	Ins	tructio	n Manı	ıal		FORCE WB	Hand Spray Gun
Symbol Marking on the Spray Gun:	((
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This MEJJI AIR spray gun complies with 2014/34/eu Directive relating to equipment and protective systems intended for use in axplosive potentially atmospheres.	Complies with European Directive	Specific Marking for Explosion Protective	Group II (Surface)	Z Category (Zone 1&2)	Type of Atmosphere (GAS)	Ignition Protection (not applied)	Additional conditions: Any static Electricity should be discharged and needs to be diverted to the ground via a conductive air hose not included.
Thank you for purchasing	MEIJI Han	d Spray Gu	n.				
		Bef	ore Usin	g this Pro	duct		
To ensure safe and proper use of this After reading this operation manual, in To lend or transfer this product, attace If this operation manual is lost or dan To improve the product quality or perf the illustrations may be different from the I you have any question or comment	keep it in place h this operation aged, immedia formance or to o nose of the actu	for your quick refe manual to the pro- tely order a new o ensure safety, the al product. uct, contact the dis	rence whenever oduct. ne from our auth parts used in the stributor of this pr	required. orized dealer or dis product are subject oduct or our autho	tributor. to change. In this c rized dealer or distri	ase, note that the de butor in your district.	scription and some parts ir
	UTION	or neglect		ate precautio			handling manners, ath, and/or serious
Fire and Explosion							
 Provide a fire extinguisher'in y. 2. Do not use a halogenated hy Chemical reaction with the solvent: methyl trichloroethane, etc. Before using a special paint or 3. Connect ground cable. Ground spray gun securely grophotogeneous particities and the solvent of the secure of	ydročarbon vent causes : chloride, eth paint thinner or example, u unded, it ger an BOdy e to select a a airtight roon d protective k, always we hazard, if the nagloves. ar ear plugs ise level of 8	solvent. spray gun body yi chloride, me t, thoroughly ch se hose with gr herates sparks of or insufficienti or insufficienti ogear. ar appropriate e paint touches for health and o db (A) or higi	thylene dichlo eck if the mate round wire. of static electri place with a bo y ventilated pla clothes and pr eyes or the sh	ride, ethylene c srial is compatib city, causing a f poth. ace, you may su otective gear (g in. Check the p	lichloride, carbo le or not. ire and explosior ffer poisoning ca oggles, G-7-04 n aint and solvent	n. aused by organic : nask, and gloves) being used. Duri	solvent, or a risk facto
 Pulling the trigger many times Improper Handling To not direct spray gun tow Never attempt to spray gun to Failure to observe this instructi Use spray gun within the ma Never use spray gun at a press During interruption of work, Before cleaning, disassembly or r If compressed air is remaining To release compressed air, std. Do not touch the tip of the ne The tip of the needle valve and 	of Equi- ard people. oward people on may resu ximum ope sure higher til release con naintenance/ii in spray gun op supplying eedle valve	or animals. It in inflammatic rating pressur nam the maximu pressed air. hspection of spra it may accider compressed air and paint nozz	ons of eyes an e. um operating p ny gun, or during tally work, or i r, paint and pa zle during ma	d the skin, or ot bressure (0.69 M g a halt of spray v cleaning solveni int thinner to spi intenance .	IPa). vork, be sure to re may spatter, ca	lease compressed using a hazard to	
Other Precautions 1. Do not modify spray gun. I gou modify spray gun, I gou modify spray gun, I gou nodify spray gun, To conduct spray work in an oper I gou touch a robot or reciproc 3. Do not use spray gun for food Corrosion of paint circuit may r 4. If an abnormal condition occ	not provide s ating area of o ating equipm od and chen	ufficient perforn other equipment ient, you may g	nance. Also, a (robot, reciproc et injury.	failure of the ma	etc.), confirm that	the equipment has	stopped first.
4 It on obnormal condition on	esult in an a	cident. Also, fr	ixture or ioreiq	gn substances n	nay result in hea	Ith disorder.	

3. Specifications

Model	Paint feed system	Paint nozzle bore mm		Spraying distance mm		Air consumption L/min	Paint spraying volume mL/min	Maximum effective pattern mm	Connection bore	Weight g
FINER-FORCE WB	Gravity	2.0	WB	200	0.2	225	200	290	G1/4 (Air/paint)	325

%Paint viscosity is 22 seconds if you use automobile-repair water-based paint and a Meiji V-1 Viscosity Cup.

4. List of Components



No.	Name	Qty.
1	Body	1
2	Paint nozzle	1
3	Air cap set	1
6	Needle valve set	1
8	Baffle plate	1
10	Needle spring	1
11	Spring insert	1
12	Paint adjusting screw	1
13	Needle cylinder	1
14	Trigger	1
15	Trigger pin (for resin)	1
16	Trigger screw	1
17	Pattern control valve set	1
23	O-ring S10 FKM	1
24	U packing P6	1
25	Needle packing screw set	1
27	Air valve	1
28	Air valve spring	1
29	Trigger stopper	1
30	Valve seat set	1
31	O-ring S12.5 FKM	1
34	Air volume control valve set	1
38	Hexagon nipple 1/4×M11G	1
40	Gun stand	1
41	Hexagon socket headless screw M12×1	1
42	Needle valve spring set (with spring insert)	1
Accessory	Identification ring / spanner set	1

1. Operation Procedure

1. Mount a paint cup and an air hose to the spray oun by using a spanner or other tool.

- 2. The appropriate spraying pressure is between 0.15 and 0.25 MPa. However, this value varies depending on the viscosity and properties of the paint, and the working conditions. DO NOT use the spray gun above the stipulated maximum working pressure (0.69 MPa).
- 3. Appropriate spraving distance is between 100 mm to 200 mm. If the spraving distance is too short, or if you sprav paint while moving the gun in a circular motion, a good result cannot be achieved.
- 4. To achieve a uniform result, always hold the spray gun perpendicular to the paint surface.



5. Tightening the air volume adjusting screw counterclock will decrease the air volume, and loosening the air volume adjusting screw clockwise will increase the air volume

- 6. If you tighten the pattern adjusting screw by turning it clockwise completely, paint is sprayed in a spot pattern. As you loosen the pattern adjusting screw by turning it counterclockwise, the spray pattern area gradually increases. When you rotate the screw approximately three times,
- the pattern area becomes the maximum. Adjust the spray pattern depending on the spray work step and the type of paint being used. 7. If you tighten the paint adjusting screw by turning it clockwise, the spray volume decreases. As you loosen the screw by turning it counterclockwise, the spray volume gradually increases. When you rotate the screw three to four times, the spray volume becomes the maximum. Set the paint volume depending on spray work conditions.



Air adjusting scree

8. Setting guidelines for various adjusting mechanisms (These values are just an example, and actual values vary depending on the various conditions. See the paint manufacturer's specifications before setting values.)

Setting condition example	Solid	Metallic pearl	Clear
Model	WB	WB	WB
Paint adjusting screw (Number of rotations)	Fully open	Fully open	2.5 to 3
Pattern adjusting screw (Number of rotations)	Fully open	Fully open	Fully open
Gun distance (mm)	150 to 200	150 to 200	200
Spraying pressure (MPa)	0.15 to 0.2	0.15 to 0.2	0.18 to 0.2

2. Maintenance and Inspection

- 1. Clean and lubricate the spray gun every day to maintain it in the best operating condition.
- 2. Wipe dust off the spray gun body with a cloth damped with a solvent. Soaking the spray gun in solvent will not only remove lubrication, but also lead to painting problems due to adhering objects entering into the air circuit. We shall not be liable for any problems resulting from the use of a gun cleaner that causes dust or paint waste to enter the air circuit of paint nozzle or air cap.
- 3. After using the spray gun, be sure to clean it with a clean solvent, and leave the cup empty.
- 4. To clean the cup, remove excess paint and pass an appropriate solvent through the cup to wash off residual paint.
- 5. Using the spray gun for painting while cleaning solvent is in the gun or cup, or while paint waste, dirt, etc. are in the paint circuit will result in a painting failure
- 6. After disassembling the air cap set (3) and paint nozzle (2), clean them with a brush. When disassembling the paint nozzle, be careful not to damage it.
- 7. To clean the paint circuit, spray a small quantity of solvent in the same manner as spray work.
- 8. Be sure not to damage each hole of the air cap set (3), and the center hole and tip periphery of the paint nozzle (2).
- 9. If the needle valve set (6) or air valve (27) malfunctions, apply a small quantity of oil (non-silicone oil) to the sliding part from the outside.
- Always remove any remaining water after cleaning, as failure to do so can cause rust.
 Do not soak the entire spray gun and the air cap set (3) in liquid such as solvent (cleaning solution). Soaking them for a long time will damage their components. -2-

5. Parts Replacement

Before replacing spray gun parts, remove residual paint, and then clean the spray gun. Then, release air pressure from the spray gun, and remove the air hose and paint cup.

To repair the spray gun, place it in a clean level place, and wear protective goggles. For parts replacement, use the specified appropriate tools. Replacement of paint nozzle and needle valve set (It is recommended that these parts should be simultaneously replaced.)

- 1. Remove the paint adjusting screw (12), and pull out the needle valve spring set (42) from the spray gun body.
- 2. Remove the air cap set (3).
- 3. Remove the paint nozzle (2) by using spanner 17 or socket wrench 17.
- 4. Tighten the paint nozzle (2) at a tightening torque of 10 N m by using a torque wrench. Please be careful of the directions of baffle pl Replacement of the air volume control valve set
- 1. Remove the air volume control valve set (34) with spanner 13.
- 2. Apply anaerobic sealing agent to the screw tip and tighten the screw.
- Replacement of the pattern control valve set
- 1. Before disassembling or assembling the pattern control valve set (17), turn the knob counterclockwise completely to loosen it.
- Replacement of the valve seat set, air valve, air valve spring, trigger stopper, and needle cylinder
- 1. Remove the paint adjusting screw (12), and pull out the needle valve spring set (42) from the spray gun body.
- 2. Remove needle cylinder (13) using socket wrench 11.
- 3. Remove the trigger stopper (29), air valve spring (28), and air valve (27) from the spray gun body. 4. Remove the valve seat set (30) by using hexagon wrench 10 so as not to damage the seat surface which makes contact with the air valve (27).
- (Do not use a ball-point hexagon wrench. This rule applies for the replacement below) 5. Tighten the valve seat set (30) by using hexagon wrench 10 until the seat touches the spray gun body. Then, re-tighten the seat lightly.
- 6. Insert the air valve (27) until it reaches the innermost end so as not to damage the seat surface. Then, insert the air valve spring (28) and trigger stopper (29).

7. Tighten the needle cylinder (13) with socket wrench 11.

Replacement of the needle packing screw set

1. Remove the needle packing screw set (25) using the supplied spanner 7. 2. Tighten the needle packing screw set (25) using the supplied spanner 7.

6. Failure Causes and Corrective Actions

Symptom	Cause(s)	Corrective action
Paint cuts out	Lack of paint in the paint container	Refill paint.
	The paint circuit is clogged.	Clean with solvent.
110000	The screw or paint nozzle (2) at the paint circuit connection is loose, or the taper seat area is damaged.	Tighten or replace.
BBBBBBBBBBBBBBBBBBBBBBBBBBBBBBBBBBBBBBB	The needle packing screw (25) is loose or worn.	Tighten or replace.
Imbalance	The square hole in the air cap (3) is partially clogged or damaged.	Clean or replace.
	Paint or dirt is adhering to the tip periphery of the paint nozzle (2).	Clean or replace.
Crescent	The square hole in the air cap (3) is partially clogged or damaged, or paint or dirt is adhered to the inside of the center hole, or it is damaged	Clean or replace.
	Paint or dirt is adhering to the tip periphery of the paint nozzle (2).	Clean or replace.
Thick in the	The bore of the paint nozzle (2) has been worn out and is larger.	Replace.
middle	Spraying pressure is too low.	Increase air volume and pressure.
W	Viscosity is too high.	Reduce viscosity.
Narrow in the	Spraying pressure is too high.	Reduce air volume and lower air pressure.
middle	Dirt or paint is adhering to the gap between the center hole of the air cap (3) and the periphery of the paint nozzle (2).	Clean.
Paint leakage from the	The needle packing screw set (25) is loose,	Adjust the needle packing screw (25).
needle packing screw	or worn.	Replace.
Fluid leakage from the	The paint nozzle (2) and needle valve set (6) are worn or damaged.	Replace.
tip of the paint nozzle	The needle packing screw set (25) or the needle valve set (6) is stuck.	Lubricate.
	The needle packing screw set (25) has been improperly adjusted.	Adjust.
Air leakage from Air valve	Seat surface of Air valve(27), Valve seat set(30) has dirt, damage or worn out.	Clean or replace
, an iounage month fur varve	Air valve spring(28) worn out.	Replace
	All valve spring(20) worn out.	Teplace

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