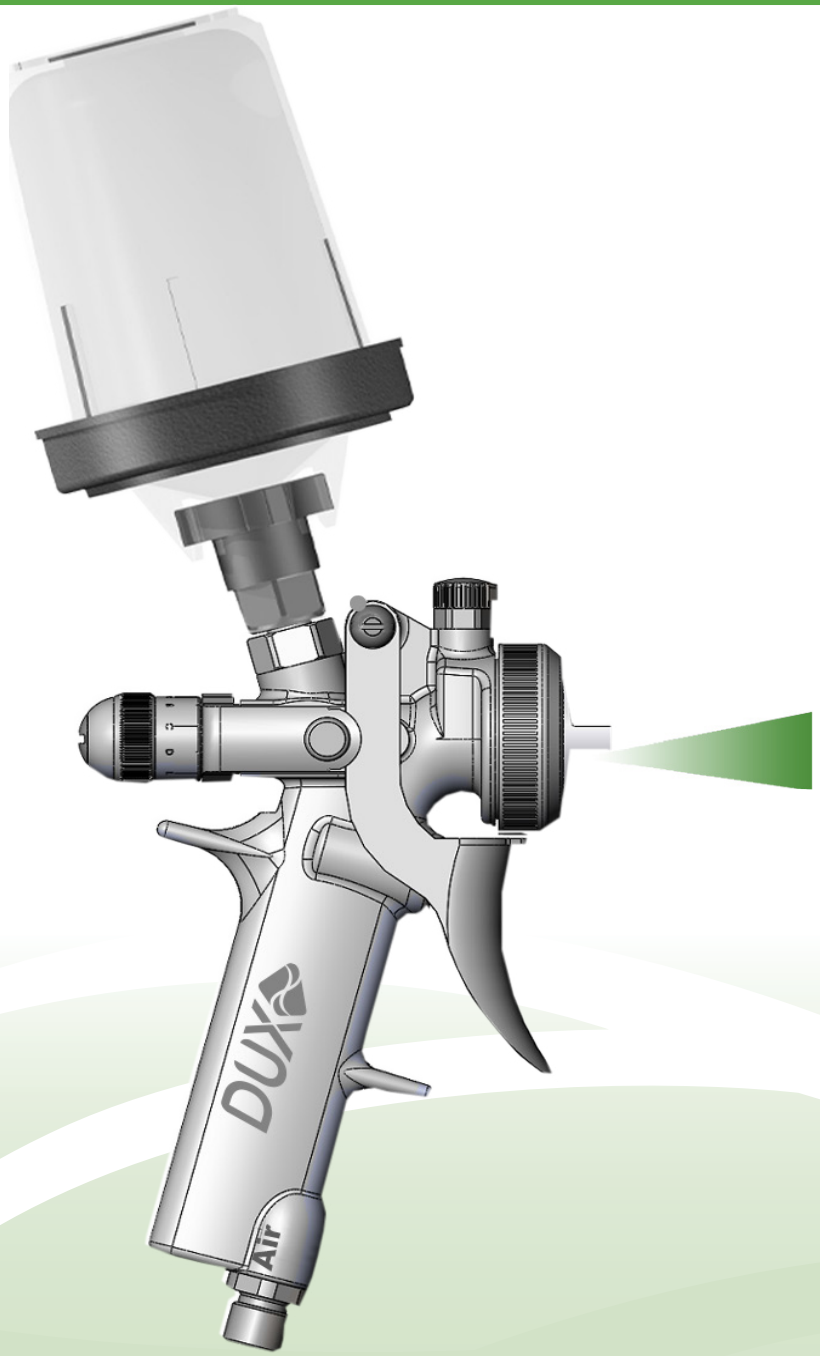
DUX Gravity Feed

3000 Platinum Series



Product Manual

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The DUX Platinum Gravity Feed

INSPIRED BY FORMULA RACE CAR ENGINES.

Once again, DUX has reinvented the spray gun from the inside out! Built upon the success of the original DUX Gravity Feed spray gun, the new "Platinum" series gun is the next step for-ward in spray gun evolution. We've maintained our patented Advanced Laminar Airflow technology, but we've added more user friendly features and a new coating with embedded PTFE for easier cleaning and longer parts life.

As always, finishers can spray nearly any type of fluid, onto nearly any surface with a single gun, while reducing coatings waste and improving finish quality.

TECHNOLOGY THAT'S EASY TO USE AND EASY ON US.

Most Gravity feed spray guns incorporate a front-heavy body design with fluid hose connections near the tip of the gun. Over the course of a long work day, the extra weight causes arm fatigue and uneven spray patterns that impact finish quality. The DUX Platinum Gravity Feed gun, however, is designed with much shorter air passages, an upright handle, and fluid and air connections located at the base of the gun. This creates a lighter, more compact and balanced gun that's easier to maneuver in small spaces.

