

# **Two-Component Dispensing Gun**

Customer Product Manual  
Part 107063-05

Issued 8/18



NORDSON CORPORATION • AMHERST, OHIO • USA

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# Change Record

<b>Revision</b>	<b>Date</b>	<b>Change</b>
C03	4/10	Added S2K manifold mount dispensing guns and 30-element extrude mixer tube and shroud.
C03	8/10	Added procedure for installing mixer shroud and tube assembly.
05	8/18	Added kit.



## Safety

Read and follow these safety instructions. Task- and equipment-specific warnings, cautions, and instructions are included in equipment documentation where appropriate.

Make sure all equipment documentation, including these instructions, is accessible to persons operating or servicing equipment.

### Qualified Personnel

Equipment owners are responsible for making sure that Nordson equipment is installed, operated, and serviced by qualified personnel. Qualified personnel are those employees or contractors who are trained to safely perform their assigned tasks. They are familiar with all relevant safety rules and regulations and are physically capable of performing their assigned tasks.

### Intended Use

Use of Nordson equipment in ways other than those described in the documentation supplied with the equipment may result in injury to persons or damage to property.

Some examples of unintended use of equipment include

- using incompatible materials
- making unauthorized modifications
- removing or bypassing safety guards or interlocks
- using incompatible or damaged parts
- using unapproved auxiliary equipment
- operating equipment in excess of maximum ratings

### Regulations and Approvals

Make sure all equipment is rated and approved for the environment in which it is used. Any approvals obtained for Nordson equipment will be voided if instructions for installation, operation, and service are not followed.

## Personal Safety

To prevent injury follow these instructions.

- Do not operate or service equipment unless you are qualified.
- Do not operate equipment unless safety guards, doors, or covers are intact and automatic interlocks are operating properly. Do not bypass or disarm any safety devices.
- Keep clear of moving equipment. Before adjusting or servicing moving equipment, shut off the power supply and wait until the equipment comes to a complete stop. Lock out power and secure the equipment to prevent unexpected movement.
- Relieve (bleed off) hydraulic and pneumatic pressure before adjusting or servicing pressurized systems or components. Disconnect, lock out, and tag switches before servicing electrical equipment.
- While operating manual spray guns, make sure you are grounded. Wear electrically conductive gloves or a grounding strap connected to the gun handle or other true earth ground. Do not wear or carry metallic objects such as jewelry or tools.
- If you receive even a slight electrical shock, shut down all electrical or electrostatic equipment immediately. Do not restart the equipment until the problem has been identified and corrected.
- Obtain and read Safety Data Sheets (SDS) for all materials used. Follow the manufacturer's instructions for safe handling and use of materials, and use recommended personal protection devices.
- Make sure the spray area is adequately ventilated.
- To prevent injury, be aware of less-obvious dangers in the workplace that often cannot be completely eliminated, such as hot surfaces, sharp edges, energized electrical circuits, and moving parts that cannot be enclosed or otherwise guarded for practical reasons.

### High-Pressure Fluids

High-pressure fluids, unless they are safely contained, are extremely hazardous. Always relieve fluid pressure before adjusting or servicing high pressure equipment. A jet of high-pressure fluid can cut like a knife and cause serious bodily injury, amputation, or death. Fluids penetrating the skin can also cause toxic poisoning.

If you suffer a fluid injection injury, seek medical care immediately. If possible, provide a copy of the SDS for the injected fluid to the health care provider.

The National Spray Equipment Manufacturers Association has created a wallet card that you should carry when you are operating high-pressure spray equipment. These cards are supplied with your equipment. The following is the text of this card:



**WARNING:** Any injury caused by high pressure liquid can be serious. If you are injured or even suspect an injury:

- Go to an emergency room immediately.
- Tell the doctor that you suspect an injection injury.
- Show them this card
- Tell them what kind of material you were spraying

**MEDICAL ALERT—AIRLESS SPRAY WOUNDS: NOTE TO PHYSICIAN**

Injection in the skin is a serious traumatic injury. It is important to treat the injury surgically as soon as possible. Do not delay treatment to research toxicity. Toxicity is a concern with some exotic coatings injected directly into the bloodstream.

Consultation with a plastic surgeon or a reconstructive hand surgeon may be advisable.

The seriousness of the wound depends on where the injury is on the body, whether the substance hit something on its way in and deflected causing more damage, and many other variables including skin microflora residing in the paint or gun which are blasted into the wound. If the injected paint contains acrylic latex and titanium dioxide that damage the tissue's resistance to infection, bacterial growth will flourish. The treatment that doctors recommend for an injection injury to the hand includes immediate decompression of the closed vascular compartments of the hand to release the underlying tissue distended by the injected paint, judicious wound debridement, and immediate antibiotic treatment.

### **Fire Safety**

To avoid a fire or explosion, follow these instructions.

- Ground all conductive equipment. Use only grounded air and fluid hoses. Check equipment and workpiece grounding devices regularly. Resistance to ground must not exceed one megohm.
- Shut down all equipment immediately if you notice static sparking or arcing. Do not restart the equipment until the cause has been identified and corrected.
- Do not smoke, weld, grind, or use open flames where flammable materials are being used or stored.
- Do not heat materials to temperatures above those recommended by the manufacturer. Make sure heat monitoring and limiting devices are working properly.

- Provide adequate ventilation to prevent dangerous concentrations of volatile particles or vapors. Refer to local codes or your material SDS for guidance.
- Do not disconnect live electrical circuits when working with flammable materials. Shut off power at a disconnect switch first to prevent sparking.
- Know where emergency stop buttons, shutoff valves, and fire extinguishers are located. If a fire starts in a spray booth, immediately shut off the spray system and exhaust fans.
- Shut off electrostatic power and ground the charging system before adjusting, cleaning, or repairing electrostatic equipment.
- Clean, maintain, test, and repair equipment according to the instructions in your equipment documentation.
- Use only replacement parts that are designed for use with original equipment. Contact your Nordson representative for parts information and advice.

### **Halogenated Hydrocarbon Solvent Hazards**

Do not use halogenated hydrocarbon solvents in a pressurized system that contains aluminum components. Under pressure, these solvents can react with aluminum and explode, causing injury, death, or property damage. Halogenated hydrocarbon solvents contain one or more of the following elements:

<u>Element</u>	<u>Symbol</u>	<u>Prefix</u>
Fluorine	F	"Fluoro-"
Chlorine	Cl	"Chloro-"
Bromine	Br	"Bromo-"
Iodine	I	"Iodo-"

Check your material SDS or contact your material supplier for more information. If you must use halogenated hydrocarbon solvents, contact your Nordson representative for information about compatible Nordson components.

### **Action in the Event of a Malfunction**

If a system or any equipment in a system malfunctions, shut off the system immediately and perform the following steps:

- Disconnect and lock out system electrical power. Close hydraulic and pneumatic shutoff valves and relieve pressures.
- Identify the reason for the malfunction and correct it before restarting the system.

### **Disposal**

Dispose of equipment and materials used in operation and servicing according to local codes.

## Description

See Figure 1.

The Two-Component dispensing gun is used in applications that require precise mixing of two component adhesive materials. Standalone and manifold mount versions are available.

