

# Airlessco Mastic Gun

3A0413B  
EN

***For professional use only.  
For the application of architectural paints and coatings.***

*4000 psi (27.6 MPa, 276 bar) Maximum Working Pressure*



## Important Safety Instructions

Read all warnings and instructions in this manual and in related manuals. Be familiar with the controls and the proper usage of the equipment. Save these instructions.

**Model: 24E365 600 Series Mastic Gun**

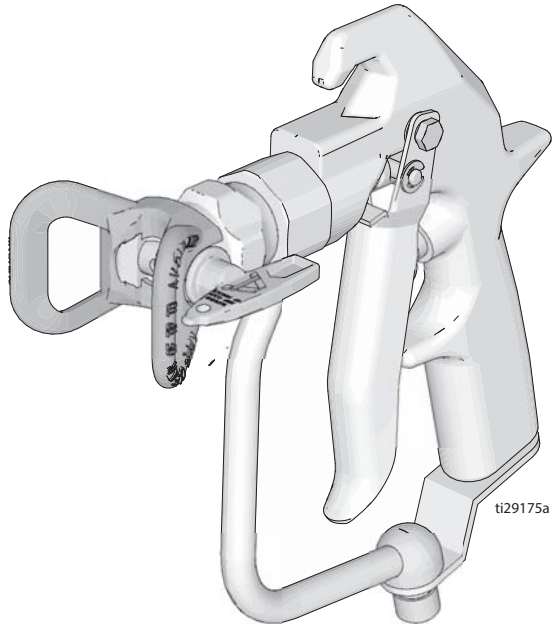
Includes ARV521 and ARV635 Rev-Tip

**Model: 24E382 500 Series Mastic Gun**

Includes ARV631 Rev-Tip

**Model: 24E470 Mastic Gun**

Gun Only (No tip included)



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## Warnings

The following warnings are for the setup, use, grounding, maintenance, and repair of this equipment. The exclamation point symbol alerts you to a general warning and the hazard symbols refer to procedure-specific risks. When these symbols appear in the body of this manual or on warning labels, refer back to these Warnings. Product-specific hazard symbols and warnings not covered in this section may appear throughout the body of this manual where applicable.

### **WARNING**



#### **FIRE AND EXPLOSION HAZARD**

Flammable fumes, such as solvent and paint fumes, in **work area** can ignite or explode. Paint or solvent flowing through the equipment can cause static sparking. To help prevent fire and explosion:

- Use equipment only in well ventilated area.
- Eliminate all ignition sources; such as pilot lights, cigarettes, portable electric lamps, and plastic drop cloths (potential static arc).
- Ground all equipment in the work area. See **Grounding** instructions.
- Never spray or flush solvent at high pressure.
- Keep work area free of debris, including solvent, rags and gasoline.
- Do not plug or unplug power cords, or turn power or light switches on or off when flammable fumes are present.
- Use only grounded hoses.
- Hold gun firmly to side of grounded pail when triggering into pail. Do not use pail liners unless they are antistatic or conductive.
- **Stop operation immediately** if static sparking occurs or you feel a shock. Do not use equipment until you identify and correct the problem.
- Keep a working fire extinguisher in the work area.

## **WARNING**



### **SKIN INJECTION HAZARD**

High-pressure spray is able to inject toxins into the body and cause serious bodily injury. In the event that injection occurs, **get immediate surgical treatment**.



- Do not aim the gun at, or spray any person or animal.
- Keep hands and other body parts away from the discharge. For example, do not try to stop leaks with any part of the body.
- Always use the nozzle tip guard. Do not spray without nozzle tip guard in place.
- Use Airlessco nozzle tips.
- Use caution when cleaning and changing nozzle tips. In the case where the nozzle tip clogs while spraying, follow the **Pressure Relief Procedure** for turning off the unit and relieving the pressure before removing the nozzle tip to clean.
- Equipment maintains pressure after power is shut off. Do not leave the equipment energized or under pressure while unattended. Follow the **Pressure Relief Procedure** when the equipment is unattended or not in use, and before servicing, cleaning, or removing parts.
- Check hoses and parts for signs of damage. Replace any damaged hoses or parts.
- This system is capable of producing 4000 psi. Use Airlessco replacement parts or accessories that are rated a minimum of 4000 psi.
- Always engage the trigger lock when not spraying. Verify the trigger lock is functioning properly.
- Verify that all connections are secure before operating the unit.
- Know how to stop the unit and bleed pressure quickly. Be thoroughly familiar with the controls.