Lower operating pressures also result in massive reductions of unhealthy paint booth fog and overspray. This drastically improves the work environment for everyone involved.

Patent Information

The design and technology forming the basis of this product is the confidential information of DUX Technologies Inc., a Washington corporation. The relevant US Patent Numbers are: US 6,793,157; US 6,425,533, and U.S. 7,004,404.

DUX Technologies Inc. may have additional patents, patent applications, trademarks, copyrights, or other intellectual property rights covering subject matter in this document. Except as expressly provided in any written license agreement from DUX Technologies Inc., this document does not grant you any license to or rights in any such patents, trademarks, copyrights, or other intellectual property.

Please note that your Gravity Feed Spray Gun was shipped with the following contents:

- **Platinum Gravity Feed Spray Gun**
- **Fluid Tip**
- **Air Cap**
- **PTFE Grease Lubricant**
- **Dux Multi-Tool**
- **Cleaning Brushes**
- **Hard Cup / Cup Adapter**
-

If anything is missing or you would like to order additional parts, please contact Dux at:

Dux Technologies, Inc.
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Tel: 888.289.2732
Fax: 888.876.1233
Website: www.DuxTechnologiesInc.com
Email: Customer.Service@DuxTechnologiesInc.com

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WARNINGS	
	Coatings and solvents may be extremely flammable or combustible. Always use the equipment in a properly ventilated area. Smoking must never be permitted in the spraying area. Make sure that all ignition sources are well out of range and always keep fire extinguishing equipment in the spraying area.
	Some solvents may cause eye injury during operation and/or while cleaning the equipment. Always wear eye protection when working with the equipment.
	NEVER USE HALOGENATED HYDROCARBON SOLVENTS in or on this equipment. They can adversely react with aluminum and cause fire and/or explosion. These materials include but are not limited to, 1-1-1 Trichloroethane, Methylene Chloride, Dichloromethane, and Carbon Tetrachloride.
	Some coatings and solvents may be harmful if there is contact with the skin or if inhaled. Always make sure to read the MSDS supplied by the material manufacturer. Always use the equipment in a properly ventilated area. If there is a chance of inhalation or contact with skin, use protective gear such as a respirator and/or proper clothing as suggested by the MSDS.

Safety

Required Maintenance

- Clean equipment after each use
- Lubricate spray gun before each use and/or after every cleaning
- Do not submerge spray gun in solvent
- Ensure proper handling of the gun at all times - damage due to dropping or mishandling of the spray gun is not covered by the warranty
- Ensure air hoses are properly connected
- Do not apply air pressures above the maximum published inlet pressure
- Problems resulting from any of the above-mentioned situations will jeopardize warranty

Platinum Gravity Feed Safety Information

- Use the equipment only for its intended purpose
- Do not point spray gun at any part of body or place hands or fingers over spray tip
- Inspect equipment for physical damage or loose fittings before each use
- Shut off air and remove coating supply to spray gun before servicing
- Use fluids and solvents that are compatible with equipment wetted parts
- Do not use with improperly operating equipment
- Always refer to the owner's manual for proper operating instructions
- Comply with all applicable safety regulations
- Read all instruction manuals, tags, and labels before operating the equipment
- Always read the MSDS supplied by the material manufacturer
- Do not exceed 75psi/5.17 bar air inlet pressure
- Equipment is not intended to be used with oxidizing materials
- Do not use equipment in ambient temperatures greater than 40° C/104° F or less than 0° C/32° F
- Always properly discharge static electricity prior to operating the equipment
- Anti-static hoses must be used in potentially explosive atmospheres.
- Always properly ground spray target and spray gun prior to use.

Quick Reference and Set-Up Guide

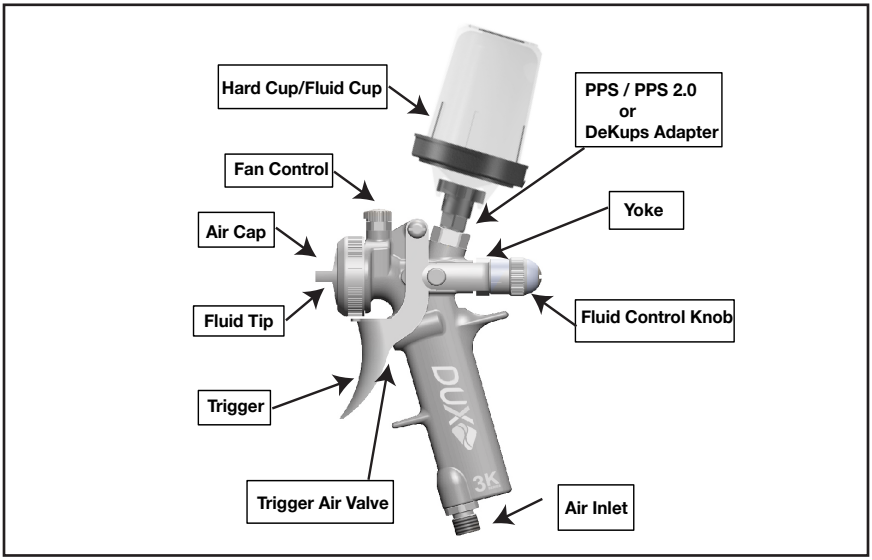


Figure 1: Gun Parts

3M PPS/PPS 2.0 Adapter

DeKups DPC-13 Adapter

Aluminum Hard Cup

Figure 2: Cup Connections

Operation Guide

Connect a clean air supply
Connect a clean, dry air supply to the Platinum Gravity Feed via the 1/4" NPS air inlet fitting.

