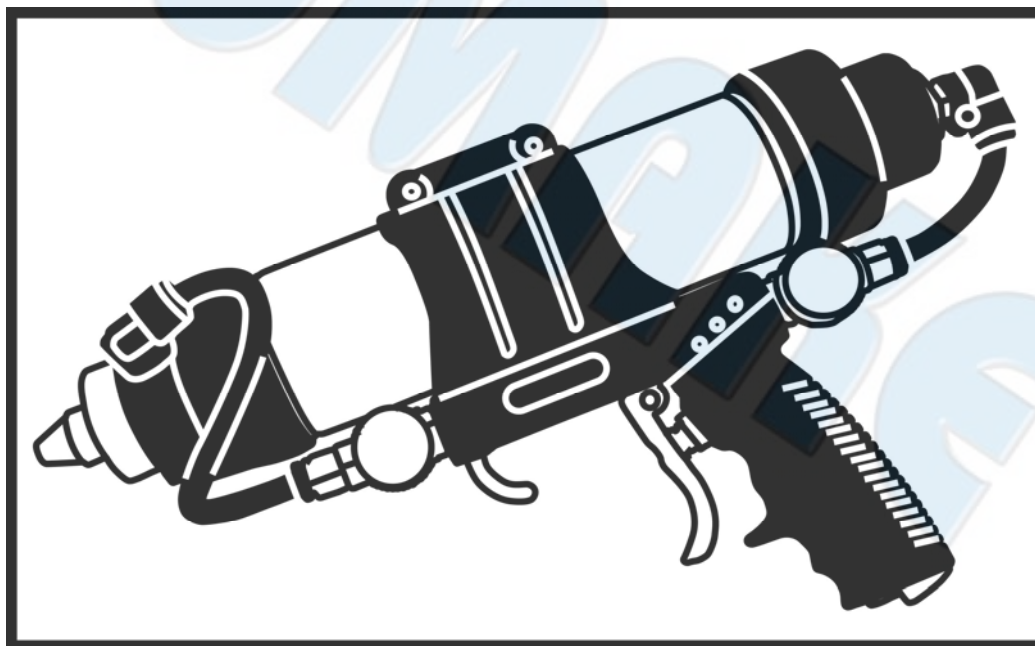




SUMAKE PNEUMATIC TOOLS



Air Sprayable Seam Sealer & Caulking Gun (9" Alum. Pipe) ST-66412

Specification:

Capacity	Cartridge: 310mm
Overall Length	300 mm
Air Consumption	6 CFM (170 L/min)
Air Inlet (PT)	1/4" (6.35 mm)
Air Hose (I.D.)	1/4" (6.35mm)
Air Pressure	60~90 psi
Net Weight	2.42 lbs (1.1 kg)

Noise and Vibration:

Vibration EN 28662-1 and EN 28662-5	Noise EN ISO 15744	Remark
No Load: 2.5 m/s ²	Sound Pressure Level No load: 65 dB(A)	Please always wear ear protector at environment noise level > 80 dB(A) due to risk of impaired hearing!
Uncertainty K= 1.5 m/s ²	Sound power level No load: 76 dB(A)	
	Uncertainty K= 3dB	

SUMAKE INDUSTRIAL CO., LTD

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ST-66412-S-1510B-S2F



EC DECLARATION OF CONFORMITY

We: **SUMAKE INDUSTRIAL CO., LTD.**

4F, No. 351, Yangguang St., Neihu District, Taipei City, Taiwan

declare in sole responsibility that the equipment

Equipment : **AIR SPRAYABLE SEAM SEALER & CAULKING GUN (9" ALUM. PIPE)**

Model/ Serial No. : **ST-66412**

to which this declaration applies, complies with these normative documents:

- Machinery Directive: 2006/42/EC

and conforms to the following EN standard,

- EN ISO 12100: 2010
-

Name and Signature/Position

Mike Su – Managing Director

Date and Place

2012/10/26

Taipei, Taiwan

Operation Manual



3 in 1 Air Sprayable Seam Sealer & Caulking Gun

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:

1. Do not change the plunger or air atomization pressure setting that were used during the application of the sealant.
2. 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 shout come out the nozzle. This will clear the outer nozzle of sealant.

Caution: During the purging cycle, the plunger pressure (GREEN 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 manufacture's warranty.

