

APOLLO

HIGH VOLUME LOW PRESSURE MAXI-MISER® SPRAYGUN INSTRUCTION MANUAL



A5100



A5105



A5110

MODELS:

A5100

SCREW-CUP GUN

A5105

PRODUCTION GUN

A5110

QUICK-RELEASE CUP
GUN

APOLLOSPRAYERS INTERNATIONAL, INC.
1030 JOSHUA WAY, VISTA, CA 92083
(619) 727-8300

760

APOLLOSPRAY HVLP MAXI-MISER® SPRAY GUN

CONGRATULATIONS!! You have just purchased the world's only dual purpose "2 in 1" HVLP spray gun patent #5279461, 5429307. Your APOLLO HVLP spray gun will work off compressed air as an air conversion gun (3hp compressor and up) or any make turbine unit (performance will vary with power level of the turbine) as a turbine HVLP spray gun. Changing from compressed air to turbine generated air is virtually instant.

Please take the time to read and familiarize yourself with these simple instructions before using your Apollo Maxi-Miser® HVLP spray gun.

INSTRUCTIONS

Check the contents of your spray gun box. The following is included:

- Spray Gun (see below)
- Spare parts kit (gaskets, etc.)
- Coupler for turbine air
- Air pressure test gauge (optional)
- Wrench
- Viscosity Cup
- Blanking cap (brass)
- Owner's manual

Your Apollo Maxi-Miser® spray gun is made in three versions.

(1) Model A5100 top of the line industrial cup gun featuring all stainless steel fluid parts, screw-on drip proof teflon coated cup, stainless steel fluid parts in the cup assembly.

(2) Model A5105 – Industrial production gun, stainless steel fluid parts etc. For use with a pressure pot/paint tank (any size).

(3) Model A5110 – Industrial cup gun same as (1) but with quick release cup assembly. The fluid parts in the spray gun are all stainless steel, the cup assembly parts are brass and aluminum.

USING YOUR APOLLO MAXI-MISER® SPRAY GUN WITH COMPRESSED AIR

Simply connect your regular compressed air hose directly onto the 1/4" NPT fitting on the handle of your spray gun. Ensure that the alloy blanking cap #14 (see diagram on pg. 9, 10, 11) is in place. Set your air pressure according to your material viscosity (see chart on pg. 5). Put the paint/material in the cup and attach it to the cup top #27 for the A.5100 gun or #38 for the A.5110 gun. For the A.5105 production gun, simply connect your 1/4" or 3/8" material hose to the fluid connector #39. Set your material pot pressure to approximately 5-7 psi. Air pressure from your compressor into the spray gun can range from **30 psi up to 80 psi maximum**. You are now ready to start spraying.

USING YOUR APOLLO MAXI-MISER® SPRAY GUN WITH A TURBINE UNIT

- 1) Disconnect your compressed air line to the handle of the spray gun – 1/4" NPT fitting (if connected).
- 2) Take the brass domed blanking cap supplied (#19) and screw it into 1/4" NPT fitting on the handle of your spray gun.
- 3) Remove the alloy air cap #14 (located above the material flow screw, #18) and in its place put the alloy turbine air hose coupler supplied.
- 4) Take your turbine air hose and plug it onto the air hose connector. Note: Most makes of turbines use the same quick connect air hose fittings. In case of difficulty call the Apollo factory for assistance. Your Apollo HVLP Maxi-Miser® spray gun is now ready to use with your turbine unit.

SPRAYING WITH YOUR APOLLO HVLP SPRAY GUN

Familiarize yourself with the controls on the spray gun. There are three principal controls – The rotating air cap (#2), the material flow screw (#18) and the aircap locking ring (adjusts the fan size) (#1).