Note that many compressed air systems may be contaminated with particulate, compressor oil and/or water. These materials can foul the inside of the spray gun, leading to gun malfunction or defects in your final finish. If you have any question regarding the quality of your air supply, please contact DUX for recommendations on proper air filter/dryer equipment.

Set Initial Air Pressure

As a starting point, adjust the air regulator to achieve approximately 5 psi at the base of the spray gun when the gun is triggered. Keep in mind that hoses cause a drop in air pressure, so it may be necessary to set the pressure at your regulator well above 5 psi to maintain 5 psi at the base of the gun. To ensure you begin with the proper pressure, it is a good idea to install a separate gauge (or a small regulator) at the base of the gun.

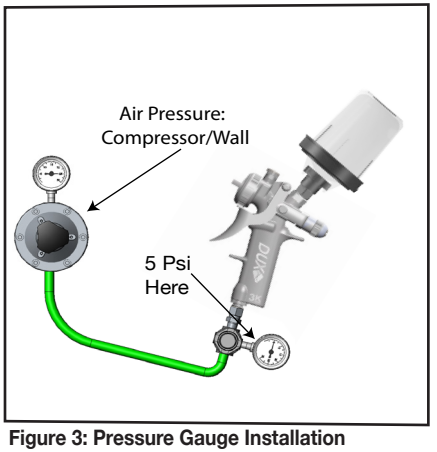


Figure 3: Pressure Gauge Installation

Due to DUX's the patented Advanced Laminar Air-flow design, a setting of 5 psi at the base of the gun will result in approximately 5 psi at the air cap—which is sufficient to atomize many coatings at a moderate fluid flow rate.

Later, when test spraying the gun, you will adjust the air pressure up or down depending upon atomization quality with your particular coating. Be sure to make a note of the triggered pressure reading at your regulator at that time. This will allow you to easily return to the proper gun settings in the future. Also, remember to adjust your settings if you change hoses, since pressure drop will vary depending upon the length and diameter on the hose used.

Note Unlike traditional HVLP and Conventional Air Spray guns, very little air pressure is lost inside the DUX gun. It is not necessary to begin with high pressure (30+ psi) at the gun inlet.

Operation Guide

Fluid Supply/Settings

During the sales process, your DUX representative will help you choose the proper tip size and fluid pressure for your application. Due to the efficient nature of the DUX gun, this flow rate is likely to be 15-40% less than your existing spray gun. However, if changes are made to your production speed, coating type, or desired finish quality, it may be necessary to use a different fluid tip size or alter the other settings. If you are using the DUX gun for the first time, or have recently changed your operations, we recommend the following steps.

First, identify the flow rate of your existing spray gun to serve as a benchmark. To do this, turn off the atomizing air at the air regulator and trigger the gun into a beaker or measuring cup for 15 seconds. Multiply the resulting volume by 4 to calculate your flow rate in ounces or cc per minute.

Next, because DUX guns are more efficient, we recommend you choose a fluid tip that is one or two sizes smaller than your existing gun. Also, because the fluid control micrometer knob is designed for very small adjustments only, we recommend you begin with the fluid micrometer set at the 4A position – which allows maximum flow.

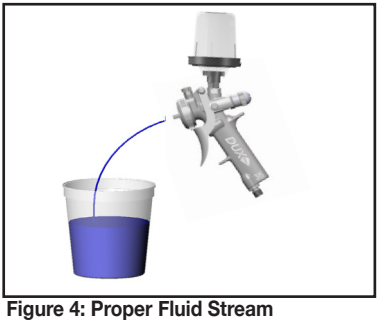


Figure 4: Proper Fluid Stream

With the atomizing air turned off, trigger the DUX gun over a beaker and use your fluid control knob to adjust the fluid flow Regulate your flow so the fluid stream arcs approximately 8" from the tip of the gun (see **Figure 4**).

If you apply too much flow at the control knob your fluid stream will be much too fast. Proper atomization may be difficult under these conditions.

Test Spraying

Proper operation of the DUX Gravity Feed requires the trigger handle to be pulled fully to the rear of the spray gun while spraying. This ensures uniform spray patterns and consistent mil thickness.

