

Spare parts list for Low Pressure Spray Guns

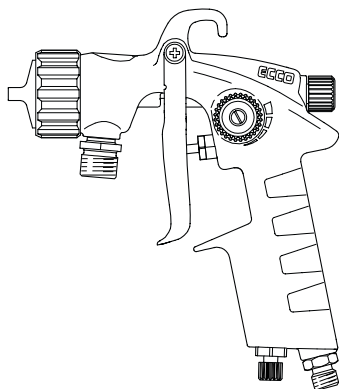
Ecco 35, -352

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ECCO FINISHING

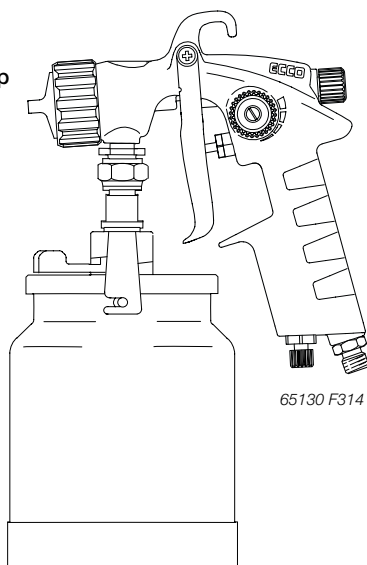
ESL 12/01-15

Ecco 35 Pressure feed



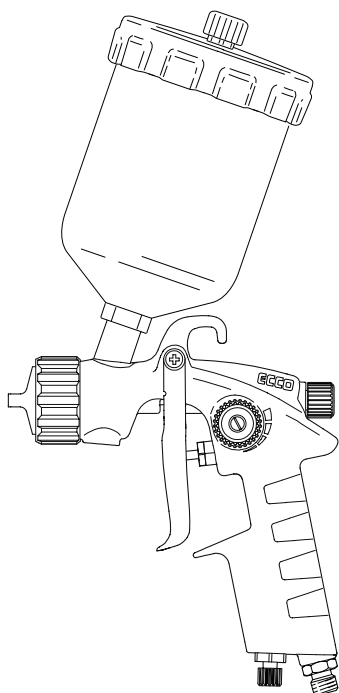
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Ecco 351 Suction feed with suction cup



65130 F314

Ecco 352 Gravity feed



65130 F295

Pressure feed guns

Type of gun	Paint nozzle Orifice diam., mm	Air cap	Prod. No. With paint needle of nylon	Prod. No. With paint needle of stainless steel
Ecco 35	1.1	T278		8611 3548 51
Ecco 35	1.1	T272	8611 3572 11	
Ecco 35	1.3	T272	8611 3572 13	8611 3548 53
Ecco 35	1.3	T274		8511 3548 54
Ecco 35	1.5	T272		8611 3548 55
Ecco 35	1.5	T274	8611 3572 15	
Ecco 35	1.8	T272	8611 3572 18	8611 3548 58
Ecco 35	2.1	T374	8611 3572 21	8611 3548 59
Ecco 35	2.7	T474	8611 3572 27	8611 3548 77

For further combinations, consult Ecco Finishing AB

Gravity feed guns with suction cup 1.0 lit.

Type of gun	Paint nozzle Orifice diam., mm	Air cap	Prod. No. With paint needle of stainless steel
Ecco 351	1.2	170	8611 3541 12
Ecco 351	1.5	273	8611 3541 15
Ecco 351	1.8	275	8611 3541 17
Ecco 351	1.8	271	8611 3541 18
Ecco 351	2.1	375	8611 3541 21
Ecco 351	2.7	475	8611 3541 27

