

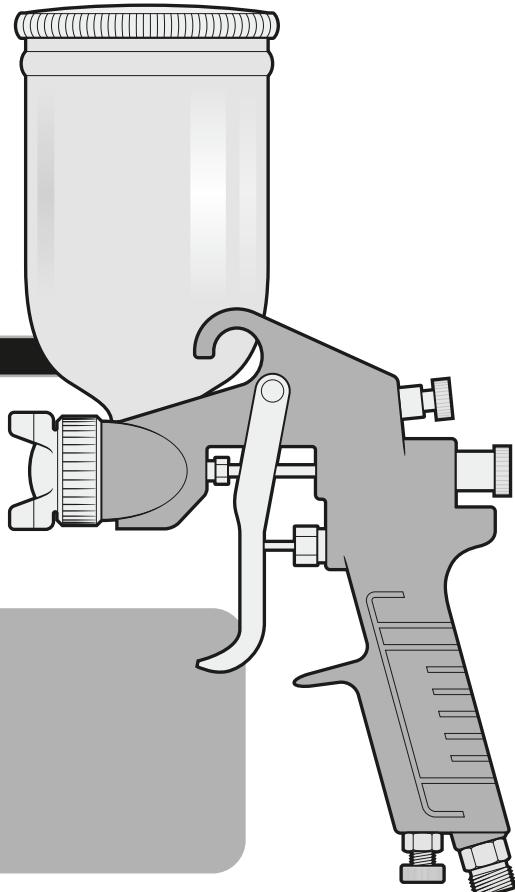
Manual

## Gravity feed spray gun

30 PSI - 50 PSI  
Air Pressure

Applies for:

| Code  | Model    |
|-------|----------|
| 11095 | PIPI-420 |
| 13061 | PIPI-421 |
| 13060 | PIPI-422 |



**PIPI-420**

**PIPI-421**

**PIPI-422**

**CAUTION**



Read the user's manual thoroughly  
before operating this tool.



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## **!** CAUTION

To gain the best performance of the tool, prolong the duty life, make the Warranty valid if necessary, and to avoid hazards of fatal injuries please read and understand this Manual before using the tool.

Keep this manual for future references.

The illustrations in this manual are for reference only. They might be different from the real tool.

## Technical data

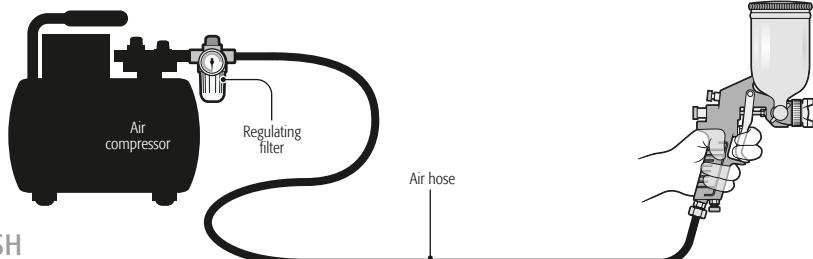
|                       | PIPI-420               | PIPI-421 | PIPI-422 |
|-----------------------|------------------------|----------|----------|
| Code •                | 11095                  | 13061    | 13060    |
| Description •         | Gravity feed spray gun |          |          |
| Jar Capacity •        | 13.5 oz                |          |          |
| Air Pressure •        | 30 PSI – 50 PSI        |          |          |
| Connection Diameter • | 1/4 NPT                |          |          |
| Air Consumption •     | 6 CFM                  |          |          |
| Nozzle Diameter •     | 0.05"                  | 0.06"    | 0.07"    |

## Pneumatic requirements

- For household jobs, it is possible to use 1.5 CV compressors with a 25 liters' deposit. For more demanding jobs, like bodywork, industry, etc., we recommend using 3 CV compressors with a 100-liter deposit as minimum.

- Use high-pressure hoses with the adequate length to do the job comfortably.

**!** CAUTION • Dust and water condensation inside the compressor tank can cause a deficient finish in the surface to be painted. To prevent that possibility, install a regulating filter between the compressor and the gun.