Spray a test pattern and evaluate the finish quality. Increase or decrease the flow by adjusting the fluid control knob until the desired results are achieved. If necessary, small incremental adjustments of the DUX fluid control knob can be made. When the optimum results are achieved, record the setting for simple future setups.

Adjusting Fluid Control Knob

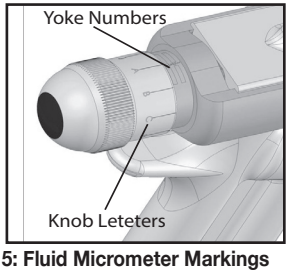


Figure 5: Fluid Micrometer Markings

The markings on the fluid control knob (**shown in Figure 5**) correspond to 0.1mm of needle travel when the trigger is fully pulled (e.g., rotating the control knob from A to B increases the needle travel by 0.1mm).

Operation Guide

The markings on the trigger yoke indicate 1.0mm of needle travel (e.g., a micrometer setting of 1A equals 1.0mm of needle travel and a setting of 2A indicates 2.0mm of needle travel).

NOTE: Maximum needle travel is 4mm, making settings beyond 4A unnecessary. Needle travel/fluid flow is not increased beyond this point.

Changing Fluid Tips

Unlike other spray guns that require a matched, or "lapped", set of needles and fluid tips, the DUX Gravity Feed uses a standard universal fluid needle. The needle does not have to be changed when different fluid tips are installed, and a new needle does not have to be purchased with each new fluid tip.

Of course different coatings or coating applications may require different sized fluid tips. DUX offers a range of tips from 0.4mm to 2.2mm in .2mm increments. Due to the precision ma-chining of DUX parts, no gasket or o-ring is re-quired between the tip and the fluid barrel.

To change tips, follow these instructions:

1. Ensure spray gun is depressurized.
2. Remove the air cap retaining ring and air cap.
3. Pull the trigger to the rear.
4. Using the DUX 10mm fluid tip driver, remove the fluid tip and inspect threads for wear or contaminations
5. Install a new fluid tip and tighten using the DUX 10mm fluid tip driver.
6. Replace the air cap and air cap retaining ring

IMPORTANT: To maintain the precise fit and seal between the fluid tip and the stainless steel fluid barrel, paint must not be allowed to dry on the threads. The threads of both the fluid barrel and tip must be thoroughly cleaned after each use.

Fan Control Knob

The fan control knob is located on the top front of the spray gun and is shown in Figure 6 below. This knob controls the amount of air delivered to the horns of the air cap to shape the spray pattern. The largest fan pattern is achieved with the fan control knob pointing toward the spray target—or the 12 o'clock position. Spray pattern size decreases as the knob is rotated in either direction from the fully forward position. Minimum spray pattern size is achieved with the fan control knob pointed toward the rear of the spray gun—or in the 6 o'clock position.

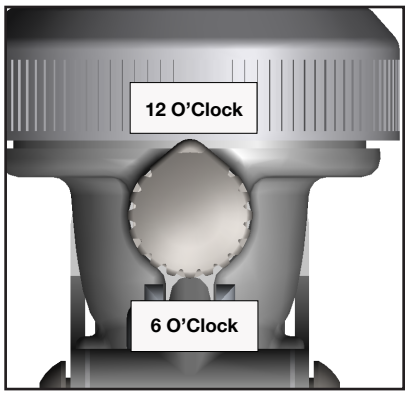


Figure 6: Fan Control Knob

Cleaning & Maintenance

Proper care and maintenance procedures must be used with the DUX gun to maintain the product warranty. To assist in the cleaning process, DUX provides proper cleaning supplies with each gun including, brushes, and lubricant. Optional Cleaning Caps are also available for purchase.

CAUTION:

- Do not submerge the spray gun in solvents or cleaning solutions—even with the cleaning caps installed
- Do not clean air cap holes with meta tools as it could effect the spray pattern
- The DUX Gravity Feed may be cleaned in a spray gun washer with the cleaning cap(s) installed

Optional Cleaning Caps

DUX provides an optional upper and lower Cleaning Cap to protect the gun's air chamber during cleaning. If proper use of these caps is not followed, fluid can enter the air chamber and may ultimately reach the air valve piston assembly . A build up of fluid in the air passage can negatively impact laminar air-flow and the gun's efficiency. Fluid build up in the air valve assembly may also cause the valve to stick. Without the cleaning caps in place, there are several ways in which fluid can enter the air passage:

*The fluid tip is removed without depressurizing the spray gun, allowing coating to run directly into air chamber.

*Holding the gun "face up" while cleaning, allowing paint and contaminated solvent to run down into air chamber.

*Submerging the gun in a bucket or tank of dirty solvent, allowing the contaminants to infiltrate the air valve area.