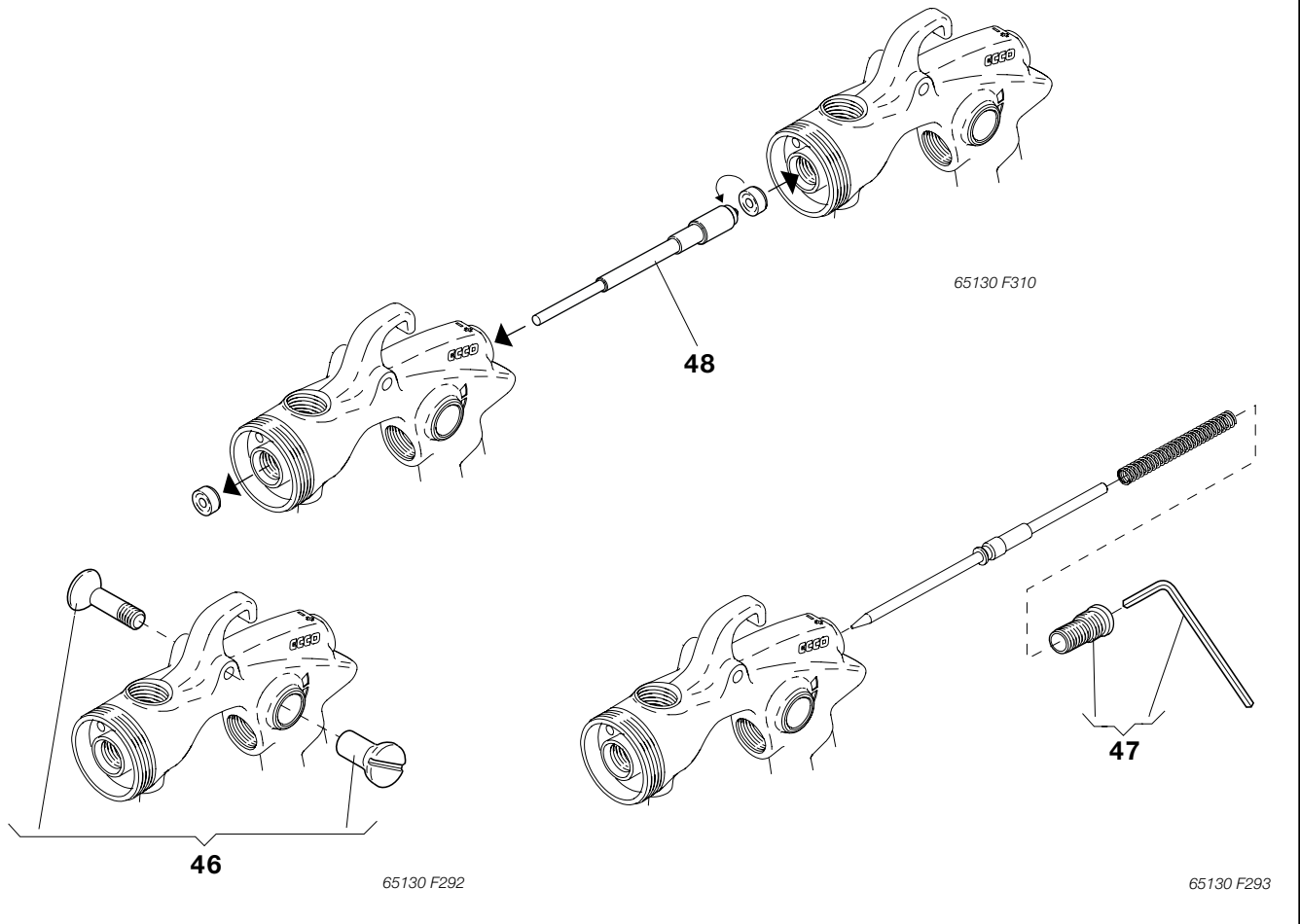
For further combinations, consult Ecco Finishing AB

Gravity feed guns with gravity cup 0.6 lit.

