

# USER MANUAL

## MODEL ONE STROKE

### AEROSOL PAINT FILLING MACHINE



442 SOUTH GREEN ROAD  
SOUTH EUCLID, OHIO 44121 USA  
VOICE: 216-481-4774  
FAX: 216-481-2427

PART #01-237



# TABLE OF CONTENTS

Introduction .....	2
Safety.....	2
Principle of Operation .....	2
Checklist.....	3
Air Supply.....	6
Setup & Operation .....	7
Maintenance & Troubleshooting .....	12
Adjusting the Safety Valve .....	12
Replacement Parts .....	14



## Introduction

Thank you for purchasing the Fillaero Systems Model One Stroke. Our improved design builds on over 25 years of industry leading experience in aerosol paint can filling while maintaining the repeatability, reliability, ease of use and technical support that you can expect from Fillaero Systems.

## Safety



**Safety First.** Read all instructions, warnings and cautions carefully. Follow all safety precautions to avoid personal injury or property damage

during use. Fillaero Systems cannot be responsible for damage or injury resulting from unsafe product use, lack of maintenance or incorrect product and/or system operation. Contact Fillaero when in doubt as to the proper safety precautions and operations. **Failure to follow the proper safety procedures can cause equipment damage and/or personal injury.**

## Principle of Operation

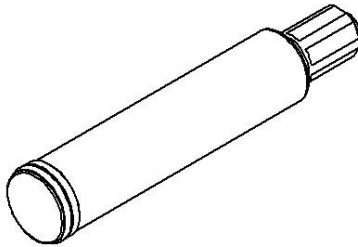
The Fillaero Systems One Stroke Machine is designed to fill one aerosol can at a time with a single stroke using 105 psi air supply. The One Stroke Machine can be used to precisely fill a wide range of aerosol cans ranging from 5 ounce to 20 ounce cans and equivalent metric sizes using a combination of different size Filling Rods and Can Spacers. The machine comes with 16 oz. Filling Rod and One Gallon Reservoir. If you need any Can Spacers, One Quart Reservoir or different size Filling Rods please contact us. If you are filling a 20 ounce can you will need to order the filling rod that is P/N 01-045.

This machine includes your choice of one of the following: Filling Heads; Female or Male when purchased. The Filling Heads can be used to fill one can at a time when no reservoir

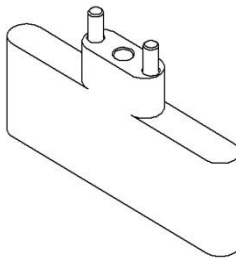
attached. Please contact us if you are not using these Filling Heads as we may be able to design one that fits your specific need.

## Checklist

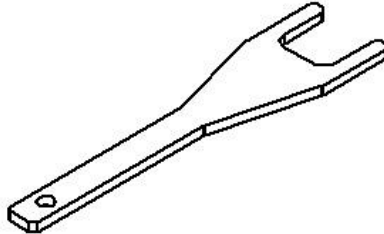
After carefully uncrating The Fillaero One Stroke Machine, examine the machine for shipping damage. If any is found, notify your carrier immediately. Open the door and remove the paint reservoir. It contains the following accessories:



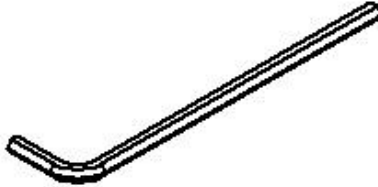
**Figure 1, (Qty. 1) P/N 01-134 (16 oz. Filling Rod Assembly)**



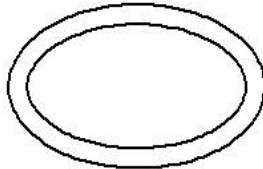
**Figure 2, (Qty. 1) P/N 100-20-FH (Spanner Wrench for Female Filling Head only)**



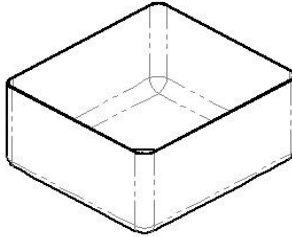
**Figure 3, (Qty. 1) P/N 01-171 (Filling Rod Wrench)**