# Safety warnings for the use of pneumatic tools

**TRUPER®**

Keep your work area clean, tidy and well lit.

**CAUTION** Cluttered and dark areas may cause accidents.



Never use the tool in explosive environments or near flammable liquids.



**DANGER** Sparks generated by the tool may cause explosion or fire.

Keep children and visitors at a safe distance when using the tool.

**WARNING** Distractions may cause loss of control and cause accidents.



Avoid contact with power lines and circuits.

**DANGER** Find and avoid both power lines and circuits, especially hidden wires and grounded devices.



Stay alert, use care and common sense.

**CAUTION** Do not rely on your knowledge of the tool. Do not get distracted while operating it. It could cause accidents.



Do not use the tool when tired or under the influence of drugs, alcohol or medication.

**DANGER** One second of distraction while using the tool may cause severe injuries.



Use the tool with guards and protective devices in place and in good working conditions.

**WARNING** Failure to comply with these measures may cause severe injuries.



Secure and support the work piece properly.

**CAUTION** Use bench vises and a stable working area.

Do not force the tool.

**CAUTION** It will do the job better and safer at the rate for which it was intended.



Store the tool in a safe place away from the reach of children.

**WARNING** Pneumatic tools are dangerous in inexperienced hands.



Dress properly.

**WARNING** Loose clothing, jewelry or long hair may get caught in moving parts.



Keep your hands away from rotating and/or mobile parts.

**WARNING** Failure to comply with this safety measure exposes you to severe personal injury.



Use adequate personal protection.

**CAUTION** Using safety glasses, anti-dust mask, safety non-skid shoes, helmet and earplugs used in adequate conditions considerably reduce the risk of injury.



Disconnect the air hose from the tool servicing, changing devices or storing.

**WARNING** Reduce the risk of unintentional starting causing accidents.



Never use a tool if the switch is not working or is not properly assembled.

**WARNING** You are exposed to severe personal injury.



Do not overreach.

**CAUTION** Good footing and balance allow you to gain better control of the tool in unexpected situations.



Never pull the air hose.

**WARNING** Do not use it to carry or disconnect the tool pulling out the air supply. Damaged or tangled hoses can burst and shoot residues towards the operator.



Avoid accidental startup.

**WARNING** Make sure the air supply tool is switched off before connecting or moving the tool.



Remove vices before starting the tool.

**DANGER** Additional tools or vices set into a moving part may cause severe injury.



Service the tool and verify it is in excellent working conditions.

**CAUTION** Carefully check all moving parts, alignment and assembly. Make this periodically. Look for damaged or malfunctioning parts to immediately be repaired.



Accessories.

**CAUTION** Use only accessories or spare parts recommended in this MANUAL or certified by TRUPER.



Never leave a running tool unattended.

**CAUTION** Switch off and disconnect the tool from the air supply after operating and before putting it aside. Avoid severe injury.



## Substances and Materials

**⚠ CAUTION** • The unit is designed to apply covering materials like paint, varnish, enamel, etc. These should have an ignition point not lower than 70 °F. Check the product can label or container.

**⚠ WARNING** • Do not spray substances you are not familiar with and if their potential danger is unknown to you.

**⚠ WARNING** • Do not spray flammable substances. • Use care with dangers originated by the sprayed substances. Read the text and information in the cans and containers or the manufacturer specifications.

## While operating the device

**⚠ CAUTION** • Never point the sprayer towards your body, passersby or animals.

• Make sure that the equipment does not absorb any steam solvent.

**⚠ CAUTION** • In the event you need to pause during the application process, do not set the sprayer sideways. Hold it by the hook of somewhere for it be vertical.

## Before operating the unit

**⚠ CAUTION** • The unit shall not be used in enclosed areas or explosive environments.

• If working outdoors consider wind direction. Wind carries the covering to great distances, causes damages and makes the job difficult.