Type of gun	Paint nozzle Orifice diam., mm	Air cap	Prod. No. With paint needle of nylon	Prod. No. With paint needle of stainless steel
Ecco 352	1.2	170	8613 3573 12	8611 3546 12
Ecco 352	1.3	273	8611 3573 13	8611 3544 53
Ecco 352	1.3	3503		8611 3560 13
Ecco 352	1.5	275	8611 3573 15	
Ecco 352	1.5	270		8611 3546 15
Ecco 352	1.8	270		8611 3546 18
Ecco 352	1.8	271	8611 3544 48	
Ecco 352	1.8	275	8611 3573 18	8611 3544 55
Ecco 352	2.1	375	8611 3573 21	8611 3546 21
Ecco 352	2.7	475	8611 3573 27	8611 3546 27

For further combinations, consult Ecco Finishing AB

Optional Equipment



Part numbers in **bold** type designate consumption parts.

Service set 6003 9095 35 Consisting of parts with ref. Nos. 3, 4, 6, 8, 12, 15, 16, 21, 22, 23 and 36.

Ref. No.	Part number	Qty			Description	Ref. No.	Part number	Qty			Description
		-35	-351	-352				-35	-351	-352	
1	-	1	1	1	Body	34	6001 2619 00 ^b	1	1	1	Nipple (G 1/4)
2	6101 5730 35	1	1	1	Air valve, compl.	35	6003 9974 35	1	1	-	Plug (G 3/8)
3	6101 2111 00 ^a	1	1	1	- Spring	36	6101 5670 15^a	-	-	1	Packing (POM)
4	6101 5008 00 ^a	1	1	1	Air valve	37	6101 5560 86	-	-	1	Paint cup G6, compl. (0.6 lit.)
5	6101 3631 00	1	1	1	- Valve pin	38	6101 3742 00	-	-	1	Plug (M14 x 1)
6	6001 1008 35^a	1	1	1	- Packing (PE)	39	6003 9714 00	-	1	-	Suction cup SD15, volyme 1 l (see spare part list No. 9836 3175. ESL 12/04-20)
7	6003 2167 00	1	1	1	- Valve housing	40	6000 8004 00	1	1	1	Cleaning brush (ø10 mm)
8	6101 5716 00 ^a	1	1	1	- Bushing	41	6000 8001 00	1	1	1	Cleaning brush (ø17 mm)
9	6004 0276 07	1	1	1	Fan width control, compl.	Optional Equipment					
10	6101 3788 00	1	1	1	-Valve screw	-	6101 6065 35	1	1	1	Retaining ring, acetal plastic (for air cap)
11	6101 3790 00	1	1	1	-Valve pin	9	6004 0276 80	1	1	1	Fan width control for left handed
12	6101 3796 00 ^a	1	1	1	- O-ring	9	6004 0276 81	1	1	1	Quick fan width control
13	6101 3789 00	1	1	1	- Valve housing	23	6004 0276 90	1	1	1	Air distributor set (set of 10)
14	6004 0276 08	1	1	1	- Knob	33	6102 9314 46	1	-	-	Paint inlet nipple (G 1/4 SS)
15	0333 5109 00 ^a	1	1	1	- Lock washer (V 3.2)	33	6003 7393 00	1	-	-	Paint inlet nipple (9/16" 20G SS)
16	0164 5013 00 ^a	1	1	1	- Screw (MKFS 3 x 6 SS A2)	34	6000 1877 00	1	1	1	Air inlet nipple (G1/4" x 9/16 20G)
17	(see page 4)	1	1	1	Paint needle	42	6004 0065 35	1	1	1	Adapter (for paint cup 3M PPS)
18	6101 2582 35	1	1	1	Spring	43	6101 5626 14	1	1	1	Plug (G1/4, alt. for air limiter valve)
19	6004 0276 09	1	1	1	Knob	44	6003 9523 00	1	1	1	Cover Cap
20	6004 0276 10	1	1	1	Trigger	45	6003 7886 00	-	1	-	Strainer set, 80 mesh (set of 10)
21	6004 0276 13 ^a	1	1	1	Screw, compl.	46	6101 5247 80	1	1	1	Plug set, for gun is not fitted with fan width control
22	6004 0276 00^a	1	1	1	Needle seal	47	6004 0276 85	1	1	1	Back head, lockable fluid volyme control
23	6004 0276 02^a	1	1	1	Air distributor (set of 10 see optional equipment)	48	6004 0276 98	1	1	1	Needle seal tool
24	(see page 4)	1	1	1	Paint nozzle						
25	(see page 4)	1	1	1	Air cap						
26	6004 0276 03 ^c	1	1	1	Air limiter valve, compl.						
27	6004 0276 05 ^c	1	1	1	- Needle						
28	6101 2111 35	1	1	1	- Spring						
29	0301 2309 00	1	1	1	- Washer (BRB 3.2 x 7)						
30	0663 2104 41	1	1	1	- O-ring (3.0 x 2.0 NBR50)						
31	6004 0276 06 ^c	1	1	1	- Base						
32	6004 0276 04	1	1	1	- Knob						
33	6101 5021 00	1	1	-	Nipple (G 3/8 SS)						