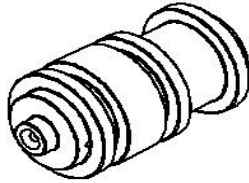
**Figure 4, (Qty. 1) P/N 01-176 (3/16" L-KEY)**



**Figure 5, (Qty. 1) P/N 01-107 O-RING**

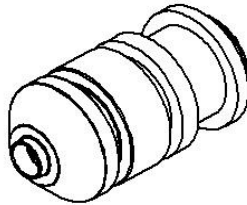


**Figure 6, P/N: 01-031 (ONE GALLON RESERVOIR)**



**Figure 7, P/N: 01-142 (MALE FILLING HEAD ASSEMBLY)**

OR



**Figure 8, P/N: 01-169 (FEMALE FILLING HEAD ASSEMBLY)**

If any part is missing, contact us or your distributor.

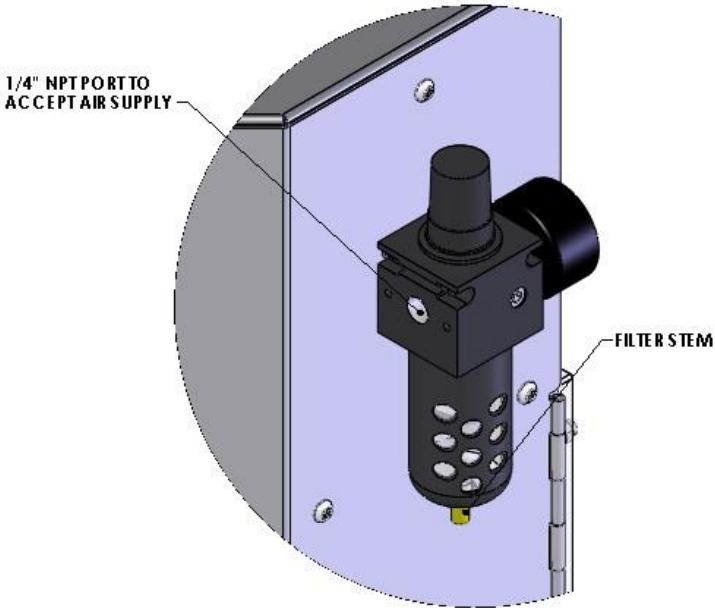


## Air Supply

The One Stroke Machine requires a 105 psi air supply at the Pressure Filter/Regulator Assembly (P/N 25-016). A minimum 1-1/4 horsepower compressor with pneumatic accumulator is required for operation of The One Stroke Machine. We recommend a 2 horsepower compressor or larger to ensure consistent air pressure. Connect the fitting for the air hose to the 1/4" NPT port on the Pressure Filter/Regulator as shown in **Figure 9, AIR FILTER/REGULATOR (P/N 25-016)**.

The built-in air filter will cause water to collect in the filter bowl (P/N 25-016-003) during operation. Empty the bowl daily by turning the stem at the base of the bowl (counter-clockwise) while the system is under pressure. It is important the air pressure remains constant. However, during the filling cycle, the piston pressure may drop to 90 psi, which is normal.