For this reason, always be sure to install the cleaning caps (shown in **Figure 8** below) BEFORE removing the fluid tip. To install, simply thread the upper cleaning cap onto the gun just as you would an air cap. Hand tighten until snug. Install the Lower Cleaning Cap on the air inlet of the gun.

The air chamber is now effectively sealed from both ends. Use the nut driver to remove the fluid tip and begin cleaning.

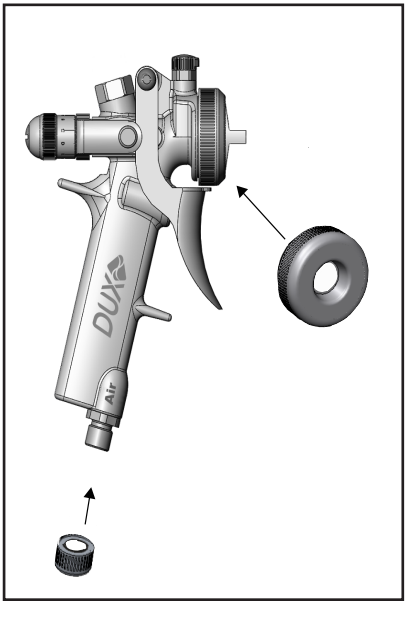
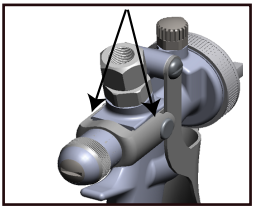


Figure 8: Cleaning Caps

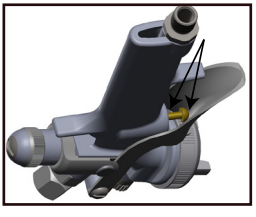
Lubrication Guide

DUX spray guns are shipped pre-lubricated and a tube of silicone-free PTFE grease lubricant is enclosed in each box. To ensure the quality and longevity of the DUX spray gun it must be lubricated before every use and after every cleaning. Follow the diagram in **Figure 9** to ensure proper lubrication

Figure 9: Lubrication Guide

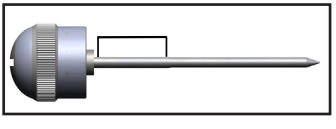


To ensure the longevity of the Dux Spray Gun, lubricate after every cleaning.
(Part # 310201)



With spray gun inverted, lubricate trigger pin and inside surface of trigger handle

Invert spray gun and lubricate underside of yoke rails



Lubricate thick section of needle

Periodic Maintenance

Cleaning the Air Valve

If proper cleaning procedures and equipment are not used, you may experience a sticky or slow moving air valve piston. As a short term solution, it is acceptable to introduce a small amount of CLEAN solvent directly into the air chamber. Simply remove the air hose, invert the gun, and introduce solvent directly into the air inlet. Squeeze the trigger several times while applying the solvent. This should temporarily free the air valve for continued spraying.

If sticking continues, a more thorough cleaning of the air valve will be required. This procedure involves the removal and cleaning of the trigger air valve assembly as follows:

- Ensure the spray gun is depressurized.
- Unscrew the trigger spindle screws and remove the chrome trigger handle. (See Figure 11)
- Using standard retaining ring pliers, remove the trigger air valve retaining ring.
- Remove the air valve piston assembly shown in Figure 12 from the gun body.
- Clean the valve by rinsing in clean water or clean solvent.
- Clean the inside of the valve bore on the gun body using clean solvent and a brush.
- Dry both the piston and the gun body thoroughly.
- Insert the trigger air valve assembly into the body and use the retaining ring to secure it.
- Replace the trigger handle, nylon washers, and trigger spindle screws.
- Lubricate according to the Dux Pres sure Feed lubrication instructions on page 7

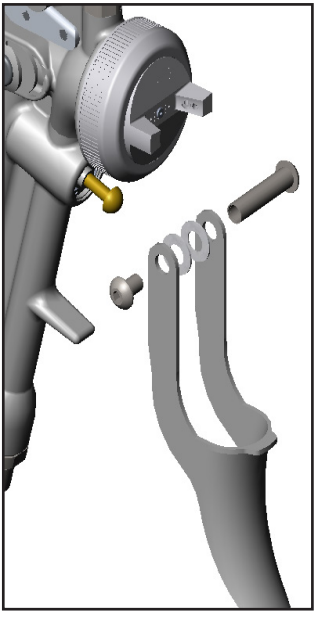


Figure 10: Trigger Removal

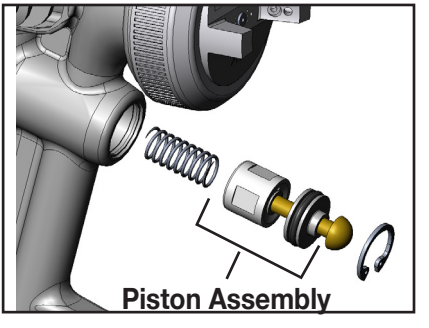


Figure 11: Air valve piston removal

Platinum 3K Series: Fluid Packing

The Platinum Gravity Feed spray gun incorporates a new self-adjusting packing. No manual packing adjustment is required. The packing device uses an internal spring to apply consistent pressure to the PTFE fluid seal—keeping fluid from leaking past the seal while allowing for easy triggering.

