

TOUBLESHOOTING GUIDE

Problem	Cause	Solution
Gun Leaking from fluid tip	Foreign substance between fluid tip and needle preventing sealing	Clean fluid needle and fluid nozzle with thinner to remove debris
Paint emerging from fluid needle and needle seat	Needle seal damaged or lost	Replace needle seating
Irregular spray pattern	Clogged air holes in air cap	Soak in thinner and clean with cleaning needle
Oval shaped spray pattern	Dirt on fluid tip or air outlet	Turn air nozzle 180 degrees, if still present clean fluid tip and air outlet.
Spray Pattern flutters or pulses	1. Not enough material in cup 2. Fluid nozzle not tightened. 3. Needle seal damaged. 4. Nozzle set dirty or damaged.	1. Refill material. 2. Tighten fluid nozzle. 3. Clean or replace needle / nozzle set.
Material bubbles in paint cup	1. Paint nozzle not tightened or air nozzle is loose. 2. Nozzle/needle set damaged	1. Tighten parts. 2. Clean or replace needle/nozzle set.



Manufactured in China for:
Primefit Inc
2021 Aeroplex Drive North
Elkhart, IN 46514
574-970-9448
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OPERATING MANUAL – MODEL SGK1000

HVLP Gravity Feed Spray Gun Kit

SPECIFICATIONS

MODEL NO: -----	SGK1000
AVG SCFM @ 90 PSI: -----	7.0 @ 40 PSI
OPERATING PRESSURE	20-45 PSI
CANISTER MATERIAL-----	Aluminum
AIR INLET -----	1/4" NPS
TIP SIZES-----	1.4mm (Large Gun), 1.2mm (Small)



⚠ WARNING

**READ THIS OPERATION MANUAL BEFORE USING THIS PRODUCT.
FAILURE TO DO SO CAN RESULT IN SERIOUS INJURY.
SAVE THIS MANUAL**

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SAFETY GUIDELINES

This manual contains information to PROTECT YOUR SAFETY and PREVENT EQUIPMENT PROBLEMS. It is important to know and understand all contents. The symbols below are designated for the following alerts:

⚠ DANGER POTENTIAL HAZARD THAT WILL RESULT IN SERIOUS INJURY OR LOSS OF LIFE

⚠ WARNING POTENTIAL HAZARD THAT COULD RESULT IN SERIOUS INJURY OR LOSS OF LIFE

⚠ CAUTION POTENTIAL HAZARD THAT MAY RESULT IN INJURY OR EQUIPMENT DAMAGE

⚠ WARNING

CALIFORNIA PROPOSITION 65

This product or its power cord may contain chemicals known to the State of California to cause cancer and birth defects or other reproductive harm. Wash hands after handling.

⚠ WARNING

You can create dust when you spray, cut, sand, drill or grind materials such as wood, paint, metal, concrete, cement, or other masonry. This dust often contains chemicals known to cause cancer, birth defects, or other reproductive harm. Wear protective gear.

⚠ WARNING

WORK ENVIRONMENT:

- RISK OF FIRE OR EXPLOSION – Do not operate tool in explosive environments, or around flammable liquids, gases, or dust. The tool will generate sparks which could result in the ignition of the dust or fumes.
- RISK OF INJURY – Keep children and others away from the tool while in use.

PERSONAL SAFETY:

- Never operate tool while fatigued, or under the influence of drugs, alcohol, or medication. Serious injury could occur.
- Never wear loose clothing or jewelry, and keep hair, clothing, and gloves away from moving parts at all times.
- Make sure tool is off and trigger is not engaged before connecting to air supply.
- Keep proper balance and footing at all times during operation of tool.
- Always use proper safety equipment, including a dust mask.
- Always wear proper eye protection.
- Always wear hearing protection.
- Do not attach hose or tool to your body at any time.
- Avoid long extended periods of operation with the tool. Extended exposure to vibration can cause permanent damage
- Never point the tool at yourself or anyone else. Serious injury could occur.