**Figure 9, AIR FILTER/REGULATOR (P/N 25-016)**

## Setup & Operation

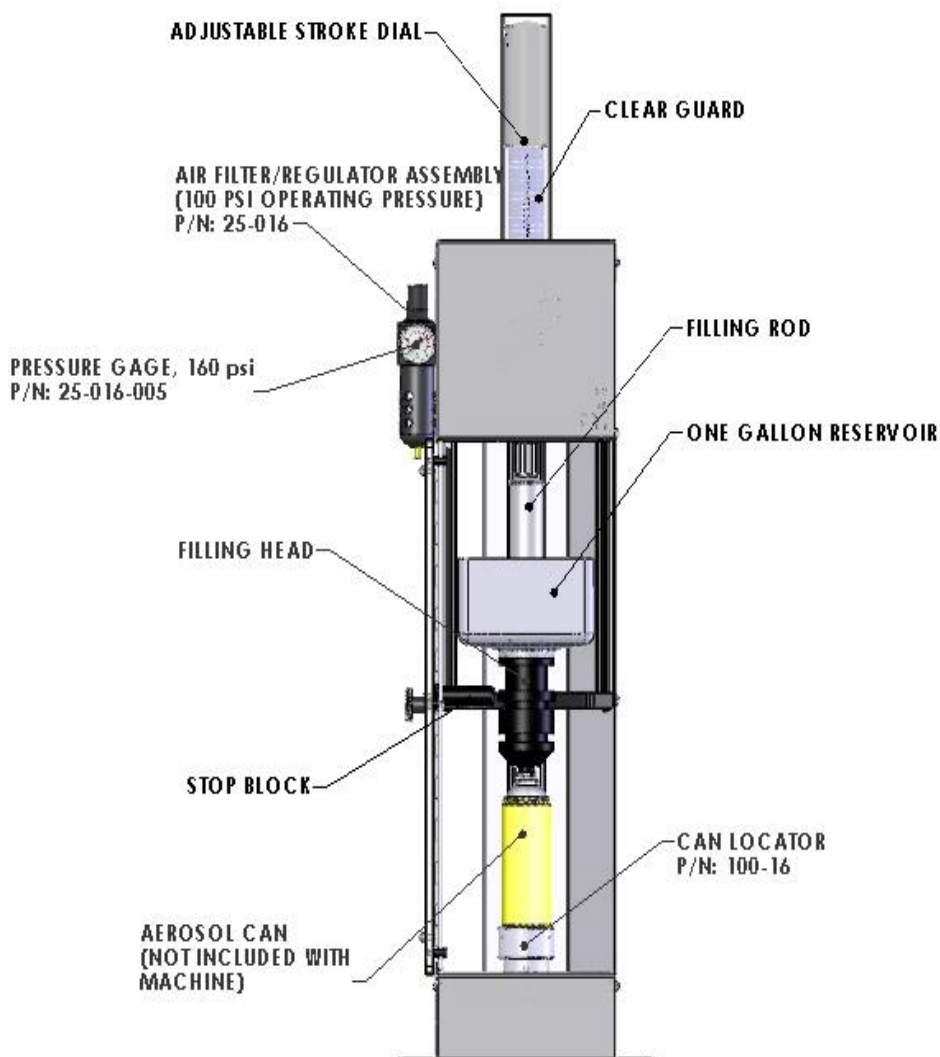


**PLEASE PUT SAFETY GLASSES ON PRIOR TO SETUP & OPERATION OF THIS MACHINE AND USE CAUTION WHEN LIFTING MACHINE AS IT IS TOP HEAVY.**

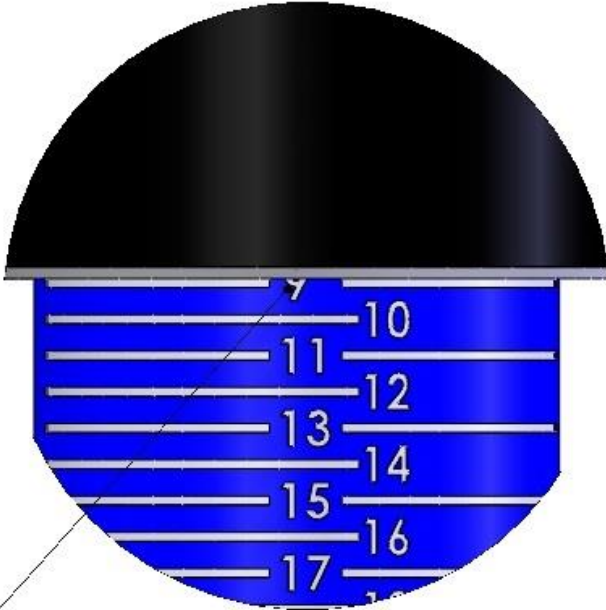
- 1) Place the machine on a sturdy bench then fasten it down with 3/8" diameter fasteners (not provided) at the base of the machine as shown in **Figure 12**.
- 2) Screw the Filling Rod to the Air Cylinder Rod



