

## Operating Instructions for HDCBX-360-4 Paint Spray Coater

The HDCBX-360-4 Paint SpinCoater is designed to spray a various array of coatings on the interior of pipe.

The paint pump and the spincoater require a total of 150 CFM @ 100 psig of clean dry air to operate efficiently. A pressure tank may be used in place of the Bulldog pump if the paint viscosity is less than 20 seconds through a Zahn II cup.

The paint pump forces the coating through the spray gun and paint hose to the spinning head on the spincoater. The paint is slung by centrifugal force produced by the spinning head in a 360 degree pattern. The volume of paint directed to the spray head can be adjusted by the pressure on the paint pump or by the pre orifice used in the back pressure orifice assembly. The wet film thickness of the paint is controlled by the speed that the spincoater is moved through the pipe.

**NOTE:** Before spraying, flush the pump fluid section with solvent that is compatible with the paint to be sprayed.

After spraying, the pump fluid section must be flushed with compatible solvent and stored with a lubricant oil to preserve the pump packings. Do not store the pump dry.

The HDCBX-360-4 spincoater air motor should be connected to an air source and run with lubricating oil prior to and after use. Wet, dirty air will cause excessive wear and shorten the life of the air motor.

The following equipment is required to operate the HDCBX-360-4 tool.

- Graco 33:1 Bulldog paint pump
- 214-625 – Surge chamber with strainer
- 235-460 – Airless spray gun
- CP-4928-A – Back pressure orifice assembly
- 240-794 – 50’ of high pressure paint hose
- Air receiver tank with air regulator and gauge
- W-5038C – 50’ x 3/8” air hose



# HDCBX-360-4: Spray Coater with a 4" Head

Ideal for an 8"-17" ID pipe

	Part #	Description
1	HDCBX-LN	Locking nut
2	HDCBX-4	Spray Head
3	HDCBX-CCS-4	Centering collars
4	ISBO3641	Centering carriage
5	HDCBX-M	Manifold
6	HDCBX-AE	Arbor extension
7	HDCBX-MFM	Manifold fitting
8A	512018	.018" Preorifice
8B	512031	.031" Preorifice
8C	512039	.039" Preorifice
9	CP-4928-A	Back pressure assembly
10	HDCBX-150-4	Air motor