**⚠ CAUTION** • If working indoors, verify there is adequate ventilation.

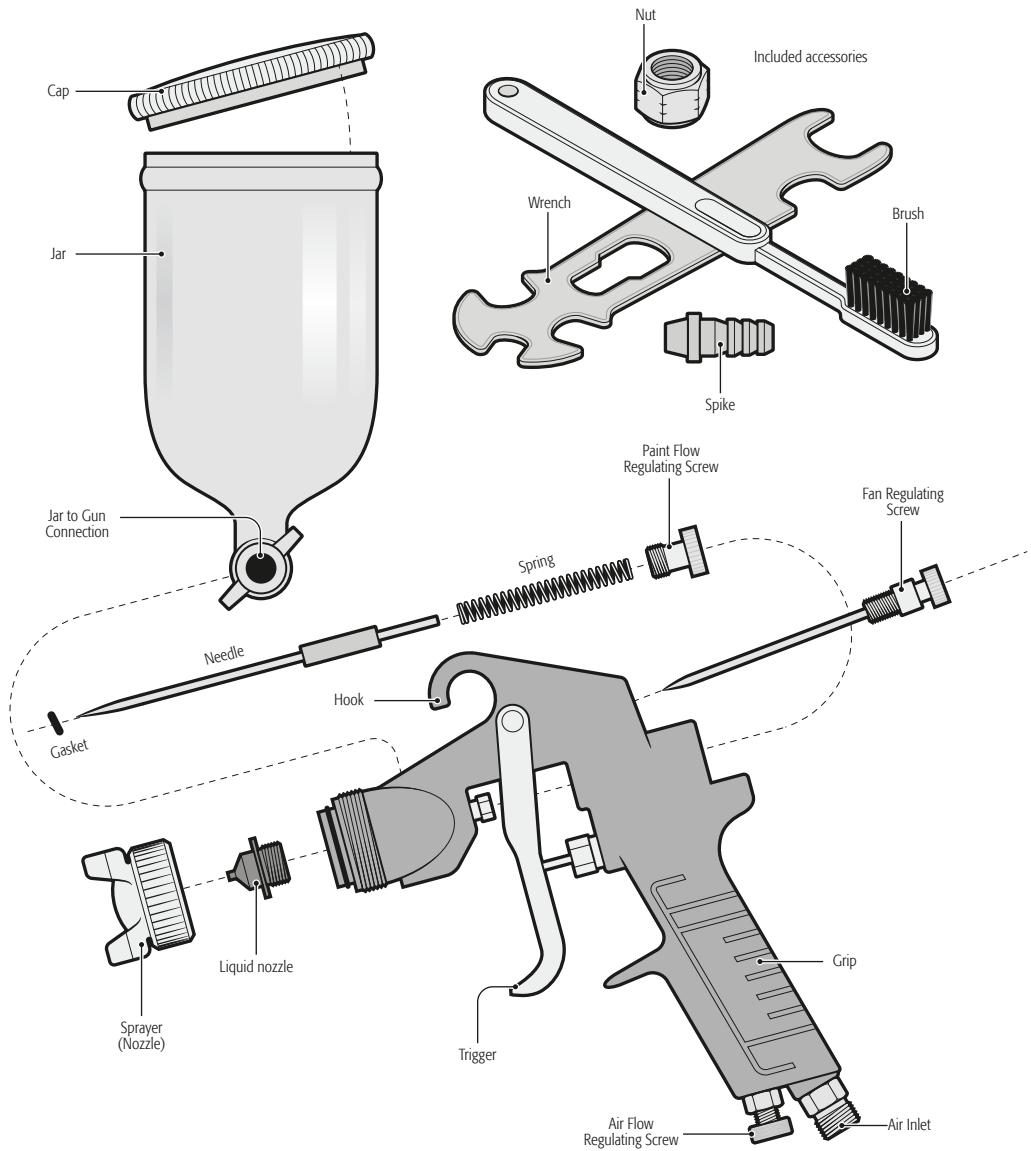
**⚠ WARNING** • The work area shall be free of any ignition source. Do not smoke while spraying or near the work area.

**⚠ CAUTION** • Wear a face mask and safety goggles when spraying. Prevents damaging lungs and eyes. • Wearing gloves and an overall is recommended to protect hands and clothes from the product when applying.



