



SUMAKE®

PNEUMATIC TOOLS



3 in 1 Air Sprayable Seam Sealer Gun & Caulking Gun (13'') ST-66413

SPECYFICATION

Capacity Cartridge (mm)	500
Capacity Sachet (ml)	300 - 600
Overall Lenght (mm)	486
Air Consumption (cfm)	6
Air Pressure (psi)	60-90
Air Hose (inch)	1/4
Air Inlet (inch)	1/4
Net Weight (kgs)	1.3

Vibration ISO 8662-1	Noise 8N-1	Remark
No-load: 2.5 m/s^2	Sound pressure level 65 dB Sound power level 80 dB	Should wear an approved ear - protector and gloves while operating tool.

EC DECLARATION OF CONFORMITY FOR MACHINERY

Manufacturer: SUMAKE INDUSTRIAL CO.,LTD.

Address: 4F,-NO. 351, YANGGUANG ST., NEIHU DISTRICT
TAIPEI CITY 114, TAIWAN

**herewith declares
that:**

ST-66413
3 in 1 Air Sprayable Seam Sealer
Gun & Caulking Gun (13”)

- is in conformity with the provisions of the Machinery Directive (Directive 89/392/EEC, 91/368/EEC, 93/44/EEC, 93/68/EEC), as amended, and with national implementing legislation:

-and have been tested according to: EN 792

Taipei, Taiwan Apr. / 20 / 2008



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Signature

MIKE SU
.....

Full name

OPERATION MANUAL

■ Air Sprayable Seam Sealer Applicator

● Nozzle Purging

A characteristic of the Air Sprayable Sealant and the Sprayable Seam Sealer Applicator Gun is that some sealant continues to flow out of the nozzle after the trigger is released. In order to control this flow of sealant, a purging method to remove the excess sealant in the nozzle was developed. The correct purging method is as follows:

- ▶ Do not change the plunger or air atomization pressure setting that were used during the application of the sealant.
- ▶ Squeeze the Air Sprayable Seam Sealer Applicator Gun trigger to approximately of the full trigger action, using. If have not, it will be leak for throttle valve. This will clear the spray nozzle of sealant. Two fast, short strokes. Only air should come out of the nozzle. This will clear the outer nozzle of sealant.



CAUTION

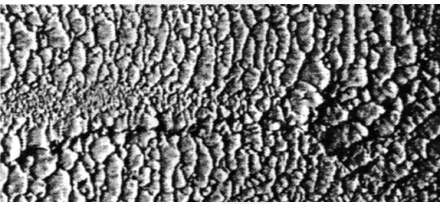
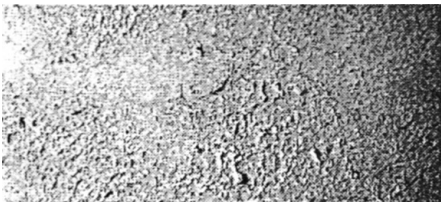

During the purging cycle, the plunger pressure (BLUE VALVE) must be SET at ZERO and the air atomization pressure (RED VALVE) must be set LOWER than 4. If pressure is set higher than 4, the procedure will create back pressure and cause the plunger in the cartridge to reverse discharge sealant into the gun barrel. It will also cause applicator gun failure and void the manufacturer's warranty.

■ Cautions for Use

● Pressure Valve Settings

Technicians will need to adjust pressure settings and vary nozzle tip distances from the surface in order to achieve the desired appearance of a bead, sprayed seam and coating. The air line pressure to the Air Sprayable Seam Sealer Applicator Gun should be controlled via a pressure regulator and operated in the range of 50-90 PSI. **(DO NOT EXCEED 90 PSI)**

When the applicator gun pressure and the distance from the surface are adjusted appropriately, no over-spray is observed. If over-spray is experienced, check the air pressure to the gun. The following pressure valve setting are listed as general guidelines for producing the desired patterns.