^a Including in service set. ^b Loctite No. 225. ^c Loctite No. 243.

Nozzle combinations

Paint nozzle (a) (b)			Paint needle (a) (b)		Air cap (b) (c) (d)		
Orifice diam. mm	Designation	Part number	Designation	Part number	Designation	Part number	Air consumption l/min at 4 bar
0.8	0-7	6001 0241 00			170	6101 2588 00	215
0.8	B0-7	6001 0966 00	00435 P00435	6004 0276 30 6004 0276 20	270	6101 2589 00	285
					271	6101 5249 00	380
					273	6103 3159 00	370
					275	6101 2590 00	380
					T272	6101 2599 00	480
					T278	6101 5614 00	480
1.1	09-7	6001 1068 00			T272	6101 2599 00	480
					T272 ^a	6102 3992 00	480
					T278	6101 5614 00	480
					T278 ^a	6102 3991 00	480
1.2	1-7	6001 0276 00			170	6101 2588 00	215
	P1-7	6001 1476 00					
1.3	1.5-7 P1.5-7 H1.5-7	6001 0999 00 6001 1477 00 6001 1092 00			271	6101 5249 00	380
					273	6103 3159 00	370
					T272	6101 2599 00	480
					T272 ^a	6102 3992 00	480
					T274	6101 2602 00	480
					PT274	6101 5785 00	480
					T278	6101 5614 00	480
1.5	1.5	6103 1303 00	0435 P0435 H0435	6004 0276 26 6004 0276 16 6004 0276 45	270	6101 2589 00	285
					271	6101 5249 00	380
					273	6103 3159 00	370
					T272	6101 2599 00	480
1.8	2-7 P2-7 H2-7	6000 9140 00 6001 1478 00 6001 0768 00			M270	6101 3293 00	155
					270	6101 2589 00	285
					271	6101 5249 00	380
					273	6103 3159 00	370
					275	6101 2590 00	380
					T274	6101 2602 00	480
2.1	3-7 P3-7 H3-7	6000 9141 00 6001 1479 00 6000 9876 00			M370	6101 3294 00	265
					375	6101 2591 00	385
					T374	6101 2603 00	510
2.7	4-7 H4-7	6000 9142 00 6000 9877 00			M470	6101 3295 00	305
					475	6101 2592 00	385
					T474	6101 2604 00	510

^a The letter "H" before the designation denotes tungsten-carbide design.

^b The letter "P" before the designation denotes nylon design. The rear part of the nylon needle is made of steel.

^c Air caps for round spray with "M" in the designation should be used together with stop ring 6101 3298.

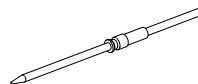
^d Air caps with a "T" in the designation are designed for pressure feed only. The other air caps are designed for suction feed but can also be used for pressure feed.

^e Acetal plastic retaining ring.