Because packing components in all spray guns will wear over time, however, it may be necessary to replace them periodically. Symptoms of a worn packing include fluid leaks from either the front or back of the gun.

If fluid is leaking from the front of the gun (via the fluid tip) be sure to first inspect the tip to ensure dried material or other foreign matter is not lodged in the tip. Any such obstruction will keep the fluid needle from fully seating in the tip, leading to the leak. If fluid is leaking from the back of the gun, it is generally an indication that the packing is worn. In this case, the packing should be replaced.

There are two methods for replacing the packing in the Platinum Gravity Feed gun:

1) Replacing the entire packing cartridge
2) Replacing the wearable packing components.

Replacing the packing cartridge is faster and simpler, but requires the purchase of a complete re-placement cartridge. Replacing the individual components is less expensive and is quite easy.

Below is a description of both methods

Option #1: Replacing the Packing Cartridge

The replacement packing cartridge includes new Stainless Steel housing components as well as the new wearable parts (spring, PTFE fluid seal, and o-rings—all fully assembled into a single unit. The part number for the cartridge is #310127

To replace the cartridge follow these steps:

1. Ensure the gun is depressurized.
2. Unscrew the fluid control knob and completely remove the needle assembly.

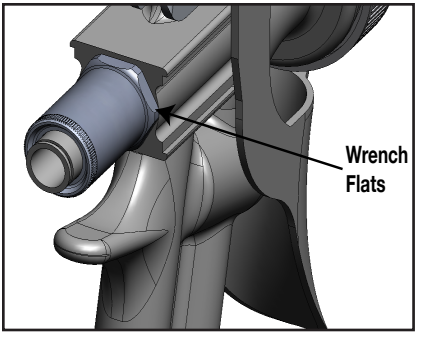


Figure 12: Packing Cartridge Removal

3. Remove the yoke by removing the c-clip at the rear of the yoke
4. Remove the packing cartridge from the spray gun body by rotating it counter-clockwise using the Dux Multi-Tool Wrench
5. Install the new packing cartridge, (including the o-ring on the cartridge) back into rear of the gun, and tighten to 2 ft. lbs. of torque.
6. Inspect yoke and c-clip for wear or contamination and reinstall; replace if needed. Be sure to install the yoke with the micrometer markings facing up.
7. Lubricate the fluid needle as indicated in Figure 10 and reinstall fluid needle assembly.

Option #2: Replacing Packing Components

Because the stainless steel packing housing components are very durable, it may be more cost effective to change only those packing components that will wear over time. Using this method, you will need DUX Part Number #310130—the Wearable Packing Component Kit.

To replace the components, first follow steps 1-4 on the previous page to remove the packing cartridge. Then follow these steps:

Removing the packing components

1. Unthread the knurled Spring Cap by hand until it releases from the cartridge housing.

2. Remove the Sleeve B Spring and Sleeve B to expose the brass Fluid Seal Nut on the inside of the packing cartridge housing.

3. Use a flat bladed screwdriver or the packing replacement tool to remove the nut by turning counterclockwise (be careful as there is a spring beneath the cap).

4. Turn the housing upside down to remove the nut and spring. Note that the spring is sized for an interference fit inside the base of the nut, so they should come out as a single unit.

5. Use the pointed end of the packing replacement tool to push/pick the PTFE fluid seal and black o-ring out of the base of the housing. It may be easiest to access these pieces from the outside of the housing. Clean the inside of housing thoroughly before inserting new packing components.

⚠

Important: Be careful when removing the Spring Cap & Packing Nut-Content are under spring pressure and may pop loose

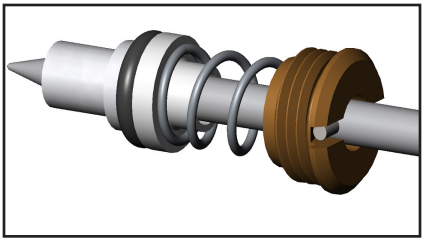


Figure 14: Packing on tool

1. Using the packing replacement tool, line up the replacement components as shown in Figure14. Be sure the slot on the brass nut lines up with the cross piece on the tool so the tool can be used as a screwdriver to turn the nut.

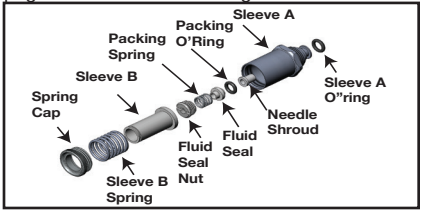
2. Push the components into the canal on the inside of the housing as shown in Figure 15. When the brass nut seats at the base of the housing, begin turning clockwise to thread the nut.