Your APOLLO Spray Gun is High Volume Low Pressure. It only uses from 3 psi to 10 psi of flow pressure measured at the air cap. Because your APOLLO spray gun uses such High Volume and Low Pressure, all passages and air ports are much larger. If one of these air passages becomes blocked, or build up of materials starts to occur, your fan pattern will become distorted. Therefore, always keep your gun clean. Your APOLLO spray gun comes fitted with a 1.00mm tip/jet and needle (inscribed with a number 2). This will cover about 85% of all the materials/coatings that you will spray. Using this size tip and needle you can achieve a 1/4" line up to a 15" fan pattern, simply by rotating the air cap #2 to the desired fan type (see diagram pg. 4) opening up the material flow screw #18 (counter-clockwise) and moving the gun closer or further away from your workpiece. A little practice will enable you to master this.

When you use your Apollo spray gun for the first time, screw the flow screw (#18) all the way in until you cannot pull the trigger back. Put a scratch mark on the back of the flow screw. Now, unscrew the flow screw 1-1/2 turns. Put material in the paint cup. Hold the gun 6" to 8" from the workpiece and start spraying. If too much material is coming out, turn the flow screw in one half or one full turn. Usually 1-1/2 turns out is about the correct setting for most materials (see diagram pg. 4). There are THREE

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other tips/jets and needles available. They are: .75mm, 1.5mm and 2.5mm. The 2.5mm is used for materials such as "Zolatone or Multi-Spec" paints, adhesives or thicker coatings that cannot be thinned. The .75 will complement the 1 mm size that comes with the gun. The .75 will offer greater control with very thin watery materials such as inks, dyes and stains. A phone call to the factory will enable you to decide if you have a need for any of these other size tips/needles. Phone (619) 727-8300.

Please note that the above items are sold in pairs. If you change the size of the tip, then you have to change the needle as well. The angle of the point is different.

Because it is Low Pressure, "Bounceback" and "Overspray" is greatly reduced. You will notice that there is no syphon/vent hold in the cup top. This is because the APOLLO spray gun works on a pressure feed system as opposed to syphon feed as on conventional guns. The APOLLO spray gun can therefore be used in almost any position without dripping. If you are spraying a ceiling, you can spray in the upward position. Do not forget to rotate the pick-up tube 180° so all of the material in the paint cup gets picked up.

The revolving nozzle/air cap has three main positions: vertical fan (1), horizontal fan (2) and round spray pattern (3). The third position is achieved with the "ears" on the nozzle in the diagonal position.

All parts in your APOLLO spray gun are noncorrosive, being aluminum, brass and stainless steel.

SPRAY PATTERN

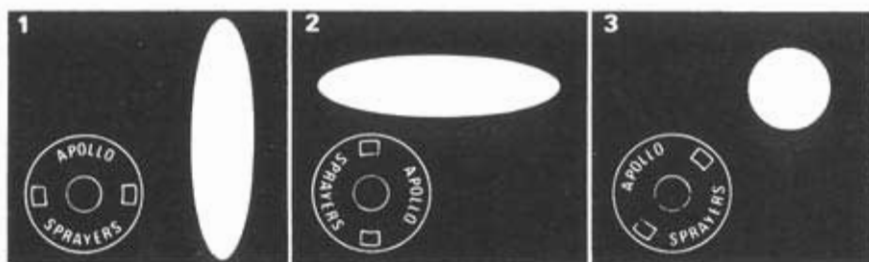


Fig. 1 Use this position when spraying across from side to side.

Fig. 2 Use this position when spraying from top to bottom.

Fig. 3 Use this position for spotting small objects, corners and sharp angles.

VISCOSITY

The most important item in spray finishing is the correct viscosity or thickness of the material. As a guide you reduce the materials being sprayed as follows:

		Viscosity in Seconds
Lacquers	25% - 50%	15 - 22 seconds
Sanding Sealer	20% - 30%	15 - 22 seconds
Enamels	20% - 40%	16 - 22 seconds
Stains (oil or water)	use from the can	15 seconds
Acrylic Enamel	50% - 60%	15 - 17 seconds
Catalyzed Polyurethane	10% - 30%	15 - 18 seconds
Polyurethanes, Varnishes	20% - 30%	16 - 22 seconds
Waterborne coatings	00% - 10%	24 - 35 seconds

Actual viscosity will vary depending on power level of the turbine or air pressure selected when the spray gun is used with a compressor. In all cases, use the viscosity cup provided. This is the equivalent of a #2 Zahn cup widely used in industry. Remember viscosity is the key to a good finish. Call the factory if you are not sure or are experiencing difficulty. As a general guide: too thick gives "orange peel", "splatter", slow application and a poor fan pattern. Too thin gives runs/sags and poor coverage.