## **WARNING**



### **EQUIPMENT MISUSE HAZARD**

Misuse can cause death or serious injury.



- Always wear appropriate gloves, eye protection, and a respirator or mask when painting.
- Do not operate or spray near children. Keep children away from equipment at all times.
- Do not overreach or stand on an unstable support. Keep effective footing and balance at all times.
- Stay alert and watch what you are doing.
- Do not operate the unit when fatigued or under the influence of drugs or alcohol.
- Do not kink or over-bend the hose.
- Do not expose the hose to temperatures or to pressures in excess of those specified by Airlessco.
- Do not use the hose as strength member to pull or lift the equipment.
- Do not spray with a hose shorter than 25 feet.
- Do not alter or modify equipment. Alterations or modifications may void agency approvals and create safety hazards.
- Make sure all equipment is rated and approved for the environment in which you are using it.



### **TOXIC FLUID OR FUMES HAZARD**

Toxic fluids or fumes can cause serious injury or death if splashed in the eyes or on skin, inhaled, or swallowed.

- Read Safety Data Sheet (SDS) to know the specific hazards of the fluids you are using.
- Store hazardous fluid in approved containers, and dispose of it according to applicable guidelines.



### **RECOIL HAZARD**

Gun may recoil when triggered. If you are not standing securely, you could fall and be seriously injured.



### **PERSONAL PROTECTIVE EQUIPMENT**

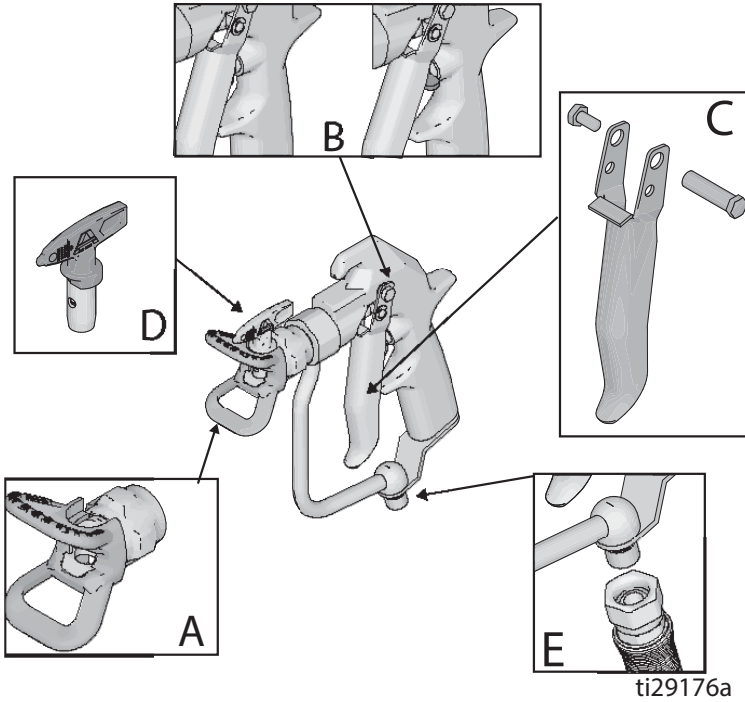
Wear appropriate protective equipment when in the work area to help prevent serious injury, including eye injury, hearing loss, inhalation of toxic fumes, and burns. Protective equipment includes but is not limited to:

- Protective eyewear, and hearing protection.
- Respirators, protective clothing, and gloves as recommended by the fluid and solvent manufacturer.