3. Thread the nut as far as it will go and keep turning until hand tight.

4. Insert the new Sleeve B and then the new Sleeve B Spring (included in the kit) back into the packing cartridge housing in the order shown in Figure 15.

5. Use the Spring Cap to compress the Spring until you are able to thread the cap back onto the housing.

6. Follow steps 6-7 on the previous page to re-install the cartridge.



Fluid Needle Replacement

As previously mentioned, the Platinum Gravity Feed spray gun utilizes a universal fluid needle. There is no need to change the needle when changing fluid tips unless special self-cleaning needles have been purchased. However, needles may wear over time, especially with very abrasive coatings, and may need to be replaced periodically.

NOTE: DUX offers optional self-cleaning fluid needles for various coatings/applications. These needles are specially designed to clean material out of the fluid tip between triggering. Due to the nature of these needles, they can only be used with tips of the same size. Contact DUX Customer Service for more information regarding this option

Removal of the fluid needle

1. Ensure the spray gun is depressurized.
2. Unscrew the fluid control knob and completely remove the needle assembly.
3. Remove the needle cap (# 5 in Figure 16).
4. Remove the spring and needle from the fluid control knob.

Replacement of the Fluid Needle

1.Install the new needle and spring into the fluid control knob.

2.Carefully replace the needle cap making certain the needle, needle holder, and spring are properly seated.

3.Lubricate the needle as indicated in figure 2 and reinsert the needle assembly into the spray gun body.

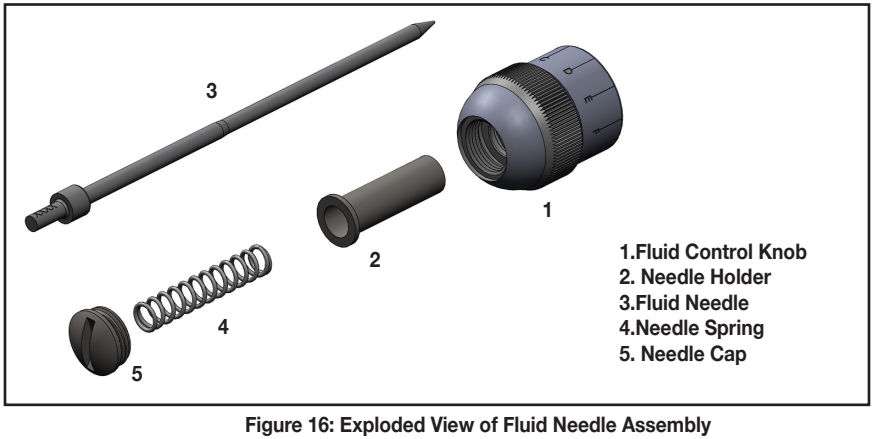


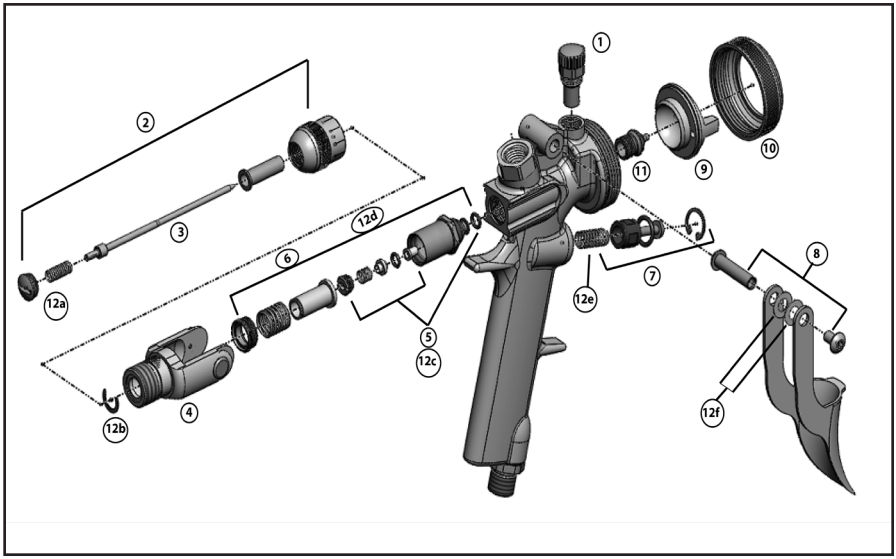
Figure 16: Exploded View of Fluid Needle Assembly

The DUX Platinum Gravity Feed is provided with a brass trigger pin. This pin is manufactured from a relatively soft metal to reduce wear on the Stainless Steel trigger.
Because it is a wearable part, it may be necessary to replace the trigger pin when heavy use of the gun has resulted in deformation. When this occurs, it is best to replace the entire trigger pis-ton assembly, since an excessively worn trigger pin may have caused unseen wear on other portions of the air valve.