In the compressed air mode you can increase the air pressure at the handle of the gun to 80 psi maximum. This will give 9.8 psi flow pressure at the air cap. If you increase the air pressure too much, you will reduce the transfer efficiency and cause unnecessary "overspray". Higher pressure is only required for thicker viscosity materials/coatings such as latex paint. In general, stay in the range of 30 psi - 70 psi.

In the turbine driven air mode the power level of your turbine unit will play a major part. For lacquers, stains and thin materials, a two stage, 3.4 psi turbine will work fine. For thick heavier water based materials and oil based paints, a 3 stage 5-6 psi turbine is required. Call APOLLO factory if you need help.

CLEANING YOUR APOLLO HVLP SPRAY GUN

After Spraying

- 1) Empty any unused paint from the paint cup and wash out any residue with solvent or water. Partly fill the cup with clean solvent and spray through the gun to flush out the material passages.
- 2) Remove the Air Distributor Nozzle and clean with solvent. Ensure that the air holes in the horns of the nozzle are clean.

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- 3) Using a brush and solvent, remove any paint deposits on the outer surface of the tip. If it is necessary to remove the tip and needle for cleaning the following procedure should be used:
- a) Unscrew the paint Flow Adjusting Screw (#18). Remove the needle (#15) spring, then withdraw the needle.
 - b) Remove the Jet (tip, #6).
 - c) Clean both tip and needle using solvents and a brush.
 - d) Reassemble making sure that all washers and gaskets are replaced correctly. Oil the needle spring and put a spot of oil on the Gland Seal washer to prevent the needle from sticking. To adjust the Gland Nut, tighten until needle sticks then slacken off by about 1/8" turn.
 - e) Check the cup Top Gasket and replace if damaged. Always seat the cup top gasket flat in the cup to the groove. Failure to do this will allow the cup to drip and impair the spray pattern due to loss of pressure.
 - f) Lubricate all threads to ensure smooth operation.

Blockages and or leaks may occur if the gun is left on its side or turned upside down. Always hang the gun by the hook when not in use.

Always experiment with pressure settings, viscosity of coating and spraying techniques prior to doing a job. Once you have learned the technique of HVLP spraying you will never want to go back to a "conventional" spray gun.

TESTING THE PRESSURE AT THE AIR CAP

To ensure compliance with your State air quality codes, a pressure gauge is an option for your Apollo spray gun. To use: rotate the air cap #2 to the horizontal position, press the nipple of the gauge (gasket) onto the center of the air cap and allow air flow through the spray gun. **IMPORTANT!!** Do not have any paint/coating/material in the spray gun. The gun should be clean and dry with an empty cup. In the case of the A.5105 production gun version, disconnect the fluid hose after depressurizing the pressure pot/paint tank. The maximum allowable air pressure at the air cap is 10 psi. This is achieved in the compressed air mode at 80 psi in at the handle.

TIPS AND NEEDLES

Four sizes of tips and needles are available (must be paired together).

.75mm Inscribed #1

1.00mm Inscribed #2

1.50mm Inscribed #3

2.50mm Inscribed #4 (Special Air Cap also required with this size)

TECHNICAL INFORMATION AND TROUBLE SHOOTING

Good quality results with your APOLLO spray finishing equipment are a combination of careful preparation of your project, a proper spraying environment, a basic knowledge of the coatings you will be using and how these coatings work with your APOLLO HVLP spray equipment.

1. No project will look good unless you have properly prepared the surface for the finish application. Thoroughly sand all imperfections and clean the surfaces to be sprayed.