## Models

Type, Model No., Series	MWP	Trigger	GUARD	Tip
<b>Mastic, 24E382, 500 Series</b>	4000 psi (276 bar, 27.6 MPa)	4-finger trigger	855052	ARV631 Rev-Tip
<b>Mastic, 24E365, 600 Series</b>	4000 psi (276 bar, 27.6 MPa)	4-finger trigger	855052	ARV521 and ARV635 Rev-Tip
<b>Mastic, 24E470</b>	4000 psi (276 bar, 27.6 MPa)	4-finger trigger	855052	No Spray Tip. Order Separately.

## Component Identification



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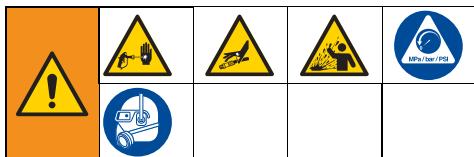
A	Tip guard
B	Trigger lock
C	Trigger
D	Tip
E	Fluid inlet

## Operation

### Pressure Relief Procedure

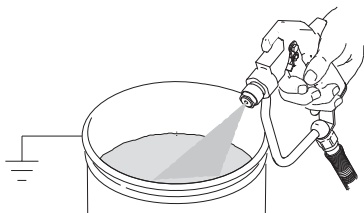


Follow the **Pressure Relief Procedure** whenever you see this symbol.



This equipment stays pressurized until pressure is manually relieved. To help prevent serious injury from pressurized fluid, such as skin injection or splashed fluid, follow the **Pressure Relief Procedure** whenever sprayer is stopped and before sprayer is cleaned or checked, and before equipment is serviced.

1. Turn sprayer **OFF**.
2. Engage the trigger lock. Always engage the trigger lock when sprayer is stopped to prevent the gun from being triggered accidentally.
3. Turn pressure control knob to lowest setting.
4. Put drain tube into a waste pail and turn Prime/Spray valve in PRIME position (drain) to relieve pressure.
5. Hold the gun firmly to a pail. Point gun into pail. Disengage the trigger lock and trigger the gun to relieve pressure.

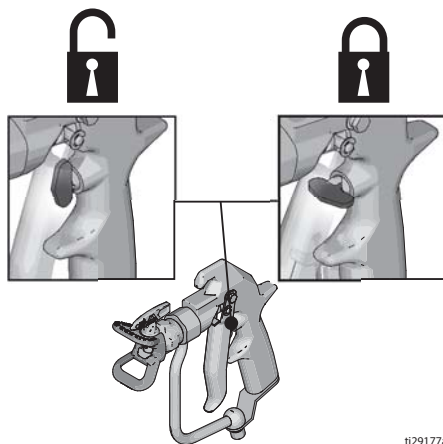


6. Engage the trigger lock.
7. If you suspect the spray tip or hose is clogged or that pressure has not been fully relieved:
  - a. **VERY SLOWLY** loosen the tip guard retaining nut or the hose end coupling to relieve pressure gradually.
  - b. Loosen the nut or coupling completely.
  - c. Clear the obstruction in the hose or tip.

### Gun Trigger Lock



To prevent injury when the gun is not in use, always engage the gun's trigger lock if unit is being shut down or left unattended.



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## Connect Gun to Sprayer

Make sure sprayer is turned off and unplugged from power source. Refer to your sprayer instruction manual for priming and spray instructions.

1. Attach supply hose to sprayer fluid outlet.
2. Attach other end of supply hose to gun inlet. Use two wrenches to tighten all connections securely.
3. Refer to sprayer instruction manual for priming instructions.

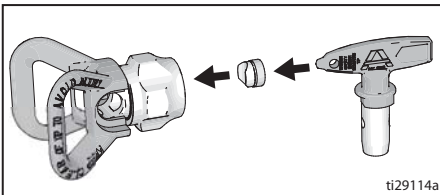
## Installing Tip and Tip Guard on Gun



To avoid serious injury from skin injection, do not place your hand in front of the spray tip when installing or removing the spray tip.

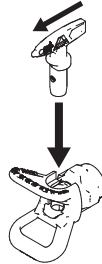
Make certain spray tip and guard are installed properly.

1. Perform **Pressure Relief Procedure**, page 8.
2. Engage trigger lock.
3. Verify spray tip and tip guard parts are assembled in the order shown.
  - a. Use spray tip to align gasket and seal in the tip guard.



