

## 24N319 Round Spray Kit

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EN

To convert a Pro Xp™  
Electrostatic Air-Assisted Spray Gun to a round spray pattern. For professional use only.



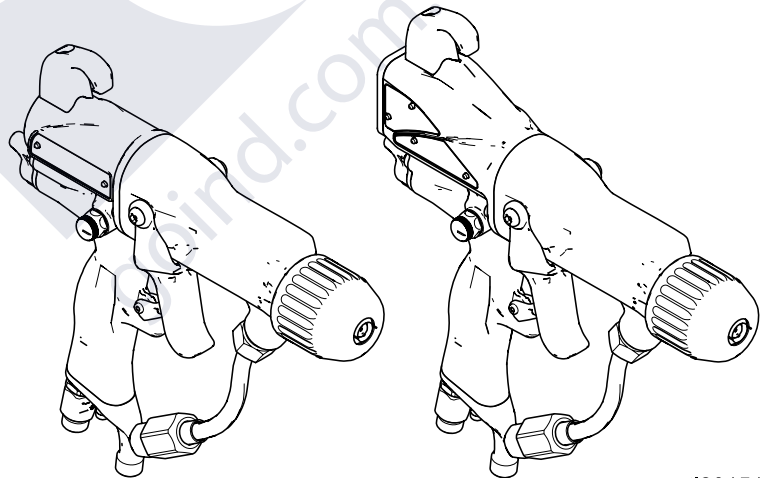
### Important Safety Instructions

Read all warnings and instructions in this manual and in your Pro Xp  
Electrostatic Air-Assisted Spray Gun manual. **Save these instructions.**

3000 psi (21 MPa, 210 bar) Maximum  
Fluid Working Pressure

100 psi (0.7 MPa, 7.0 bar) Maximum  
Air Working Pressure

See page 4 for part numbers. Gun is  
not included.

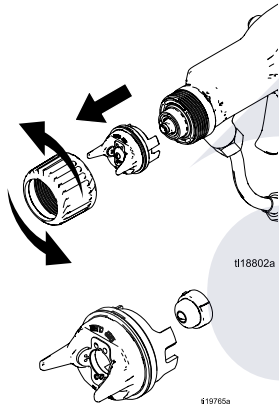


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# Installation

				
<p>To reduce the risk of injury, follow the <b>Pressure Relief Procedure</b> in your Pro Xp manual before installing this kit.</p>				

1. Relieve the pressure.
2. Remove the retaining ring, air cap/tip guard, and spray tip.

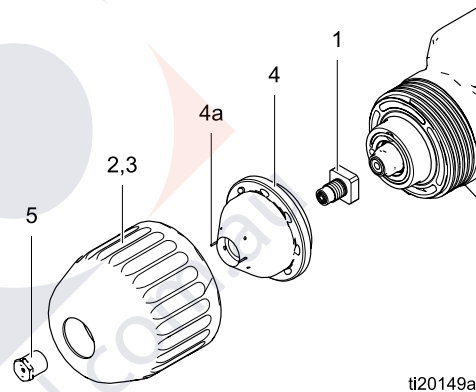


3. Flush the gun as instructed in your gun manual. Relieve the pressure.

<b>NOTICE</b>
<p>Do not operate the gun with a damaged electrode (4a). Make sure the electrode is in place before installing the air cap/electrode assembly (4).</p>

**NOTE:** The kit includes a large retainer (2) for a larger pattern, and a small retainer (3) for a smaller pattern.

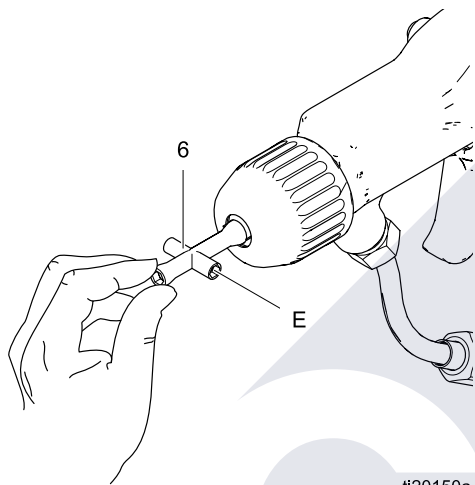
4. Check that the electrode (4a) is in place in the air cap. The two ends of the electrode should be inserted in the two holes on the back of the air cap, and should protrude through the front of the air cap. Install the diffuser/seal assembly (1), air cap/electrode assembly (4), and desired retainer (2 or 3) onto the gun. Tighten the retainer firmly.



**NOTICE**

Overtightening the spray tip (5) can damage the tip and cause poor spray performance.

5. Install the spray tip (5) and tighten using the wrench (6). When tightening, only grip the end of the wrench with your fingers. Do not grip the wrench cross-arms (E).



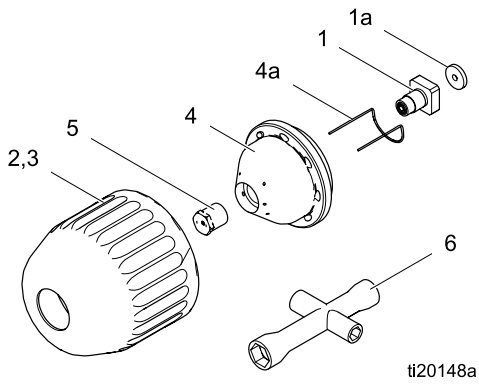
6. Adjust the spray pattern as explained in the Gun Setup Checklist of your Pro Xp gun manual.