2. Be sure the environment in which you will be working is clean, properly ventilated and a moderate temperature is maintained. It should be neither too hot or too cold. 70°F is the optimum.

COATINGS

3. Almost all solvent based coatings need to be reduced (thinned) before spray finishing. Correct viscosity is easily achieved. APOLLO SPRAYERS supplies you with a viscosity cup (#2 Zahn equivalent) and a guideline for thinning a variety of coatings. Common sense and a phone call to the APOLLO factory (619) 727-8300 if necessary can resolve any viscosity question. Many manufacturers of coatings will offer guidelines for thinning their product. These recommendations are usually for conventional compressed air spraying. Most often they will work perfectly for APOLLO HVLP Sprayers. If not, slight modification in viscosity might be necessary.

4. The new waterborne coatings are different from solvent based coatings. Their composition does not allow them to be thinned (reduced) as easily as solvent finishes. They are formulated to be used straight from the can. Thinning (if necessary) should only be done with an appropriate reducer from the coating manufacturer of the waterborne finish.

HVLP SPRAY EQUIPMENT VARIABLES

5. Your APOLLO Maxi-Miser® Spray gun when used in the compressor mode gives the user the option of varying supplied air pressure from 30 psi to 80 psi depending upon the viscosity of your coating. You will generally find that 50 psi to 60 psi is average. Lower pressure for thinner materials, higher for heavier viscosities. This will offer you the greatest efficiency with your sprayer. Your APOLLO HVLP Spray Gun is designed for maximum transfer efficiency and minimal "overspray". Using your sprayer correctly will ensure the most efficient results.

6. The APOLLO portable turbine units generate a high volume of air (94cfm - 200cfm) which in turn creates low pressure at the air cap to produce a fine atomization of your coatings. (The turbine units are excellent for use on-site or when clean, warm, dry air is important or when mobility of equipment is desirable or compressed air supply is not sufficient to operate the HVLP spray gun). Unlike compressed air which can be increased or decreased, turbine air power is limited to the maximum air power of the unit. Each turbine unit represents a different air power level. You CANNOT increase the power of turbine generated air. (You can decrease it if necessary). Smaller or lower powered turbine units might require additional thinning of some coatings to achieve a fine enough atomization. Certain materials/coatings/paints where thinning is not desirable might limit or preclude some applications with lower powered units.

TECHNIQUE

Like any skill, practice makes perfect. Never try to rush the spray finishing process. Try to learn the characteristics of the coating you will be spraying. Build up layers of material, (3-4 applications or more if necessary), sand between coats and allow proper drying time between applications.

CONTINUED NEXT PAGE . . .

When using your APOLLO Spray Gun you have control of five things.

1. Fluid Flow
 2. Distance of the spray gun from your work. (5" - 8" is average, closer if necessary).
 3. Pattern Direction (Vertical fan, horizontal fan and round).
 4. Speed of Application.
 5. Fan Pattern Control (adjust air cap ring) See #1 (opposite page).
- Numbers 1, 2 and 4 directly relate to each other.

It is important to remember to always keep the distance of the spray gun the same when moving across your work. (Called a "pass"). Do not rotate or turn your wrist from side to side, rather move the spray gun across your work from end to end. Also, be sure to maintain the same speed of movement. This will ensure an even application of coating. Always release the trigger at the end of a "pass". Continue spraying in the opposite direction overlapping your previous coat by 1/3 to 1/2. When finished you should have an even wet coat on your work. If you have dry spots you have overlapped too wide. If you have heavy or wet spots, you have overlapped too much. When spraying a large or pre-assembled piece, start at the top and work down. Try to spray the hard to reach and underneath surfaces first. Again, common sense and some forethought will prevent errors.