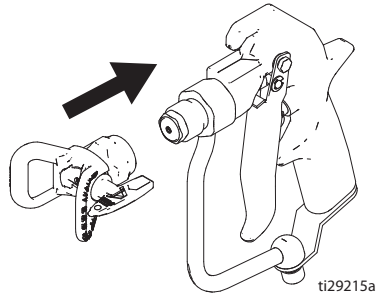
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- b. Spray tip must be pushed all the way into the tip guard. Turn spray tip to push down.



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- c. Turn the arrow shaped handle on the spray tip forward to the spray position.
4. Screw spray tip and tip guard assembly on to the gun and tighten.



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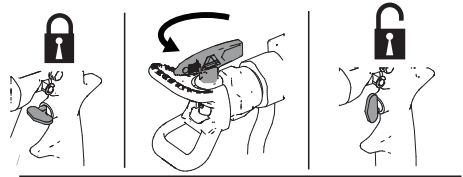
# Operation

## Spraying

1. Unlock trigger lock.
2. Be sure the arrow shaped tip faces forward (spray).
3. Hold gun perpendicular and approximately 12-inches (30 cm) from surface. Move gun first, then pull gun trigger to spray a test pattern.
4. Slowly increase pump pressure until coverage is uniform and even (see sprayer instruction manual for additional information).

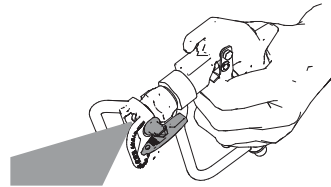
**NOTE:** If spray tip is difficult to rotate when turning to the unclog position, perform **Pressure Relief Procedure**, page 8, then turn Prime/Spray valve to spray position and repeat step 1.

2. Engage trigger lock. Rotate spray tip back to spray position. Disengage trigger lock and continue spraying.



## Aligning Spray

1. Perform **Pressure Relief Procedure**, page 8.
2. Loosen tip guard retaining nut.
3. Align tip guard horizontally to spray a horizontal pattern.
4. Align tip guard vertically to spray a vertical pattern.

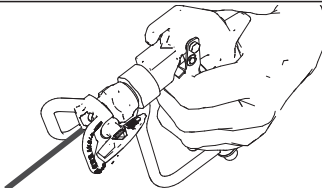
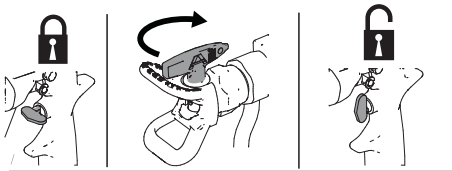


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## Clear Tip Clog

In the event that particles or debris clog the spray tip, this sprayer is designed with a reversible spray tip that quickly and easily clears the particles without disassembling the sprayer.

1. Engage trigger lock. Rotate spray tip to unclog position. Disengage trigger lock. Trigger gun at waste area to clear clog.



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## Cleanup

Flush gun after each work shift and store in a dry location. Do not leave the gun or any parts in water or cleaning solvents.

## Maintenance

To avoid personal injury, always read all warnings in this manual, and the equipment manual, before performing any maintenance on the gun.				

## Repair

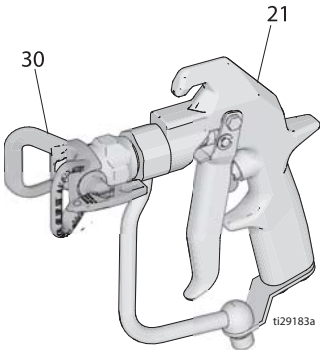


To avoid personal injury, always read all warnings in this manual, and the equipment manual, before performing any repairs on the gun.

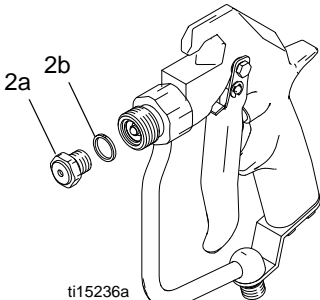
## Disassemble

**NOTE:** If replacing only the needle and seat, steps 4 and 5 are not required. However, removing them allows you to clean the gun more thoroughly.