OPERATION of TOOL:

- Always make sure the work piece is secure and on a stable platform.
- Do not operate tool if the trigger is broken or does not properly turn the tool on or off.
- Always disconnect the tool from the air source before making any adjustments, clearing jams, or performing any maintenance on the tool.
- Always operate and store tool out of the reach of children or untrained persons.
- Check tool for damaged or improperly working parts and have tool serviced if necessary

SAFETY GUIDELINES - Continued

⚠ DANGER

- Toxic vapors can be produced by spraying certain materials. ALWAYS wear protective eyewear, gloves, and a respirator to prevent toxic vapor to come in contact with eyes, mouth or skin.
- RISK OF FIRE OR EXPLOSION – Do not operate tool in explosive environments, or around flammable liquids, gases, or dust.
- Never use oxygen, co2, or combustible gases or any other bottled gas to operate the tool.
- Use only a pressure regulated compressed air source to regulate the pressure supplied to the tool. The regulated pressure must not exceed 90 PSI. If the regulator fails, the compressor can not be capable of delivering greater than 200 psi to the tool, or the tool could explode causing serious injury or death.
- Fluid and solvent can be highly flammable or combustible. Always spray in a well ventilated area and away from ignition sources and open flames.
- Always disconnect tool from air supply before performing maintenance and while not in use.
- Use clean, dry and regulator compressed air regulated between 20PSi and 45PSi. Never exceed 90 PSI operation pressure.
- Use only parts, nozzles, and accessories recommended by manufacturer.
- Never use homogenate hydrocarbon solvent, which can chemically react to aluminum and zinc parts. Only use solvents that are chemically compatible with aluminum and zinc.

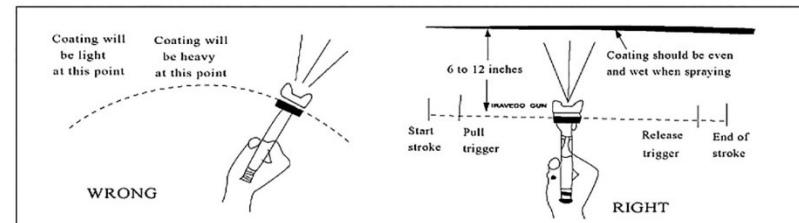
⚠ WARNING

OPERATING INSTRUCTIONS

- Check and replace any damaged or worn parts
- Before operating tool, make sure all screws, and caps are securely tightened.
- Make sure the trigger and nozzle operate freely before use.
- Connect the gun to air supply regulated to between 20 and 45 PSI. Air pressure should be adjusted depending on the viscosity of the paint.
- Pour paint into the container.

GUN HANDLING

- Always hold the gun keeping the gun body perpendicular to the spraying surface and move in a parallel motion to the spraying surface.
- Start the stroke before pulling the trigger and release the trigger before the stroke is finished.
- Keep a distance of 6-12 inches between the gun tip and the spraying surface as shown in the figure below