### Standalone Dispensing Gun

Two component adhesive materials consist of both a base and a catalyst component. A metering system delivers the base material into the base material inlet (5) and the catalyst material into the catalyst material inlet (6).

The dispensing gun is air operated. Compressed air enters on the right side into the base air-open inlet (1) and the base air-close inlet (2) to move the packing cartridge stem.

On the left side of the dispensing gun, air enters the catalyst air-open inlet (9) and the catalyst air-close inlet (8) to move the packing cartridge stem.

Both materials remain separate throughout the dispensing process until they combine in the dispensing gun mixer tube.

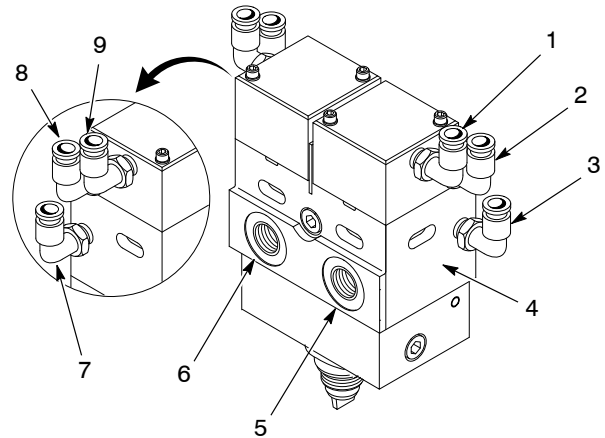
A temperature conditioning system delivers a constant flow of water into the water port inlet (7) and out the water port outlet (3). The temperature conditioning system controls the material temperature in the hoses and the dispensing gun.

### Manifold Mount Dispensing Gun

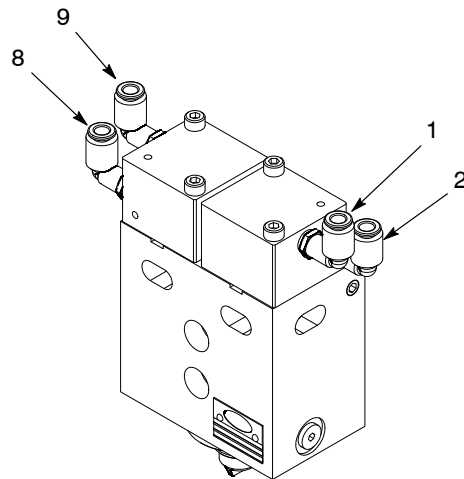
The manifold mount dispensing gun is identical to the standalone version with the exception that the material delivery and temperature conditioning is dependent upon the manifold configuration.

### Static Mixer Tubes and Shrouds

The static mixer tube combines the base and catalyst material. The mixed material passes through an extrude or stream nozzle, or an optional swirl nozzle. Refer to the *Parts* section for more information about mixer tubes and shrouds.



STANDALONE DISPENSING GUN



MANIFOLD MOUNT DISPENSING GUN

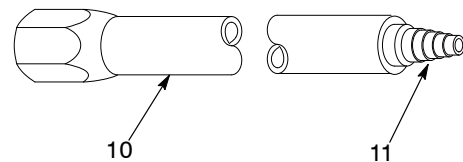


Figure 1 Typical Two Component Dispensing Guns

- |                            |                             |
|----------------------------|-----------------------------|
| 1. Base air-open inlet     | 7. Water port inlet         |
| 2. Base air-close inlet    | 8. Catalyst air-close inlet |
| 3. Water port outlet       | 9. Catalyst air-open inlet  |
| 4. Gun body                | 10. Shroud                  |
| 5. Base material inlet     | 11. Static Mixer Tube       |
| 6. Catalyst material inlet |                             |

### Teach Nut

See Figure 2.

A teach nut (1) is available to program robot movement patterns and to prevent damage to the nozzle shroud. The teach nut allows the user to mount a mixer tube (2) without the nozzle shroud.

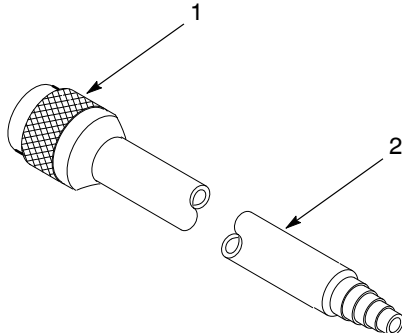


Figure 2 Teach Nut and Mixer Tube

- 1. Teach nut
- 2. Mixer tube

### Theory of Operation

The dispensing gun has a valve for the base material on the right side and a valve for the catalyst material on the left side.

**NOTE:**

- The theory of operation for the manifold mount dispensing gun is identical to the standalone version with the exception that the material flow and temperature conditioning is dependent upon the manifold configuration.
- The resting position of the dispensing valves without any air pressure applied is closed.

### Base Material Side

See Figure 3.

Air supplied to the base air-open inlet (3) pushes the base piston (6) down, forcing the stem (7) through the packing cartridge bushing (8). Base material flows through the base material inlet (9) and out the base material outlet (11) into the nozzle connector.

Air supplied to the base air-close inlet (4) forces the base piston up, cutting off the base material flow. The created suction pulls the base materials back from the nozzle connector, preventing the nozzle from dripping.

### Catalyst Material Side

See Figure 3.

Air supplied to the catalyst air-open inlet (2) pushes the catalyst piston (5) down, forcing the stem (7) through the packing cartridge bushing (8). Catalyst material flows through the catalyst material inlet (10), and out the catalyst material outlet (12) into the nozzle connector.

Air supplied to the catalyst air-close inlet (1) forces the catalyst piston (5) up, cutting off the catalyst material flow. The created suction pulls the catalyst materials back from the nozzle, preventing dripping. The base and catalyst materials flow from the valves through the nozzle connector into the mixer tube.

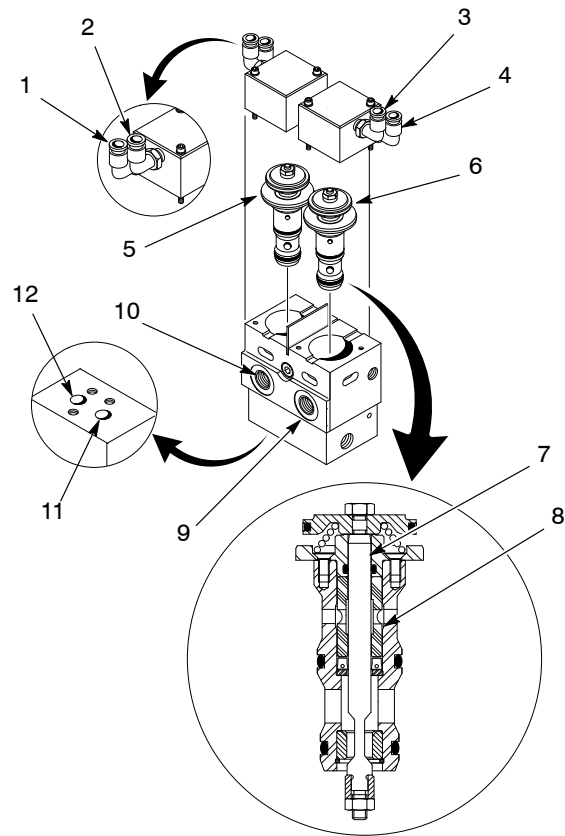


Figure 3 Typical Cutaway View

- |                             |                              |
|-----------------------------|------------------------------|
| 1. Catalyst air-close inlet | 8. Packing cartridge bushing |
| 2. Catalyst air-open inlet  | 9. Base material inlet       |
| 3. Base air-open inlet      | 10. Catalyst material inlet  |
| 4. Base air-close inlet     | 11. Base material outlet     |
| 5. Catalyst piston          | 12. Catalyst material outlet |
| 6. Base piston              |                              |
| 7. Stem                     |                              |



## Installation



**WARNING:** Allow only qualified personnel to perform the following tasks. Follow the safety instructions in this document and all other related documentation.