BEADS	SPRAYED SEAM	COATING
<p>Adjust red valve to: 10° - 15° Adjust blue valve to: Narrow Bead 15° - 30° Wide Bead 35° - 55° Heavy Bead 60° - 90° * Spray at a distance of 0 - 1 inches from the surface to minimize over-spray.</p>	<p>Adjust red valve to: 45° - 60° Adjust blue valve to 35° - 55° * Spray at a distance of 6 - 10 inches from the surface to minimize over-spray.</p>	<p>Adjust red valve to: 20° - 35° Adjust blue valve to 60° - 90° * Spray at a distance of 6 - 10 inches from the surface to minimize over-spray.</p>
		

■ **Nozzle Cleaning**

Immediately after each use, clean the glue, air and spraying nozzles.

In preparation for spraying Air Sprayable Seam Sealer, always check three nozzles to ensure that cured sealant is not blocking the nozzle orifice or within the nozzle tip. Remove cured sealant blockage using a heavy gauge wire, e.g. clothes hanger. Using the wrench to detach The air nozzle then remove sealant blockage.

Some signals that current sealant is blocking or partially blocking the nozzle are:

- Symptom - The sealant will not spray or caulk.

Solution:

- ▶ Wear eye protection
- ▶ Disconnect air supply
- ▶ Turn both knobs to 10°
- ▶ Point tip in safe direction
- ▶ Squeeze trigger two or more times
- ▶ Insert settings back to "0" before reattaching air

- Symptom - The sprayed seam pattern is narrow and distorted.

Solution:

Remove the black outer nozzles and check for cured sealant along the inside walls of the nozzle. Remove the current sealant using a heavy gauge wire.

■ **Paint Window**

Air Sprayable Seam Sealer provide excellent paint adhesion for up to 72 hours prior to application of automotive paint systems. Scuffing the sealant with Scuff Pad is not necessary or recommended, especially for sprayed seams or coatings. Air Sprayable Seam Sealer may be painted immediately after application (in thickness up to 1/4 inch). Most competitive sprayable products must be painted within the first few hours of application to provide adequate paint adhesion.

■ **Air Caulking Gun - Cartridge & Sachet**

- Range Type

Cartridge - 9" (310 ml), 11" (310 ml & 400 ml), 13" (310 ml, 400 ml, 500 ml)

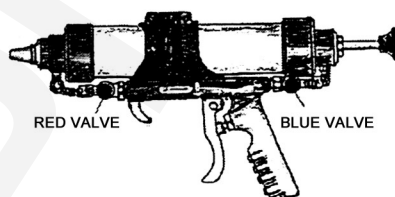
Sachet - 9" (310 ml & 400 ml), 11" (310 ml & 400 ml, 450 ml), 13" (310 ml, 400 ml, 450 ml, 500 ml, 600 ml)

Unique piston rod thrust makes it impossible to obtain compressed air in sealant.

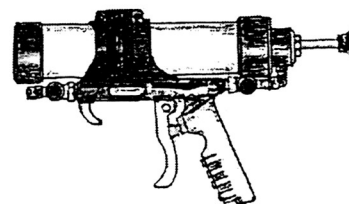
For Pneumatic cartridge applicator without piston and rod. It will keep orange length. For Sachet applicator will need the piston and rod. It will push the sealant.

Easy to dismantle for cleaning and changing between cartridge, sachet. Instant discharge of air: sealant stops immediately.

Contoured handle and lightweight construction make for more comfortable operation.