Nozzle sets

Stainless-steel versions

Consists of: Air cap of tufram-treated aluminium, paint nozzle and paint needle stainless steel.



Nozzle set Part number	Designation	Air cap Designation	Paint nozzle Designation	Orifice dia mm	Capacity ml/min	Paint needle Designation
6004 0282 11	T278-1.1	T278	09-7	1.1	150-225	00435
6004 0282 31	T374-1.1	T374	09-7	1.1	150-225	00435
6004 0282 73	T274-1.3	T274	1.5-7	1.3	200-350	0435
6004 0282 33	T374-1.3	T374	1.5-7	1.3	200-350	0435

Operator's Instructions

- Use Ecco genuine parts and accessories only for best function and safety.
- Before starting, read through **all instructions** carefully.

Principal data

Type	Max. working pressure bar	Paint cup volume l
Ecco		
35	7	-
351	7	1.0
352	7	0.6

Important



WARNING

Do not use halogenated hydrocarbons in coating application equipment where aluminium or galvanized parts come in contact with the solvent or coating material. Halogenated hydrocarbons e.g. 1,1,1-trichloroethane and methylene chloride react, violently with such parts, causing corrosion and danger for explosion.



WARNING

The high velocity flow of air and liquids through hoses and nozzles may develop static electricity. Be sure that the equipment, object being sprayed, spraybooth, paint and waste container are properly grounded to prevent static discharge or sparks.



WARNING

As the equipment works under pressure the utmost care must be observed during the work. Bearing this in mind, never aim the spray gun at a person or towards any part of the body. In the event of personal injury caused by the spraying pressure, immediate medical attention is essential. Before carrying out any adjustment or repair, the equipment must be switched off and the paint pressure relieved.

Paint spraying



CAUTION

Inhalation of paint, paint dust and solvent is not healthy. Make sure an approved spraybooth is used. The operator must use personal protection-breathing mask or fresh air hood.

Operation

- Install and operate the spray gun according to Fig. 1.
- Blow the paint and air hoses clean before connection.
- Check that all connections are tight (pay particular attention to the connection between paint cup and spray gun).
- Keep the spray gun clean and lubricate moving parts at regular intervals.
- Lubricants for surface-treatment equipment must not contain silicon.
- In the event of leakage around the paint needle, the needle seal (22 Fig. 2) shall be exchanged.
- For short standstill periods, for instance over a night, it will suffice to clean the air and paint nozzles on the outside. If a two-component paint is used, however, the gun **must be flushed through immediately** with solvent. This must also be done if the gun is to remain unused for a longer period of time.

- When cleaning the air cap and the paint nozzle, use a soft brush or rag dipped in solvent. Do not place the entire gun in solvent, as the oil on the lubricated parts would be dissolved. Blow the air cap dry with compressed air from both sides.
- Never use iron or steel wire to clean air holes and ducts in the nozzles.

How to operate

Recommended paint viscosity differs according to paint properties and painting conditions. 15 to 23 sec./Ford cup 4 is recommendable.

The gun is operated at low air pressure, high transfer efficiency will not be obtained if the spray distance is too far.

Set the spray distance from the gun to the work piece as near as possible within the range of 150-300 mm.

Air caps

The air caps are tested and certified according to the SEAVA method. This gives a "finger print" of the spray pattern on each air cap. For further information please contact your supplier.

The retaining ring for the air cap shall only be tightened with hand force. No tools are required. Especially important when a cap cleaner is used.

Air caps can be sent back for checking and comparison of the performance. For further information please contact your supplier.

Connections and controls (see Fig. 1)

- 11** Fan width adjusting. If the knob is screwed all the way in a round fan will be obtained other positions give broad fans.
- 21** Paint flow adjusting. Clockwise turning results in a smaller paint flow and counter-clockwise turning increases the flow. The fluid flow is regulated in the first instance by the choice of paint nozzle and paint pressure.
- 28** Adjusting valve for atomizing air flow.
- 35** Paint hose connection G 3/8.
Hose: Inside dia. 6.3 mm (1/4") or 9.5 mm (3/8").
- 36** Atomizing air hose connection G 1/4.
Hose: Inside dia. 6.3 mm (1/4").