### Standalone Dispensing Gun

Refer to the following procedures to install a standalone dispensing gun.

#### Mounting

Inspect the dispensing gun for dents, scratches, corrosion, and other physical damage. If any damage is detected, contact your Nordson representative.

See Figure 10.

1. Mount the two component dispensing gun directly on its mounting surface.
2. Use the mounting footprint to transfer the hole pattern to the mounting surface.
3. Install the insulation plate between the two component dispensing gun and the mounting surface.
4. Use two customer-supplied hex head cap screws and washers to mount the dispensing gun to the mounting surface.  
Tighten to 12–16 N•m (9–12 ft-lb).

#### Connecting the Air Supply

Supply a minimum of 4.1 bar (60 psi) of clean shop air to the control valves which direct air to the dispensing gun:

See Figure 4.

1. Install a 1/4-in. air supply line between the base air control valve and the base air-open inlet (2).
2. Install a 1/4-in. air supply line between the base air control valve and the base air-close inlet (4).
3. Install a 1/4-in. air supply line between the catalyst air control valve and the catalyst air-open inlet (1).
4. Install a 1/4-in. air supply line between the catalyst air control valve and the catalyst air-close inlet (3).

#### Connecting the Temperature Conditioning

The optional temperature conditioning component maintains constant material temperature and viscosity for reproducible dispensing results.

See Figure 4.

1. Install a 1/4-in. water supply line between the temperature conditioning inlet (5) and the temperature conditioner outlet on the temperature conditioner.
2. Install a 1/4-in. water supply line between the temperature conditioning outlet (6) and the temperature conditioner inlet.

#### Connecting the Material Supply

The material hose size may vary depending on the system and the dispensing material.

See Figure 4.

1. Install a supply line between the base material inlet (8) and the base material supply.
2. Install a supply line between the catalyst material inlet (7) and the base material supply.

#### Installing a Mixer Shroud and Tube Assembly



**CAUTION:** Lubricate the nozzle threads with petroleum jelly to prevent two component reactive material from curing onto them.

See Figure 4.

1. Clean the nozzle threads (9) to ensure that the mixer shroud and tube assembly (10) properly seat onto the nozzle. Coat the nozzle threads (9) with petroleum jelly.
2. Install the mixer shroud and tube assembly (10) onto the nozzle (9). Tighten the mixer shroud to 14–16 N•m (10.5–12 ft-lb).

#### Manifold Mount Dispensing Gun

Refer to the system layout and interconnect drawings in the System Documentation that was provided with the system to install a manifold mount dispensing gun.

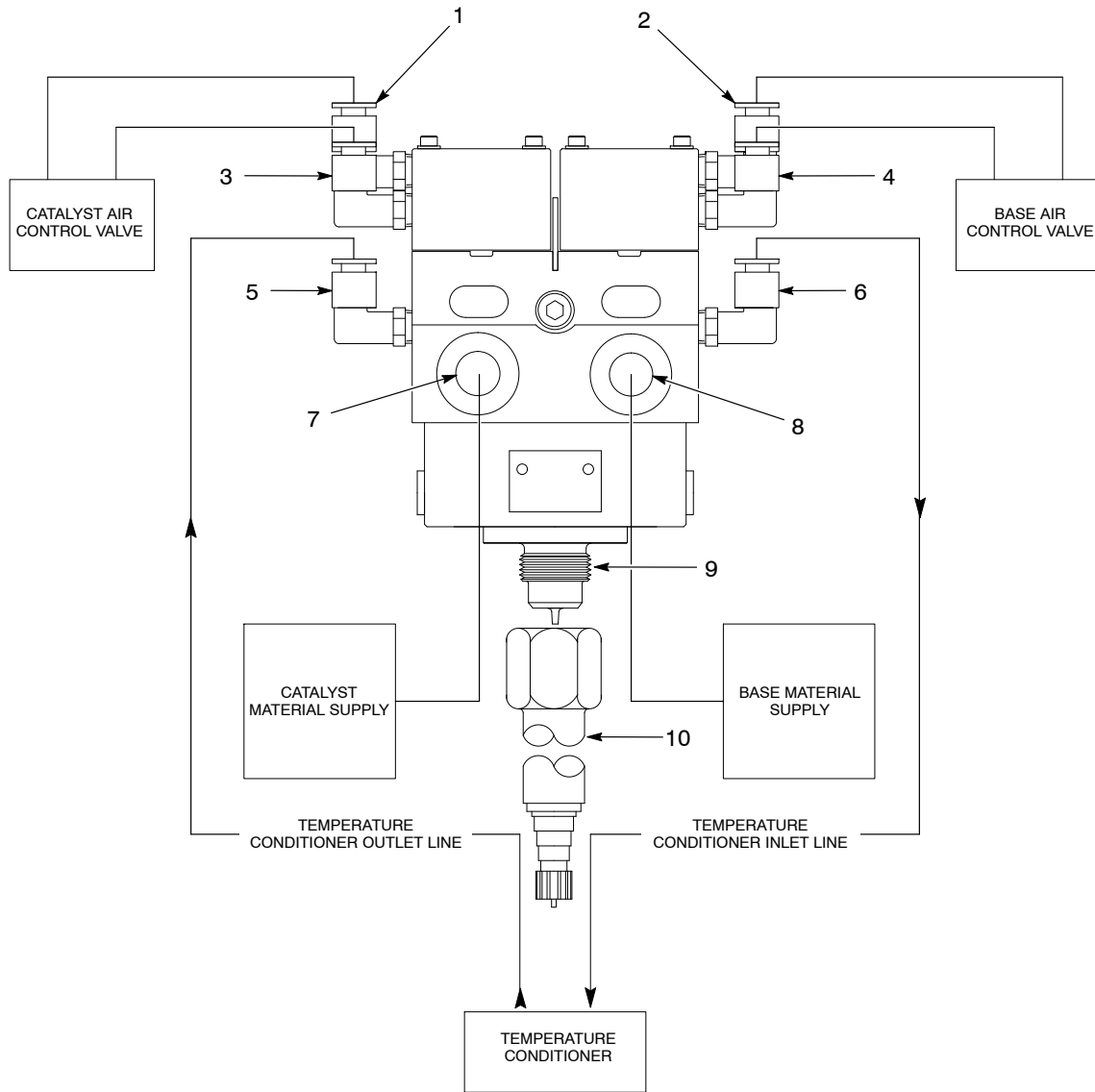


Figure 4 Standalone Two Component Dispensing Gun Connections

- |                             |                                    |                                    |
|-----------------------------|------------------------------------|------------------------------------|
| 1. Catalyst air-open inlet  | 5. Temperature conditioning inlet  | 9. Nozzle                          |
| 2. Base air-open inlet      | 6. Temperature conditioning outlet | 10. Mixer Shroud and Tube Assembly |
| 3. Catalyst air-close inlet | 7. Catalyst material inlet         |                                    |
| 4. Base air-close inlet     | 8. Base material inlet             |                                    |

## Operation

The dispensing gun is remotely operated by a system controller. Refer to your system controller documentation for more information.