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 shout 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 overspray is observed. If overspray 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

Adjust red valve to: 10⁰–15⁰

Adjust blue valve to :

Narrow Bead 15⁰ - 30⁰

Wide Bead 35⁰ - 55⁰

Heavy Bead 60⁰ - 90⁰

* Spray at a distance of 0 – 1 inches

from the surface to minimize overspray

SPRAYED SEAM

Adjust red valve to 45⁰-60⁰

Adjust blue valve to 35⁰-55⁰

* Spray at a distance of 6 – 10 inches

from the surface to minimize overspray.

COATING

Adjust red valve to 20⁰-35⁰

Adjust blue valve to 60⁰-90⁰

* Spray at a distance of 6 – 10 inches

from the surface to minimize overspray.



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 than remove sealant blackage.

Some signs that cured sealant is blocking or partially blocking the nozzle are:

1. **Symptom** – The sealant will not spray or caulk.

Solution:

- a. Wear eye protection
 - b. Disconnect air supply
 - c. Turn both knobs to “10⁰”
 - d. Point tip in safe direction
 - e. Squeeze trigger two or more times
 - f. Insert settings back to “0” before reattaching air
2. **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 cured 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”(310ml) , 11” (310ml & 400ml), 13” (310ml, 400ml , 500ml)

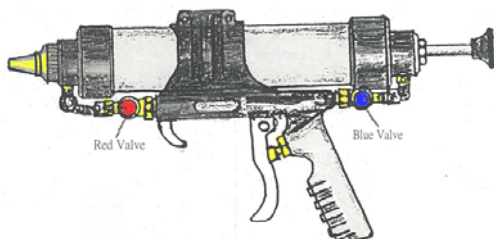
Sachet - 9”(310ml & 400ml), 11”(310ml , 400ml, 450ml) , 13”(310ml , 400ml , 450ml , 500ml , 600ml)

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

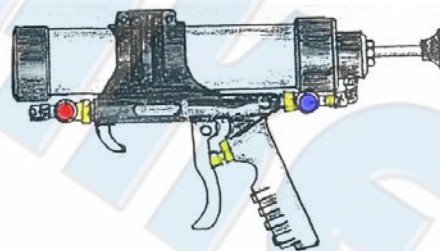
For Pneumatic cartridge applicator without piston and road. It will keep orange length. For Sachet applicator will need the piston and rod. It will push the sealant .

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 open 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 regulators to biggest



6. Spray out residual glue in tool



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



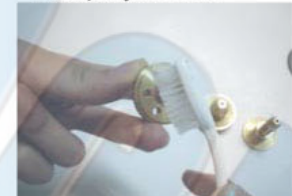
8. Use the ring wrench to remove the air nozzle