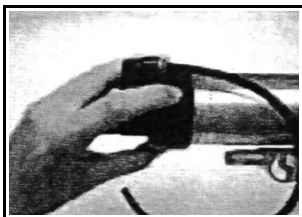
Air Sprayable Seam Sealer



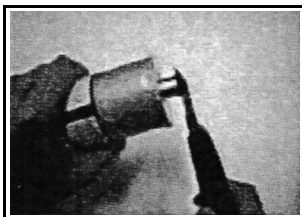
Air Caulking Gun

■ How to use sprayable function and Cleaning

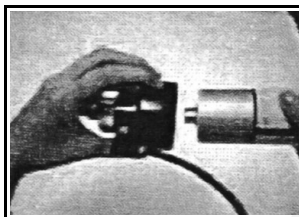
● How to assemble for cartridge



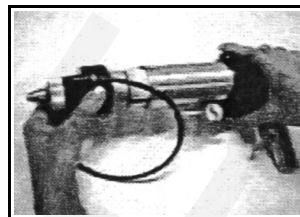
1. First to shift the spray head ass'y



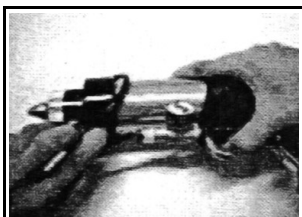
2. Cutting the glue tube head



3. Then lock up the glue and spray head ass'y



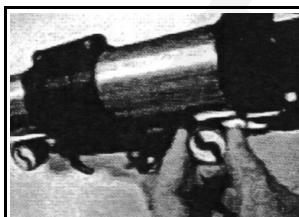
4. Put this full ass'y into pipe (if this tool has push rod that will pull it back, if it is line type that will use rod to push piston to button)



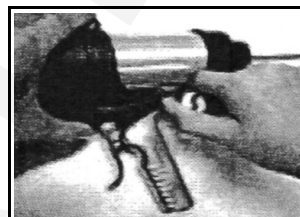
5. Plug the air hose into hose jointer



6. First turn 1/3 of red air regulator to spray dust on the work of surface (right now the blue regulator has to be close)

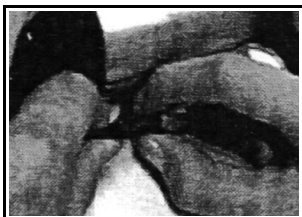


7. According to procedures to do, step by step. If you need bead that will opened the blue regulator to 1/2

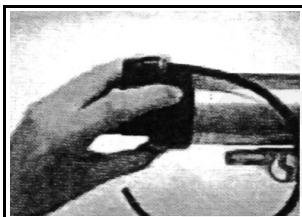


8. If you need like pellet that will turn over 1/2. Opposite that will turn a litter bit

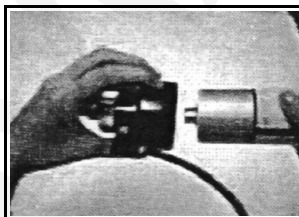
● How to clean before you used



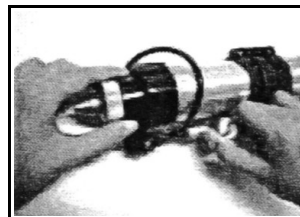
1. First dismantle the air hose



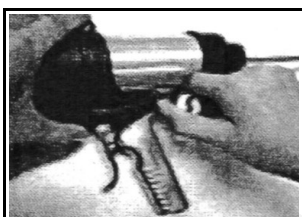
2. loosen the spray head ass'y and take it out



3. Separate the head and glue tube



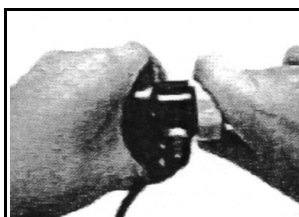
4. Then lock the head back and connecting air hose again