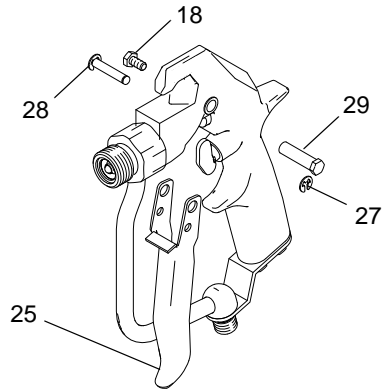
1. **Relieve Pressure**, page 8.
2. Disconnect fluid hose (A). Remove tip guard (30). Unscrew spring screw (21) about 1/4 in. (7 mm) to release spring tension.



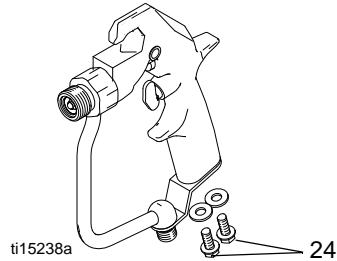
3. Unscrew valve seat (2a). Remove gasket (2b).



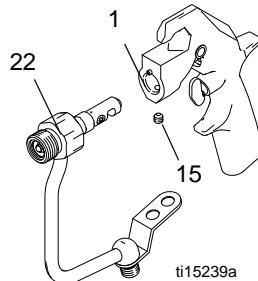
4. Remove one e-clip (27). Push out pin (18). Remove screw (29), pivot pin (28), and trigger (25).



5. Remove screws (24).

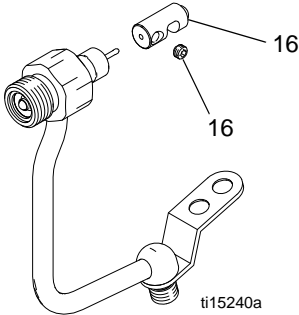


6. Loosen setscrews (15). Pull fluid housing (22) away from gun body (1).

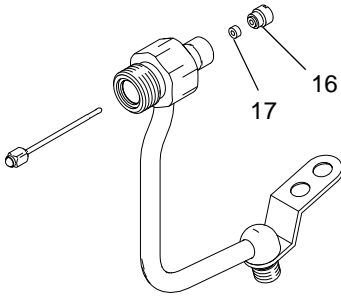


# Repair

7. While supporting spring guide (16) to prevent bending needle, loosen setscrews (17). Remove spring guide (16).



8. Remove needle (2c). Unscrew seal retainer (2d). Remove seal (2e).

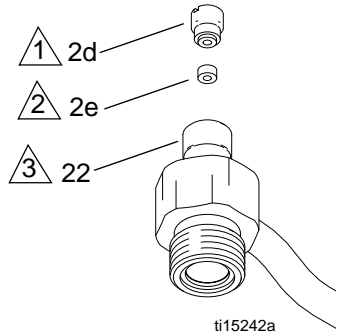


## Cleaning

Clean all parts and cavities thoroughly with a compatible solvent. Dry with a rag or compressed air. Replace any parts that are worn or damaged.

## Reassemble

1. Lightly grease inner cavities of fluid housing (22). Install small seal (2e) so lips face into fluid housing cavity. Install seal retainer (2d) and torque to 30-40 in-lb (3.4-4.5 N•m).