**NOTE:** The recommended spraying distance from the front of the gun to the object being sprayed is 8–12 in. (203–305 mm). Round spray tips emit a soft pattern. If the gun is too far from the object, the floating charged particles may be attracted to the gun or operator instead of to the grounded object.

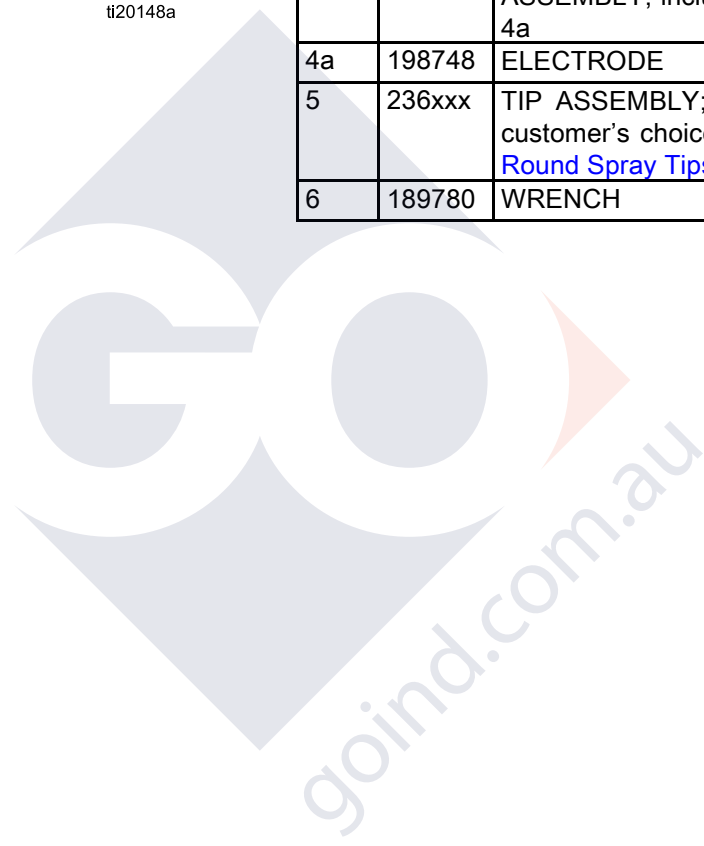
**NOTE:** See [Round Spray Tips, page 5](#), for fluid flow information. See [Spray Pattern Troubleshooting, page 5](#), to correct spray pattern problems.

**NOTE:** If the spray tip clogs, stop spraying immediately and relieve pressure. Clean the tip as explained in your Pro Xp gun manual. To help reduce spray tip clogging, clean or replace the fluid filter supplied with the gun.

# Parts



Ref. No.	Part No.	Description	Qty
1	236768	DIFFUSER/SEAL ASSEMBLY; includes item 1a	1
1a	183459	SEAL; UHMWPE	1
2	24R776	RETAINER, large (shown)	1
3	24R775	RETAINER, small (not shown)	1
4	245294	AIR CAP/ELECTRODE ASSEMBLY; includes item 4a	1
4a	198748	ELECTRODE	1
5	236xxx	TIP ASSEMBLY; customer's choice; see <a href="#">Round Spray Tips, page 5</a>	1
6	189780	WRENCH	1



## Round Spray Tips

Part No.	Size No.	Approximate Flow Rates for Light to Medium Viscosity Coatings (20–40 centipoise)*		
		300 psi (2.1 MPa, 21 bar)	600 psi (4.2 MPa, 42 bar)	1200 psi (8.4 MPa, 84 bar)
236836	4A	2.5 oz/min (73 cc/min)	4.1 oz/min (120 cc/min)	5.7 oz/min (170 cc/min)
236837	6A	2.9 oz/min (86 cc/min)	5.1 oz/min (150 cc/min)	7.4 oz/min (220 cc/min)
236838	7A	3.2 oz/min (95 cc/min)	5.4 oz/min (160 cc/min)	7.8 oz/min (230 cc/min)
236839	5B	5.4 oz/min (160 cc/min)	7.8 oz/min (230 cc/min)	11.0 oz/min (330 cc/min)
236840	7B	7.1 oz/min (210 cc/min)	9.1 oz/min (270 cc/min)	14.2 oz/min (420 cc/min)
236841	9B	8.8 oz/min (260 cc/min)	11.8 oz/min (350 cc/min)	17.9 oz/min (530 cc/min)
236842	11B	11.8 oz/min (350 cc/min)	16.2 oz/min (480 cc/min)	23.7 oz/min (700 cc/min)

\* Flows are based on white acrylic, enamel paint.

## Spray Pattern Troubleshooting

**NOTE:** Some spray pattern problems are caused by the improper balance between air and fluid.

Problem	Cause	Solution
Spray is too forceful (high velocity).	Air flow too high.	Use gun atomizing air adjustment valve to reduce air flow.
	Spray tip worn.	Replace tip.
	Diffuser worn.	Replace diffuser.
	Fluid flow too high.	Use smaller tip or lower pressure
Spray gun spitting.	Air flow too low.	Use gun atomizing air adjustment valve to increase air flow.
	Tip size is too large.	Use smaller tip.
Tip clogging.	Paint not properly filtered.	Clean or replace the gun filter. Install inline filter or clean/replace inline filter.
	Tip size is too small.	Use larger tip.
Distorted spray pattern (heavy to one side).	Tip is clogged.	See "Tip clogging," above.
	Spray tip worn or damaged.	Replace tip.

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**Graco Headquarters:** Minneapolis

**International Offices:** Belgium, China, Japan, Korea

**GRACO INC. AND SUBSIDIARIES • P.O. BOX 1441 • MINNEAPOLIS, MN 55440-1441 • USA**

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