5. Opened two regulator to biggest



6. Spray out residual glue in tool



7. According to steps from 1 to 3 to do again, remove the spray nozzle



8. Use the ring wrench to remove the air nozzle



9. If the glue have not dry that can use cleanser and brush to clean. If had dry that can use knife to shave



10. It is same way to clean spray nozzle



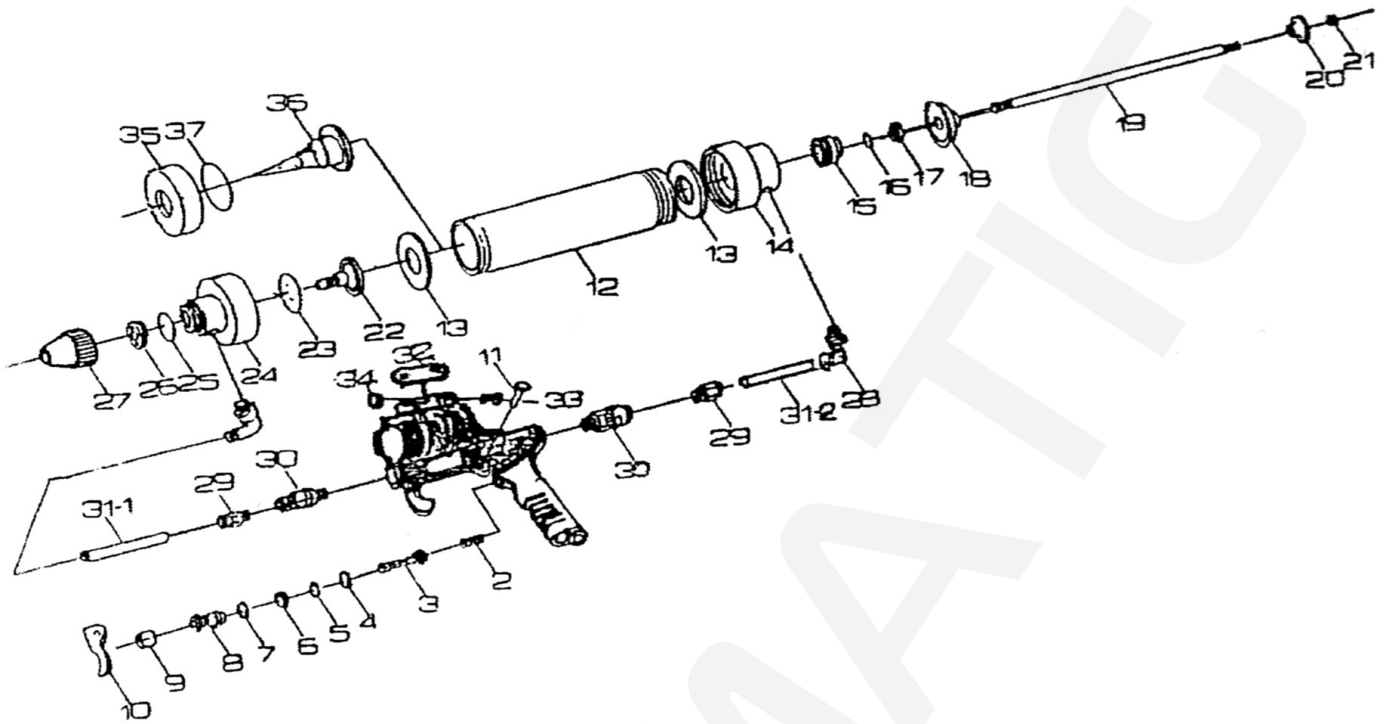
11. It is same way to clean air nozzle



12. The spray head cap cannot put into cleanser that same other nozzle to clean

According to cleaning steps to do that will get a new and long life tool

ST-66413 AIR SPRAYABLE SEAM SEALER & CAULKING GUN 13"



PART LIST

No.	Parts No.	Description	Q'ty	No.	Parts No.	Description	Q'ty
1	66409-01	Handle	1	20	66409-20	Rod Puller	1
2	66409-02	Spring	1	21	66409-21	Lock Nut	1
3	66409-03	Throttle Valve	1	22	66409-22	Glue Nozzle	1
4	66409-04	O-Ring	1	23	66409-23	O-Ring	1
5	66409-05	O-Ring	1	24	66409-24	Spray Cover Connector	1
6	66409-06	O-Ring	1	25	66409-25	O-Ring	1
7	66409-07	O-Ring	1	26	66409-26	Air Nozzle	1
8	66409-08	Valve Bushing	1	27	66409-27	Spray Nozzle	1
9	66409-09	Stem Cover	1	28	66409-28	„L” Hose Q.C.Connector	2
10	66409-10	Trigger	1	29	66409-29	Hose Q.C.Connector	2
11	66409-11	Trigger Riveter	1	30	66409-30	Regulator Control	2
12	66413-12	Aluminum Tube	1	31-1	66413-31-1	Hose (L)	1
13	66409-13	Gasket	2	31-2	66413-31-2	Hose(S)	1
14	66409-14	Tube Connector Cover	1	32	66409-32	Space	1
15	66409-15	Push Road Bushing	1	33	66409-33	Screw	2
16	66409-16	O-Ring	1	34	66409-34	Nut	2
17	66409-17	Nulon Lock Nut	2	35	66409-35	Front Cover	1
18	66409-18	Piston	1	36	66409-36	Glue Nozzle – Soft Tube	1
19	66413-19	Push Rod	1	37	66409-37	O-Ring	1