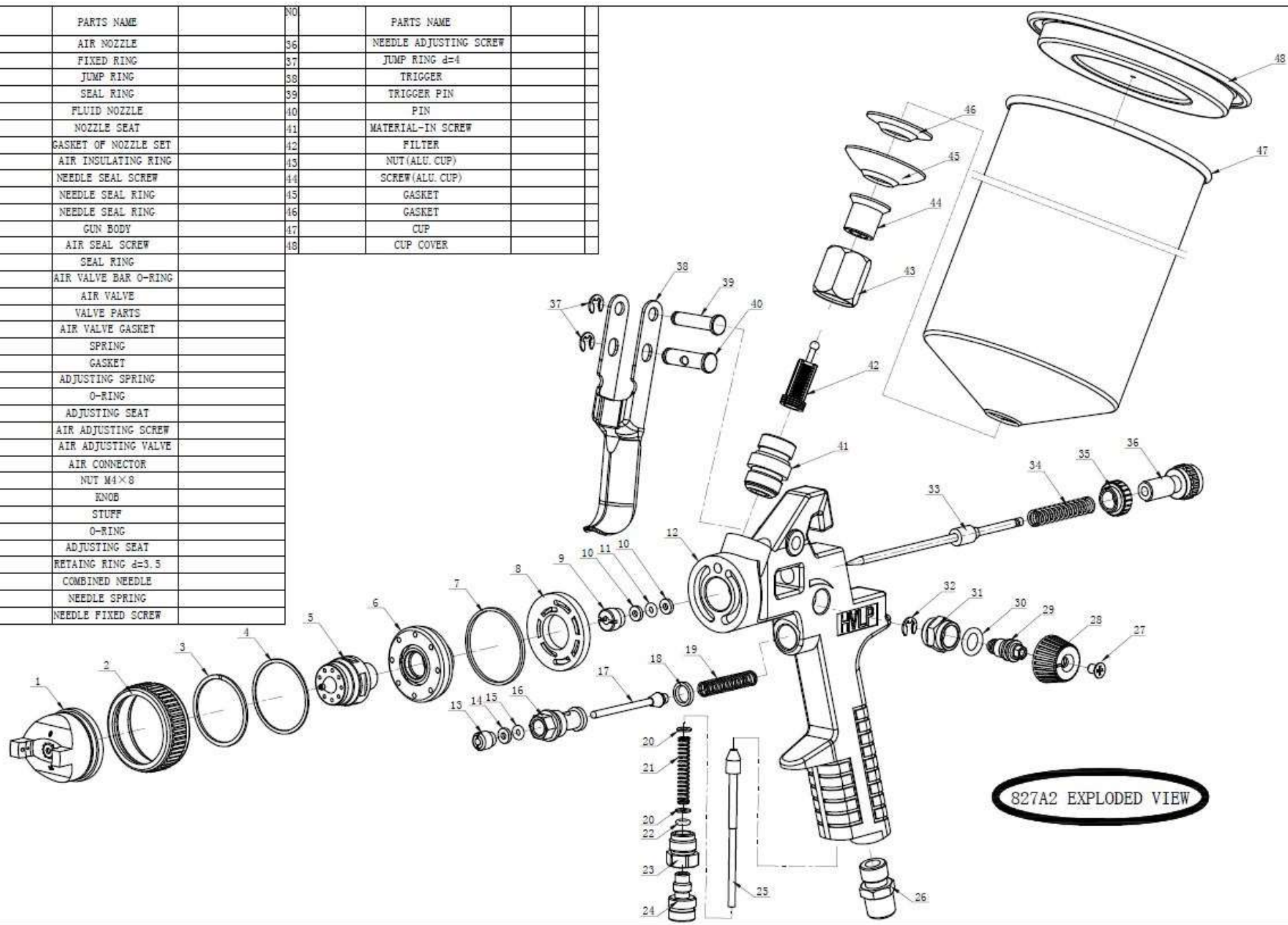
ADJUSTMENT

- Material volume is regulated by adjusting the Fluid Control knob on the back of the tool (18) as shown on attached parts diagram.
- Air flow and spray atomization is adjusted with the Air Valve Adjustment screw (31) on the bottom of the tool near the air inlet.
- Spray pattern is adjusted with the Pattern adjustment screw on the side of the tool (22).