**CAUTION:** To prevent damage to the packing cartridges, check the dispensing material compatibility with the ultra high molecular weight (UHMW) red and UHMW blue packing cartridges before operating the dispensing gun.

**NOTE:** For optimum results, make sure the dispensing gun is positioned perpendicular to the workpiece surface at all times.

## Maintenance

Follow your preventive maintenance schedule to keep your dispensing gun operating efficiently.



**WARNING**



- Allow only qualified personnel to perform the following tasks. Follow the safety instructions in this document and all other related documentation.
- System or material pressurized. Relieve pressure. Failure to observe this warning may result in serious injury or death.
- Wear protective clothing, safety goggles, and approved respiratory protection. Failure to observe may result in serious injury.

Use Table 1 as a guide for maintaining the two component dispensing gun in good operating condition.

Table 1 Maintenance Schedule

Item	Daily	Periodically
Check nozzle for wear. Replace if necessary. Check nozzle for leaks. Clean if necessary. Check gun response speed. If the dispensing gun responds too slow, adjust the solenoid air pressure or replace the packing cartridge. Check gun body for leaks through the weep hole. If leaks occur, replace packing cartridge.	X	
Check air lines and material supply lines for leaks or damage. Replace lines and hoses if necessary.		X

## Repair

Repair procedures for the two component dispensing gun are limited to packing cartridge replacement.



- Allow only qualified personnel to perform the following tasks. Follow the safety instructions in this document and all other related documentation.
- Disconnect equipment from line voltage. Failure to observe may result in personal injury, death or equipment damage.
- System or material pressurized. Relieve pressure. Failure to observe this warning may result in serious injury or death.
- Wear protective clothing, safety goggles, and approved respiratory protection. Failure to observe may result in serious injury.

### Replacing the Packing Cartridge

Perform these steps to replace the packing cartridge:



**CAUTION:** To prevent inadvertently switching packing cartridges or mixing base and catalyst materials, do not replace the packing cartridges in the base and catalyst side at the same time. Switching packing cartridges could damage seals when exposed to aggressive dispensing materials.

See Figure 5.

1. Remove the screws (1) and washers (2) from the air cylinder cap (3).

**NOTE:** A 14.7-cm (5.97-in.) space is required above the dispensing gun to remove the packing cartridge.

2. Remove the air cylinder cap.
3. Place a screw driver (6) in each of the slots (5) and pry out the packing cartridge (4).
4. Clean all parts.
5. Use synthetic lubricant Mobil SHC 634 to lubricate the O-rings.
6. Insert the new packing cartridge.
7. Install the air cylinder cap, washers and screws. Tighten screws to 5.65 N•m (50 in.-lb).
8. Repeat steps 1–7 to replace the second packing cartridge.

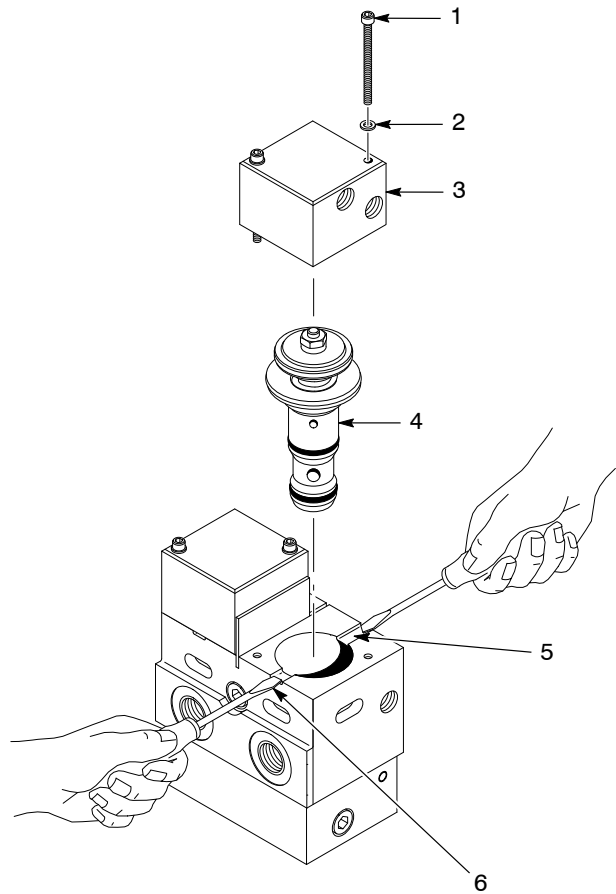


Figure 5 Typical Packing Cartridge Replacement

- |                     |                      |
|---------------------|----------------------|
| 1. Screw            | 4. Packing cartridge |
| 2. Washer           | 5. Slot              |
| 3. Air cylinder cap | 6. Screw driver      |

## Parts

To order parts, call the Nordson Customer Service Center or your local Nordson representative. Use this five-column parts list, and the accompanying illustration, to describe and locate parts correctly.

### ***Using the Illustrated Parts List***

Numbers in the Item column correspond to numbers that identify parts in illustrations following each parts list. The code NS (not shown) indicates that a listed part is not illustrated. A dash (—) is used when the part number applies to all parts in the illustration.

The number in the Part column is the Nordson Corporation part number. A series of dashes in this column (- - - - -) means the part cannot be ordered separately.

The Description column gives the part name, as well as its dimensions and other characteristics when appropriate. Indentations show the relationships between assemblies, subassemblies, and parts.

- If you order the assembly, items 1 and 2 will be included.
- If you order item 1, item 2 will be included.
- If you order item 2, you will receive item 2 only.

The number in the Quantity (Qty) column is the quantity required per unit, assembly, or subassembly. The code AR (As Required) is used if the part number is a bulk item ordered in quantities or if the quantity per assembly depends on the product version or model.

Letters in the Note column refer to notes at the end of each parts list. Notes contain important information about usage and ordering. Special attention should be given to notes.

Item	Part	Description	Qty	Note
—	0000000	Assembly	1	
1	000000	• Subassembly	2	A
2	000000	• • Part	1	

### Standalone Dispensing Gun

See Figure 6 and the following parts list.