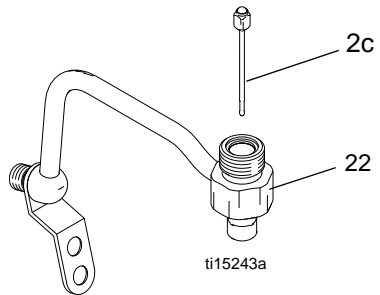


1 Torque to 20-30 in-lb (3.4-4.5 N•m)

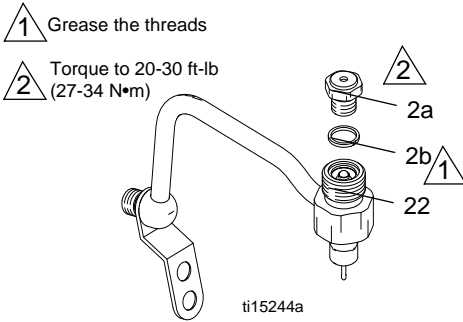
2 Lips of seal must face into housing

3 Grease inner cavity of housing

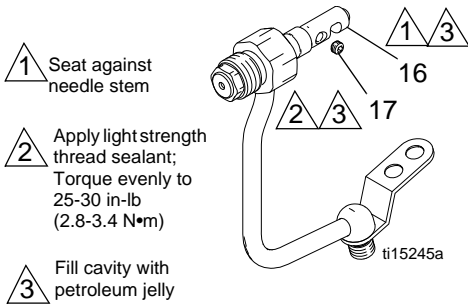
2. Lightly grease small end of needle (2c). Guide (2c) into large end of fluid housing (22).



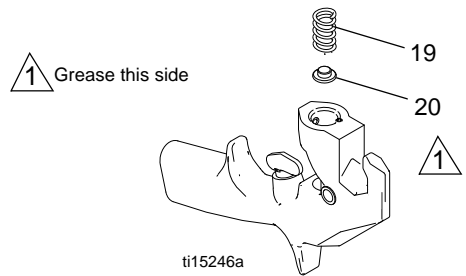
- Place gasket (2b) on valve seat (2a). Screw valve seat into fluid housing (22). Torque to 20-25 ft-lb (27-34 N•m).



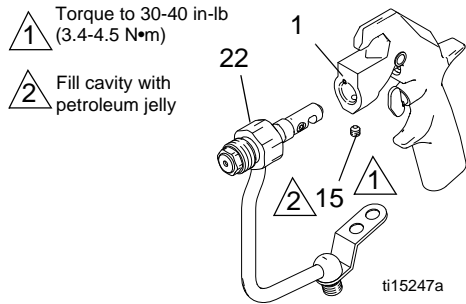
- Install spring guide (16) and seat it against needle. Loosely thread both setscrews (17) into spring guide, then alternately and evenly tighten setscrews to 10-15 in-lb (1.1-1.6 N•m). Fill setscrew cavities with petroleum jelly.



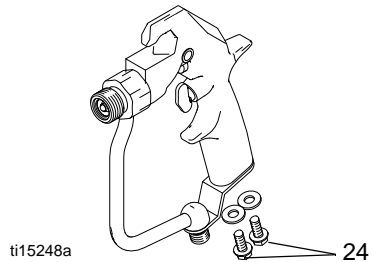
- If spring (19) was removed, grease spring adjuster (20) and replace spring. Drop the assembly into gun body (1).



- Push fluid housing (22) onto gun body (1) until fully seated. Tighten setscrew (15) to 30-40 in-lb (3.4-4.5 N•m). Fill setscrew cavity with petroleum jelly.

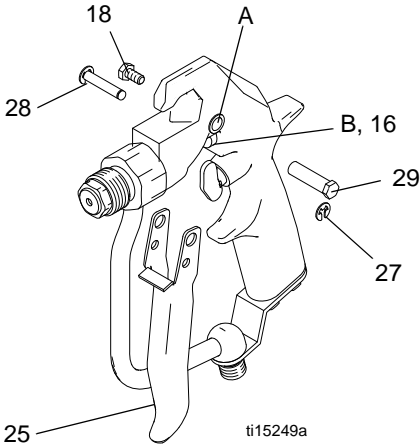


- Install screws (24).




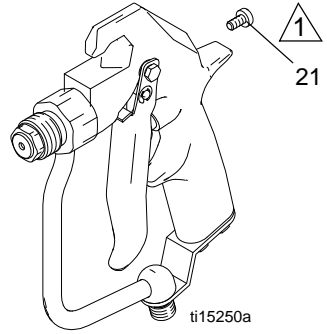
# Repair

- Position trigger (25) on gun body. Insert pivot pin (28) into top hole (A) and secure with screw (29) on other side. Place an e-clip (27) on one end of trigger pin (18). Slide pin through lower trigger holes and through slot (B) in spring guide (16). Turn spring guide to align as needed. Install other e-clip (27).