## After operating the unit

**⚠ WARNING** • When finishing the job clean the gun perfectly to eliminate any product residue. Accumulations can damage the gun and cancel the Warranty



- Preparing the surface to be sprayed is important to carry out a good job. Thin the paint or product to gain the right viscosity before applying.
- Double check always the surface to be sprayed is free of dust, dirt or grease.
- Make sure to cover with adhesive tape, some newspaper and/or plastic those areas that do not require spraying.
- Paint or product to be sprayed shall be mixed perfectly before filling the jar to prevent settling and make them lump-free.
- Before buying the product read the manufacturer recommendations.

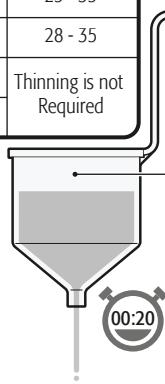
## Thinning the material

- Most paints are sold ready to be used with a brush. They need to be thinned before applying with a paint gun. Follow the manufacturer's instructions to correctly thin the material.
- Adding a thinner is recommended. Add 5 to 10% until reaching the right viscosity to apply the material.
- Use the din 4 viscosity flow cup (not included) to determine the paint right viscosity. Viscosity is determined by counting the seconds it takes for the material to be discharged into the measuring glass. The following table shows the recommended times for different products.

| Product            | Second to discharge      |
|--------------------|--------------------------|
| Water based Paint  | 20 - 25                  |
| Primer             | 24 - 28                  |
| Varnish            | 20 - 25                  |
| Oil Based Paint    | 18 - 22                  |
| Enamel Paint       | 18 - 22                  |
| Aluminum Paint     | 22 - 25                  |
| Automotive Sealant | 25 - 35                  |
| Wood Sealant       | 28 - 35                  |
| Wood Preserver     | Thinning is not Required |
| Wood Stain         |                          |

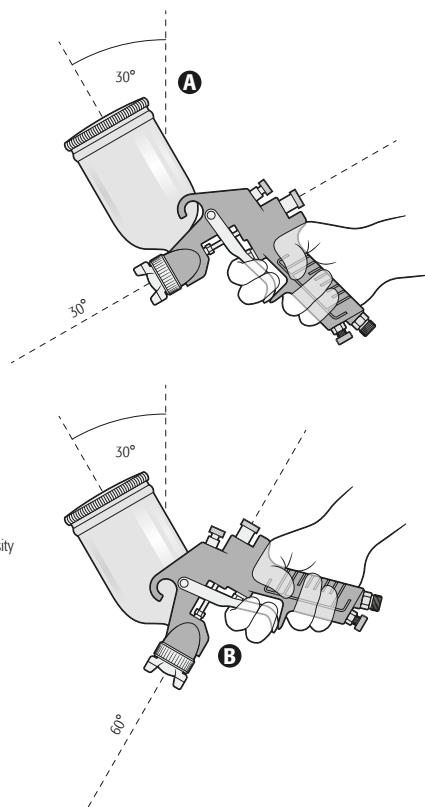
If after thinning the product the dispersion capacity is too low add thinner. Add slowly from 5 to 10 % until the dispersion capacity meets your needs.

If the paint is too thick, the painted surface will be too rough (orange peel). If the paint is too liquid, there is risk of dripping.



## Filling the Jar

- Unscrew the paint gun jar to fill up with paint. Close the cap to prevent spilling.
- The jar can easily be filled up during the paint process.
- The jar shall not be tilted more than 30° from the vertical to assure a continuous paint flow (A).
- In the event the job requires tilting the gun more than 30° you can adjust the jar to compensate the vertical and keep the paint flow running (B).



## Adjusts

**CAUTION** • During the adjusting process and before applying the paint onto the work surface make some tests on scrap material until gaining the adequate paint flow.