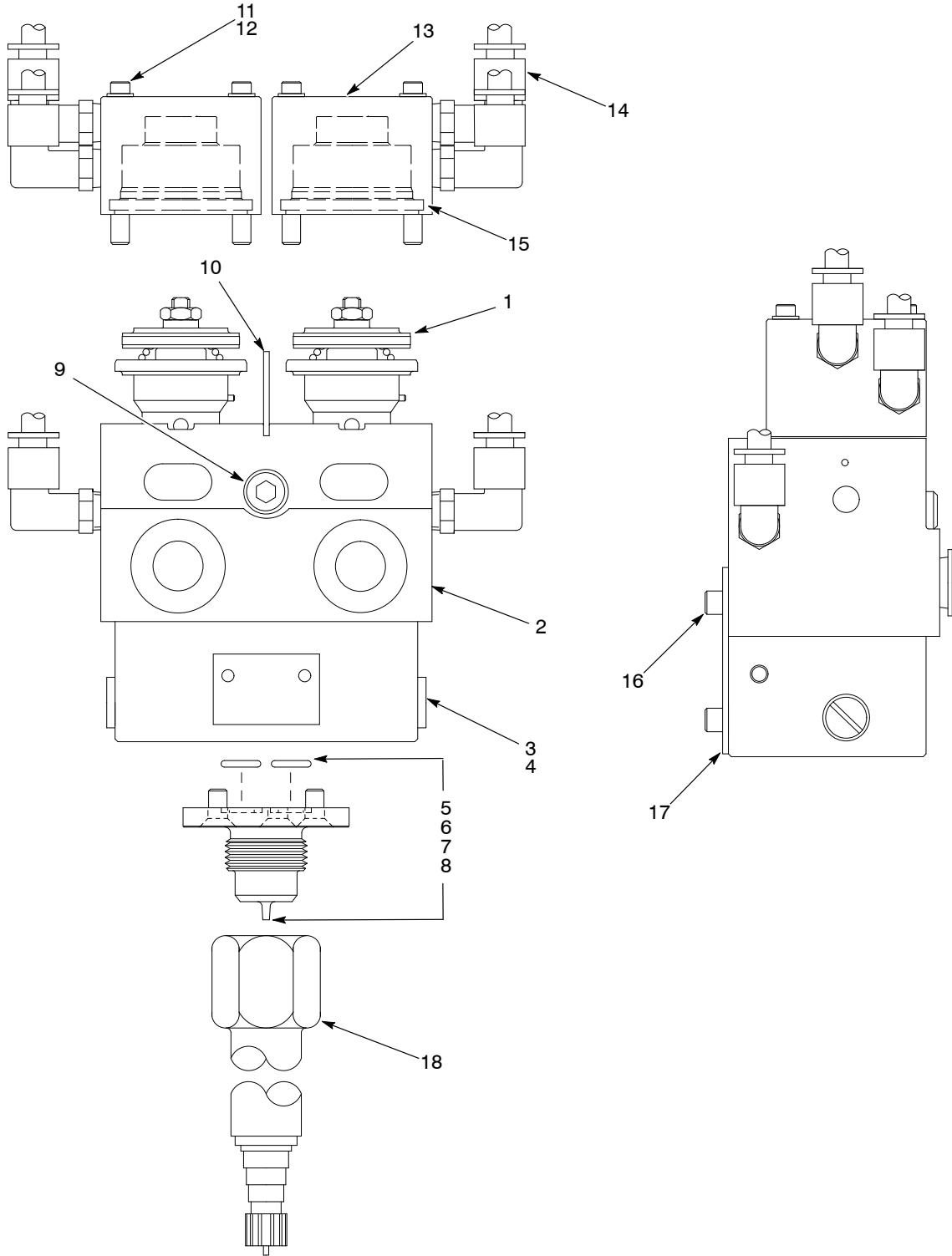


Figure 6 Two Component Dispensing Gun Parts

Item	Part	Part	Description	Qty	Note
—	329935		GUN, dispensing, aluminum	1	
—	-----	329938	GUN, dispensing, stainless steel	1	
1	1078212	-----	• CARTRIDGE, packing, carbide, UHMW, red	1	A
1	1078169	-----	• CARTRIDGE, packing, carbide, UHMW, blue	1	B
1	-----	1078213	• CARTRIDGE, packing, carbide, stainless steel	2	
2	329941	-----	• MANIFOLD, cut off gun , 2K, aluminum	1	
2	-----	329940	• MANIFOLD, cut off gun, 2K, stainless steel	1	
3	973402	973402	• PLUG, pipe, socket, flush, 1/8, zinc	1	
4	945036	945036	• O-RING, Buna-N, 1/8 tube	2	
5	329945	329945	• KIT, service, connector, nozzle, stream and extrude, stainless steel 7/8-14 thread	1	C
6	-----	-----	• • CONNECTOR, nozzle, 7/8-14, stainless steel	1	D
7	982188	982188	• • SCREW, flat, socket, M5 x 16, black	3	D
8	940111	940111	• • O-RING, Viton™, 0.301 I.D. x 0.070	2	D
9	178451	178451	• PLUG, O-ring, 5/16-14 straight thread	2	
10	173019	173019	• PLATE, divider, 2K	1	
11	982374	982374	• SCREW, socket head, M5 x 40, black	4	
12	983408	983408	• WASHER, flat, narrow, M5, steel, zinc	4	
13	173016	173016	• CYLINDER, cap, air, 2K	2	
14	972119	972119	• ELBOW, male, 1/4 tube x 1/8 NPT	6	
15	940281	940281	• O-RING, Viton, 1.375 x 1.500 x 0.063	2	
16	985409	985409	• PIN, dowel, 0.250 x 0.500, hardened, ground	2	
17	178450	178450	• INSULATOR, spacer	1	
NS	156289	156289	• LUBRICANT, Mobil SHC™ 634	AR	
18	-----	-----	MIXER TUBE/SHROUD	1	E

NOTE A: Use on catalyst side of 2K dispensing gun.

B: Use on base side of 2K dispensing gun.

C: This kit is not included with the gun and must be ordered separately.

D: Not included with the gun; supplied in service kit part 329945.

E: This part is not included with the assembly. Refer to the *Mixing Tubes, Shrouds, and Teach Nuts* section to order this part.

AR: As Required

NS: Not Shown

### Manifold Mount Dispensing Gun

See Figure 7 and the following parts list.