Disassembly-Reassembly (see Fig. page 2)

(see also Fig. 2 page 6)



WARNING

Before any intervention on the spray gun, shut off and relieve the compressed air supply and paint pressure to the gun.

Before reassembling the different components:

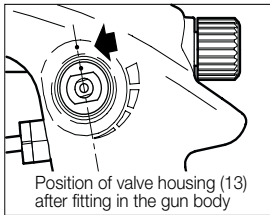
- Clean the parts with the appropriate cleaning agent by means of brush.
- Install new seals after having lubricated them with PTFE grease.
- Install new parts if necessary.

Needle packing and needle

1. Unscrew the control knob (19) and remove the spring (18).
2. Remove the paint needle (17).
3. Remove the air cap (25), and the paint nozzle (24).
4. Pry out the needle seal (22), use the needle seal tool (48).
Not! The needle seal can not be refitted.
5. Clean everything well with cleaning agent and then blow out with air.
6. Fit the new needle seal (22), use the needle seal tool (optional equipment 48).
The needle seal shall be pushed in until it reaches the bottom.
7. Re-fit the paint nozzle (24) (screwing torque 20 Nm) and the air cap (25) by hand.

Fan width control

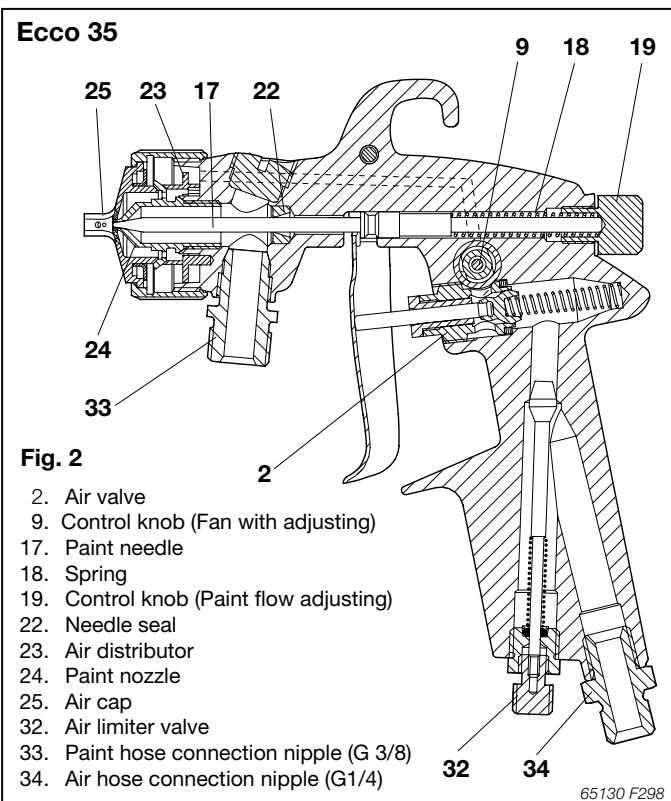
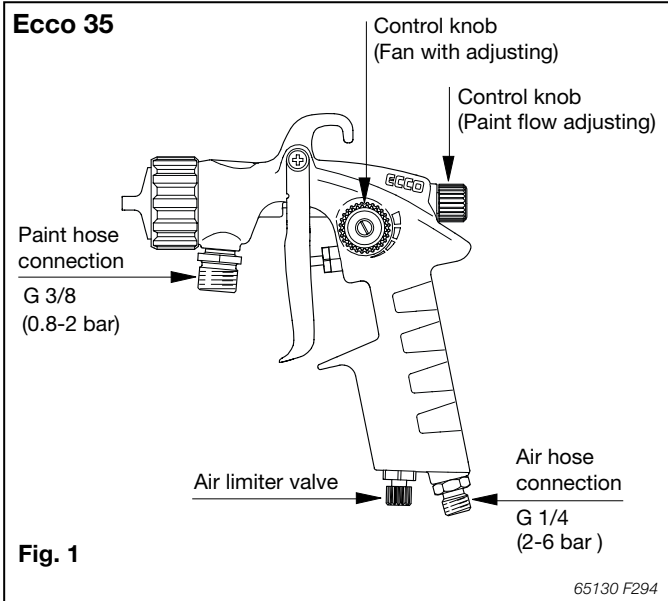
1. Dismantle first the the fan with control (9) then the air valve (2).
2. Assemble first the air valve (2) before assemble the fan with control (9).
3. Check when fitting the valve housing (13) that the marking on the body agrees with fig. below.