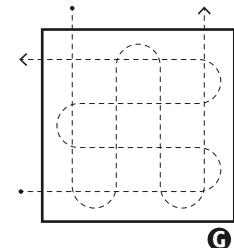
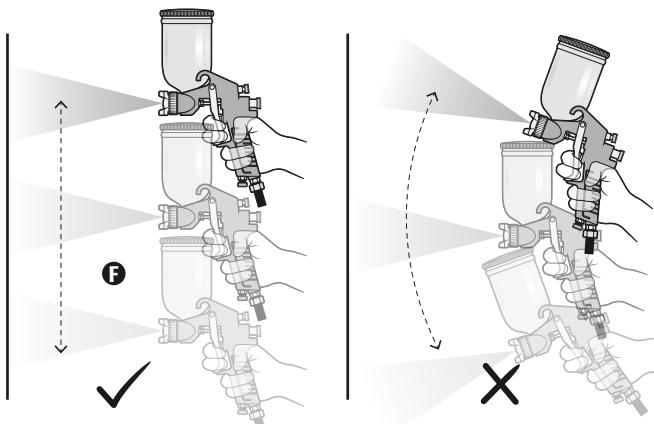
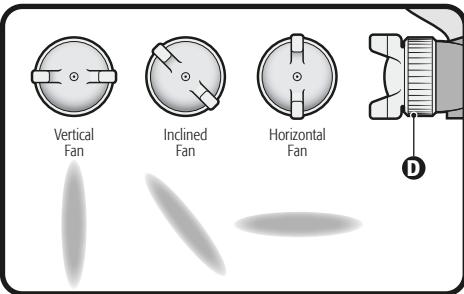
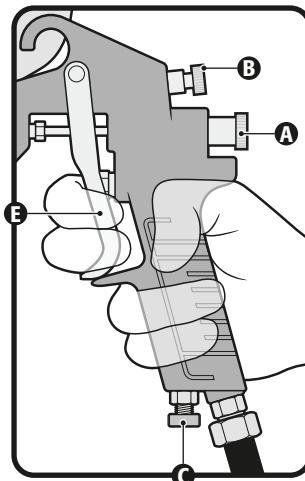
- Turn the adjusting screw (**A**) in a counterclockwise direction to increase the volume of the material to be sprayed.
- Turn the adjusting screw in a clockwise direction to diminish the volume of the material to be sprayed.
- Turn the adjusting screw (**B**) to modify the fan pattern needed to apply the paint.
- Turn the adjusting screw (**C**) to modify the air flow needed to apply paint.
- Turn the sprayer (**D**) to determine the angle to apply the spray pattern.

## Spraying Techniques

- To gain best results keep the gun always parallel to the surface (**F**). Keep the nozzle 7.8" - 12" from the surface and spray in an even manner from one side to the other and upwards and downwards. Do not spray in an angle with regards to the surface. Pass softly and evenly. When spraying on large areas use the crossed pattern (**G**).
- Displace the gun using uniform and constant speed. Fast movements produce thin layers and slow movements, produce thick layers.
- Apply one layer at a time. If another layer is needed see the drying recommendations in the manufacturer product before applying a second layer. Keep in mind that to gain a better finish applying two thin layers is always better than one thick layer.
- When spraying small areas turn the adjusting screw to reduce the volume of material to be applied. This is helpful to use less paint and prevents from over-spraying.
- To assure applying evenly avoid pausing while spraying an object when possible.

## Turning on

- Turn on the compressor.
- Press the trigger (**E**) to open the air flow and start suctioning the product from the jar. Aim the gun against a piece of cardboard until the spraying starts.
- Release the trigger to stop the spraying flow.



## Cleaning and Care

- It is very important to clean the paint gun thoroughly after each use.