Troubleshooting

Problem	Cause	Solution
Coating leakage out of the tip of spray gun	Foreign material is interfering with seal between fluid tip and needle	1. Remove fluid tip and needle 2. Look for small bits of dried paint or other foreign material 3. Clean thoroughly and reinstall
Split Pattern 	1. Air Pressure too high 2. Fluid flow to low	1. Reduce inlet air pressure 2. Turn fluid control knob counter-clock-wise Note: If setting is at 4A replace fluid tip with next largest size
Heavy Right or left side pattern 	Dirty or damaged air cap/holes	Clean Air Cap Note: If problem persists after cleaning, replace air cap Note: Do not use metal tools to clean air cap
"Orange Peel" or heavy pattern 	1.Air pressure is to low 2.Spray gun is too close to working surface 3.Fluid adjustment is too high	1. Increase inlet air pressure 2. Ensure proper distance from surface is achieved, normally 6-8" from surface 3. Adjust fluid control knob clockwise to decrease fluid flow
Heavy top or bottom pattern 	1. Air cap dirty or damaged 2. Fluid tip dirty or damaged	1. Clean air cap Note: Do not use metal tools to clean air cap 2. Clean fluid tip Note: If problem persists after cleaning replace air cap or fluid tip
Will not spray 	1.Insufficient air pressure 2.Insufficent fluid settings 3. Fluid too heavy for current settings 4. Plugged fluid tip	1. Check inlet air pressure and in-crease if necessary 2. Adjust fluid control knob counter clockwise to increase fluid flow 3. Thin coating and/or change fluid tip to next largest size 4. Remove and clean fluid tip
Spray gun sputtering	1. Damaged fluid tip 2. Loose fluid tip 3. Dried material in fluid tip/needle 4. Fluid supply empty/low 5. Packing nut too loose	1. Remove and inspect for damage 2. Ensure fluid tip is tight 3. Flush pressure feed with solvent 4. Check/ Refill coating 5. See solution: (coating leakage out of rear of spray gun)
Spray pattern starved or dry	1. Air pressure too high 2. Fluid adjustment too low 3 .Spray too far from working surface	1. Reduce inlet air pressure 2. Adjust fluid control knob until desired results are achieved 3. Ensure proper distance from surface is achieved , normally 6-8"
Excessive Fog 	The Dux Pressure Feed was designed to eliminate excessive fog. If you find that you are having this problem, it may be that the air pressure too high	Reduce inlet air pressure

Gravity Feed 3K Platinum Series Exploded View



No.	Part	Description
1.	310110	Fan Control Assembly
2.	310116	Fluid Control Assembly
3.	310117	Fluid Needle
4.	310125	Yoke
5.	310130	Platinum Fluid Needle Packing Kit
6.	310127	Platinum Complete Yoke Spring Cartridge
7.	310159	Air Valve Trigger Kit
8.	310131	Trigger Kit
9.	410507	Air Cap, A0 (PTFE)
	410508	Air Cap, A1(PTFE)
	410509	Air Cap, A2(PTFE)
	410465	Air Cap, A0 (SS)
	410466	Air Cap, A1(SS)
	410467	Air Cap, A2(SS)
10.	310157	Air Cap Ring
11.	310237	Fluid Tip 0.4mm
	310250	Fluid Tip 0.6mm
	312051	Fluid Tip 0.8mm
	310252	Fluid Tip 1.0mm
	310253	Fluid Tip 1.2mm
	310254	Fluid Tip 1.4mm
	310255	Fluid Tip 1.6mm
	310256	Fluid Tip 1.8mm
	310257	Fluid Tip 2.0mm
	310258	Fluid Tip 2.2mm
12.	310170	Platinum Wearable Parts Kit Including:
	a.	(1)Needle Spring
	b.	(1)Yoke C-Clip
	c	(1)Platinum Needle Packing Kit
	d.	(1)Platinum Complete Yoke Spring Cartridge
	e.	(1)Trigger Spring
	f.	(2)Washers
	g.	(1)Fluid Control O-Ring (Not Pictured)
	310160	Fluid Control O-Ring 5 PK
13	310239	Hook Kit

Technical Specifications	
Body Material	Investment Cast Aluminum
Fluid Passage Material	Stainless Steel
Air Cap Material	PTFE Coated Aluminum/ Stainless Steel
Weight (w.o Cup)	13.6 oz
Maximum Inlet Air Pressure (To Maintain HVLP Compliance)	11 Psig
Maximum Inlet Fluid Pressure	75 psi
Air Inlet	1/4" NPS Male
Feed Type	Gravity
Triggering Pressure	39.85oz
Air Consumption (at stated air cap pressure)	A0 @ 10psi- 8.9 scfm A1 @ 10psi- 10.2 scfm A2@ 10psi- 11.0 scfm

Dux Standard Warranty

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