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



10. It is same way to clean spray nozzle



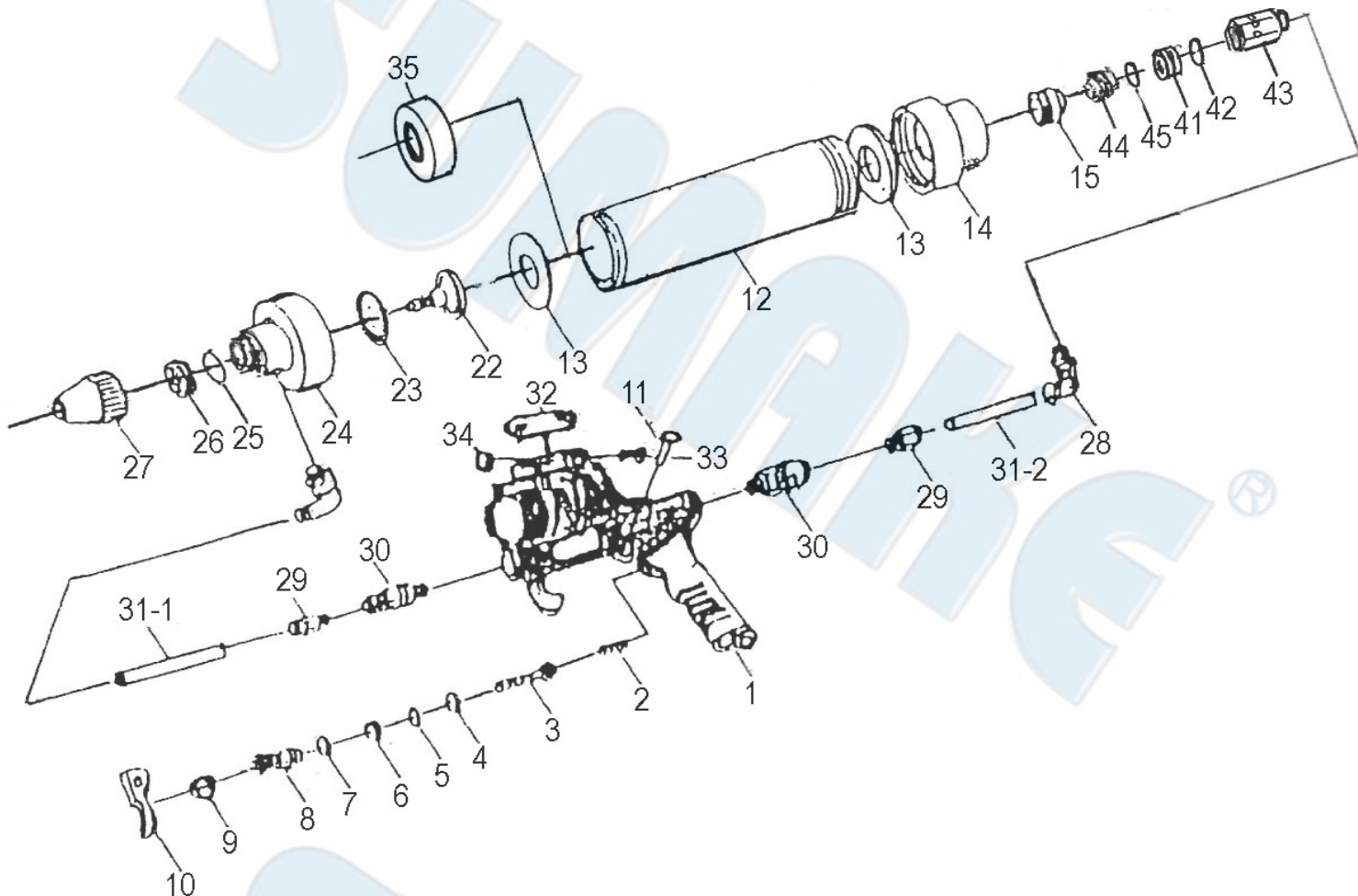
11. it is same way to clean air nozzle



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-66412AIR SPRAYABLE SEAM SEALER & CAULKING GUN (9" ALUM. PIPE)
- ST-66412-11AIR SPRAYABLE SEAM SEALER & CAULKING GUN (11" ALUM. PIPE)
- ST-66412-13AIR SPRAYABLE SEAM SEALER & CAULKING GUN (13" ALUM. PIPE)



PARTS LIST

No.	Parts No.	Description	Q'TY
1	66412-01	Handle	1
2	66412-02	Valve Spring	1
3	66412-03	Throttle Valve	1
4	66412-04	O-Ring	1
5	66412-05	O-Ring	1
6	66412-06	O-Ring	1
7	66412-07	O-Ring	1
8	66412-08	Valve Bushing	1
9	66412-09	Stem Cover	1
10	66412-10	Trigger	1
11	66412-11	Riveter	1
12	66412-12A	Alum. Tube (9") [ST-66412]	1
	66412-12B	Alum. Tube (11") [ST-66412-11]	1
	66412-12C	Alum. Tube (13") [ST-66412-13]	1
13	66412-13	Gasket	2
14	66412-14	Tube Connector Cover	1
15	66412-15	Connector Nut	1
22	66412-22	Glue Nozzle	1
23	66412-23	O-Ring	1
24	66412-24	Glue Nozzle Connector	1
25	66412-25	O-Ring	1

No.	Parts No.	Description	Q'TY
26	66412-26	Air Nozzle	1
27	66412-27	Spray Nozzle	1
28	66412-28	"L" Hose Q.C. Connector	2
29	66412-29	Hose Q.C. Connector	2
30	66412-30	Regulator Control	2
31-1	66412-31-1A	Air Hose (L) (9") [ST-66412]	1
	66412-31-1B	Air Hose (L) (11") [ST-66412-11]	1
	66412-31-1C	Air Hose (L) (13") [ST-66412-13]	1
31-2	66412-31-2A	Air Hose (S) (9") [ST-66412]	1
	66412-31-2B	Air Hose (S) (11") [ST-66412-11]	1
	66412-31-2C	Air Hose (S) (13") [ST-66412-13]	1
32	66412-32	Space	1
33	66412-33	Screw	2
34	66412-34	Nut	2
35	66412-35	Cap	1
41	66412-41	Piston	1
42	66412-42	O-Ring	1
43	66412-43	Valve Body	1
44	66412-44	Valve Head	1
45	66412-45	O-Ring	1

NOTE

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