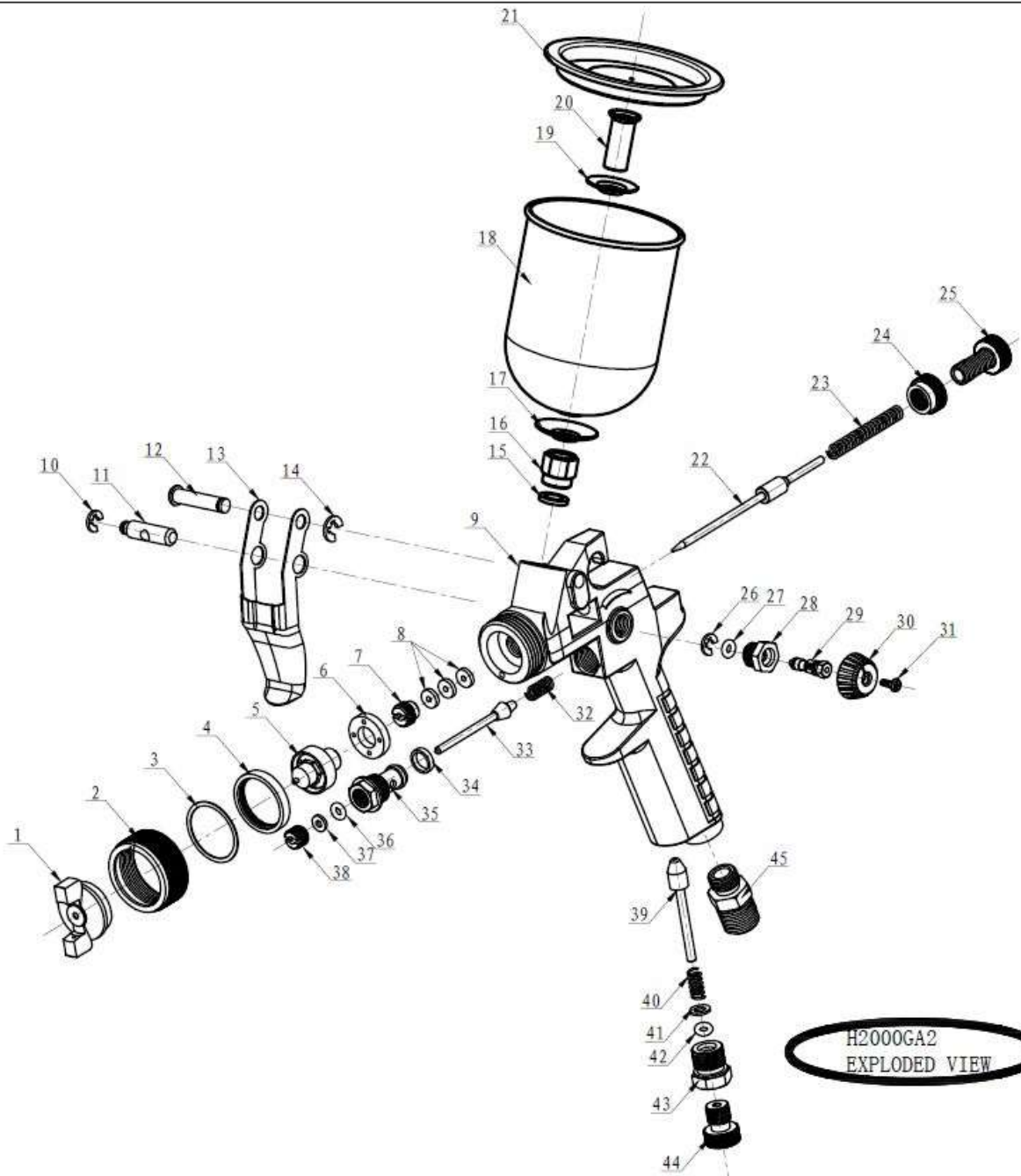
MAINTENANCE

- Pour remaining paint into another container and clean paint passage and air cap.
- Spray a small amount of thinner through the gun to clean all passages.
- Clean other sections with brush soaked with thinner.
- NEVER spray foods or chemicals through the spray gun
- Never immerse the entire gun into solvent as it will damage the air cap, fluid nozzle and needle.

NO.	PARTS NAME	NO.	PARTS NAME
1	AIR NOZZLE	36	NEEDLE ADJUSTING SCREW
2	FIXED RING	37	JUMP RING d=4
3	JUMP RING	38	TRIGGER
4	SEAL RING	39	TRIGGER PIN
5	FLUID NOZZLE	40	PIN
6	NOZZLE SEAT	41	MATERIAL-IN SCREW
7	GASKET OF NOZZLE SET	42	FILTER
8	AIR INSULATING RING	43	NUT(ALU. CUP)
9	NEEDLE SEAL SCREW	44	SCREW(ALU. CUP)
10	NEEDLE SEAL RING	45	GASKET
11	NEEDLE SEAL RING	46	GASKET
12	GUN BODY	47	CUP
13	AIR SEAL SCREW	48	CUP COVER
14	SEAL RING		
15	AIR VALVE BAR O-RING		
16	AIR VALVE		
17	VALVE PARTS		
18	AIR VALVE GASKET		
19	SPRING		
20	GASKET		
21	ADJUSTING SPRING		
22	O-RING		
23	ADJUSTING SEAT		
24	AIR ADJUSTING SCREW		
25	AIR ADJUSTING VALVE		
26	AIR CONNECTOR		
27	NUT M4x8		
28	NOB		
29	STUFF		
30	O-RING		
31	ADJUSTING SEAT		
32	RETAING RING d=3.5		
33	COMBINED NEEDLE		
34	NEEDLE SPRING		
35	NEEDLE FIXED SCREW		



827A2 EXPLODED VIEW



NO.	PARTS NAME
1	AIR NOZZLE
2	FIXED RING
3	AIR NOZZLE SEAL RING
4	AIR NOZZLE LOCK RING
5	FLUID NOZZLE
6	AIR INSULATING RING
7	NEEDLE SEAL SCREW
8	NEEDLE SEAL GASKET
9	GUN BODY
10	JUMP RING d=3.5 GB896-86
11	PIN
12	TRIGGER PIN
13	TRIGGER
14	JUMP RING d=4 GB896-86
15	GASKET
16	NUT W80.5-1
17	GASKET HR99G.4a-5
18	ALU. CUP
19	GASKET HR99G.4a-4
20	SCREW
21	CUP COVER
22	COMBINED NEEDLE
23	NEEDLE SPRING
24	NEEDLE ADJUSTING SEAT
25	NEEDLE ADJUSTING SCREW
26	JUMP RING d=2.5
27	O-RING $\phi 2.5 \times \phi 1.8$
28	ADJUSTING SEAT
29	ADJUSTING SCREW
30	KNOB
31	NUT BOLT M2.5X5
32	SPRING
33	AIR VALVE PARTS
34	VALVE GASKET
35	AIR VALVE
36	O-RING $\phi 5 \times \phi 1.5$
37	LEATHER GASKET
38	AIR VALVE SEAL SCREW
39	AIR ADJUSTING VALVE
40	ADJUSTING SPRING
41	GASKET
42	O-RING $\phi 2.8 \times \phi 1.8$
43	AIR ADJUSTING SEAT
44	AIR ADJUSTING SCREW
45	AIR CONNECTOR