- 3) If a Can Spacer is needed place it on the Can Locator as shown in **Figure 10**.
- 4) Rotate the Volume Dial to line up with the corresponding graduation line. This is to achieve the correct volume of paint you are using as shown in **Figure 11**.
- 5) Insert the Filling Head/Reservoir Assembly into the One Stroke Machine on the Mid-cross Plate as show in **Figure 10**.
- 6) Pour paint into the Filling Head/Reservoir Assembly. It may be easier to do this by pulling the assembly forward and down as far as the Filling Rod Assembly will allow.
- 7) Lift the Filling Head/Reservoir Assembly and reposition it back on the Mid-cross Plate.
- 8) Set the Pressure Gauge to 105 psi.
- 9) Place an aerosol can on the Can Locator
- 10) Close the Door and rotate the Door Knob clockwise to start the Filling Rod in motion
- 11) After the can is filled, rotate the Door Knob counter-clockwise to retract the Filling Rod

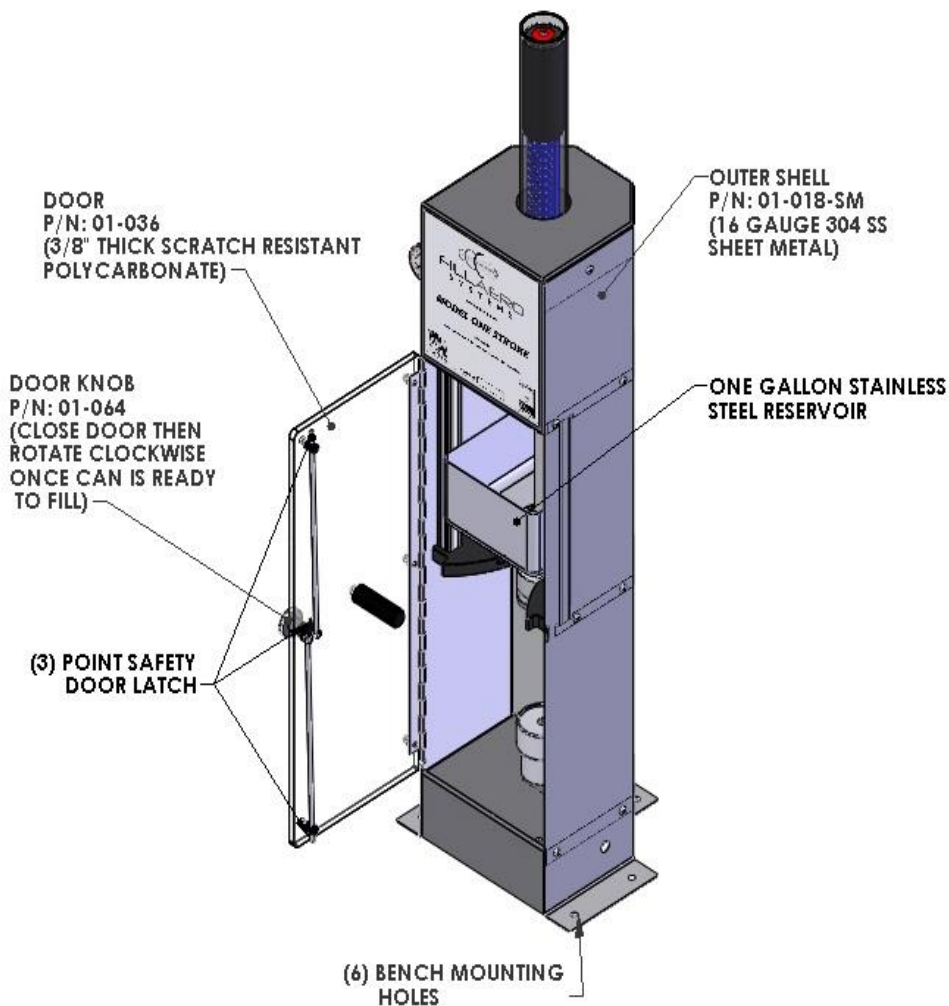


**Figure 10**



THE DIAL SHOULD BE SET BETWEEN 7 AND 13 TO FILL A 16 OZ CAN WITH 130-150 GRAMS OF PAINT. 7 CORRESPONDS TO ABOUT 150 GRAMS OF PAINT AND 13 CORRESPONDS TO 130 GRAMS OF PAINT.