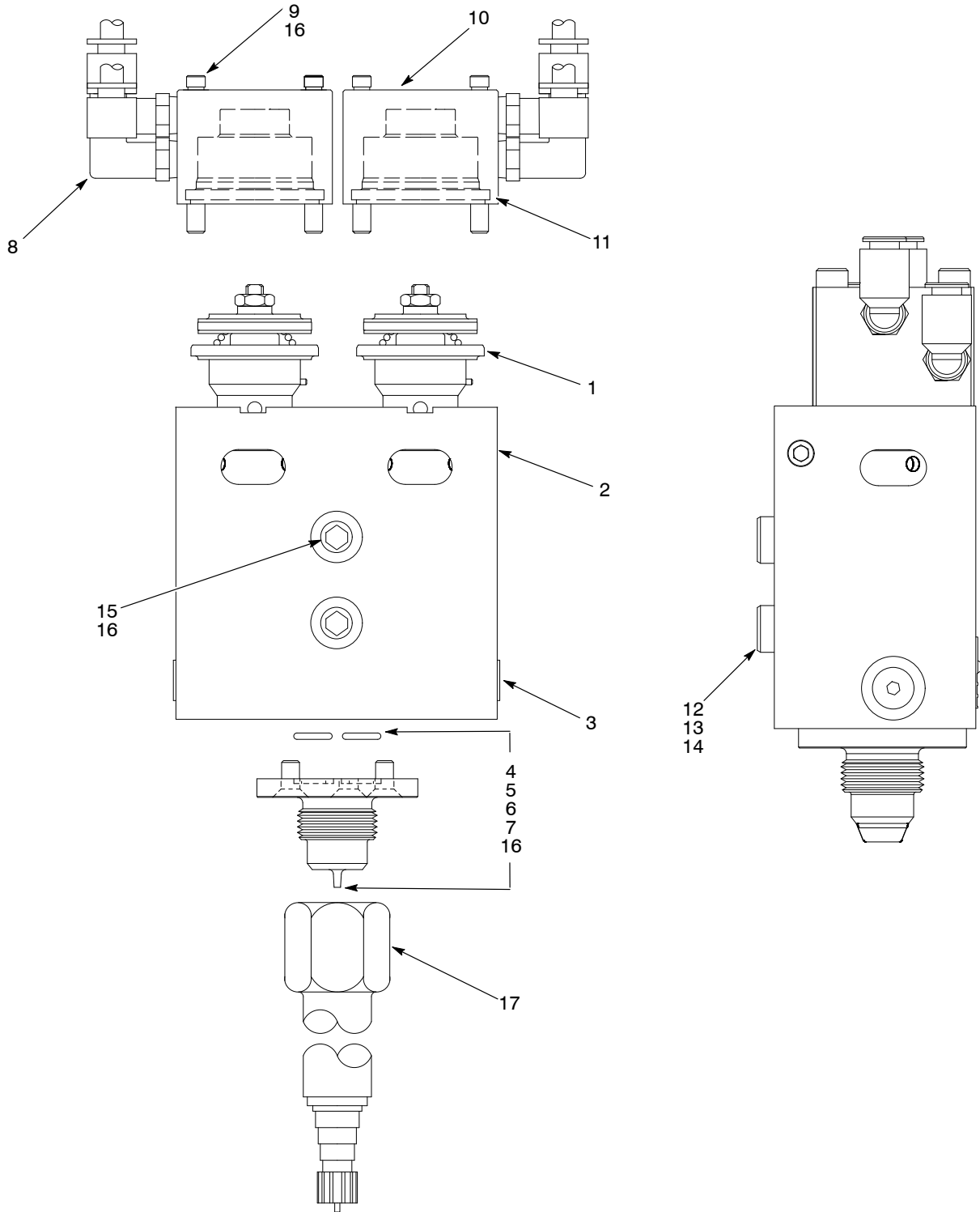


Figure 7 Two Component Dispensing Gun Parts



Item	Part	Part	Description	Qty	Note
—	1074179		GUN, dispensing, manifold mount Pro-Meter 2K, aluminum	1	
—	-----	1086720	GUN, dispensing, manifold mount Pro-Meter 2K, stainless steel	1	
1	1078212	-----	• CARTRIDGE, packing, carbide, UHMW, red	1	A
1	1078169	-----	• CARTRIDGE, packing, carbide, UHMW, blue	1	B
1	-----	1078213	• CARTRIDGE, packing, carbide, stainless steel	2	
2	1071175	-----	• BODY, manifold mount Pro-Meter 2K, aluminum	1	
2	-----	1086725	• BODY, manifold mount, Pro-Meter 2K, stainless steel	1	
3	973576	-----	• PLUG, O-ring, straight thread, 5/16-24	1	
3	-----	1086724	• PLUG, O-ring, straight thread, 5/16-24, stainless steel	1	
4	1078394	1078394	• MODULE, connector nozzle, 7/8-14 thread, 2K gun	1	C
5	-----	-----	• • CONNECTOR, nozzle, 7/8-14	2	
6	982188	982188	• • SCREW, flat, socket, M5 x 16, black	3	
7	940111	940111	• • O-RING, Viton, 0.301 I.D. x 0.070	2	
8	972119	972119	• ELBOW, male, 1/4 tube x 1/8 NPT	6	
9	982374	982374	• SCREW, socket head, M5 x 40, black	4	
10	173016	173016	• CYLINDER, cap, air, 2K	2	
11	940281	940281	• O-RING, Viton, 1.375 x 1.500 x 0.063	2	
12	1071158	1071158	• PIN, dowel, hollow, 12 mm x 16 mm	2	
13	941133	941133	• O-RING, Viton, 0.562 x 0.750 x 0.094	2	E
14	940111	940111	• O-RING, Viton, 0.301 I.D. x 0.070	2	E
15	982624	982624	• SCREW, socket, M8 x 60	2	E
16	900344	900334	• LUBRICANT, Never Seez <sup>®</sup> , 8-oz can	AR	
17	-----	-----	MIXER TUBE/SHROUD	1	F

NOTE A: Use on catalyst side of 2K dispensing gun.

B: Use on base side of 2K dispensing gun.

C: This kit is not included with the gun and must be ordered separately.

D: Not included with the gun; supplied in Module 1078394.

E: This part is shipped loose with the assembly.

F: This part is not included with the assembly. Refer to the *Mixing Tubes, Shrouds, and Teach Nuts* section to order this part.

AR: As Required

NS: Not Shown

### Mixer Tubes, Shrouds, and Teach Nuts

See Figure 8 and the following parts lists.

