

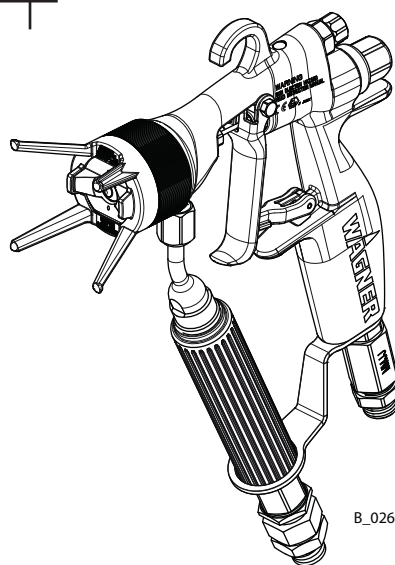


Translation of the original Operating manual

AC 4600 Professional

Edition 06/2012

AirCoat spray guns for flat - and round jet nozzles



B_02695

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1 ABOUT THESE INSTRUCTIONS

This operating manual contains information on the operation, repair and maintenance of the unit.

→ Always observe these instructions when operating the unit.

This equipment can be dangerous if it is not operated in accordance with this manual.

Compliance with these instructions constitutes an integral component of the warranty agreement.

1.1 LANGUAGES

This operating manual is available in the following languages:



Language:	Part No.	Language:	Part No.
German	394870	English	394871
French	394872	Dutch	394873
Italian	394874	Spanish	394875
Danish	394876	Swedish	394877

1.2 WARNINGS, NOTES AND SYMBOLS IN THESE INSTRUCTIONS



Warning instructions in this manual point out particular dangers to users and equipment and state measures for avoiding the hazard.

These warning instructions fall into the following categories:



Danger - imminent danger. Non-observance will result in death or serious.

 SIHL_0100_GB	
	<p>This line warns of the hazard! Possible consequences of failing to observe the warning instructions. The signal word points out the hazard level.</p> <p>→ The measures for preventing the hazard and its consequences.</p>

Warning - possible danger. Non-observance can result in death or serious injury.

 SIHL_0103_GB	
	<p>This line warns of the hazard! Possible consequences of failing to observe the warning instructions. The signal word points out the hazard level.</p> <p>→ The measures for preventing the hazard and its consequences.</p>

Caution - a possibly hazardous situation. Non-observance can result in minor injury.

 SIHL_0101_GB	
	<p>This line warns of the hazard! Possible consequences of failing to observe the warning instructions. The signal word points out the hazard level.</p> <p>→ The measures for preventing the hazard and its consequences.</p>

Notice - a possibly hazardous situation. Non-observance can cause material damage.

 SIHL_0102_GB	<p>NOTICE</p>
	<p>This line warns of the hazard! Possible consequences of failing to observe the warning instructions. The signal word points out the hazard level.</p> <p>→ The measures for preventing the hazard and its consequences.</p>

Note - provide information on particular characteristics and how to proceed.

2 GENERAL SAFETY INSTRUCTIONS

2.1 SAFETY INSTRUCTIONS FOR THE OPERATOR

- Keep these operating instructions to hand near the unit at all times.
- Always follow local regulations concerning occupational safety and accident prevention.



2.1.1 ELECTRICAL EQUIPMENT

Electrical plant and unit

- To be provided in accordance with the local safety requirements with regard to the operating mode and ambient influences.
- May only be maintained by skilled electricians or under their supervision.
- Must be operated in accordance with the safety regulations and electrotechnical regulations.
- Must be repaired immediately in the event of problems.
- Must be put out of operation if they pose a hazard.
- Must be de-energized before work is commenced on active parts. Inform staff about planned work, observe electrical safety regulations.



2.1.2 PERSONNEL QUALIFICATIONS

- Ensure that the unit is operated and repaired only by trained persons.

2.1.3 A SAFE WORK ENVIRONMENT

- Make sure that the floor in the area where you are working is derivable in accordance with EN 61340-4-1.
- Ensure that all persons within the working area wear derivable shoes.
- Ensure that during spraying, persons wear derivable gloves so that they are earthed via the handle of the spray gun.
- Customer to provide paint mist extraction units conforming to local regulations.
- Ensure that the following components of a safe working environment are available:
 - Material/air hoses adapted to the working pressure
 - Personal safety equipment (breathing and skin protection)
- Ensure that there are no ignition sources such as naked flame, glowing wires or hot surfaces in the vicinity. Do not smoke.



2.2 SAFETY INSTRUCTIONS FOR STAFF

- Always follow the information in these instructions, particularly the general safety instructions and the warning instructions.
- Always follow local regulations concerning occupational safety and accident prevention.



2.2.1 SAFE HANDLING OF WAGNER SPRAY UNITS

The spray jet is under pressure and can cause dangerous injuries.

Avoid injection of paint or cleaning agents:

- Never point the spray gun at people.
- Never reach into the spray jet.
- Before all work on the unit, in the event of work interruptions and functional faults:
 - Switch off the energy/compressed air supply.
 - Secure the spray gun against actuation.
 - Relieve the pressure from the spray gun and unit.
 - By functional faults: Identify and correct the problem, proceed as described in chapter „Trouble shooting“.

In the event of skin injuries caused by paint or cleaning agents:

- Note down the paint or cleaning agent that you have been using.
- Consult a doctor immediately.

Avoid danger of injury through recoil forces:

- Ensure that you have a firm footing when operating the spray gun.
- Only hold the spray gun briefly in any one position.



2.2.2 EARTH THE UNIT

Depending on the electrostatic charge and the flow speed of the spray, an electrostatic charge may occur in the equipment. This could cause a spark or flame on discharging.

- Ensure that the unit is earthed for every spraying operation.
- Earth the work pieces being painted.
- Ensure that all persons inside the working area are earthed, e.g. that they are wearing derivable shoes.
- When spraying, wear derivable gloves to earth yourself via the spray gun handle.



2.2.3 PAINT HOSES

- Ensure that the hose material is chemically resistant to the sprayed materials.
- Ensure that the material hose is suitable for the pressure generated in the unit.
- Ensure that the following information is visible on the high pressure hose:
 - Manufacturer
 - Permissible operating overpressure
 - Date of manufacture.
- The electrical resistance of the complete high pressure hose must be less than 1 MOhm.



2.2.4 CLEANING

- De-energize the unit electrically.
- Disconnect the pneumatic supply line.
- Relieve the pressure from the unit.
- Ensure that the flash point of the cleaning agent is at least 5 K above the ambient temperature.
- To clean, use only solvent-free cloths and brushes. Never use hard objects or spray on cleaning agents with a gun.

An explosive gas/air mixture forms in closed containers.

- When cleaning units with solvents, never spray into a closed container.
- Earth the container.



2.2.5 HANDLING HAZARDOUS LIQUIDS, VARNISHES AND PAINTS

- When preparing or working with paint and when cleaning the unit, follow the working instructions of the manufacturer of the paints, solvents and cleaning agents being used.
- Take the specified protective measures, in particular wear safety goggles, protective clothing and gloves, as well as hand protection cream if necessary.
- Use a mask or breathing apparatus if necessary.
- For sufficient health and environmental safety: Operate the unit in a spray booth or on a spraying wall with the ventilation (extraction) switched on.
- Wear suitable protective clothing when working with hot materials.



2.2.6 TOUCHING HOT SURFACES

- Touch hot surfaces only if you are wearing protective gloves.
- When operating the unit with a coating material with a temperature of $> 43\text{ }^{\circ}\text{C}$; $109.4\text{ }^{\circ}\text{F}$:
 - Identify the unit with a warning label that says „Warning - hot surface“.

Order No.

9998910 Information label

9998911 Safety label



2.3 CORRECT USE

WAGNER accepts no liability for any damage arising from incorrect use.

- Use the unit only to work with the materials recommended by WAGNER.
- Operate the unit only as an entire unit.
- Do not deactivate safety equipment.
- Use only WAGNER original spare parts and accessories.



2.4 USE IN AN EXPLOSION HAZARD AREA

2.4.1 CORRECT USE

The unit is suitable for working liquid materials in accordance with the classification into explosion classes.

2.4.2 EXPLOSION PROTECTION IDENTIFICATION

As defined in the Directive 94/9/CE (ATEX 95), the unit is suitable for use in areas where there is an explosion hazard.

CE Ex II 2G X

- CE: Communautés Européennes
Ex: Symbol for explosion protection
II: Unit class II
2: Category 2 (Zone 1)
G: Ex-atmosphere gas
X: See: "Special Notes" in the operating manual



2.4.3 MAXIMUM SURFACE TEMPERATURE

X: The maximum surface temperature corresponds to the permissible material temperature.
This and the permissible ambient temperature can be found in the Technical Data.

2.4.4 SAFETY INSTRUCTIONS

Safe handling of WAGNER spray units

Mechanical sparks can form if the unit comes into contact with metal.

In an explosive atmosphere:

- Do not knock or push the unit against steel or rusty iron.
- Do not drop the spray gun.
- Use only tools that are made of a permitted material.

Ignition temperature of the coating material

- Ensure that the ignition temperature of the coating material is above the maximum surface temperature.

Medium supporting atomizing

- To atomize the material, use only weakly oxidizing gases, e.g. air.

Cleaning

If there are deposits on the surfaces, the unit may form electrostatic charges. Flames or sparks can form if there is a discharge.

- Remove deposits from the surfaces to maintain conductivity.

2.5 GERMAN REGULATIONS AND GUIDELINES

See chapter 3.3

3 3+2 YEARS GUARANTEE FOR PROFESSIONAL FINISHING

3.1 SCOPE OF GUARANTEE

All Wagner professional colour application devices (hereafter referred to as products) are carefully inspected, tested and are subject to strict checks under Wagner quality assurance. Wagner exclusively issues extended guarantees to commercial or professional users (hereafter referred to as „customer“) who have purchased the product in an authorised specialist shop, and which relate to the products listed for that customer on the Internet under www.wagner-group.com/profi-guarantee.