**Figure 11, NOTE: THE GRADUATION LINE SETTING MAY SOMETIMES VARY DUE TO CLEANLINESS OF THE ONE STROKE MACHINE COMPONENTS AND TEMPERATURE CHANGES.**



**Figure 12**



## Maintenance & Troubleshooting



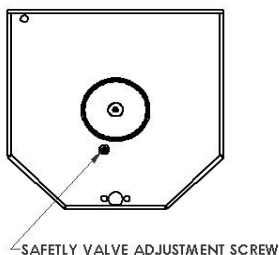
### **ALWAYS DISCONNECT THE AIR SUPPLY PRIOR TO CLEAN-UP OR MAINTENANCE OF THE MACHINE**

Keeping this machine free of dried up paint and debris is critical of proper function and longevity of the components.

#### **Adjusting the Safety Valve**

If the unit does not operate even after all the components are cleaned and there are no air leaks there is a good chance the aerosol can is not the correct height. If the can is not the correct height it will not allow the **Safety Valve Subassembly (P/N: 35-057-SA)** to actuate properly which does not allow the machine to function. Follow the steps below to adjust the Safety Valve

- 1) Pull the plug off the **Safety Valve Adjustment Screw** that is located behind the Can Platform shown in **Figure 13**
- 2) Obtain the 3/16" L-KEY (P/N: 01-176) that was purchased with the machine
- 3) Insert the L-KEY into the head of the screw and rotate a full turn as shown in **Figure 14, ROTATING SAFETY VALVE ADJUSTMENT SCREW**
- 4) Reinsert the can on to the Can Platform and try and run the machine again
- 5) Repeat Steps 1-4 if necessary until machine works properly
- 6) Replace the plug on the Safety Valve Adjustment Screw



