



## **2400 Cup Gun Assembly Procedure**

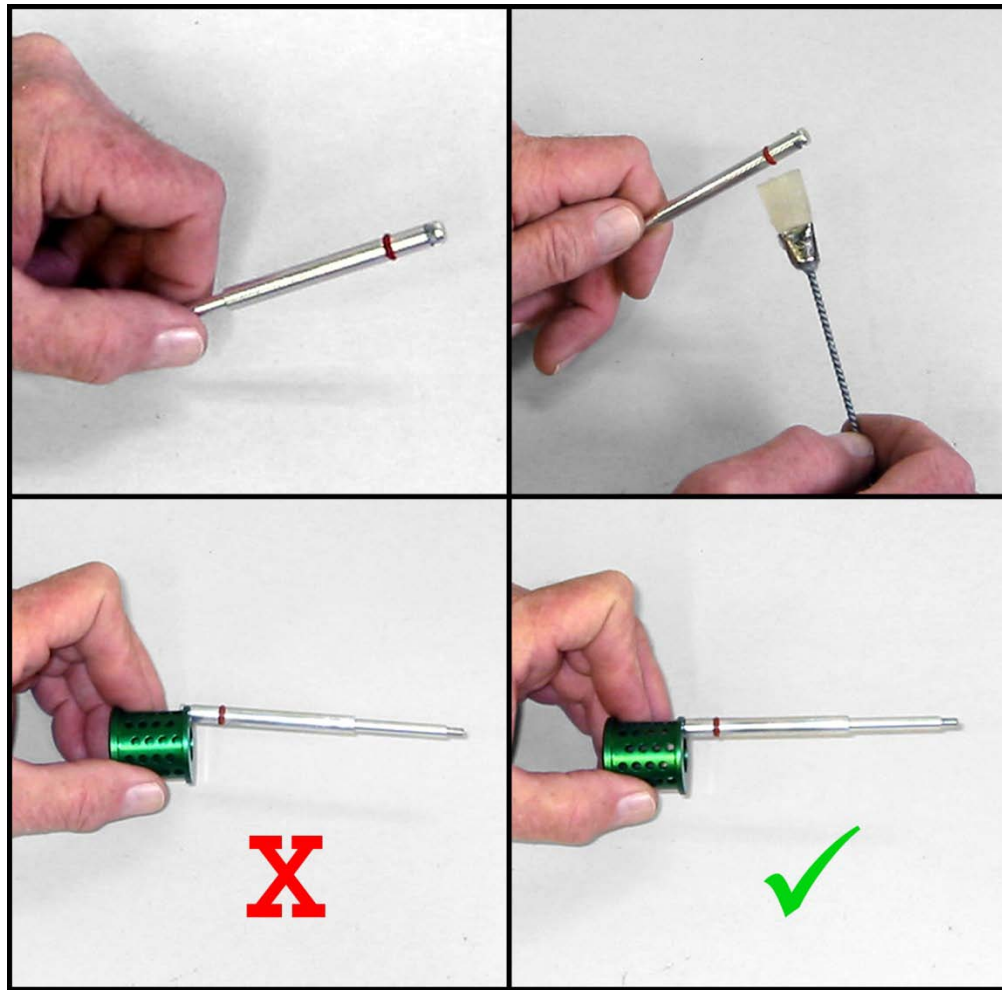
## Parts List:

<u>Part Description</u>	<u>Part #</u>	<u>Quantity</u>
2400 Gun Body	#2400A	1
Gun Tool Kit	#2400HGKT	1
Repair Kit	#2400RK	1
Quart Cup Gaskets (10 per package)	#2401	1
Pint Cup Gaskets (10 per package)	#2402	1
1/2 Pint Cup Gaskets (10 per package)	#2403	1
Stainless Steel Cup - Quart	#2404	1
Stainless Steel Cup - Pint	#2405	1
Plastic Cup - 1/2 Pint (3 per package)	#2406	1
Aluminum Cup - Quart	#2407	1
• Brass Barb	#2408	1
Aluminum Quart Cup Gaskets (5 per package)	#2410WH	1
• Trigger Axle Screw	#9030	1
• Trigger Axle Housing	#9031	1
• Teflon Needle Packing	#9034	1
• Front Packing Screw	#9035	1
• O-Ring for Aid Adjustment Screw	#9046	1
• Adjustment Rod Knurled Nut	#9048	1
• O-Ring	#9052	1
Air Cap: A - Small Fan	#9060	1
B - Medium Fan	#9061	1
C - Medium/Large Fan	#9062	1
BC - Full Fan	#9065	1
Fluid Tip: A - 0.5mm	#9070	1
B - 0.75mm	#9071	1
C - 1.0mm	#9072	1
D - 1.25mm	#9073	1
E - 1.5mm	#9074	1
G - 2.0mm	#9076	1
H - 2.5mm	#9077	1
• 3/8" NPT Stainless Steel Fluid Fitting	#9233	1
Needle Guide Lock Nut	#9240	1
Needle Guide	#9241	1
• Trigger Return Spring	#9243	1
• Sleeve for Air Adjustment Screw	#9245	1
• Air Adjustment Screw	#9247	1
• Shuttle Rod	#9253	1
Fluid Needle: A - 0.5mm	#9280	1
B - 0.75mm	#9281	1
C - 1.0mm	#9282	1
D - 1.25mm	#9283	1
E - 1.5mm	#9284	1
G - 2.0mm	#9286	1
H - 2.5mm	#9287	1
• Gun Trigger	#9295	1
• Sleeve	#9296	1
• Fluid Adjustment Screw	#9297	1
• Fan Piston	#9359	1

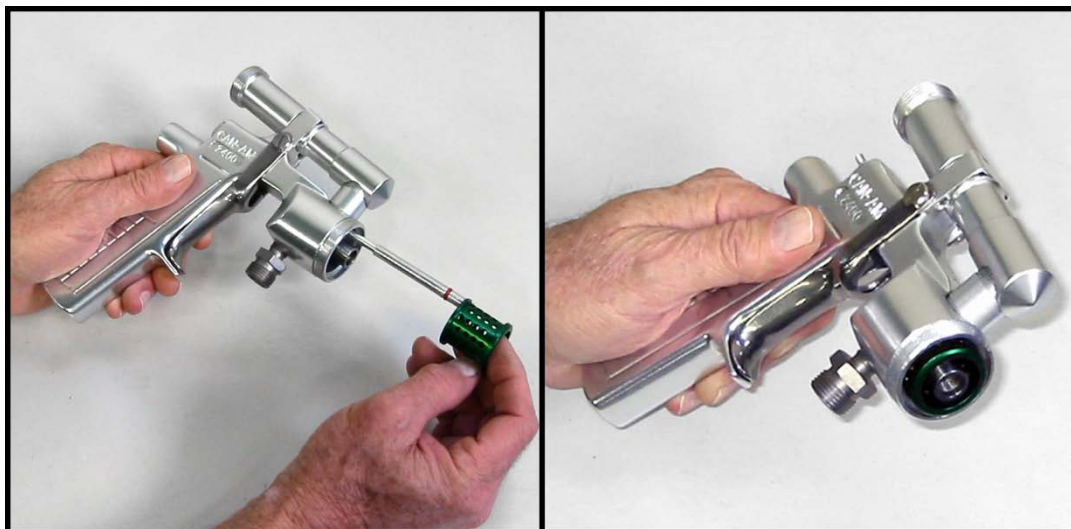
( • indicates that this item generally comes pre-assembled on the gun body)