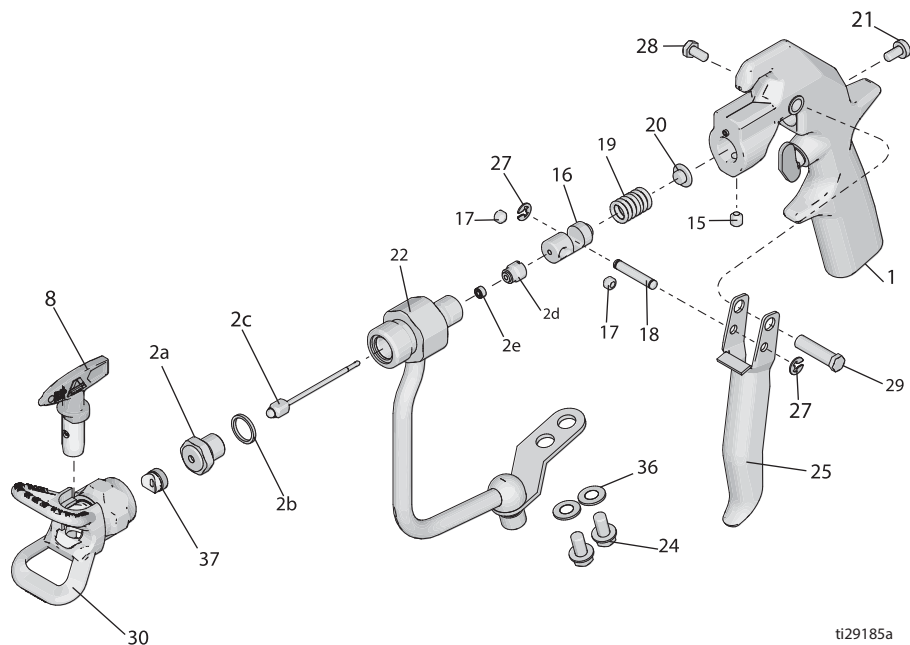
- If spring tension screw (21) was removed, install it at rear of gun. Thread screw in until it stops.

 Turn in until screw stops



## Parts

### 24E365, 24E382, 24E470 Texture Airless Spray Gun



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Ref. Part	Description	Qty.	Ref. Part	Description	Qty.
1	24E455 KIT, gun replacement handle	1	18	189958 TRIGGER PIN	1
2	237260 NEEDLE and SEAT KIT (parts not sold separately)	1	19	102924 SPRING	1
2a	VALVE SEAT	1	20	189990 SPRING ADJUSTER	1
2b	GASKET	1	21	110637 ADJUSTING SCREW	1
2c	NEEDLE	1	22	237694 FLUID HOUSING	1
2d	SEAL RETAINER	1	24	112774 SCREW, 1/4-20	2
2e	SEAL	1	25	189974 GUN TRIGGER	1
8	ARV521REV-TIP (Model 24E365)	1	27	112410 E-CLIP	2
	ARV635REV-TIP (Model 24E365)	1	28	187965 PIVOT PIN	1
	ARV631REV-TIP (Model 24E382)	1	29	203953 SCREW, hex washer hd, 10-24	1
15	102207 SET SCREW, 1/4-20	1	30	855052 KIT, tip guard	1
16	189960 SPRING GUIDE	1	36	110755 WASHER, flat	2
17	112729 SET SCREW, soc hd	2	37	858029 SEAL, metal with o-ring (Rev-tip)	1

▲ Replacement Danger and Warning labels, tags and cards are available at no cost.

