



# HVLP Spray Guns

## 6613, 6614, 6617, 6618

**Transtar HVLP professional spray guns are designed to produce high quality finishes in all applications...high production, spot and panel refinishing and vehicle restoration. For professional top quality finishes. Available in 1.0mm, 1.3mm, 1.4mm and 1.7mm tips.**

### Products

Clearcoat & Color Gun HVLP (1.3 mm) Part #6613

/ This is perfect for applying basecoats, clearcoats and single stage top coats.

Clearcoat & Color Gun HVLP (1.4 mm) Part #6614

/ Provides excellent atomization of color and clearcoats for optimum coverage and leveling capabilities.

Primer Gun HVLP (1.7 mm) Part #6617

/ Excellent for solvent and waterborne primers, finishing fillers, self-etching primers and other fill and build coatings.

Touch Up Gun HVLP (1.0 mm) Part #6618

/ Designed to produce high quality finishes in touch-up, jambing, and detail refinishing.

*Note: 6618 is not recommended for use with waterborne products.*

### Product Specifications

	6613	6614	6617	6618
Gun Weight	17 oz (482 g)	17 oz (482 g)	17 oz (482 g)	11.3 oz (320 g)
Air intake	1/4" BSP	1/4" BSP	1/4" BSP	1/4" BSP
Max pressure @aircap	10 PSI	10 PSI	10 PSI	8.5 PSI
Max pressure @ gun	20 PSI	20 PSI	20 PSI	32 PSI
Air consumption	4-8 cfm	4-8 cfm	4-8 cfm	4 cfm
Cup type	Aluminum	Aluminum	Aluminum	Aluminum
Gun set-up (needle/nozzle)	1.3 mm	1.4 mm	1.7 mm	1.0 mm
Spray width	12"	12"	12"	8-10"
Cup capacity	600 CC	600 CC	600 CC	125 CC
Transfer efficiency	>65%	>65%	>65%	65%

**Set up & adjustment**

1. Starting
    - a. Use the spanner wrench to tighten the fluid nozzle.
    - b. Tighten the air cap and paint cup.
    - c. Before connecting to gun, check air lines and fittings to ensure that they are clean and damage free.
    - d. Soak gun thoroughly with cleaning solvent. Clean using approved cleaning materials according to local & federal regulations.
  2. Fan adjustment
 

Use the fan adjustment control on the left side of the gun to obtain the desired pattern.
  3. Air adjustment
 

Adjust the air pressure using the air adjustment knob at the bottom of the gun or the #6621 Air Regulator.
  4. Fluid adjustment
 

Use the fluid control knob to obtain the desired fluid flow volume.
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**Maintenance**

To assure proper fit and performance, always change air cap, fluid nozzle and needle as a matched set.

To change the needle packing, remove the fluid needle, fluid nozzle and the packing nut. A narrow, flat head screwdriver is required to remove the packing nut.

Cleaning and gun care:

- a. Immediately soak with solvent to remove all coatings after using.
- b. Clean the air cap with the brush provided.
- c. Lightly lube all moving parts with a non-petroleum based lubricant.

Note: Never use improper cleaning instruments as they may damage the part and adversely affect gun performance. Never immerse the gun in solvent.

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**Troubleshooting**

- Problem.....Gun is leaking from fluid nozzle.  
 Causes.....Fluid nozzle is loose, foreign particle or dried paint is keeping needle from seating.  
 Remedy.....Tighten nozzle or remove and clean nozzle.
- Problem.....Gun is leaking from needle sealing area.  
 Causes.....Teflon® packing is damaged or missing.  
 Remedy.....Replace Teflon® packing.
- Problem.....Gun sprays sickle-shaped to the left or right ) (  
 Causes.....Air holes are clogged on air cap or air cap is damaged.  
 Remedy.....Clean air holes or replace air cap.
- Problem.....Tear drop or oval-shaped spray pattern ◆  
 Causes.....Air cap is clogged at fluid needle orifice.  
 Remedy.....Remove and clean air cap and fluid nozzle.
- Problem.....Paint sputters from gun.  
 Causes.....Insufficient material in cup, material not filtered, fluid nozzle loose, needle Teflon® packing damaged, needle & nozzle are dirty.  
 Remedy: .....Refill cup, filter material, tighten loose parts, replace Teflon® packing, clean needle & nozzle.
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**Troubleshooting Cont.**

Problem.....Incorrect atomization.  
 Causes.....Inlet air pressure is too low or material is too thick; pressure is too high or material is too thin.  
 Remedy.....Adjust air pressure and/or product viscosity.  
*Teflon® is a registered trademark of DuPont.*

**Accessories Available for HVLP Spray Guns**

**Rebuild Kit**

6600 Rebuild Kit for 6613/6614/6617, 1/case

6601 Rebuild Kit for 6618, 1/case

**Needle Nozzle Kit**

6602 Touch Up HVLP Needle Nozzle Kit 1.2 mm, 1/case

6603 HVLP Needle Nozzle Kit 1.3 mm, 1/case

6604 HVLP Needle Nozzle Kit 1.4 mm, 1/case

6607 HVLP Needle Nozzle Kit 1.7 mm, 1/case

6608 Touch Up HVLP Needle Nozzle Kit 1.0 mm, 1/case

**HVLP and LVLP Air Regulator**

6621 Air Regulator 1/4", 1/case

**Medium Mesh Filters**

6635 Medium Mesh Filters for ALL Transtar HVLP spray guns, 6/package, 1 package/case

**Spray Gun Cups**

Select the size (125 cc, 600 cc or 1000 cc) and type of cup (aluminum or plastic) you prefer. All spray gun cups & lids will fit on the 6613, 6614, 6617, and 6618 HVLP spray guns.

6630 1000 cc Aluminum Spray Cup with Lid, 1/case

6631 600 cc Aluminum Spray Cup with Lid, 1/case

6632 125 cc Aluminum Spray Cup with Lid, 1/case

6633 600 cc Plastic Spray Gun with Lid, 1/case.

**17 Piece Spray Gun Brush Cleaning Kit**

17 piece brush kit for the cleaning of Transtar's spray guns.

6636 Spray Brush Gun Cleaning Kit, 1/case

**Replacement Seals**

6643 Cup Lid Seal for 6618, 1/case

6644 Cup Lid Seal for 6613/6614/6617, 1/case

6645 Plastic Air Baffle, 1/case



**Limitations & Precautions**

- Visit [www.tat-co.com](http://www.tat-co.com) to assure use of the most current instructions and TDS on this product.
- See website ([www.tat-co.com](http://www.tat-co.com)) for this document in other languages. (Vea el web site para este documento en español. Voir le site web pour ce document en français.)
- For use only by professional, trained painters. Not for sale to or use by the general public.

**LIMITED WARRANTY**

The successful performance of this product is dependent on many factors beyond our control. Results are dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Transtar Autobody Technologies, Inc. warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within shelf life as stated in this datasheet, Transtar Autobody Technologies, Inc. will, at its sole discretion, either replace the product or issue credit for the original purchase price of the product. The replacement or refund shall be the buyer's sole remedy and Transtar Autobody Technologies, Inc. and its affiliates MAKE NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, DESIGN COMPATIBILITY AND FITNESS FOR A PARTICULAR PURPOSE. LABOR OR COST OF LABOR AND OTHER INCIDENTAL AND/OR CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED. The technical data contained herein are true and accurate to the best of our knowledge. Published technical data and instructions are subject to change without prior notice.