TROUBLE SHOOTING

1. Paint cup full, HVLP air is supplied to gun. Trigger is pulled and no paint comes out - Reason: Cup not pressurizing.

Check:

- | | | |
|--|-------|----------|
| a) Capillary tube | (#29) | (A.5235) |
| b) Air feed tube | (#26) | (A.5232) |
| c) Air feed connector | (#8) | (A.5211) |
| d) Cup (#35) is screwed or clamped on tight. | | |
| e) Cup top gasket (#32) is not damaged. | | |

2. When spray gun is connected to a turbine and the turbine is on, air continually flows through the air cap even if the trigger is not pulled. - Response: This is correct. All APOLLO spray guns in the turbine mode are "bleeder" type guns. This is necessary and desirable to ensure longevity of the turbine motor.

3. If you think that you are getting too much "overspray".

- Try: Moving the spray gun closer to the work.
Close down the fluid flow.
Reduce the air power.
Consider a smaller tip/needle assembly.

4. If the sprayed surface is not flat and level after drying, "orange peel" effect.

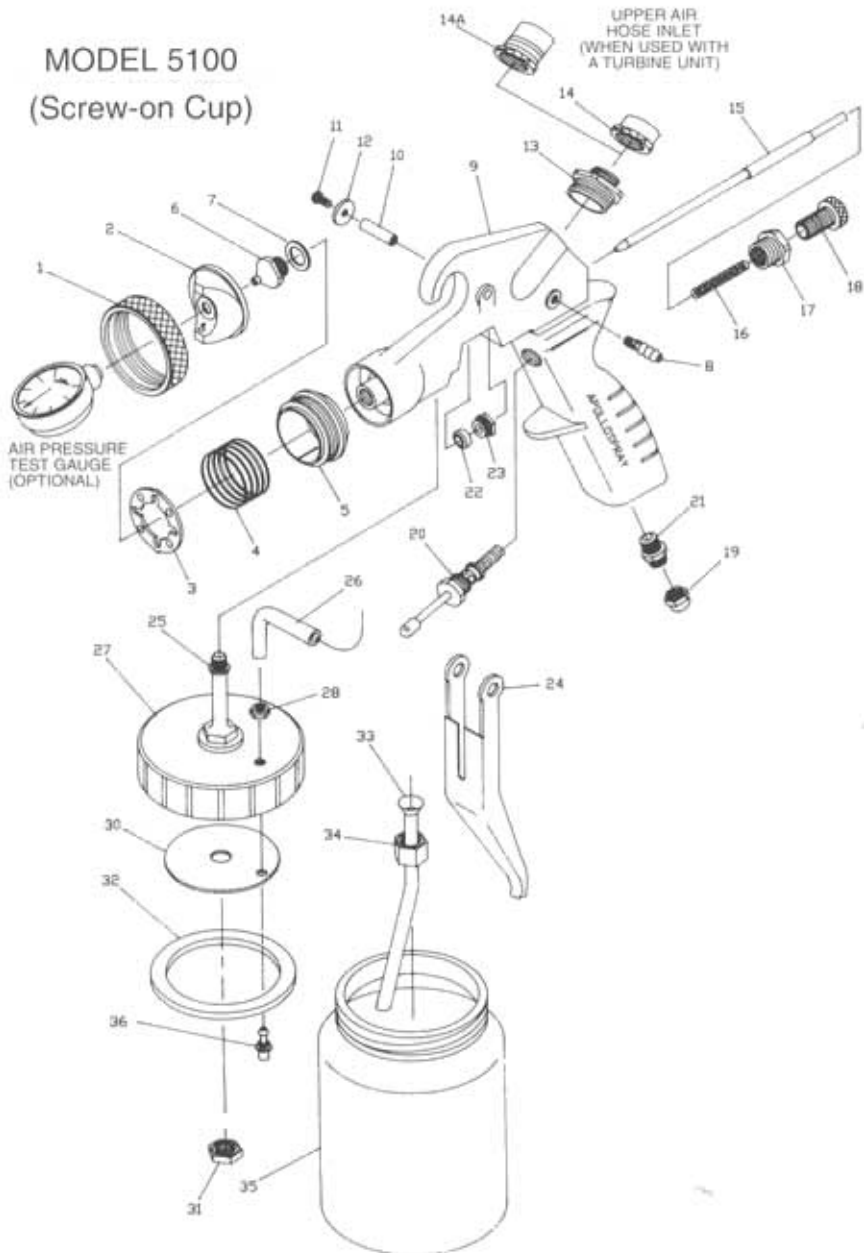
- Try: Increasing air power (model 1100/1200 turbine or "2 in 1" spray gun only).
Thinning the coating.