65130 F316

Air distributor

After dismantling the paint nozzle (24), shall the air distributor (23) **always** exchange.



Trouble shooting

Introduction

Always commence trouble shooting by checking the general condition of the spray gun. This can most easily be determined by test spraying, which provides an opportunity for checking the spray pattern and capacity, air leakage and gasket leakage.

Trouble shooting chart



Correct Spray Pattern

Types of problems

Collection of information which makes it possible to identify the error symptoms applicable to the spray gun in the event of malfunctioning is a matter of vital importance. Identification of symptoms makes it possible to decide whether the spray gun itself is the direct cause of the malfunctioning or if this may have been caused by an external factor.

The following external factors can cause malfunctioning and should be thoroughly checked:

1. The quality of the air, i.e. content of moisture, dirt particles and oil.
2. The quality of the paint, i.e. its viscosity, purity, etc.
3. The air and paint pressure in relation to viscosity of the paint and nozzle combination used.
4. The size of the air/paint hoses.

Spray Pattern	Cause	Remedy
<p>Asymmetrical to the left or to the right</p>	a) Dried paint on holes for atomizing air. b) Damage to holes for atomizing air. c) Air cap not sufficiently tightened.	a) Dried paint on holes for atomizing air. Clean the air holes, use appropriate cleaning agent and a soft brush. b) Damage to holes for atomizing air. Replace the air cap with a new one. c) Air cap not sufficiently tightened. Tighten the air cap properly by hand.
<p>Distorted in the middle</p>	a) Damage to the tip of the paint nozzle. b) The pressure of the atomizing air in relation to the viscosity of the paint.	a) Fit a new paint nozzle. b) Adjust the air pressure of the atomizing air.
<p>Narrowing off in the middle</p>	a) Wrong nozzle combination. b) Fan air pressure too high. c) Paint viscosity unsuitable. d) Incorrect spray angle.	a) Select a new nozzle combination suitable for the viscosity of paint. b) Reduce the pressure of the fan air. c) Adjust the viscosity of the paint. d) Adjust the angle with the fan width control.
<p>Irregular spray (spitting)</p>	a) Paint needle gasket leaky. b) Paint nozzle not tightened. c) Dirt on sealing surfaces of paint nozzle and distributor ring. d) Paint hose connection not tightened. e) Paint hose defective.	a) Adjust the packing screws. If this does not suffice, change the paint needle gaskets. b) Tighten the paint nozzle. c) Clean the sealing surfaces of the paint nozzle and distributor ring with solvent and blow clean. d) Tighten the paint hose connection. e) Change the paint hose.
<p>Kontrol knob in position round spray</p> <p>Incorrect spray pattern</p>	a) damaged the air distributor	a) Change the air distributor

Paint leaking - Air leaking	Cause	Remedy
Paint leaking	Worn needle packing and/or needle.	Replace damaged parts with new ones.
Paint leaking through the paint nozzle when the gun is closed.	Pollution between the needle and the nozzle or needle and nozzle worn or damaged.	Unscrew air cap (25) and nozzle (24). Clean carefully and check for any sign of damages or wear.



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