The buyer's claim for liability for defects from the purchase agreement with the seller as well as statutory rights are not impaired by this guarantee.

We provide a guarantee in that we decide whether to replace or repair the product or individual parts, or take the device back and reimburse the purchase price. The costs for materials and working hours are our responsibility. Replaced products or parts become our property.

3.2 GUARANTEE PERIOD AND REGISTRATION

The guarantee period amounts to 36 months. For industrial use or equal wear, such as shift operations in particular, or in the event of rentals it amounts to 12 months.

Systems driven by petrol or air are also guaranteed for a 12 month period.

The guarantee period begins with the day of delivery by the authorised specialist shop. The date on the original purchase document is authoritative.

For all products bought in authorised specialist shops from 01.02.2009 the guarantee period is extended to 24 months providing the buyer of these devices registers in accordance with the following conditions within 4 weeks of the day of delivery by the authorised specialist shop. Registration can be completed on the Internet under

www.wagner-group.com/profi-guarantee.

The guarantee certificate is valid as confirmation, as is the original purchase document that carries the date of the purchase. Registration is only possible if the buyer is in agreement with having the data being stored that is entered during registration.

When services are carried out under guarantee the guarantee period for the product is neither extended nor renewed.

Once the guarantee period has expired, claims made against the guarantee or from the guarantee can no longer be enforced.

3.3 HANDLING

If defects can be seen in the materials, processing or performance of the device during the guarantee period, guarantee claims must be made immediately, or at the latest within a period of 2 weeks.

The authorised specialist shop that delivered the device is entitled to accept guarantee claims. Guarantee claims may also be made to the service centres named in our operating instructions. The product has to be sent without charge or presented together with the original purchase document that includes details of the purchase date and the name of the product. In order to claim for an extension to the guarantee, the guarantee certificate must be included.

The costs as well as the risk of loss or damage to the product in transit or by the centre that accepts the guarantee claims or who delivers the repaired product, are the responsibility of the customer.

3.4 EXCLUSION OF GUARANTEE

Guarantee claims cannot be considered

- for parts that are subject to wear and tear due to use or other natural wear and tear, as well as defects in the product that are a result of natural wear and tear, or wear and tear due to use. This includes in particular cables, valves, packaging, jets, cylinders, pistons, means-carrying housing components, filters, pipes, seals, rotors, stators, etc. Damage due to wear and tear that is caused in particular by sanded coating materials, such as dispersions, plaster, putty, adhesives, glazes, quartz foundation.
- in the event of errors in devices that are due to non-compliance with the operating instructions, unsuitable or unprofessional use, incorrect assembly and/or commissioning by the buyer or by a third party, or utilisation other than is intended, abnormal ambient conditions, unsuitable coating materials, unsuitable operating conditions, operation with the incorrect mains voltage supply/frequency, over-operation or defective servicing or care and/or cleaning.
- for errors in the device that have been caused by using accessory parts, additional components or spare parts that are not original Wagner parts.
- for products to which modifications or additions have been carried out.
- for products where the serial number has been removed or is illegible
- for products to which attempts at repairs have been carried out by unauthorised persons.
- for products with slight deviations from the target properties, which are negligible with regard to the value and usability of the device.
- for products that have been partially or fully taken apart.

3.5 ADDITIONAL REGULATIONS

The above guarantees apply exclusively to products that have been bought by authorised specialist shops in the EU, CIS, Australia and are used within the reference country.

If the check shows that the case is not a guarantee case, repairs are carried out at the expense of the buyer.

The above regulations manage the legal relationship to us conclusively. Additional claims, in particular for damages and losses of any type, which occur as a result of the product or its use, are excluded from the product liability act except with regard to the area of application.

Claims for liability for defects to the specialist trader remain unaffected.

German law applies to this guarantee. The contractual language is German. In the event that the meaning of the German and a foreign text of this guarantee deviate from one another, the meaning of the German text has priority.

J. Wagner GmbH
Division Professional Finishing
Otto Lilienthal Strasse 18
88677 Markdorf
Federal Republic of Germany

Wagner professional guarantee
(Status 01.02.2009)

3.6 CE-CONFORMITY

Herewith we declare that the supplied version of



AC 4600 Pro (blue)	AC 4600 Pro (green)
AC 4600 Pro (red)	GM 4600 Pro Box

Complies with the following guidelines:

98/37/EG
94/9/EG

Applied standards, in particular:

DIN EN ISO 12100-1, 2004-04	DIN EN ISO 14121, 2007-12
DIN EN ISO 12100-2, 2004-04	DIN EN ISO 3746, 1995-12
DIN EN 1127-1, 2008-02	DIN EN 13463-1, 2002-04
DIN EN 1953, 1998-12	DIN EN ISO 13732-1, 2006-12

Applied national technical standards and specifications, in particular:

- a) BGR 500 Part 2, Chap. 2.29, „Using coating materials“
- b) BGR 500 Part 2, Chap. 2.36, „Working with liquid ejection devices“
- c) BGR 104 Explosion protection rules
- d) TRBS 2153 Avoiding ignition risks
- e) BGR 180 Setting up for cleaning with solvents for cleaning workpieces with solvents
- f) BGI 740 Painting rooms and equipment
- g) ZH 1/406 Guidelines for liquid ejection devices

Note: All titles can be ordered from Heymanns Publishing House in Cologne, or they are to be found in the Internet.

CE Certificate of Conformity

The certificate is enclosed with this product. The certificate of conformity can be reordered from your WAGNER representative, quoting the product and serial number.

Part number:

398892



4 DESCRIPTION

4.1 FIELDS OF APPLICATION, USING IN ACCORDANCE WITH THE INSTRUCTIONS

The gun is suitable for atomising liquid materials, particularly coating materials, using the AirCoat process.

4.1.1 PROCESSIBLE MATERIALS

Top-coat paints, primer paints, corrosion protection solvents, textured paints, lyes, staining solvents, clear paints, parting solvents, etc. on a solvent or water basis. If you want to spray other working materials than the aforementioned, turn please to a Wagner agency.

	<div style="text-align: center;">  WARNING </div> <p>Hot coating substances! Burns</p> <ul style="list-style-type: none"> → Wear antistatic protective gloves. → When operating the unit with a coating material with a temperature greater than 43 °C; 109.4 °F: Identify the unit with a warning sticker "Warning - hot surface".
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Note: Please contact your local WAGNER dealer and the paint manufacturer if you encounter application problems.

4.2 SCOPE OF DELIVERY

These AirCoat gun is available with three different variants.

4.2.1 VARIANT WITH NOZZLE ACF3000 11/40

Qty	Part No.	Description
1	394150	AC 4600 Professional (blue)
1	394151	AC 4600 Professional (red)
1	394152	AC 4600 Professional (green)

4.2.2 VARIANT WITHOUT NOZZLES

Qty	Part No.	Description
1	394156	AC 4600 Professional (blue)
1	394157	AC 4600 Professional (red)
1	394158	AC 4600 Professional (green)

The standard equipment for each variant includes:

Qty	Part No.	Description
1	398892	CE-conformity
1	394870	Operating manual German
1	see chap. 1	Operating manual for the other language

For special versions the delivery note applies.

4.3 DATA

4.3.1 MATERIALS OF THE PARTS TRANSPORTING PAINT

Metal		Plastic	
Tungsten carbide	Stainless steel 1.4305	POM	FPM
Stainless steel 1.4301	Stainless steel 1.4104	PTFE	PA

4.3.2 TECHNICAL DATA

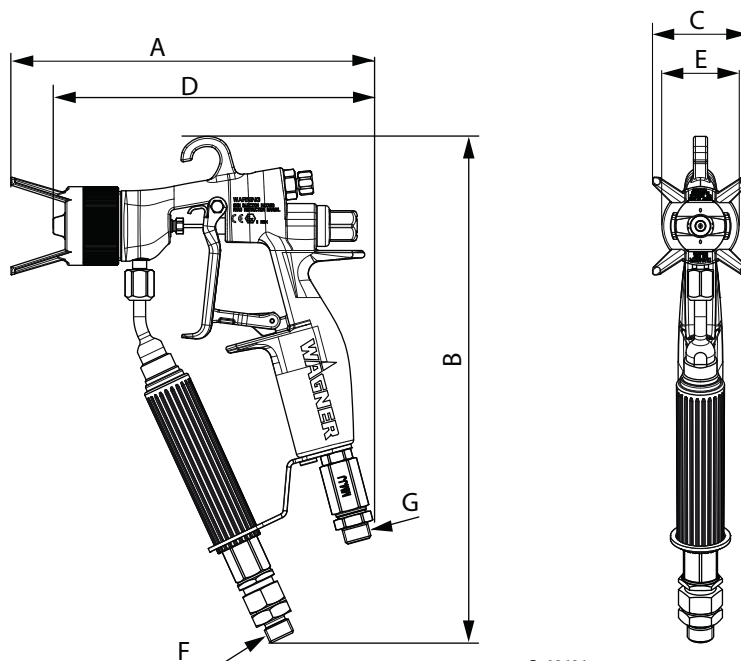
Description	Units	Value
Maxi. air inlet pressure	MPa/ psi/ bar	0.8/ 120/ 8
Maxi. material pressure	MPa/ psi/ bar	25/ 3625/ 250
Paint connection	Inch	NPSM1/4
Air connection	Inch	G1/4"
Filter insert **	Mesh	100
Weight	g/ oz	671 / 23.7
pH range of the material	pH	3.5 - 9
Maxi. temperature material	°C/ °F	55/ 131
Maxi. temperature air	°C/ °F	43/ 109
Sound level at 0.3 MPa; 3 bar; 43.5 psi air pressure and 11 MPa; 110 bar; 1549 psi material pressure***	dB(A)	< 82