5. If the finish looks like "dry mist" or if you think the speed of the application is too slow.

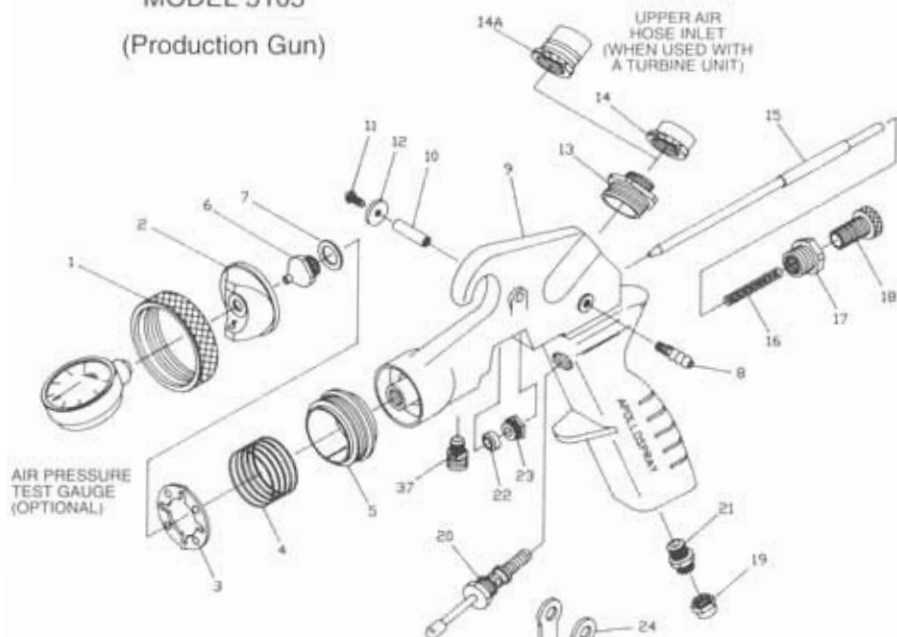
- Try: Increasing the fluid flow.
Moving the gun closer to the work.
Thin the coating more.

The work you produce is usually judged on its appearance. Your APOLLO Spray equipment can provide you with the highest quality and most efficient way to apply your coatings. A little time, patience and understanding will help you to achieve the best results. Our technical division can answer questions about most finishes that you might encounter.

MODEL 5100
(Screw-on Cup)