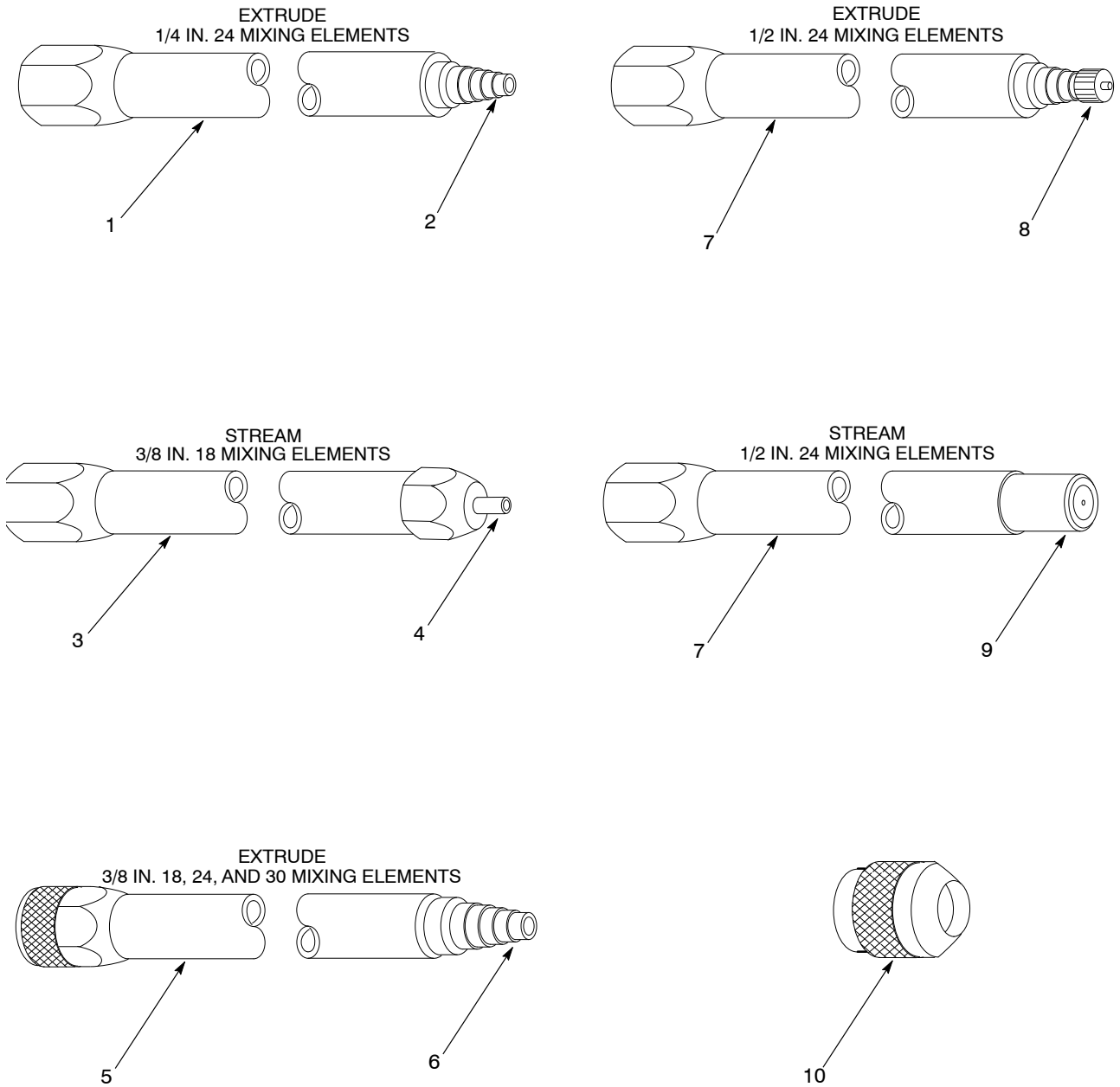


Figure 8 Mixer Tubes, Elements, and Teach Nuts

**Extrude 1/4-Inch I.D. 24 Mixing Elements**

Item	Part	Description	Qty
1	238326	SHROUD, nozzle, stream and extrude, 0.248 I.D. mixer, 24 mixing elements	1
2	238325	TUBE, mixer, extrude, 0.248 I.D., 24 mixing elements, 0.090 tip orifice	1
10	1004384	TEACH NUT, 0.248 I.D. mixers, 7/8-14 thread	1

**Extrude 3/8-Inch I.D. 30 Mixing Elements**

Item	Part	Description	Qty
5	1090236	SHROUD, nozzle, extrude, 0.366 I.D. mixer, 30 mixing elements	1
6	1087945	TUBE, mixer, static, 0.366 I.D., 30 mixing elements, 0.120 tip orifice	1
10	1009680	TEACH NUT, 0.366 I.D. mixers, 7/8-14 thread	1

**Stream 3/8-Inch I.D. 18 Mixing Elements**

Item	Part	Description	Qty
3	1008425	SHROUD, nozzle, stream and extrude, 0.366 I.D. mixer, 18 mixing elements	1
4	1005696	TUBE, mixer, stream, static, 0.366 I.D., 18 mixing elements, 0.060 tip orifice	1
10	1009680	TEACH NUT, 0.366 I.D. mixers, 7/8-14 thread	1

**Stream and Extrude 1/2-Inch I.D. 24 Mixing Elements**

Item	Part	Description	Qty
7	186473	SHROUD, nozzle, stream and extrude, 0.497 I.D. mixer, 24 mixing elements	1
8	186481	TUBE, mixer, extrude, static, 0.497 I.D., 24 mixing elements, 0.115 tip orifice	1
9	296544	TUBE, mixer, stream, static, 0.497 I.D., 24 mixing elements, 0.050 tip orifice	1
10	186482	TEACH NUT, 0.497 I.D. mixers, 7/8-14 thread	1

**Extrude 3/8-Inch I.D. 18 Mixing Elements**

Item	Part	Description	Qty
5	1076018	SHROUD, nozzle, extrude, 0.366 I.D. mixer, 18 mixing elements	1
6	1076019	TUBE, mixer, static, 0.366 I.D., 18 mixing elements, 0.120 tip orifice	1
10	1009680	TEACH NUT, 0.366 I.D. mixers, 7/8-14 thread	1

**Extrude 3/8-Inch I.D. 24 Mixing Elements**

Item	Part	Description	Qty
5	331627	SHROUD, nozzle, extrude, 0.366 I.D. mixer, 24 mixing elements	1
6	331628	TUBE, mixer, static, 0.366 I.D., 24 mixing elements, 0.120 tip orifice	1
10	1009680	TEACH NUT, 0.366 I.D. mixers, 7/8-14 thread	1

**Options**

Order the following parts to convert a two component dispensing gun to a hand-held device with cable.

Part	Description	Qty
296427	KIT, hand gun, dispensing, 2K, aluminum	1
296520	CABLE, handgun, 2K, 60 ft.	1
1614106	KIT, connector, nozzle, 7/8 - 14, stainless steel	1

**Swirl Nozzle Attachments**

The 2K swirl nozzle attachments mount to the Two Component dispensing gun to provide a thoroughly mixed, temperature-conditioned material stream in a swirl-type pattern. Refer to this document for ordering information:

Part Number 1007839, 2K Swirl Nozzle Attachments

**Nozzle Kit**

Part	Description	Qty
1614106	KIT, connector, nozzle, 7/8 - 14, stainless steel	1

**Specifications**

NOTE: All specifications are approximate.

**Standalone Dispensing Gun**

See Figure 9.

Weight (stainless steel version)	3173 g (7.0 lb)
Weight (aluminum version)	1630 g (3.6 lb)
Maximum material operating pressure (base)	207 bar (3000 psi)
Maximum material operating pressure (catalyst)	207 bar (3000 psi)
Maximum water operating pressure	7 bar (100 psi)
Air pressure	4-7 bar (60-100 psi)