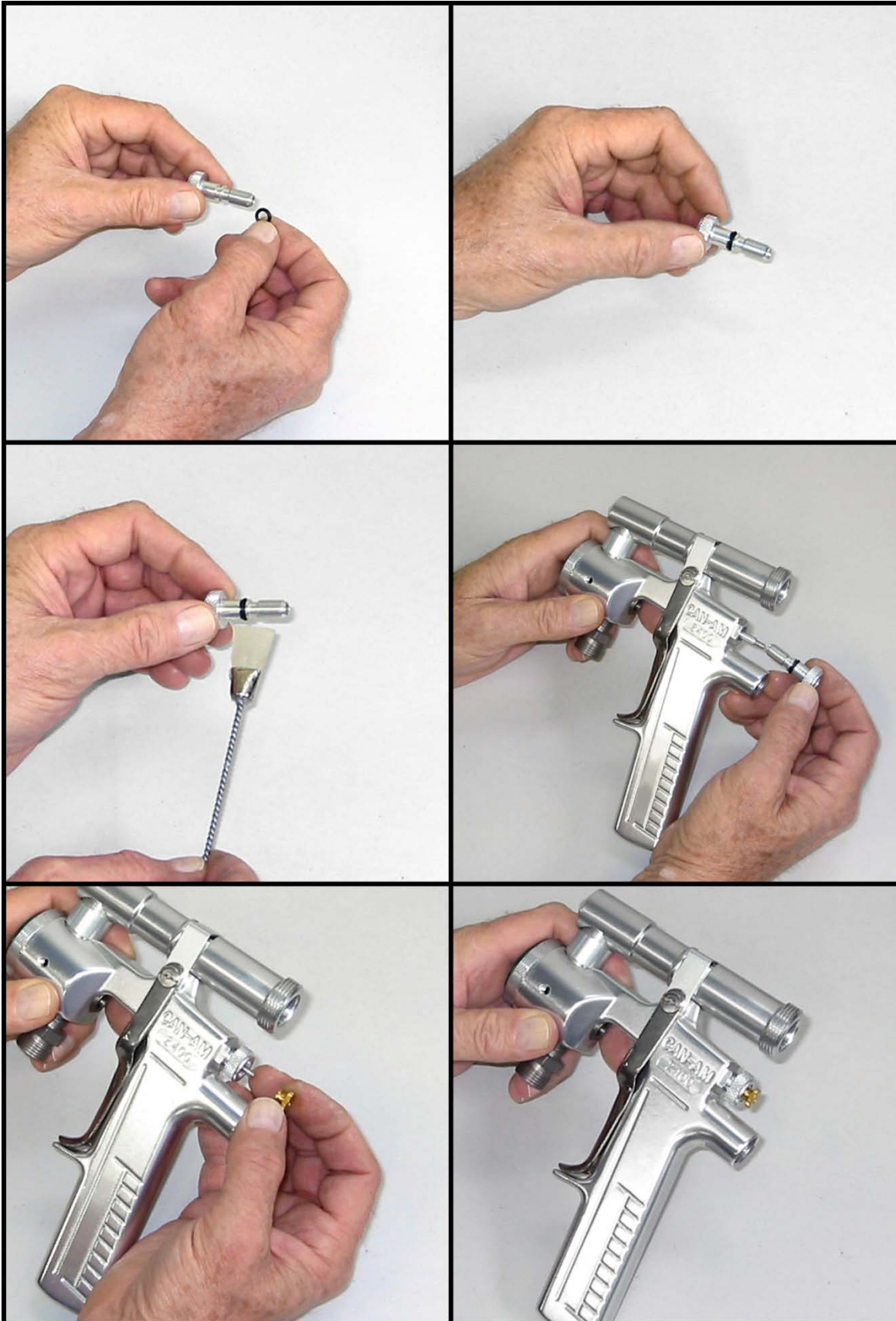
- 1.) **Use Compressed Air to thoroughly blow out Gun Body.**
- 2.) **Assemble Fan Piston to Shuttle Rod.** Make sure that the O-Ring on the Shuttle Rod is not cracked. If it is, replace with a new one. Use petroleum jelly to lubricate the O-Ring and surrounding area of the Shuttle Rod. Place the Fan Piston on the Shuttle Rod so that it hangs pointed straight. If it sags, remove and rotate the Shuttle Rod 180° so that it hangs properly.



- 3.) **Insert Shuttle assembly into the gun body.** Insert as shown in the pictures. Make sure it goes all the way back to ensure proper assembly.



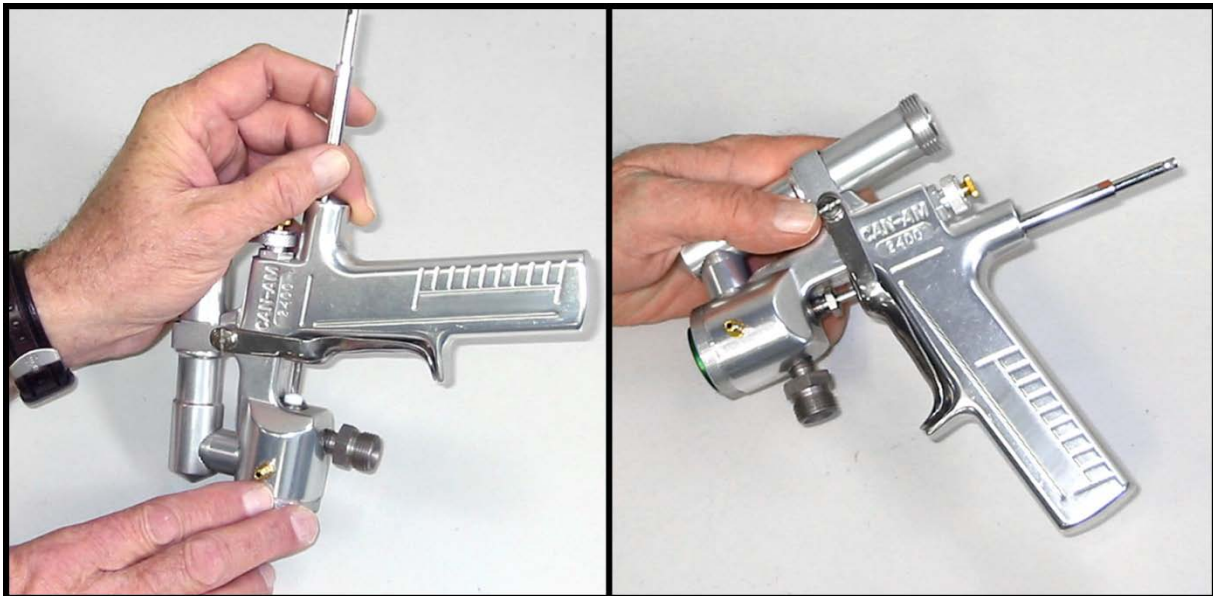
- 4.) **Attach Air Adjustment Screw.** Apply petroleum jelly to the threads and O-Ring of the Air Adjustment Screw. Insert it into the sleeve and thread it in all of the way. Put the Shuttle Rod Nut on the end and tighten down by hand. Use pliers to tighten it fully. Check to make sure the Air Adjustment Screw can turn freely.



- 5.) **Attach Brass Barb to Gun Body.** Apply Loctite to threads, then hand thread in to the Gun Body. Tighten with a 1/4" wrench.



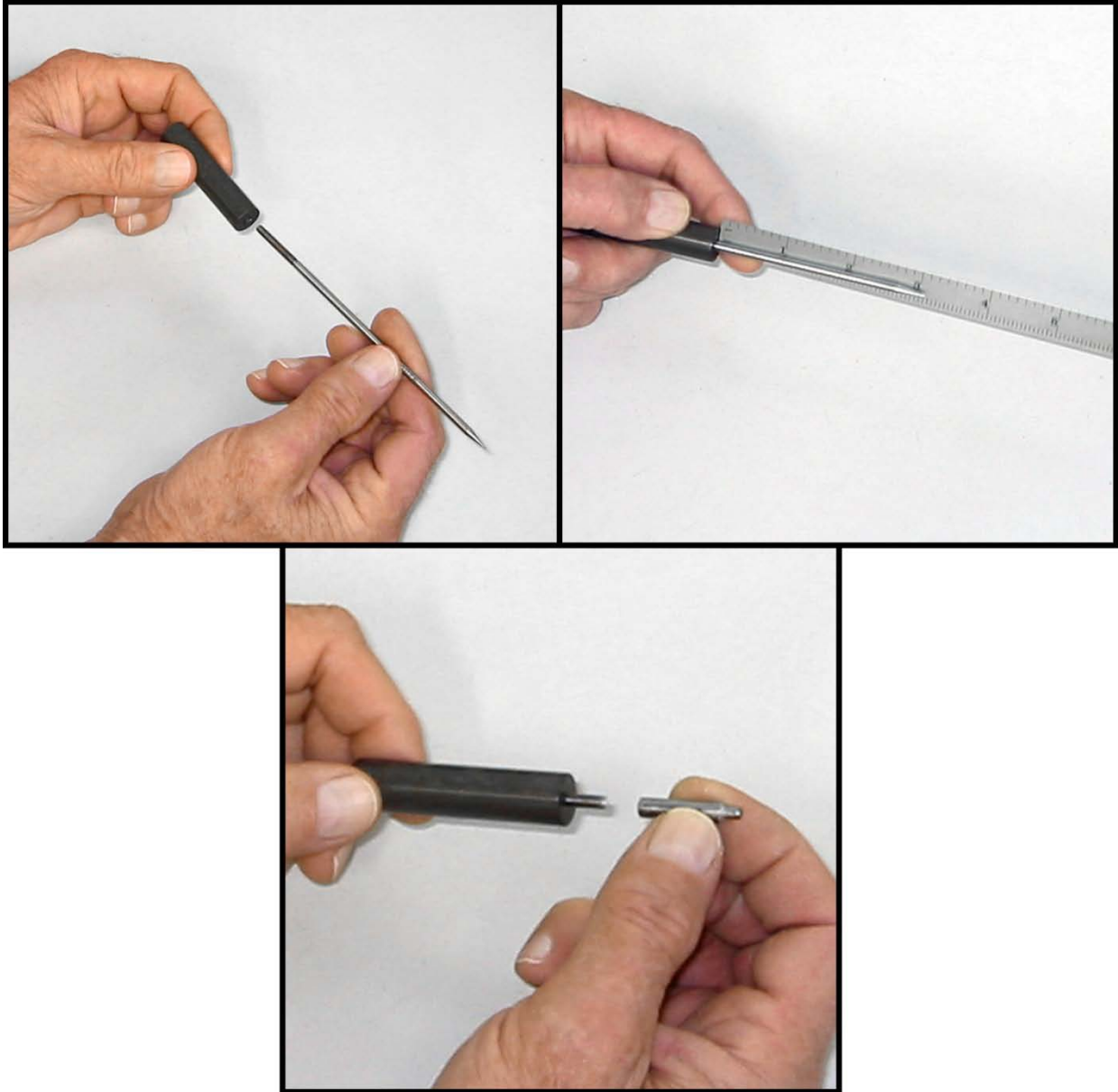
- 6.) **Insert Packing** Insert the Packing into the hole on the front side of the gun, using an old needle to properly align it. Then thread the packing nut into the hole by hand, again using the old needle to guide it.



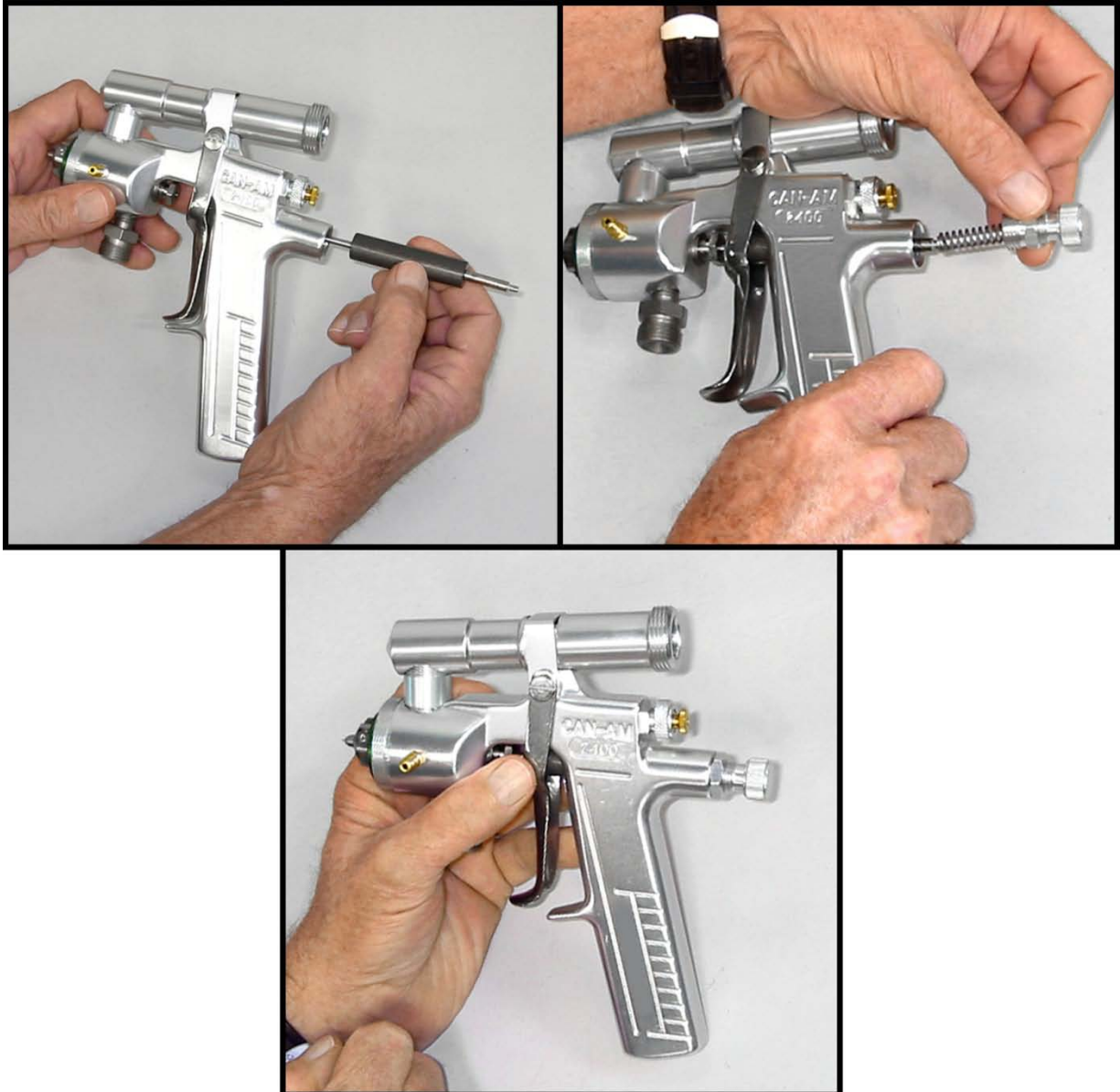
- 7.) **Attach Nozzle.** Thread Nozzle into the fluid tube. Tighten firmly using a Nozzle Wrench or an 18mm Socket Wrench.



- 8.) **Assemble and adjust the Fluid Needle Assembly.** Take the Fluid Needle and thread it into the Needle Guide as shown in the picture. Measure from the end of the Needle Guide to the tip of the Fluid Needle. This measurement is specified at 3.125" (3-1/8")  $\pm$  0.05". Once the Needle Fork is properly positioned, thread the Lock Nut onto the back of the needle until it locks against the Needle Guid. Finally, hold the Needle Guide to keep it from twisting, and use pliers to tighten the Lock Nut against the Needle Guide so that it locks its position.



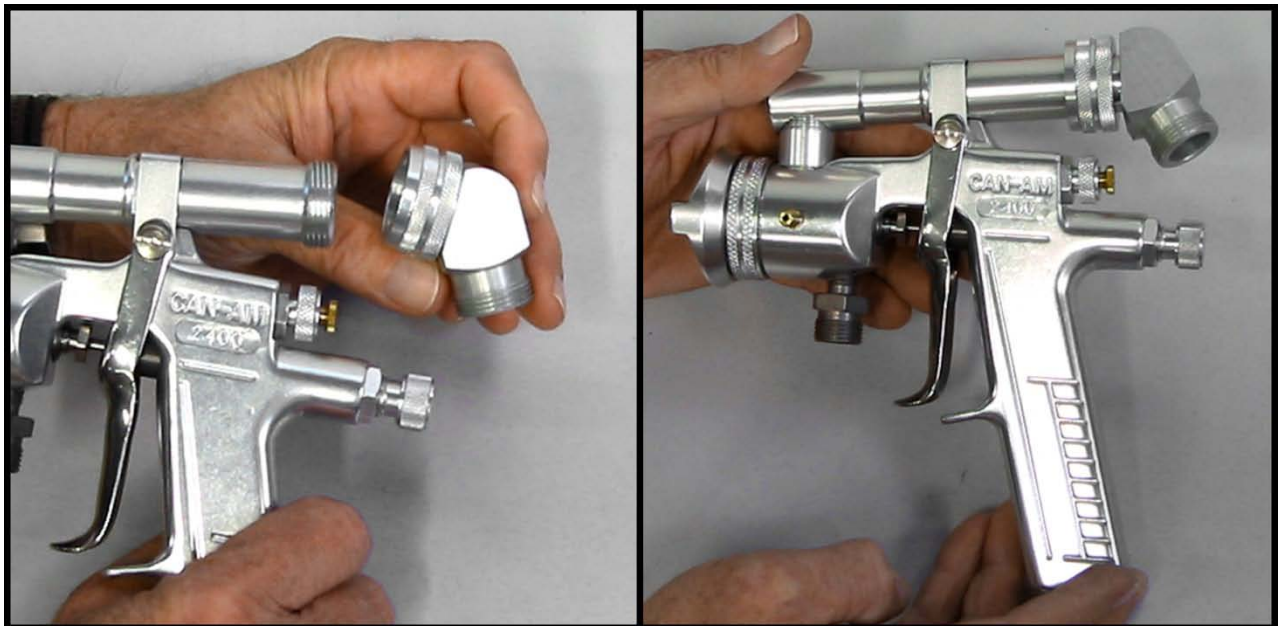
- 9.) **Insert Needle and Attach Fluid Adjustment Screw.** Using petroleum jelly, lubricate the Needle Assembly from the Lock Nut until 1" before the tip of the needle. Insert the Needle Assembly into the Gun Body. Apply petroleum jelly to the threads of the Sleeve and the Fluid Adjustment Screw, as well as the Spring. Thread the Sleeve into the back of the Gun Body. Tighten with wrench. Insert the spring over the Needle. Thread the Fluid Adjustment Screw into the Sleeve. Grip the gun and squeeze the trigger fully, then tighten the Fluid Adjustment Screw by hand until the trigger of the gun starts to move.



10.) Attach the Air Cap.



11.) Attach the Air Fitting.



- 12.) **Adjust the Packing Nut.** Tighten the Front Packing Screw to the point that the Needle is snug when moving. If fluid leaks, tighten the Front Packing Screw. If it is too snug and the trigger sticks, loosen the Front Packing Screw slightly.