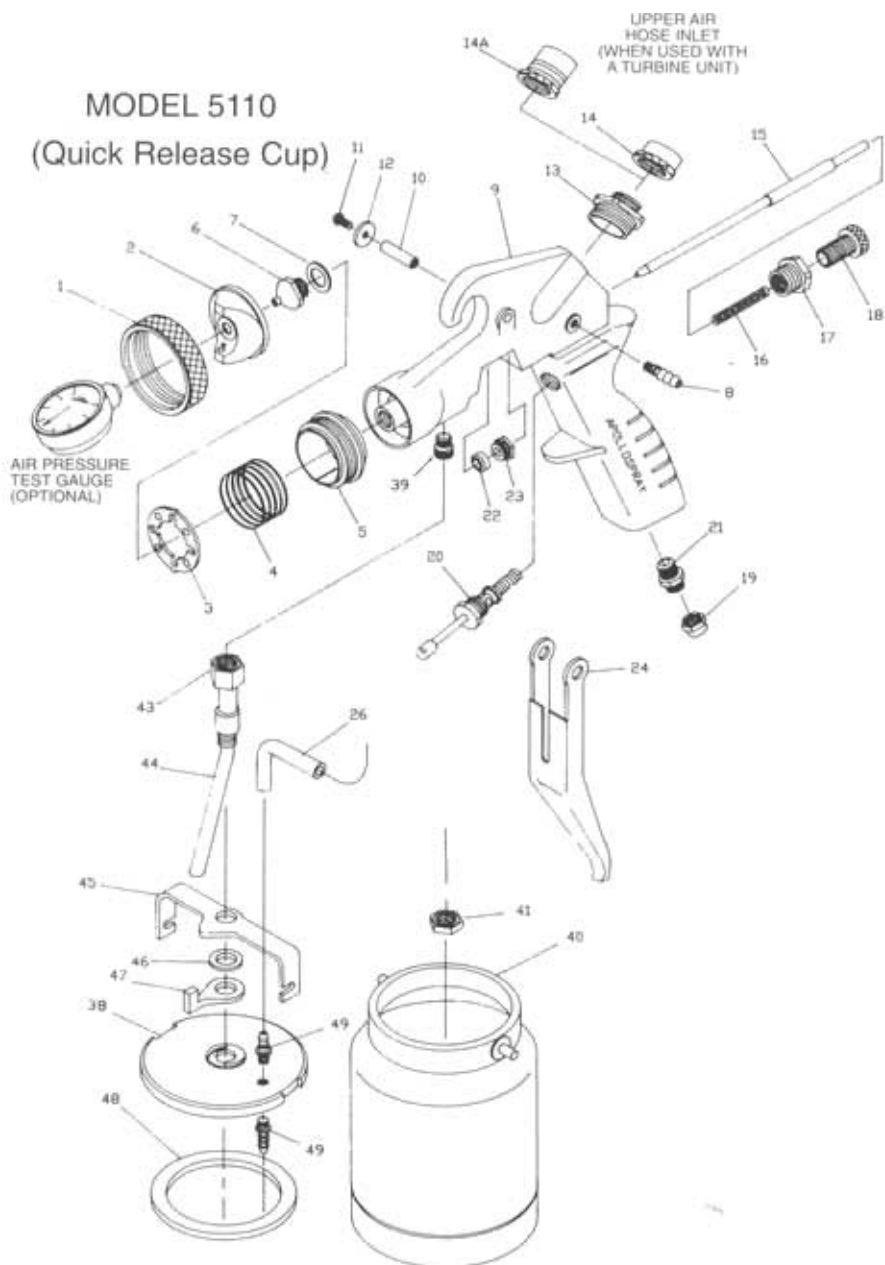


MODEL 5105
(Production Gun)