** Other filter types see chapter 9.4

*** A rated sound pressure level measured at 0.5m distance according to DIN EN ISO 3746 -1995.

Dimensions

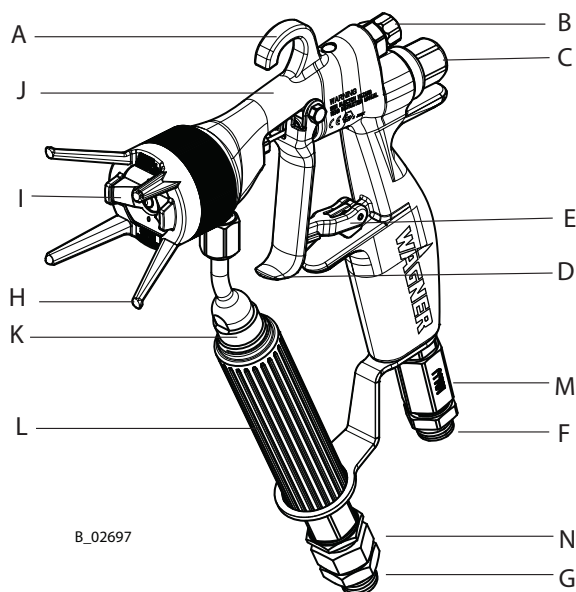
Dim.	mm	inch
A	181	7.13
B	248	9.76
C	48	1.88
D	160	6.30
E	38.5	1.52
F	-	NPSM1/4"
G	-	G1/4"



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4.4 FUNCTIONAL DESCRIPTION

4.4.1 DESIGN OF SPRAY GUN



	Description
A	Suspension hook
B	Shaping air regulator
C	Spring cover
D	Trigger guard
E	Trigger safety
F	Air connection
G	Paint connection



	Description
H	Union nut with nozzle guard
I	Nozzle / Air cap
J	Gun housing
K	Filter housing
L	Handle tube
M	Swivel Air
N	Swivel Material

4.4.2 FUNCTIONS OF THE GUN

If the trigger (D) is operated with released locking (E), first the air valve opens. Atomizing air to flow through via air connection (F) to the air cap (I). The material valve opens only if approx. 1/2 of the trigger guard way are bridged. The quantity of air for the atomization of the jet spray becomes preset over the external air automatic controller. The atomizing air control (B) adjusts the total quantity of air flowing through the spray gun.

The spray gun is rendered safe with the trigger safety catch (E). Turn the trigger safety catch in the spraying direction and fasten in the groove.

5.1.2 VENTILATION OF THE SPRAY BOOTH

	<div style="text-align: center;"> WARNING</div> <p>Toxic and/or flammable vapor mixtures! Risk of poisoning and burns</p> <ul style="list-style-type: none"> → Operate the unit in a spraying booth approved for the working materials. -or- → Operate the unit on an appropriate spraying wall with the ventilation (extraction) switched on. → Observe national and local regulations for the outgoing air speed.
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5.1.3 AIR SUPPLY

The use of an air filter with the air regulator (D) ensures that only dry, clean atomising air gets into the spray gun! Dirt and moisture in the atomising air reduce the spraying quality and the appearance of the finished piece.

5.1.4 FLUID (PAINT) HOSES



<div style="text-align: center;">CAUTION</div> <p>Impurities in the spraying system! Spray gun blockage, materials harden in the spraying system</p> <p>→ Flush the spray gun and paint supply with a suitable cleaning agent.</p>
--

SIHI_0001_GB



	<div style="text-align: center;"> DANGER</div> <p>Bursting hose, bursting threaded joints! Danger to life from injection of material</p> <ul style="list-style-type: none"> → Ensure that the hose material is chemically resistant. → Ensure that the spray gun, threaded joints and material hose between the unit and the spray gun is suitable for the pressure generated in the unit. → Ensure that the following information can be seen on the high pressure hose: <ul style="list-style-type: none"> - Manufacturer - Permissible operating pressure - Date of manufacture.
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SIHI_0029_GB

5.1.5 EARTHING

	<p style="text-align: center;"> WARNING</p> <p>Discharge of electrostatically charged components in atmospheres containing solvents! Explosion hazard from electrostatic sparks or flames</p> <p>→ Earth all unit components. → Earth the workpieces being painted.</p>
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	<p style="text-align: center;"> WARNING</p> <p>Heavy paint mist if earthing is insufficient! Risk of poisoning Insufficient paint application quality</p> <p>→ Earth all unit components. → Earth the workpieces being painted.</p>
--	--

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Any material containers and the unit must be connected by a potential equalisation (earth) cable.

5.2 PREPARATION OF PAINTS



The viscosity of the paints is of great importance. The best results are obtained with paints between 80 and 260 milli Pascal x Sec (mPas).

Please also read the technical data sheet for the paint for optimal processing, viscosity adjustment and intermixing of the material.

5.3 STARTING-UP

5.3.1 GENERAL RULES FOR HANDLING THE SPRAY GUN

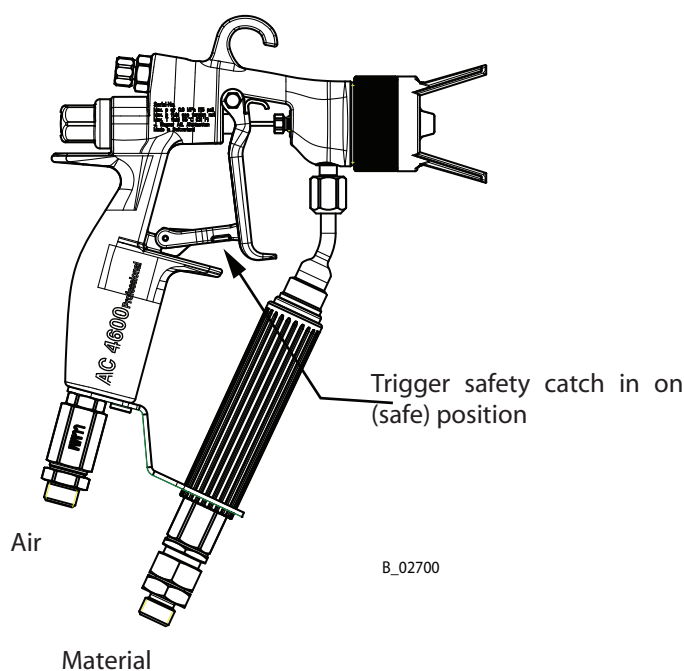
→ Observe general **safety instructions** in chapter 2.

	 WARNING
	<p>Unintentional putting into operation! Risk of injury</p> <p>Before all work on the unit, in the event of work interruptions and functional faults:</p> <ul style="list-style-type: none"> → Switch off the energy/compressed air supply. → Relieve the pressure from the spray gun and unit. → Secure the spray gun against actuation. → By functional faults: Identify and correct the problem, proceed as described in chap „Trouble shooting“.

SIHI_0065_GB

CAUTION
<p>Cleaning agent in the air duct! Functional faults caused by swollen seals</p> <ul style="list-style-type: none"> → Always point the spray gun down when cleaning. → Ensure that neither paint nor cleaning agent enters the air duct.

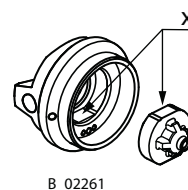
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5.3.2 PREPARATION FOR STARTING UP

1. Secure the spray gun.
2. Connect material hose to the spray gun and material supply system.
3. Connect air hose to spray gun and to oil-free, dry air supply with regulator.
4. Insert suitable gun filter.
5. Place the nozzle into the nozzle seal. Fit the air cap over the nozzle, ensuring that the location flats (X) are in line. Fit the union nut with nozzle guard and tighten by hand.
6. Visually check the permissible pressures for all the system components.
7. Make sure that the unit and all other conductive parts within the work area are earthed.
8. Set material pressure at 100 bar; 10 MPa; 1450 psi and use a suitable medium (solvent or water) to check that connections do not leak.

**Note:**

Pull the trigger and then release, checking that the gun closes cleanly.

9. Relieve spray gun and unit pressure and secure the spray gun.

	<p style="text-align: center;">! WARNING</p> <p>Operating the gun with a coating material with a temperature higher than 43°C; 109.4°F Burns from hot surface (to 60°C; 140°F)</p> <p>→ Wear antistatic protective gloves: → Identify the spray gun with a warning label that says „Warning - hot surface“ (Part No. 9998910 or 9998911).</p>
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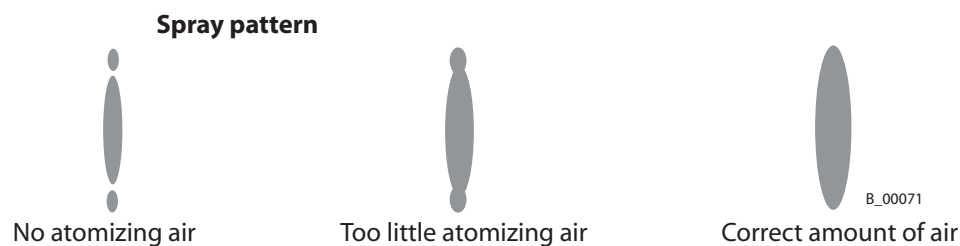
5.4 WORKS

5.4.1 START-UP FOR SPRAYING

1. Start up with material supply set to approx. 8 MPa; 80 bar; 1160 psi operating pressure
2. Spray (release trigger safety catch and pull trigger) and check the atomisation.
3. Set the fluid pressure to the point where a further increase in fluid pressure would significantly improve fluid atomization.
4. Open air pressure controller for the atomizer air and adjust so as to achieve optimal atomization. (The interrelation between spray pattern and atomizer air is shown in the figure below).
5. Use the shaping air controller on the gun to adjust the shaping air to atomizer air ratio, until the optimal spray pattern is achieved.

Note:

Repeat point 4 and 5 until the optimum spray pattern is reached (process iterative).

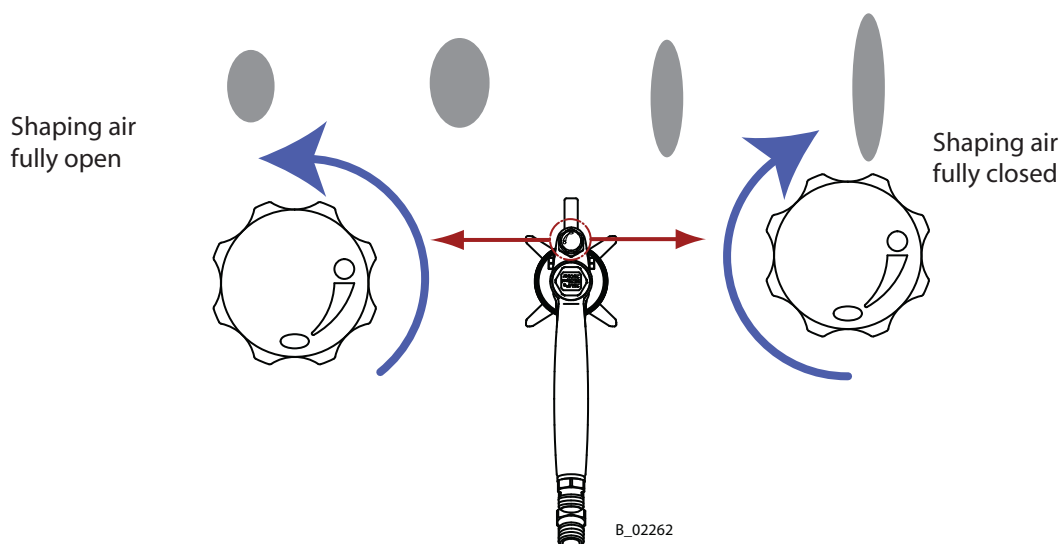
**Note**

The paint output volume can be changed by:

- Changing the material pressure or
- Fitting another flat jet nozzle (see chap. 5.4.3 and chap. 9).

5.4.2 ADJUSTING THE SPRAY PATTERN

The spray pattern can be adjusted to suit the object being sprayed using the fan air regulator. The illustration below shows the influence of the shaping air regulator on the spraying pattern. Other nozzle sizes can be used to obtain larger or smaller spraying patterns.



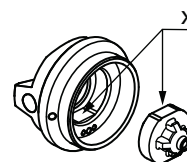
5.4.3 CHANGING THE AIRCOAT NOZZLE**CAUTION****Defective AirCoat nozzle!**

Insufficient paint application quality

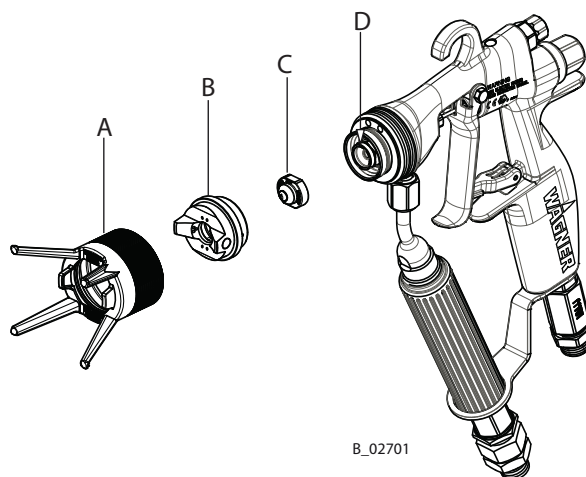
→ Do not use sharp-edged objects to treat hard metal on the AirCoat nozzle.

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1. Relieve spray gun and unit pressure.
2. Secure gun with trigger safety catch.
3. Screw off the union nut (A).
4. Remove air cap (B).
5. Press AirCoat nozzle (C) out of the air cap (B) by hand and brush with cleaning solvent until all remaining paint has been dissolved.
6. **Mounting:**
Place AirCoat nozzle (C) in nozzle seal (D).
7. Fit the air cap (B) over the nozzle (C), ensuring that the location flats (X) are in line.
8. Fit the union nut with nozzle guard (A) and tighten by hand.



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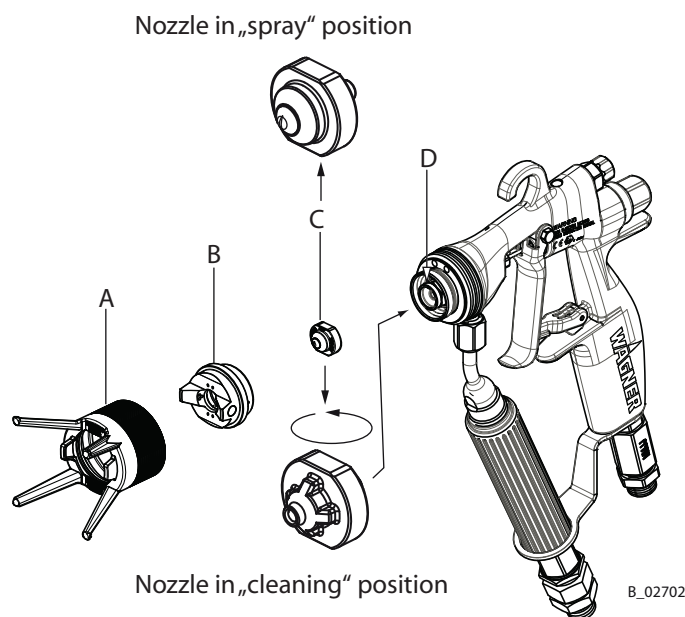
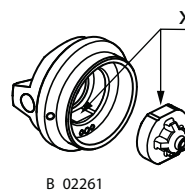
5.4.4 CLEANING AIRCOAT NOZZLE

For disassembly and assembly of AirCoat nozzles see chapter 5.4.3.

The AirCoat nozzle (C) can be placed into a cleaning solvent which has been recommended by the paint manufacturer.

5.4.5 ELIMINATE NOZZLE CLOGGING

1. Relieve spray gun and unit pressure.
 2. Secure gun with trigger safety catch.
 3. Unscrew the union nut with nozzle guard (A).
 4. Remove air cap (B).
 5. Pull out the clogged nozzle (C) from the air cap (B), reverse it and replace it into nozzle seal (D).
 6. Fit the air cap (B) over the nozzle (C), ensuring that the location flats (X) are in line.
 7. Fit the union nut with nozzle guard (A) over the air cap (B) onto the spray gun and tighten by hand.
 8. Switch the material pressure back on.
 9. Turn the safety catch to the spraying position and briefly pull trigger.
 10. When the blockage has been flushed out secure the gun with safety catch.
 11. Relieve spray gun and unit pressure.
 12. Unscrew the union nut with nozzle guard (A).
 13. Remove air cap (B) and reverse nozzle (C) again. Clean nozzle and replace on the nozzle seal (D) in spray position.
 14. Refit air cap (B) on the nozzle (C).
- Take care that the nozzle fitted is correctly (see flat side X).
15. Fit the union nut with nozzle guard (A) over the air cap (B) onto the spray gun and tighten by hand.
 16. Switch the material pressure and the air pressure back on.



6.0 MAINTENANCE

→ Observe general **safety instructions** in chapter 2.

The spray gun and the unit must be cleaned every day. The cleaning solvent used for this must be suitable for the spray material.

CAUTION

Cleaning agent in the air duct!

Functional faults caused by swollen seals

→ Never immerse the spray gun in cleaning agent.

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WARNING


Incorrect maintenance/repair!

Risk of injury and damage to the equipment

- Repairs and part replacement may only be carried out by specially trained staff or a WAGNER service center.
- Before all work on the unit and in the event of work interruptions:
 - Switch off the energy/compressed air supply.
 - Relieve the pressure from the spray gun and unit.
 - Secure the spray gun against actuation.
- Observe the operating and service instructions when carrying out all work.

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6.1 FINISHING WORK AND CLEANING

	<p style="text-align: center;">! DANGER</p> <p>Exploding gas/ air mixture! Danger to life from flying parts and burns</p> <p>→ Never spray into a closed container. → Earth the container.</p>
---	--

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<p style="text-align: center;">CAUTION</p> <p>Cleaning agent in the air duct! Functional faults caused by swollen seals</p> <p>→ Always point the spray gun down when cleaning. → Ensure that neither paint nor cleaning agent enters the air duct.</p>	
---	--

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	<p style="text-align: center;">! WARNING</p> <p>Explosive atmosphere! Explosive gases are produced when aluminium comes into contact with halogenized hydrocarbons</p> <p>→ To clean aluminium, do not use liquids containing halogenized hydrocarbons.</p>
---	--

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Note:

Methylene chloride is not recommended as a flushing or cleaning solvent with this gun or any system components.

1. Relieve spray gun and unit pressure.
2. Secure gun with trigger safety catch.
3. Connect cleaning supply.
4. Remove AirCoat -jet nozzle and clean separately (see chapter 5.4.3).
5. Pressurize the cleaning supply to approx. 4 MPa; 40 bar; 580 psi and thoroughly flush the spray gun.
6. Relieve spray gun and unit pressure.
7. Secure gun with trigger safety catch.
8. Clean gun body with a cleaning agent recommended by the manufacturer, and dry with a cloth.

6.2 REPLACING THE MATERIAL HOSE OR AIR HOSE

1. Finishing work and cleaning.
2. Relieve spray gun and unit pressure.
3. Secure gun with trigger safety catch.

Material hose

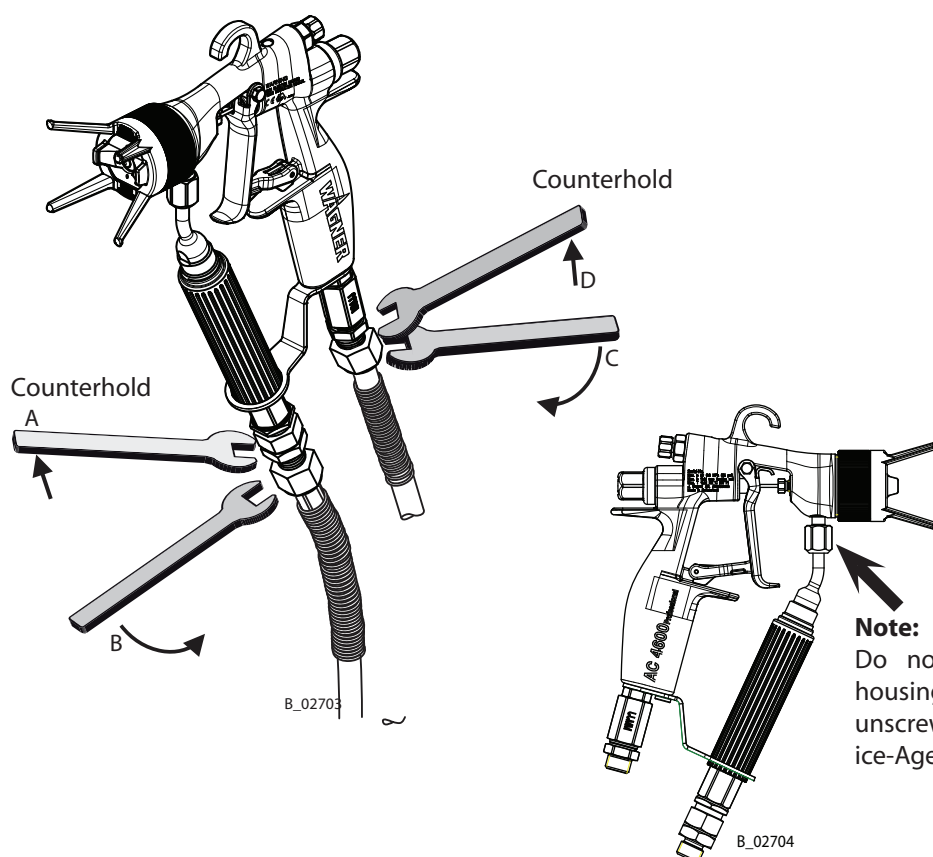
4. Place open-ended wrench wrench size A on flats of paint connection and counterhold.
5. Turn nut to the right with open-ended wrench wrench size B and unscrew material hose.

Air hose

4. Place open-ended wrench wrench size D on flats of air connection and counterhold.
5. Turn nut to the right with open-ended wrench wrench size C and unscrew air hose.

6. Mounting:

Fit the material hose respectively air hose by hand and tighten with 2 open-ended wrenches.



Description	Key A wrench size	Key B wrench size	Key C wrench size	Key D wrench size
AC 4600 Professional NPS 1/4"	17 mm 0.67 inch	19 mm 0.75 inch	17 mm 0.67 inch	14 mm 0.55 inch

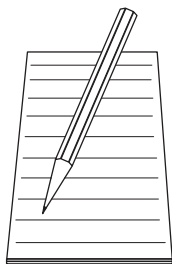
ADDITION 06/2008

BASTION DOME 4600 C394870

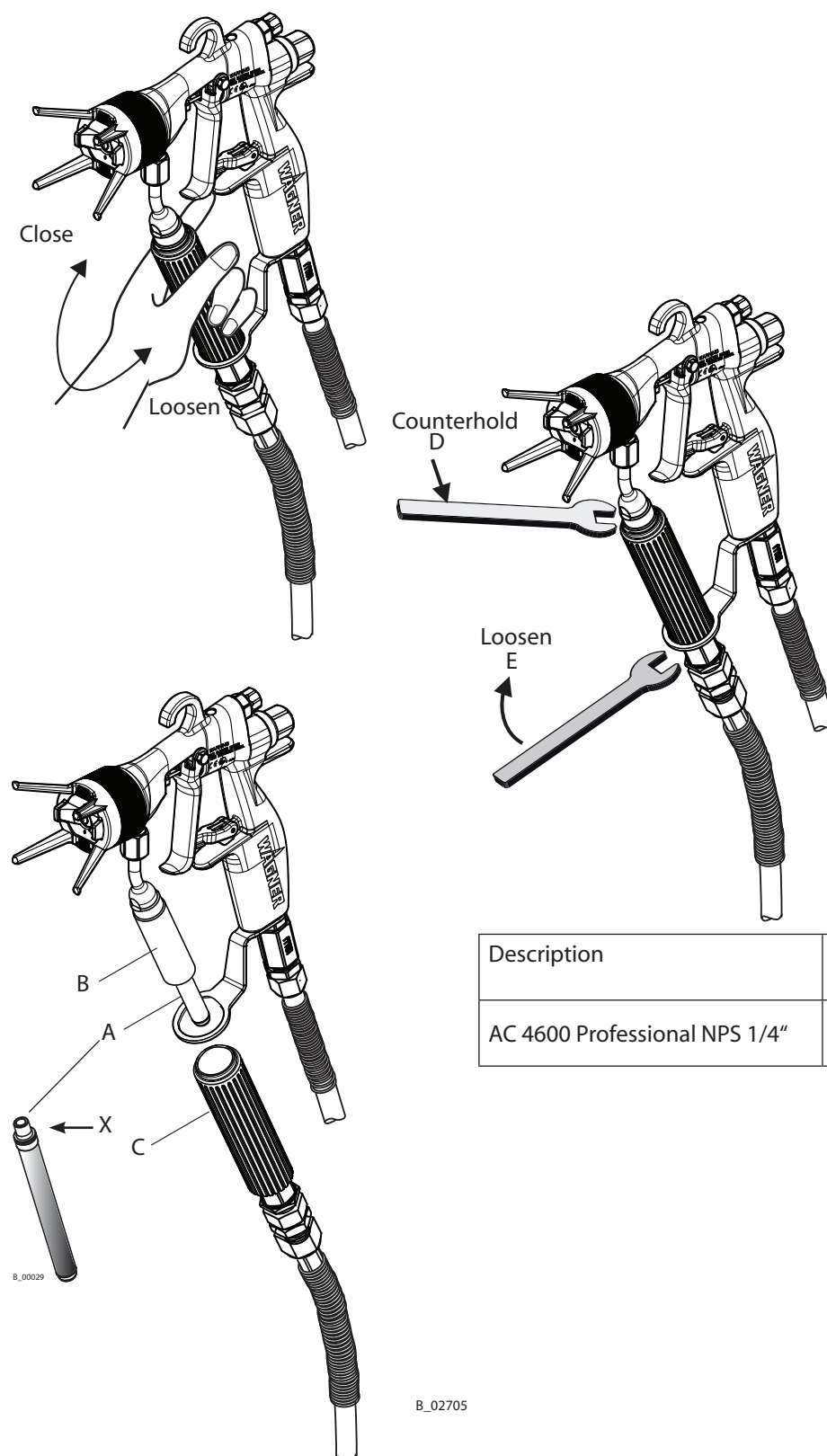
AC 4600 Pro

OPERATIONSMANUAL

WAGNER



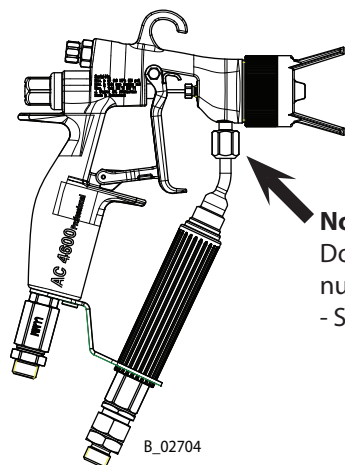
A series of horizontal lines for writing, starting from the top of the page and extending down to the bottom, providing a space for the user to write or draw.

6.3 CHANGING OR CLEANING FILTER INSERT

Description	Key D wrench size	Key E wrench size
AC 4600 Professional NPS 1/4"	13 mm 0.51 inch	17 mm 0.67 inch

B_02705

1. Finishing work and cleaning.
2. Relieve spray gun and unit pressure.
3. Secure gun with trigger safety catch.
4. Loosen complete swivel by hand through turning at the handle tube (C) and drive out downward together with the material hose.
5. Pull filter insert (A) out of the filter housing (B).
6. Flush swivel, filter housing and filter insert (A) with cleaning agent.
7. Push in cleaned or new filter insert (A) with cone (X) upward into the filter housing.
8. Put handle tube with female hexagon on swivel and screw from down over the filter insert onto the filter housing by hand.

**Note:**

Do not unscrew the filter housing. The nut must only be unscrewed by WAGNER - Service-Agency.

6.4 REPLACING PARTS ON THE VALVE ROD**6.4.1 DISASSEMBLING**

1. Finishing work and cleaning.
2. Relieve spray gun and unit pressure.
3. Secure gun with trigger safety catch.
4. Unscrew spring cover (5) and remove compression springs (2) and (3).
5. Loosen screw (22) and remove together with nut (20).
6. Remove trigger guard (21).
7. Loosen sealing screw (10) with single open-end wrench (100) with wrench size 7 mm; 0.28 inches.

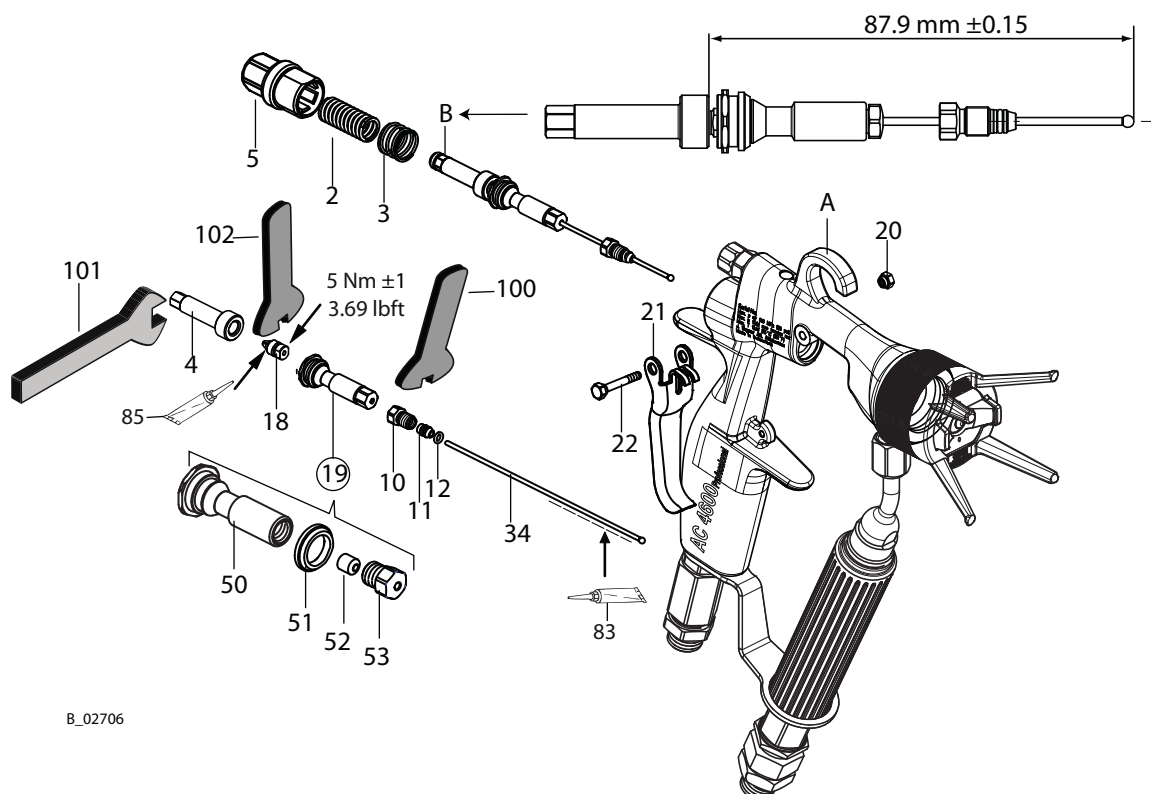
CAUTION**Unsuitable tool!**

Damage to seals and sealing surfaces

→ Do not hold the valve rod with pliers or a similar tool.

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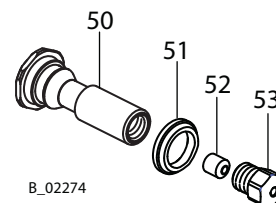
8. Carefully pull the complete valve rod (B) together with sealing screw out of the gun housing (A) toward the rear.
9. Hold the clamping sleeve (4) with open-end wrench (101) wrench size 6 mm; 0.24 inches and loosen the collet chuck (18) with open-end wrench (102) wrench size 5 mm; 0.20 inches.
10. Carefully pull the valve rod (34) out toward the front. Replace the relevant parts.



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6.4.2 REPLACEMENT OF VALVE ROCKER SEALS

1. Support valve tappet (50) with single open-end wrench with wrench size 13 mm; 0.51 inches and unscrew cover (53) with single open-end wrench with wrench size 7 mm; 0.28 inches.
2. Remove air valve seal (51) and seal (52) and replace with new seals.
3. Screw valve tappet (50) and cover (53) together by hand. Carefully tighten in small increments with open-end wrench with wrench size 7 mm; 0.28 inches and with wrench size 13 mm; 0.51 inches until a slight resistance is perceptible when moving the valve rod (34) in the valve tappet.

**Note:**

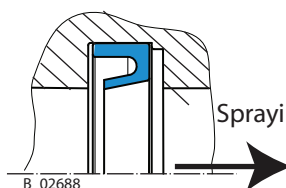
The seal (52) can be pulled out of the cover (53) with the help of an eyebolt.

6.4.3 REPLACING THE ROD SEAL (35)

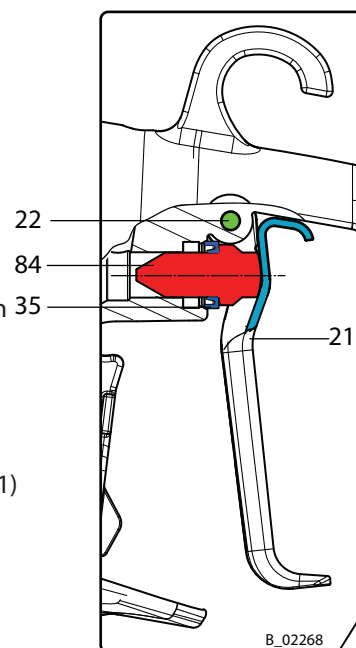
1. Carefully pull the rod seal (35) out of the gun housing.
2. Clean sealing surfaces in the gun housing.
3. Mount new rod seal (35) to the rod seal tool (84).

Note

Installation position of the rod seal (35)



4. Insert rod seal tool (84) together with rod seal (35) into the hole.
5. Fit trigger guard (21) with screw (22) to body of gun *and*
6. Carefully push the tool with the rod seal (35) over the trigger guard (21) into the recess in the housing.
7. Remove trigger guard (21), screw (22) and rod seal tool (84).

**6.4.4 ASSEMBLY**

1. Fit seal collar (11) to valve rod (14), together with inserted O-ring (12) and sealing screw (10).
2. Push completely assembled valve tappet (19) onto valve rod (14).
3. Insert preassembled valve rod into the collet chuck (18) as far as the stop.
4. Fix clamping sleeve (4) with wrench size 6 mm; 0.24 inches, screw the preassembled valve rod to the clamping sleeve and tighten (open-end wrench with wrench size 5 mm; 0.20 inches).
5. Carefully insert the complete valve rod (B) into the gun housing.
6. Screw in sealing screw (10) but do not tighten yet.
7. Position trigger guard (21) and secure with screw (22) and nut (20).
8. Insert compression springs (3) and (2) and screw on the spring cover (5).
9. Carefully tighten the seal collar (11, 12) by turning the sealing screw (10). Ensure that the trigger guard moves easily.
10. Start up in accordance with chapter 5.3.

Note:

Only use silicone and resin free grease.

6.5 REPLACING THE NOZZLE SEAL

CAUTION

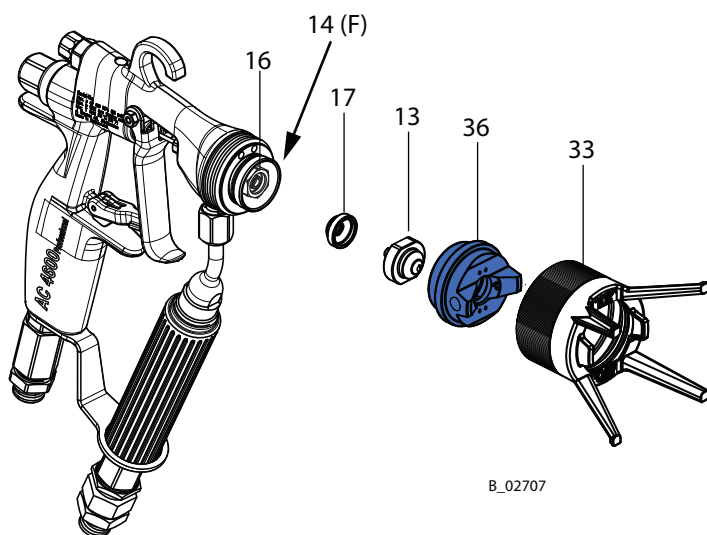
Defective nozzle seal!

Material sprays into the air cap next to the nozzle
Risk of contamination

- Do not clean the nozzle seal with sharp-edged objects.
- Replace the nozzle seal if the sealing surface is damaged.

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1. Finishing work and cleaning.
2. Relieve spray gun and unit pressure.
3. Secure gun with trigger safety catch.
4. Unscrew the union nut with nozzle guard (33).
5. Remove air cap (36) and nozzle (13).
6. Carefully release the nozzle seal (17) with the help of a screwdriver.
7. Fit new nozzle seal to valve housing (16).
8. Continue assembly in the reverse order.



6.6 REPLACING THE „AIR“ SEALING RING**CAUTION****Forming air and atomizer air not separate!**

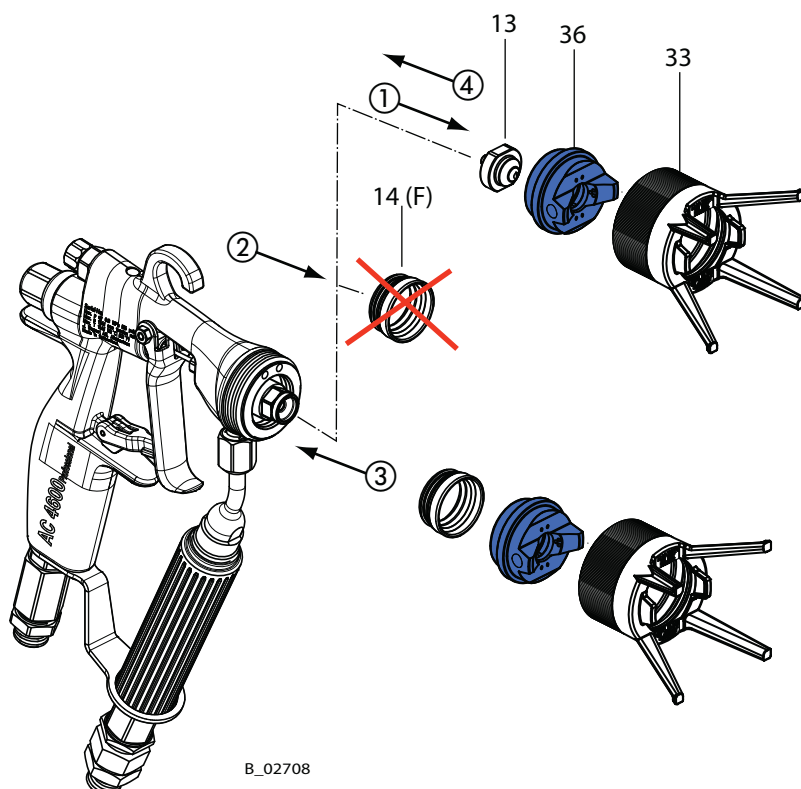
Poor spray pattern

Spray jet cannot be adjusted

→ Treat the distributor seal (F) with care.

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1. Finishing work and cleaning.
2. Relieve spray gun and unit pressure.
3. Secure gun with trigger safety catch.
4. Unscrew the union nut with nozzle guard (33).
5. Remove air cap (36) and nozzle (13).
6. Remove defective sealing ring (14/F) with the help of pipe tongs or with a large screwdriver.
7. **Mounting:**
Fit new distributor seal (14/F) to air cap (36).
8. Place air cap in body of gun together with sealing ring (14).
9. Attach union nut (33) and screw in until the sealing ring snaps into place in the mounting groove (snap hearable).
10. Demount union nut (33) and air cap (36) and complete spray gun according to paragraph 5.4.3.



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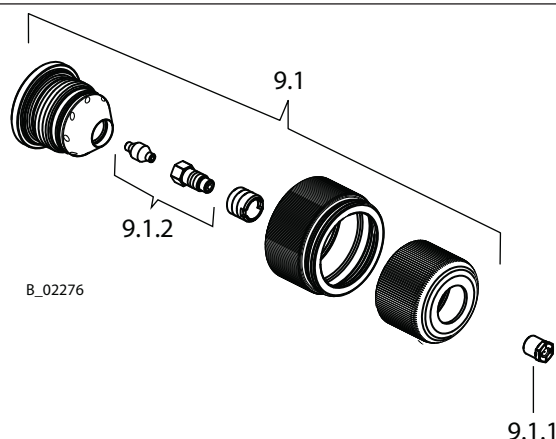
7 TROUBLE SHOOTING AND SOLUTION

Functional fault	Cause	Remedy	see chapter
Insufficient material discharge	Nozzle too small	Select larger nozzle	9
	Material pressure too low	Increase material pressure	
	Filter of gun or high-pressure filter at pump clogged	Clean or replace filter	6.3
	Nozzle is clogged	Nozzle cleaning	5.4.5
	Valve stem defective	Replace valve rod	6.4
Poor spray pattern	Wrongly adjusted atomizing air	Readjust atomizing air	5.4.1
	Nozzle too large	Select smaller nozzle	9.1
	Material pressure too low	Increase pressure at pump	
	Material viscosity too high	Thin material in accordance with the manufacturer's instructions	
	Partial nozzle blockage	Nozzle cleaning	5.4.5
	Wrongly adjusted atomizing air	Readjust the atomizing air	5.4.1
	Aircap faulty (blocked holes, damaged seal)	Clean or replace air cap	
	Wrong aircap type	Replace as required aircap (solvent / water based)	
Valve rod leaks (Paint- or air path)	Paint seal (packing) damaged or worn, valve stem damaged	Adjust or replace packing or replace valve stem complete	6.4
	Air valve seals damaged	Replace air valve seals	6.4
	Pretension too low	Re tighten sealing screw	
Spray gun will not shut-off correctly	Worn valve seat / valve ball	Replace parts	6.4
	Packing-screw too tight, or packing stuck with dried paint	Replace the seals	6.4

9 ACCESSORIES

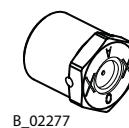
9.1 ROUND JET NOZZLE CAP

Part No.	Description
394180	Round jet nozzle cap (without nozzle insert)



9.1.1 NOZZLE INSERTS RXX

Part No.	Description	Marking	Volume flow*	Jet-ø **
132720	Nozzle insert R11	11	0.16; 160	approx. 250; 9.84
132721	Nozzle insert R12	12	0.22; 220	approx. 250; 9.84
132722	Nozzle insert R13	13	0.27; 270	approx. 250; 9.84
132723	Nozzle insert R14	14	0.34; 340	approx. 250; 9.84
132724	Nozzle insert R15	15	0.38; 380	approx. 250; 9.84
132725	Nozzle insert R16	16	0.43; 430	approx. 250; 9.84
132726	Nozzle insert R17	17	0.48; 480	approx. 250; 9.84
132727	Nozzle insert R18	18	0.53; 530	approx. 250; 9.84
132728	Nozzle insert R19	19	0.59; 590	approx. 250; 9.84
132729	Nozzle insert R20	20	0.65; 650	approx. 250; 9.84
132730	Nozzle insert R21	21	0.71; 710	approx. 250; 9.84
132731	Nozzle insert R22	22	0.77; 770	approx. 250; 9.84

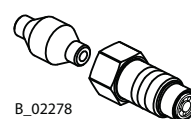


* Volume flow in ml/min; cc/min water at 10 MPa; 100 bar; 1450 psi.

** Jet width in mm; inches at a distance of 30 cm; 11.8 inches from the object and at a pressure of 10 MPa; 100 bar; 1450 psi, synthetic resin paint, 20 DIN4 seconds.

9.1.2 NOZZLE SCREWED CONNECTION COMPL.

Part No.	Description
132922	Nozzle screwed connection compl.





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9.2 AIRCOAT NOZZLES ACF3000

Part No.	Marking	Diameter of bore inch; mm	Spray-angle	Recommended edge filter	
					Use
379107	07/10	0.007-0.18	10°	200 mesh	Natural paint
379207	07/20	0.007-0.18	20°		
379209	09/20	0.009-0.23	20°		Transparent lacquer
379309	09/30	0.009-0.23	30°		Oils
379409	09/40	0.009-0.23	40°		
379509	09/50	0.009-0.23	50°		
379609	09/60	0.009-0.23	60°	100 mesh	Synthetic resin paints
379111	11/10	0.011-0.28	10°		PVC paint
379211	11/20	0.011-0.28	20°		
379311	11/30	0.011-0.28	30°		
379411	11/40	0.011-0.28	40°		
379511	11/50	0.011-0.28	50°		
379611	11/60	0.011-0.28	60°		
379113	13/10	0.013-0.33	10°		Paints
379213	13/20	0.013-0.33	20°		Undercoat
379313	13/30	0.013-0.33	30°		Priming paint
379413	13/40	0.013-0.33	40°		Filler
379513	13/50	0.013-0.33	50°		
379613	13/60	0.013-0.33	60°	60 mesh	Filler
379813	13/80	0.013-0.33	80°		Rustproofing paint
379115	15/10	0.015-0.38	10°		
379215	15/20	0.015-0.38	20°		
379315	15/30	0.015-0.38	30°		
379415	15/40	0.015-0.38	40°		
379515	15/50	0.015-0.38	50°		
379615	15/60	0.015-0.38	60°		
379815	15/80	0.015-0.38	80°		
379217	17/20	0.017-0.43	20°		Rustproofing paint
379317	17/30	0.017-0.43	30°		Latex paint
379417	17/40	0.017-0.43	40°		
379517	17/50	0.017-0.43	50°		
379617	17/60	0.017-0.43	60°		
379817	17/80	0.017-0.43	80°		

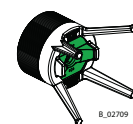
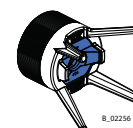
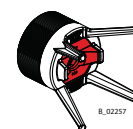


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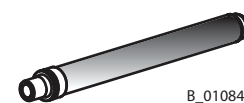
Part No.	Marking	Diameter of bore inch; mm	Spray-angle	Recommended edge filter	
					Use
379219	19/20	0.019-0.48	20°	60 mesh	Rustproofing paint Latex paint
379319	19/30	0.019-0.48	30°		
379419	19/40	0.019-0.48	40°		
379519	19/50	0.019-0.48	50°		
379619	19/60	0.019-0.48	60°		
379819	19/80	0.019-0.48	80°		Mica paint Zinc dust coating Rustproofing paint Distemper
379221	21/20	0.021-0.53	20°		
379421	21/40	0.021-0.53	40°		
379521	21/50	0.021-0.53	50°		
379621	21/60	0.021-0.53	60°		
379821	21/80	0.021-0.53	80°		
379423	23/40	0.023-0.58	40°		
379623	23/60	0.023-0.58	60°		
379823	23/80	0.023-0.58	80°		
379425	25/40	0.025-0.64	40°		
379625	25/60	0.025-0.64	60°		
379825	25/80	0.025-0.64	80°		
379427	27/40	0.027-0.69	40°		
379627	27/60	0.027-0.69	60°		
379827	27/80	0.027-0.69	80°		
379429	29/40	0.029-0.75	40°		
379629	29/60	0.029-0.75	60°		
379829	29/80	0.029-0.75	80°		
379431	31/40	0.031-0.79	40°		
379631	31/60	0.031-0.79	60°		
379831	31/80	0.031-0.79	80°		
379435	35/40	0.035-0.90	40°		
379635	35/60	0.035-0.90	60°		
379835	35/80	0.035-0.90	80°		

9.3 AIR CAPS

Part No.	Description
394910	Air cap LV compl. (red) for low viscosity paints
394911	Air cap HV compl. (blue) for high viscosity paints
394912	Air cap compl. (green)

**9.4 FILTER INSERT**

Part No. for 1 piece	Part No. for 10 pic.	Filter type	Mesh	Use for nozzles
34383	97022	Gun filter rot	200	0.007" - 0.015"
43235	97023	Gun filter yellow	100	0.015" - 0.019"
34377	97024	Gun filter white	50	0.017" - 0.021"

**9.5 HOSES**

Part No.	Description
9984595	Hose set AC Material DN3; Air DN6 7.5 m; 24.61 ft
9984596	Hose set AC Material DN3; Air DN6 10 m; 32.81 ft
	Consisting of Material-, Air- and protective hose. Material: NPSM1/4"; DN 3 mm; ID 0.12 inch; 27 MPa; 270 bar; 3916 psi Air: G1/4"; DN 6 mm; ID 0.24 inch; 0.8 MPa; 8 bar; 116 psi

9.6 SWIVELS

Part No.	Description
347706	Swivel for paint connection (NPSM 1/4")
364938	Swivel for air connection G1/4"



B_02712



B_02687

9.7 MISCELLANEOUS

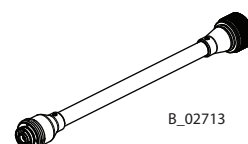
Part No.	Description
9997001	Nozzle cleaning brush
394942	Service set AC 4600 Professional
394904	Conversion kit 16 MPa; 160 bar; 2320 ps
394905	Conversion kit 25 MPa; 250 bar; 3625 psi
367560	Double connection NPSM1/4" (outside thread) for paint hose extension
9985720	Double nipple G1/4" (outside thread) for air hose extension
394090	Nozzle extension AC 300 (not approved for use in explosive areas)



B_02685



B_02686



B_02713

10 SPARE PARTS

10.1 HOW TO ORDER SPARE PARTS?

Always supply the following information to ensure delivery of the right spare part:

Part Number, description and quantity

The quantity need not be the same as the number given in the „Quantity“ column. This number merely indicates how many of the respective parts are used in each sub assembly.