**WARNING** Inadequate cleaning will result in malfunctioning and will cancel the warranty.

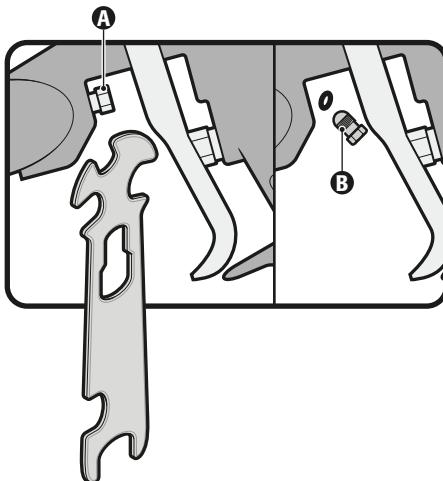
- Without removing the jar press the trigger to remove all the product inside the system.
- Pour the remaining material into an adequate container.
- Disconnect the paint gun hose.
- Clean the jar, the gasket seal and the suction pipe thoroughly with a rag soaked with the solvent that is right for the product.
- Disassemble the regulator, the sprayer, the nozzle and the needle. Clean them with a brush and solvent.
- Clean the paint gun body with a piece of rag moistened with solvent.

**CAUTION** Do not immerse the gun in solvent. The gaskets may get damaged.

- When the parts are clean assemble back the paint gun.
- Pour a small amount of solvent into the jar. Connect the hose to the paint gun.
- Turn on the compressor and spray into a container until getting clean solvent out through the nozzle.

## Needle Seal

- Use special care adjusting the needle seal. This is important to get a better job.
- Using the wrench adjust the needle seal (A).
- Check the seal often to assure it is not damaged. To gain access to the seal, remove the needle and remove the seal pressing part (B).





Right Mist Pattern

## Problem

Wrong Spraying Pattern:

- Half Moon

- Leaning

- Divided

- Centered

## Cause

- Paint build up in the nozzle.

- Paint build up in the nozzle or sprayer.
- Damaged nozzle.
- Nozzle wrongly tightened.

- Paint viscosity is too poor.
- Fluid outlet is too high.

- Paint viscosity is too high.
- Fluid outlet is too low.

## Solution

- Remove the obstructions from the nozzle.
- CAUTION** Do not use metal objects to clean the funnel orifices.

- Remove the obstructions from the nozzle and sprayer.
- Replace nozzle.
- Tighten the nozzle.

- Add paint to the mix.
- Adjust the paint flow regulator or the air flow.

- Add thinner to the mix.
- Adjust the paint flow regulator or the air flow.



Right Fan

## Problem

Wrong Fan:

- Fluctuation



## Cause

- Air enters between the nozzle and the gun body.
- Air is suctioned through the needle seal gasket.

- Nozzle and needle are not correctly set.
- Damaged nozzle and/or needle.

- Paint build up inside the gun system.

## Solution

- Clean the nozzle and the gun joint. If damaged, replace the nozzle.
- Tighten the needle seal as indicated in page 8.

- Clean the nozzle and needle.

- Replace the fluids nozzle and the fluids needle.
- Disassemble the gun parts and clean all the components.

## Air leaks.

- Residues or damage in the air flow regulating screw. Components are not correctly tightened.

- Disassemble the system to check, clean and tighten the air valve, its seat and washers. Replace any damaged part.

## Paint leaks.

- Residues or damage in the nozzle and / or needle. Components are not correctly tightened.

- Disassemble the system to check, clean and tighten the nozzle, needle its seat and washers. Replace any damaged part.

## Paint is not flowing.

- Regulating paint flow screw is not open enough.
- There is obstruction in the system.

- Turn the screw in a counterclockwise direction to increase the flow.
- Disassemble the gun parts and clean all its components.

| Code  | Model    | Brand          |
|-------|----------|----------------|
| 11095 | PIPI-420 | <b>TRUPER®</b> |
| 13061 | PIPI-421 |                |
| 13060 | PIPI-422 |                |

This product is guaranteed for 10 years against manufacturing defects, malfunctions, and workmanship. To claim the warranty or purchase parts or replacements, you should present the product at 35 Corregidora St, Col. Centro, Cuauhtémoc, CDMX, ZIP Code 06060, or at the establishment where you bought it. For questions or comments, visit [www.truper.com](http://www.truper.com) or call 800 018 7873. Made in China. Imported by TRUPER, S.A. de C.V. Parque Industrial 1, Parque Industrial Jilotepec, Jilotepec, State of Mexico, ZIP Code 54257.

Purchase date:

