



# OPERATION & Parts List

## Operating & Maintenance Instructions

Your Kraft Texture Machines are designed to spray a variety of texture coatings. Please read the following instructions before attempting to spray.

The Kraft \*PC300 and \*PC500 texture machines come with the following:

1. Gun & Hopper
2. 50' of 1/2" air line with fittings
3. Hose to compressor fittings
4. Compressor assembly with cart

### Assembly Instructions

#### Hose to Compressor

(1) Remove plastic plug located at the front of compressor. (See Figure #1)

Plastic Plug

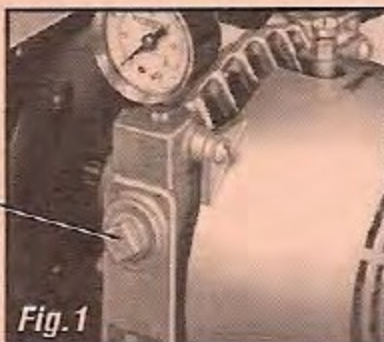


Fig. 1

(See Figure #2)

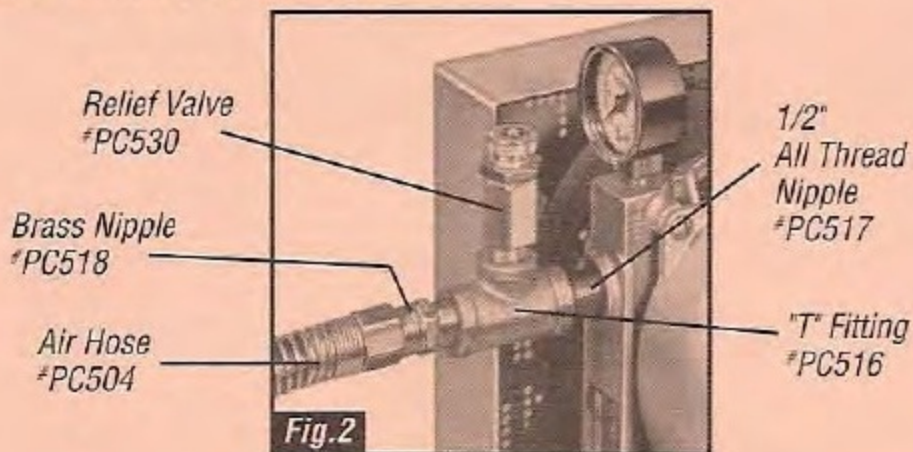
(2) Screw 1/2" all thread nipple into compressor.

(3) Screw "T" fitting into all thread nipple.

(4) Screw brass nipple into opposite end of "T".

(5) Screw relief valve into top side of "T".

(6) Connect air hose to brass fitting.



Relief Valve  
\*PC530

Brass Nipple  
\*PC518

Air Hose  
\*PC504

1/2"  
All Thread  
Nipple  
\*PC517

"T" Fitting  
\*PC516

Fig. 2

(7) Air hose connects to gun with a quick disconnect fitting. (See Figure #3)



Quick Disconnect  
Fitting #PC519

Fig. 3

### Spray Operation

The Kraft hopper has a special "Built in angle" which allows ceiling work without additional angle attachments.

After mixing, material is poured into the hopper. When the air line is connected to the gun, continuous air flows from the brass air tip. When the trigger is pulled, material mixed with the air flows through the orifice plate. When the trigger is released, material flow stops.

(Note: Trigger does not control air flow)

# Operating & Maintenance Instructions

The type of material and the desired finish are important concerns in spraying. The following points are crucial to the type of spray pattern your gun will achieve.

## (1) Material Consistency

Follow the material manufacturers instructions for correct consistency. A mix which is too stiff will not flow through the gun properly, resulting in irregular spray pattern.

**NOTE:** For best results, always mix texture material with a drill type mixer.

## (2) Air Requirement

The Kraft compressor unit is rated at 6.2 CFM free air at 25 PSI.

**(Note: If you are using your own compressor it must have an equivalent or larger capacity.)**

The Kraft compressor is designed for continuous operation. There is no holding tank which builds reserve air. When the compressor is running, a continuous supply of air will flow through the gun.

## (3) Pattern Adjustments

### (A). Size of orifice plate opening

The orifice plate found at the front of the gun has (5) different size openings to choose from. The plate can be rotated by loosening the orifice plate nut and the orifice clamp nut. The size of opening will determine the amount of material flow when the trigger is squeezed. The more material allowed to flow from the gun, the more coarse the pattern. **(See Figure #4)**

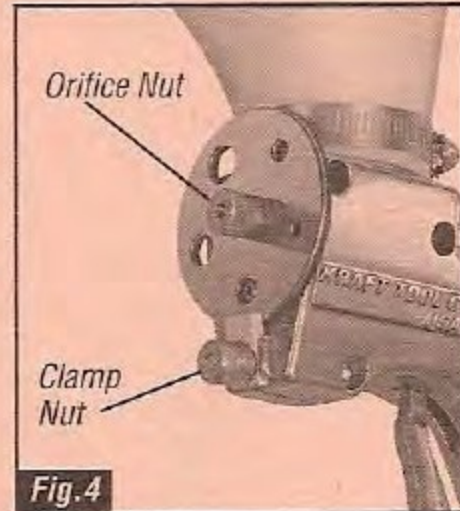


Fig. 4

### NOTE:

Orifice plate and air tip are preset at the factory for the most popular texture size.