	PART #		PART #
1 Air cap ring	A.5200	30 Cup Top Disc (Stainless)	A.5236
2 Air cap #1	A.5201	31 Nut, Cup Top Bolt (Stainless)	A.5237
Air cap #2	A.5202	32 Cup Top Gasket (Ethafoam)	A.5238
3 Air distributor plate (Stainless)	A.5203	Cup Top Gasket (Cork)	A.5239
4 Air distributor spring (Stainless)	A.5204	Cup Top Gasket (Neoprene)	A.5240
5 Air distributor housing (brass)	A.5205	Cup Top Gasket (Leather)	A.5241
6 Fluid Nozzle/Jet (Stainless) .75 mm	A.5206	33 Material Pick-Up Tube (Stainless)	A.5242
Fluid Nozzle/Jet (Stainless) 1.0 mm	A.5207	34 Material Tube Nut	A.5243
Fluid Nozzle/Jet (Stainless) 1.5 mm	A.5208	35 Screw Paint Cup (Quart)	A.5244
Fluid Nozzle/Jet (Stainless) 2.5 mm	A.5209	Screw Paint Cup (Quart) Teflon Lined	A.5245
7 Fluid Nozzle Gasket	A.5210	36 Capillary Tube Nipple	A.5251
8 Air Feed Connector	A.5211	37 Fluid Nipple 1/4 NPT	A.5252
9 Gun Casting	A.5212	38 Cup Top O/R Gun	A.5270
10 Trigger Bushing	A.5213	39 Fluid Nipple 3/8 NPT	A.5254
11 Trigger Pivot Screw (Stainless)	A.5214	40 Cup	A.5277
12 Trigger Screw Washer	A.5215	41 Locking Nut	A.5272
13 Upper Port Insert	A.5216	42 Center Bolt	
14 Air Blanking Plug	A.5217	43 Pick-up Tube	
15 Needle (Stainless) .75 mm	A.5218	44 Yoke	A.5271
Needle (Stainless) 1.0 mm	A.5219	45 Gasket	A.5276
Needle (Stainless) 1.5 mm	A.5220	46 Lever	A.5278
Needle (Stainless) 2.5 mm	A.5221	47 Cup Top Gasket	A.5273
16 Needle Spring (Stainless)	A.5222	48 Air Nipples (Brass)	A.5211
17 Flow Screw Insert	A.5223	49 Air Nipples	A.5211
18 Material Flow Adjusting Screw	A.5224	14A Turbine Coupler	A.5277
19 Air Blanking Plug	A.5259		
20 Air Valve Assembly	A.5260		
21 Air Coupler 1/4 NPT Brass	A.5261		
22 Gland Seal	A.5228		
23 Gland Seal Nut	A.5229		
24 Trigger (Stainless)	A.5230		
25 Cup Top Bolt (Stainless)	A.5231		
26 Air Feed Tube and Valve	A.5232		
27 Cup Top Casting	A.5233		
28 Capillary Fixing Nut	A.5234		

MODEL 5110
(Quick Release Cup)



Apollo Sprayers International, Inc.

Limited Warranty

This Apollo Spray Gun is WARRANTED by APOLLO SPRAYERS INTERNATIONAL INC. for a total period of TWO YEARS, from the ORIGINAL date of purchase by the ORIGINAL PURCHASER. Proof of purchase to be included and all SHIPPING CHARGES to be pre-paid.

APOLLO SPRAYERS INC., upon examination of the spray gun will replace or repair at their discretion and defects in material or workmanship, includes labor.

This WARRANTY does NOT include: mis-use, damage, neglect, alterations or modifications, lack of maintenance, cleaning.

This WARRANTY is in lieu of all other express warranties, any WARRANTY implied by law, including but not limited to, implied Warranties of merchantability or fitness, is excluded to the maximum extent permitted by law and, if not excludable, is limited to the duration of the express Warranty. No representative or person is authorized to extend this Warranty or to create for APOLLO SPRAYERS INTERNATIONAL INC. any other liability in connection with the sale of any APOLLO SPRAYERS product. APOLLO SPRAYERS INTERNATIONAL INC. shall not be liable for any consequential, incidental or special damages of any kind directly or indirectly resulting from breach of any express or implied Warranty. Some States do allow the exclusion or limitation of incidental or consequential damages or limitations on the length of any Warranty so that the above limitations and exclusions may not apply to you; however, to the maximum extent permitted under applicable law, the only rights and remedies shall be to obtain a replacement for any defective product. This Warranty gives you specific legal rights and you may also have other rights which vary from State to State.

SERVICING AND PARTS

No matter how long you have owned your equipment, APOLLO SPRAYERS, INC. will guarantee to repair/service it. We carry in stock for immediate shipment a full inventory of parts, both for the turbine and the spray guns. If your turbine or spray gun requires repair send it to us U.P.S. insured, as soon as we receive it, we will estimate the cost of the repair including labor. All repairs are usually turned around and shipped back within 48 hours. If for any reason we cannot repair your spray gun or turbine unit due to non availability of parts we will REPLACE the item with a new one AT NO CHARGE . . . We still service machines manufactured in 1966!!

**MANUFACTURED & DESIGNED IN THE U.S. BY
APOLLO SPRAYERS INTERNATIONAL INC., VISTA, CA
PHONE: (619) 727-8300
FAX: (619) 727-9325
E MAIL: apollo@hvlp.com**

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