**Figure 13**

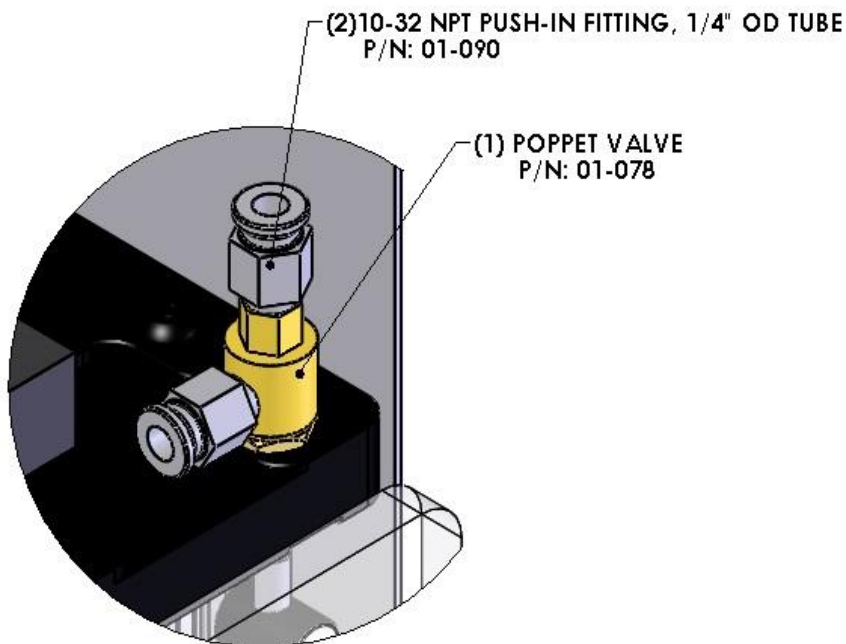


**Figure 14, ROTATING SAFETY VALVE ADJUSTMENT SCREW**

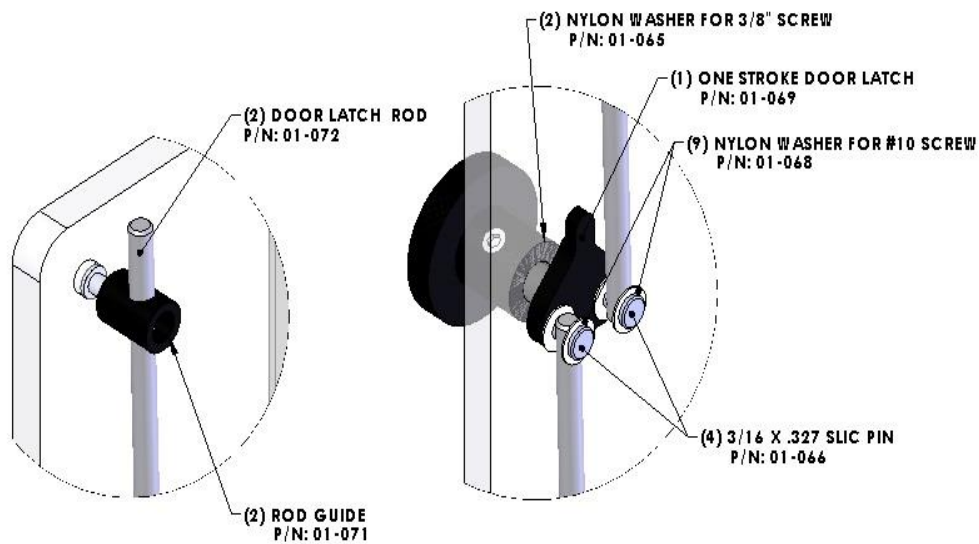
## **Replacement Parts**

Throughout this manual and **Figures 16-18** show common parts that might need to be repaired or replaced. If a part is not shown that needs repaired or replaced please contact us at 216-481-4774 or visit our website at [fillaero.com](http://fillaero.com).

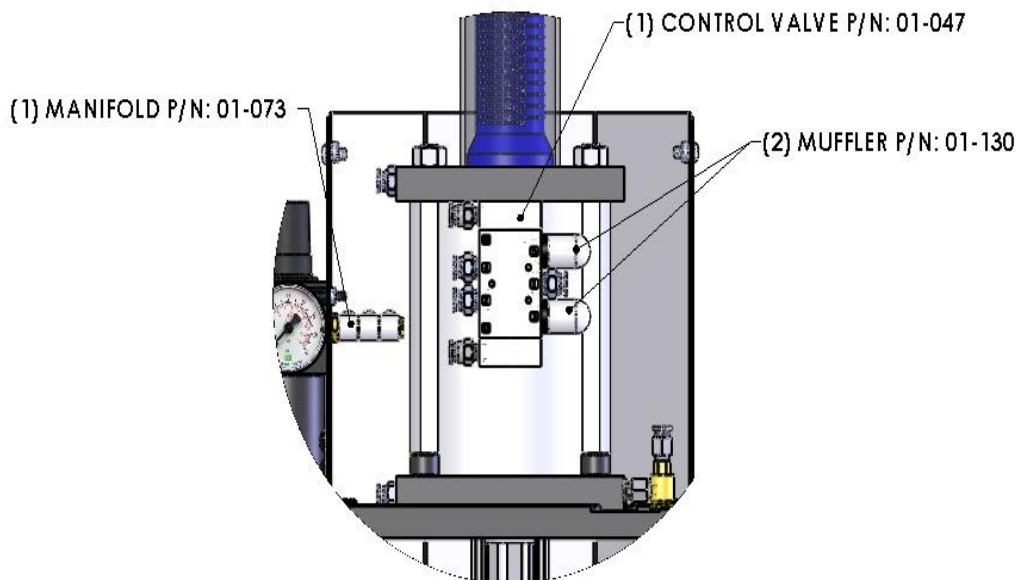




**Figure 15**



**Figure 16**



**Figure 17**