# Technical Data

## Technical Data

	US	Metric
<b>Dimensions</b>		
Weight (includes tip and tip guard):	25.7 oz.	720 g
Height:	8.0 in.	203 mm
Length (handle extended):	8.25 in.	210 mm
<b>Sprayer</b>		
Maximum Working Pressure	4000 psi	276 bar, 27.6 MPa
Fluid Orifice Size	0.125 in.	3.2 mm
Inlet Size	1/4 npt (m)	
Fluid tube inside diameter	0.245 in/	6.2 mm
Wetted parts	Tungsten carbide, 17-4PH passivated stainless steel, polypropylene, polyethylene	
<b>Noise Level</b>		
Sound Power	93 dBa	
Sound Pressure	84 dBa	







## Airlessco Standard Warranty

Airlessco warrants all equipment referenced in this document which is manufactured by Airlessco and bearing its name to be free from defects in material and workmanship on the date of sale to the original purchaser for use. With the exception of any special, extended, or limited warranty published by Airlessco, Airlessco will, for a period of twelve months from the date of sale, repair or replace any part of the equipment determined by Airlessco to be defective. This warranty applies only when the equipment is installed, operated and maintained in accordance with Airlessco's written recommendations.

This warranty does not cover, and Airlessco shall not be liable for general wear and tear, or any malfunction, damage or wear caused by faulty installation, misapplication, abrasion, corrosion, inadequate or improper maintenance, negligence, accident, tampering, or substitution of non-Airlessco component parts. Nor shall Airlessco be liable for malfunction, damage or wear caused by the incompatibility of Airlessco equipment with structures, accessories, equipment or materials not supplied by Airlessco, or the improper design, manufacture, installation, operation or maintenance of structures, accessories, equipment or materials not supplied by Airlessco.

This warranty is conditioned upon the prepaid return of the equipment claimed to be defective to an authorized Airlessco distributor for verification of the claimed defect. If the claimed defect is verified, Airlessco will repair or replace free of charge any defective parts. The equipment will be returned to the original purchaser transportation prepaid. If inspection of the equipment does not disclose any defect in material or workmanship, repairs will be made at a reasonable charge, which charges may include the costs of parts, labor, and transportation.

**THIS WARRANTY IS EXCLUSIVE, AND IS IN LIEU OF ANY OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING BUT NOT LIMITED TO WARRANTY OF MERCHANTABILITY OR WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE.**

Airlessco's sole obligation and buyer's sole remedy for any breach of warranty shall be as set forth above. The buyer agrees that no other remedy (including, but not limited to, incidental or consequential damages for lost profits, lost sales, injury to person or property, or any other incidental or consequential loss) shall be available. Any action for breach of warranty must be brought within two (2) years of the date of sale.

**AIRLESSCO MAKES NO WARRANTY, AND DISCLAIMS ALL IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, IN CONNECTION WITH ACCESSORIES, EQUIPMENT, MATERIALS OR COMPONENTS SOLD BUT NOT MANUFACTURED BY Airlessco.** These items sold, but not manufactured by Airlessco (such as electric motors, switches, hose, etc.), are subject to the warranty, if any, of their manufacturer. Airlessco will provide purchaser with reasonable assistance in making any claim for breach of these warranties.

In no event will Airlessco be liable for indirect, incidental, special or consequential damages resulting from Airlessco supplying equipment hereunder, or the furnishing, performance, or use of any products or other goods sold hereto, whether due to a breach of contract, breach of warranty, the negligence of Airlessco, or otherwise.

### **FOR AIRLESSCO CANADA CUSTOMERS**

The Parties acknowledge that they have required that the present document, as well as all documents, notices and legal proceedings entered into, given or instituted pursuant hereto or relating directly or indirectly hereto, be drawn up in English. Les parties reconnaissent avoir convenu que la rédaction du présente document sera en Anglais, ainsi que tous documents, avis et procédures judiciaires exécutés, donnés ou intentés, à la suite de ou en rapport, directement ou indirectement, avec les procédures concernées.

# Airlessco Information

For the latest information about AIRLESSCO products, visit [www.airlessco.com](http://www.airlessco.com).

For patent information, see [www.graco.com/patents](http://www.graco.com/patents).

***TO PLACE AN ORDER OR FOR SERVICE***, contact your Airlessco distributor,  
or call 1-800-223-8213 to identify the nearest distributor.

*All written and visual data contained in this document reflects the latest product information available at the time of publication.*

*Airlessco reserves the right to make changes at any time without notice.*

Original Instructions. This manual contains English. MM 3A0413

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