### (B). Air flow

The amount of air which reaches the gun is controlled by the relief valve located at the front of the compressor. When tightened all the way down, the compressor will deliver maximum air to the gun. (Compressor air gauge will read 17-22 PSI with 1/8" air tip, 25-28 PSI with 3/32" tip.) As the relief valve is backed off, air will bleed off through the top of the valve. This will decrease the amount of air which will reach the gun. The more air supplied to the gun the finer the pattern. As pressure decreases, the pattern will become coarse, reaching a splatter texture at about 5-10 PSI. **(See Figure #5)**

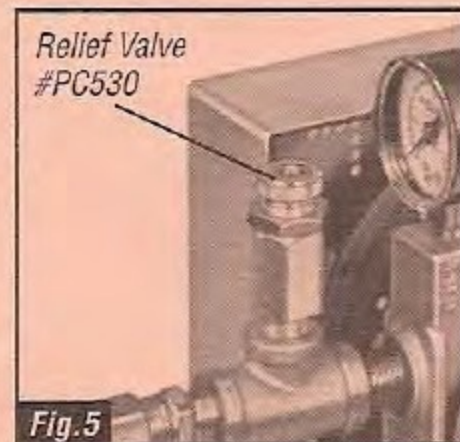


Fig. 5

### (C). Air Shut-Off Valve

The Kraft model (PC300) and (PC301) are supplied with an air shut-off valve at the rear of the gun. This valve should be used only with Tank Type Compressors. Using the shut-off valve with the Kraft rotary vane compressor is not recommended for the following reasons. **(See Figure #6)**



Fig. 6

(a.) Blocking the air flow at the gun creates excessive back pressure at the compressor - resulting in premature wear.

(b.) High back pressure increases electrical current flow which may cause the circuit breaker or fuse to open.

### (D). Trigger Stop Adjustment

The trigger stop found on the side of the gun can also be used to control the amount of material flow. When the trigger stop is all the way toward the rear of the gun, trigger has maximum travel, allowing for maximum flow of material. As the trigger stop is moved toward the front of the gun, trigger travel and material flow is reduced. As mentioned before, the more material, the coarser the pattern. **(See Figure #7)**



Fig. 7

**NOTE:** It is recommended that you set your pattern on scrap material before spraying your finished product. By experimenting with the various adjustments, you should be able to obtain your desired texture.

## Clean-up & Maintenance

It is not necessary to completely disassemble the gun after each spray operation. It is advisable to remove the gun from the hopper so that the bowl in the gun can be easily flushed with water.

After cleaning the gun, place a few drops of oil on the front bushing by turning the gun upside down, tilting the gun down and pulling back on the trigger. A couple of drops of oil on the air stem will help lubricate the front bushing. **(See Figure #8)**

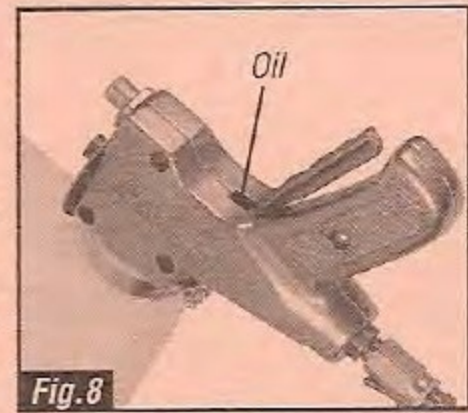


Fig. 8

Next place a few drops of oil on the rear bushing by pushing the trigger stop all the way forward. A couple of drops of oil on the air stem will help lubricate the rear bushing. **(See Figure #9)**



Fig. 9

### CAUTION:

When an extension cord is necessary, use at least 12 gauge cord, no longer than 100 ft. Extensions in excess of 100 ft. may cause voltage drops resulting in damage to the electric motor.

The electric motor on your compressor unit is covered by a one-year warranty by the original manufacturer. If motor problems develop, contact the nearest authorized service center. If the situation is not handled to your satisfaction, please let us know.

## Oiling Instructions for Rotary Vane Compressor

Please follow these instructions before operating compressor:

(1) At the top of the compressor you will find the glass oiler assembly. Oil flows from this assembly into the compressor through a wick type feed. Only a small amount of oil is necessary to provide sufficient lubrication. **(See Figure #10)**



Fig. 10

(2) To fill with oil, remove top portion of assembly by unscrewing hex nut. When filling with oil keep downward pressure on the glass to prevent leakage. Use only 20 or 30 wt. Detergent oil. It is only necessary to fill with 1/2" to 1" of oil.

### CAUTION:

Overfilling will cause excessive lubrication and may result in malfunction.

(3) On each side of the compressor you will find oiler stems with silver caps. These carry oil to the shaft bearings. A few drops in each stem every 8 to 10 hours of operation will provide sufficient lubrication. **(See Figure #11)**

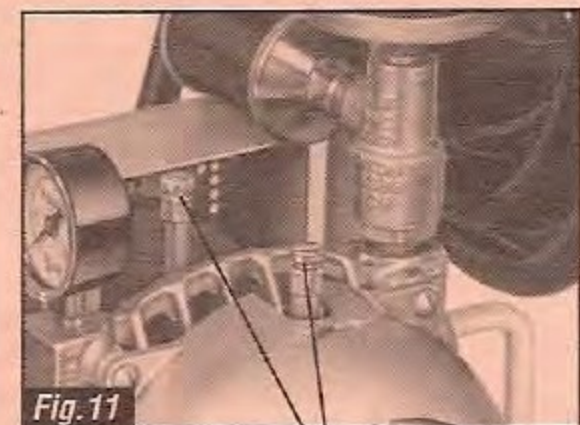


Fig. 11

Oiler Stems

**WARNING**  
Be safe, always wear safety goggles and filter mask while spraying.

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