



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

Description

See Figure 1. The air injector manifold is designed for use with a CE20 gun. When installed to a CE20 gun, an operator can connect an air injector to it and calibrate the system bubble detect function.

The bleed valve is used to bleed off excess pressure during the bubble detect calibration procedure. Refer to the *Bubble Detect Calibration Kit* instruction sheet for more data.

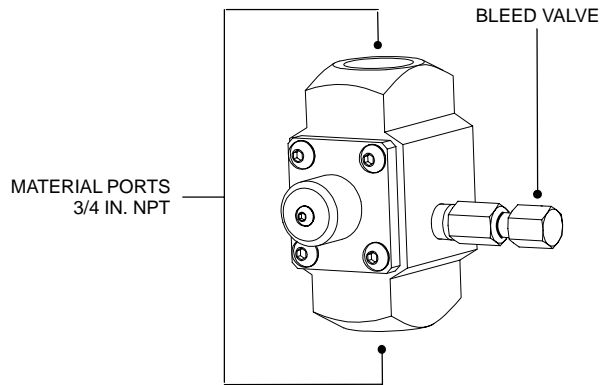


Figure 1 Manifold Assembly Kit

Installation

See Figure 2. The following customer-supplied parts are required to install the air injector manifold to a CE20 gun:

- Two $\frac{3}{4}$ -in. NPT fittings
- One ball valve

NOTE

The recommended air injector manifold installation is shown in Figure 2; upstream from the CE20 gun. If the air injector manifold cannot be installed as shown, install it as close as possible to the CE20 gun. The maximum fluid path distance from the air injector port to the dispense valve nozzle tip is 18 inches.

1. Connect the $\frac{3}{4}$ -in. NPT fittings (3, 5) to the manifold (4) and the CE20 gun body (6). Tighten the fittings securely.
2. Install the ball valve (2) to the manifold (4) and tighten securely.
3. Connect a material supply line (1) to the the ball valve (2) and tighten securely.

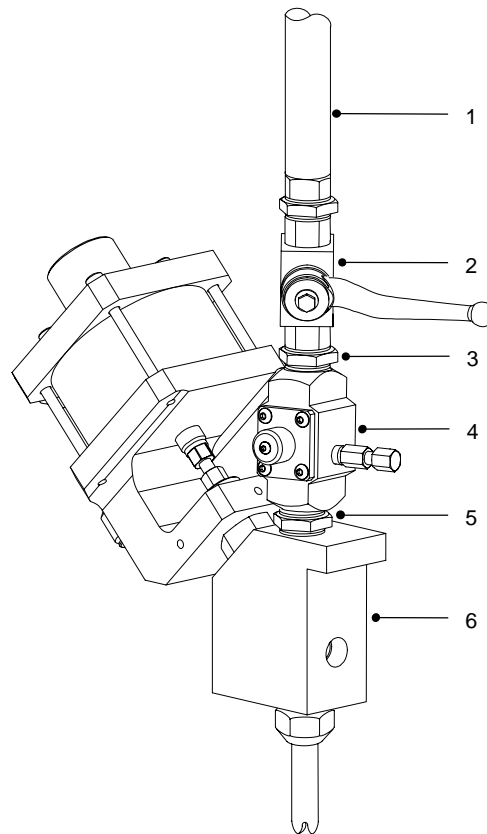
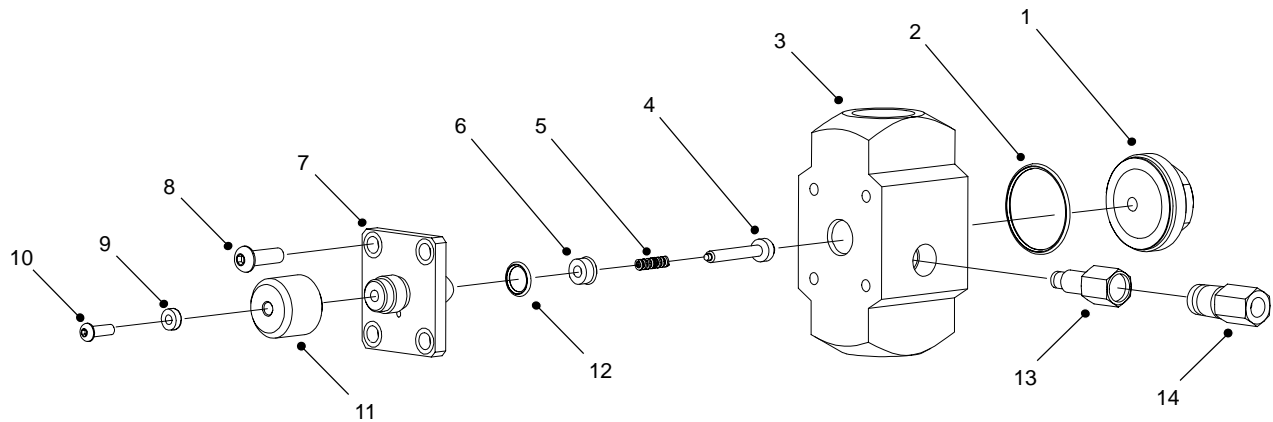


Figure 2 Recommended Installation

Parts

To order parts, call the Nordson Customer Service Center or your local Nordson representative.

See Figure 3 and the following parts list.



LUBRICATION POINTS

- Item 1: Apply petroleum jelly to threads.
- Items 2, 6, and 13: Apply petroleum jelly to surfaces.
- Item 14: Apply pipe adhesive to the threads.

TORQUE SPECIFICATIONS

- Item 1: 25 ft-lb (34 N•m)
- Item 8: 50 in.-lb (5.6 N•m)
- Item 10: 60 in.-lb (6.8 N•m)

Figure 3 CE20 Gun Manifold Assembly Parts

Item	Part	Description	Qty	Note
—	1052971	Air injector manifold	1	
1	-----	• Air injector plug	1	
2	940281	• O-ring, Viton, 1.375 x 1.5 x 0.063	1	
3	-----	• Air injector housing	1	
4	1052263	• Valve stem	1	
5	1052356	• Compression spring, 0.18 OD x 1 inch	1	
6	238329	• Lip seal, UHMW with O-ring	1	
7	-----	• Check valve holder	1	
8	-----	• Button screw, 1/4-20 x 0.75, 14432-GDI	4	
9	-----	• Sealing sleeve, 1/4 screw	1	
10	-----	• Button screw, 1/4-28 x 0.25	1	
11	-----	• Check valve cap	1	
12	940133	• O-ring, Viton, 0.426 ID x 0.070, 10413	1	
13	-----	• Bleeder valve body	1	
14	-----	• Adjustable poppet screw	1	