low for proper application before the tank is empty, try increasing the initial filling pressure. *Do not exceed 90 psi!*
2. If the glue flow is too fast when the tank is initially pressurized it may be necessary to add a Glue Control Needle Valve (part #26). This valve can be used to reduce the hydraulic pressure when the initial tank pressure is high. As the tank pressure decreases you can open the needle valve to allow more product to be applied. This valve is not needed on the PISTOL GRIP SPRAYER nor the P.A.T. SPRAYER.
3. If in doubt, contact the Gluefast Company.

PATSPRAYER

P.A.T. (Pneumatic Adhesive Tank) PARTS LIST

<u>PART NO.</u>	<u>DESCRIPTION</u>
1	H2C Nipple - Quick Disconnect - .25"
2	On / Off Valve - Air - .25"
3	Regulator / Gauge Assembly
3A	Gauge Only
3B	Regulator (Only)
4	Air Side Stainless Steel Socket (White Band)
4A	Socket Fitting
5	Air Inlet Tube
6	"O" Ring
7-3T	3-Gallon Stainless Steel Tank (Part #4A-11A)
7-5T	5-Gallon Stainless Steel Tank "
7-10T	10-Gallon Stainless Steel Tank "
7-3NH	3-Gallon Stainless Steel Tank (Part #1-12)
7-5NH	5-Gallon Stainless Steel Tank "
7-10NH	10-Gallon Stainless Steel Tank "
8	Closure with Safety Valve & Gasket
8A	Gasket (Only)
8B	Closure Foot
9	Safety Relief Valve - NOT SOLD SEPARATELY
10-3	Liquid Tube for 3 Gallon Tank
10-5	Liquid Tube for 5 Gallon Tank
10-10	Liquid Tube for 10 Gallon Tank
11	Liquid Side Stainless Steel Socket (Black Band)
11A	Socket Fitting
12	Female Elbow - .25"
13	Coiled Hose (25 feet) with Fittings
14	"T" Connection for two Hoses - .25"
18	Glue Handle, 6" Length, Ported .25" & .125"
19	Short Nipple - .125"
20-1	Manual Glue Valve with Plastic Toggle Handle
20-2	Aluminum Toggle Thumb Handle
20-3	Plastic Toggle Thumb Handle
20-4	Viton A O-Ring
20-5	Valve Spring
21	Male Nipple - Quick Disconnect - .125"
22	Quick Disconnect Coupler - .125"
23-1	1 Inch Wide Glue Head (3 Orifices)
23-BR	1 Inch Wide Glue Brush
23-2	2 Inch Wide Glue Head (7 Orifices)
23-3	3 Inch Wide Glue Head (11 Orifices)
23-6	6 Inch Wide Glue Head (23 Orifices)
23-8	8 Inch Wide Glue Head (31 Orifices)
23-9501	Skid-Lock Spray Head
24	Steel Plug
25	Female Cap Plug with Coupler - .125"
26	Glue Control Needle Valve - .125"
AS	In-Line Adhesive Strainer
EGL	Extra Glue Line and Valve (Part #13-21)

P.A.T. SCHEMATIC DIAGRAM



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