The following information is also required to ensure smooth processing of your order:

- Address for the invoice
- Address for delivery
- Name of the person to be contacted in the event of any queries
- Type of delivery required (air freight or mail, sea route or overland route, etc.)

Marks in spare parts lists

Note to column „K“ in the following spare parts lists.

- ◆ = Wearing parts
Note: No liability is assumed for wearing parts
- = Not part of standard equipment, available, however, as additional extra.

	 WARNING
	<p>Incorrect maintenance/repair! Risk of injury and damage to the equipment</p> <ul style="list-style-type: none"> → Repairs and part replacement may only be carried out by specially trained staff or a WAGNER service center. → Before all work on the unit and in the event of work interruptions: <ul style="list-style-type: none"> - Switch off the energy/compressed air supply. - Relieve the pressure from the spray gun and unit. - Secure the spray gun against actuation. → Observe the operating and service instructions when carrying out all work.

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10.2 SPARE PARTS LIST AC4600 PROFESSIONAL

Spare parts list AC 4600 Professional

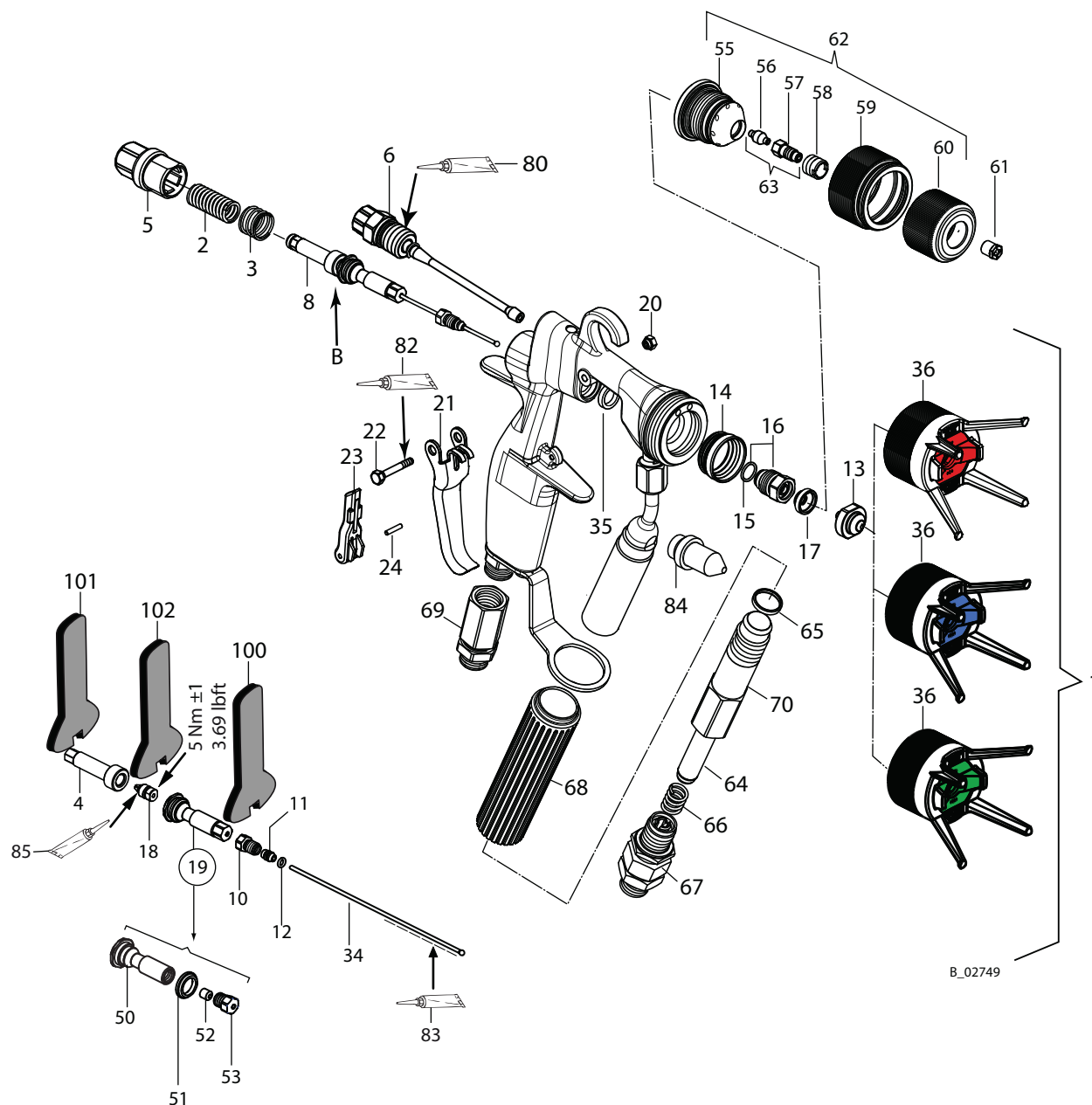
Pos	K	Qty	Part No.	Description
1		1	394150	AC 4600 Professional; NPSM1/4" (blue) compl.
1		1	394151	AC 4600 Professional; NPSM1/4" (red) compl.
1		1	394152	AC 4600 Professional; NPSM1/4" (green) compl.
2		1	9999501	Screw spring Paint
3		1	9999500	Screw spring Air
4		1	2312140	Tension sleeve
5		1	394333	Spring cover 25 MPa; 250 bar; 3625 psi
6		1	394924	Air tappet complete
8	◆	1	2311320	Valve rod unit assy.
10		1	394327	Sealing screw
11	★ ◆	1	394328	Gasket
12	★ ◆	1	9971445	O-ring
13	◆	1	379411	Nozzle ACF3000 11/40 (other nozzle sizes see chapter 9.2)
14	★ ◆	1	394339	Sealing ring
15	★ ◆	1	9974245	O-ring
16	★ ◆	1	394922	Valve seat compl.
17	★ ◆	1	394338	Seal Nozzle
18		1	2312149	Chuck
19		1	394257	Valve tappet compl.
20		1	394318	Nut
21		1	394601	Trigger
22		1	394319	Screw
23		1	394334	Safety catch
24		1	9935088	Cylindrical shaft
34	★ ◆	1	394920	Valve rod compl.
35	★ ◆	1	394323	Rod seals
36	◆	1	394910	Air cap LV compl. (red)
36	◆	1	394911	Air cap HV compl. (blue)
36	◆	1	394912	Air cap (green)
50		1	394309	Valve tappet
51	★ ◆	1	179338	Air valve seal

◆ = Wearing part

★ = Included in service set

● = Not part of standard equipment for spray gun. Available, however, as additional extra

Detail B

**Mounting materials**

Pos	K	Part No.	Description
80	●	9992831	Loctite 542
81	●	9992833	Loctite 638 green
82	●	9992590	Loctite 222
83	●	9992698	Vaseline white PHHV II
84	★ ●	394342	Tool valve rod seal
85	●	-	Molykote

Spare parts list AC 4600 Professional

Pos	K	Qty	Part No.	Description
52	★ ◆	1	179395	Seal
53	★ ◆	1	394322	Cap
55	●	1	394336	Nozzle body
56	◆ ●	1	128327	Sealing nipple
57	◆ ●	1	132516	Nozzle screw connection compl.
58	●	1	132351	Nozzle screw connection holder
59	●	1	394308	Union nut
60	●	1	394337	Nozzle nut
61	◆ ●	1	132...	Nozzle insert R (various dimensions see chap. 9.1.1)
62	●	1	394180	Round jet nozzle cap (see chap. 9.1)
63	◆ ●	1	132922	Nozzle screw connection compl.
64	◆	1	43235	Filter insert yellow, 100 mesh (other filter types see chapter 9.2)
65	★ ◆	1	364340	Seal filter
66	★ ◆	1	43590	Compression spring
67	◆	1	347706	Swivel compl. paint
68		1	364349	Handle tube
69	◆	1	364938	Swivel Air
70		1	394615	Filter tube AC 4600 Pro NPS 1/4"
		1	394942	Service set AC 4600 Professional

◆ = Wearing part

★ = Included in service set

● = Not part of standard equipment for spray gun. Available, however, as additional extra

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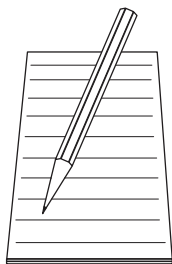
ADDITION 06/2008

BASTION DOME 4600 C394870

AC 4600 Pro

OPERATION MANUAL

WAGNER



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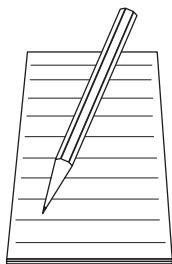
ADDITION 06/2008

BASTION DOME 4600 C394870

AC 4600 Pro

OPERATION MANUAL

WAGNER



WAGNER



Order number 394871

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