

NOZZLE CHART FOR 700 SERIES HVLP GUNS

The Lemmer series 700 spray gun comes with the 1.4 mm nozzle set which is desired for most industrial finish applications. However, other combinations may be required for very fine finish work, or when spraying heavier materials.

Fluid set selection

Nozzle sets range in size to provide different fluid flow rates. For low flow rates or light viscosity fluid, select the smaller nozzle sizes. For high flow rates or high viscosity fluid, select the larger nozzle sizes. For the best atomization, use the fluid nozzle that will give the required flow with the needle fully triggered (a partially open needle may cause an uneven spray pattern).

Measuring paint viscosity

1. Thin paint according to paint can instructions. Be certain to use a thinner which is compatible with paint used. If no thinning instructions are given, a general rule of thumb is 5 to 15% thinners. (fine finish up to 35%)
2. Stir paint completely and strain.
3. Use the viscosity cup to measure paint as follows:
 - a) Submerge the **Lemmer Viscosity cup** in the paint.
 - b) Lift the cup out of the paint and begin timing.
 - c) Stop timing when the steady paint stream is first broken.
 - d) The time recorded is the paint's viscosity.
4. Now read the nozzle chart and choose the nozzle which lists the viscosity range (under "type of material") your material falls into.



Note: This nozzle chart has been made as accurately as possible. Not all paints will exactly comply due to paint ingredient variations. However, this chart is an excellent starting point for learning the basics spray painting.



Size	Air cap	Fluid nozzle & fluid needle	Type of material	Materials used
.5 mm.	L080-834 "S 1"	L080-840	thin 10 - 15 sec.	Ultra fine finish work with stains, dyes, ink, automatic touch up, spot jobs.
.7 mm.	L080-834 "S 1"	L080-841	thin 12 - 17 sec.	Fine finish work with all automotive finishes - color matching automotive base coat.
1.0 mm.	L080-834 "S 1"	L080-842	thin 14 - 19 sec.	Fine finish work with stains, lacquers, urethanes, enamels, automotive base/clear coats.
1.2 mm.	L080-834 "S 1"	L080-843	thin to medium 16 - 22 sec.	Medium speed application acrylic lacquers & enamels - urethanes, clear coats.
1.4 mm. (standard)	L080-834 "S 1"	L080-844	medium 16 - 25 sec.	Normal output with lacquer & enamels, urethanes, varnish, zinc chromate, automotive primers.(also thinned latex & oil base)
1.6 mm.	L080-835 "S 20"	L080-845	medium 18 - 25 sec.	Hi-build primers, medium speed industrial finishes.
1.8 mm.	L080-835 "S 20"	L080-846	medium 20 - 28 sec.	Higher speed industrial finishes.
2.0 mm.	L080-835 "S 20"	L080-847	heavy 22 - 30 sec.	Heavy output with lacquer & enamels, butyrate & nitrate dope & epoxies. Latex and oil wall paints.
2.8 mm.	L080-836 "20"	L080-848	heavy 30+ sec.	Wax base stripper. Sound deadeners. Latex paint.
3.6 mm.	L080-837	L080-849	very heavy	Special application.