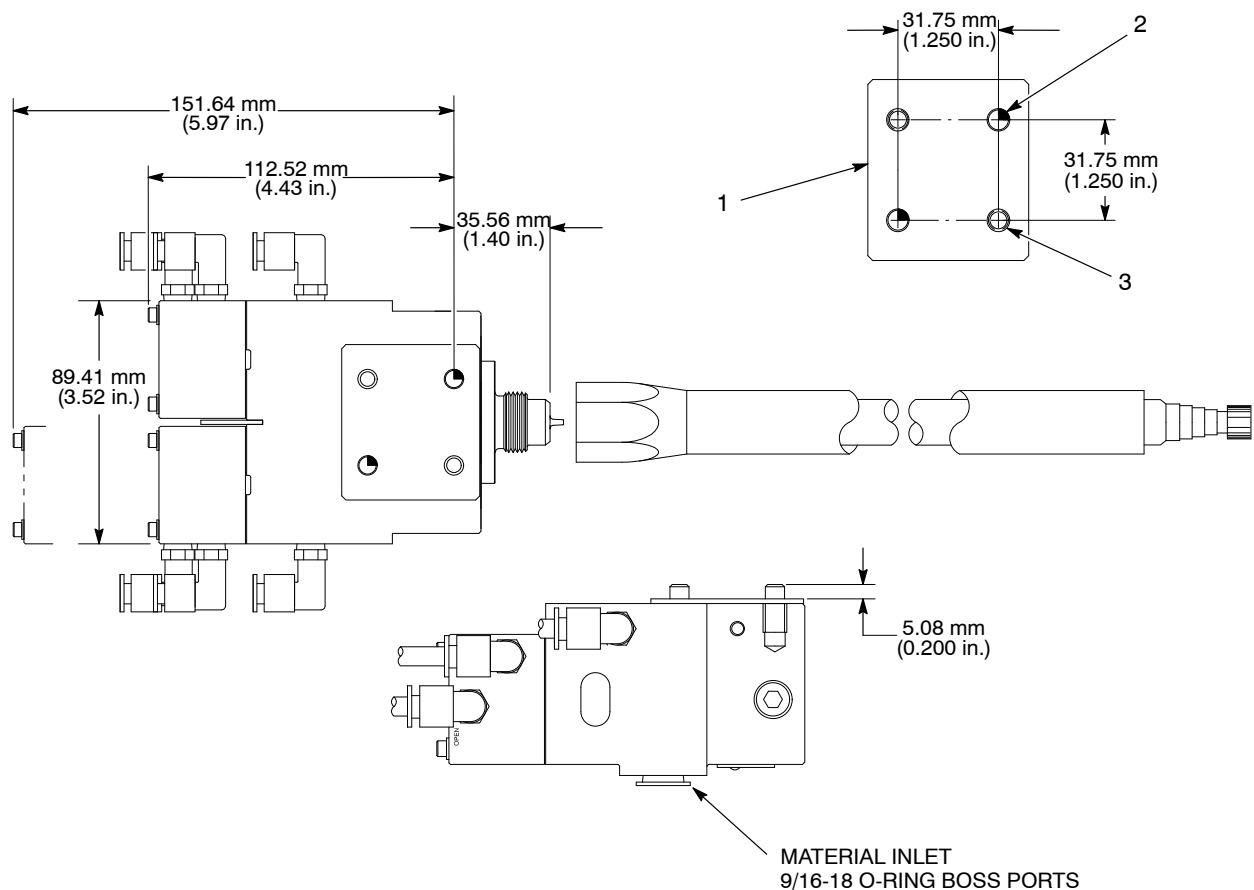


Figure 9 Standalone Dispensing Gun Dimensions

- 1. Mounting footprint
- 2. Dowel pin 0.2501/0.2503 in.
- 3. Threaded hole 2x1/4-20 UNC-2B, 0.430 in. depth

## Manifold Mount Dispensing Gun

See Figure 10.

Weight (stainless steel version)	3173 g (7.0 lb)
Weight (aluminum version)	1630 g (3.6 lb)
Maximum material operating pressure (base)	207 bar (3000 psi)
Maximum material operating pressure (catalyst)	207 bar (3000 psi)
Maximum water operating pressure	7 bar (100 psi)
Air pressure	4–7 bar (60–100 psi)

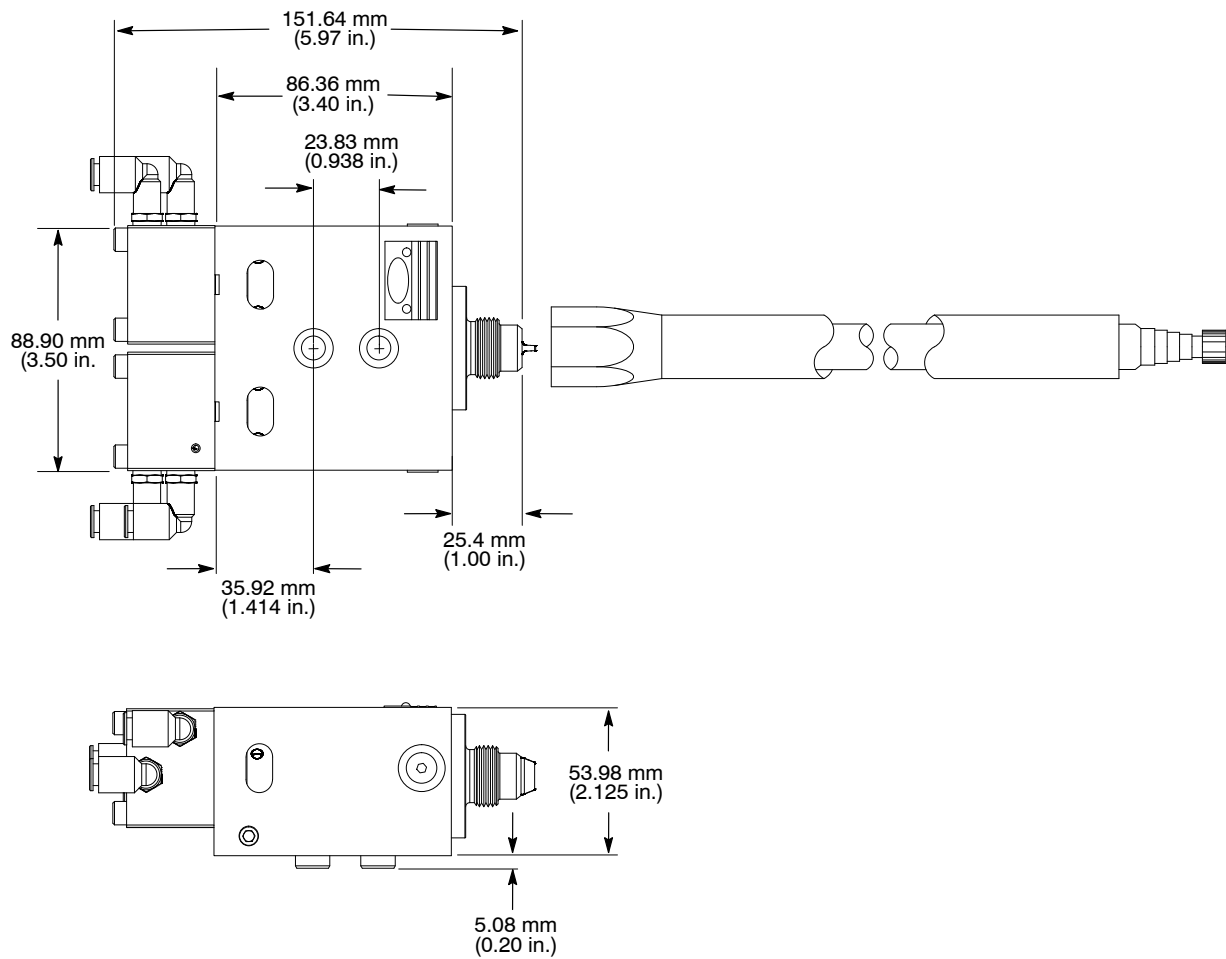


Figure 10 Manifold Mount Dispensing Gun Dimensions

