

Trilogy® AC Air Spray and LVLP Gravity Fed Manual Spray Guns

Customer Product Manual
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**For parts and technical support, call the Industrial Coating
Systems Customer Support Center at (800) 433-9319 or
contact your local Nordson representative.**

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Contact Us

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Change Record

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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 him this card
- Tell him 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.

Fire Safety (contd)

- 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

The Trilogy General Purpose Air Spray and LVLP Gravity Fed Manual Spray Guns are compressed-air operated low-pressure manual spray guns for the application of sprayable fluids at air pressures of 2.0–3.5 bar (28–50 psi).

The guns are differentiated by the type of air cap used. A gun may be converted from Air Spray to LVLP (low volume, low pressure) or vice-versa simply by changing the air cap. The Air Spray guns are used for fine atomization and clear coats. The LVLP guns are used for high transfer efficiency and base coats.

Refer to Options for nozzles, air caps, needles, and nozzle kits in different sizes, and air compliance caps and gauge kits to test air flow and ensure compliance with regulations. Refer to Compliance Kit Installation and Use for instructions.

Also available are adapters that install on the gravity cup fitting for use with the disposable paint cups of the 3M™ PPS™ (Paint Preparation System) or the HSM SPA-System.

Specifications

Item	Specification
Weight (without cup)	474 grams (1.04 lb)
Maximum Air Pressure	7.0 bar (100 psi)
Recommended Atomizing Air Pressure	2.0–3.5 bar (28–50 psi)
Maximum Material Temperature	Without protective gloves: 40 °C (104 °F) With protective gloves: 60 °C (140 °F)
Material Flow Rate	295 grams/min with the following: Nozzle Size: 1.4 mm Air Pressure: 2.5 bar (35 psi) Viscosity: 18 sec DIN 4 mm at 20 °C (68 °F)
Air Consumption @ 2.5 bar (35 psi) (with air regulator set to maximum)	Air Spray, Round Pattern: 10.3 m ³ /h (6.1 cfm) Air Spray, Flat Pattern: 16.7 m ³ /h (9.8 cfm) LVLP, Round Pattern: 10.7 m ³ /h (6.3 cfm) LVLP, Flat Pattern: 18.7 m ³ /h (11.0 cfm)
Sound Pressure Level (A)	2.5 bar (35 psi) round pattern: 74 dB/A
	2.5 bar (35 psi) flat pattern: 77 dB/A
(A) Sound pressure level measurements and specifications are in accordance with <i>Third regulation to apparatus safety law DIN 45635 part 1/04.84</i> .	

Installation

See Figure 1.

Air connection: Connect an air hose to the quick-connect coupling (6). The compressed air supply should be clean and dry. Use an appropriate filter/regulator.

Flushing: Before using your spray gun for production, flush the spray gun to remove any oil and contaminants left over from the manufacturing process.

1. Thread the paint cup onto the gun.
2. Pour a small amount of solvent or waterborne cleaning solution compatible with your paint into the cup.
3. With the spray gun touching the side of a grounded waste container, spray into the container for a minute or two.

Operation

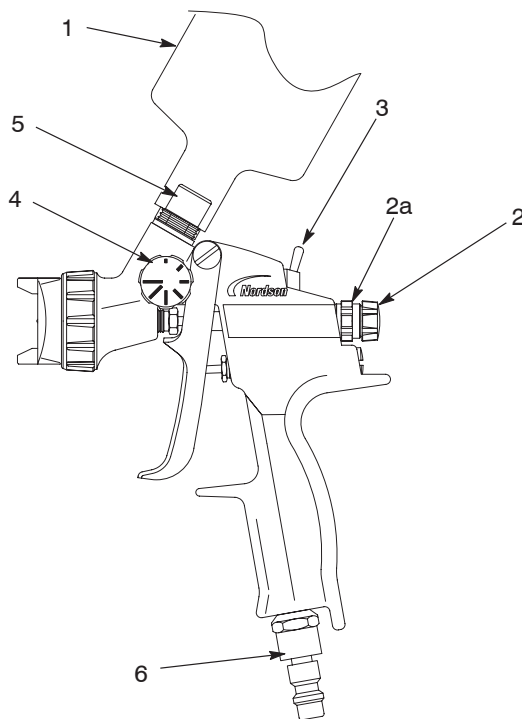


Figure 1 Trilogy General Purpose Air Spray and LVLP Gun Components

- | | | |
|----------------------------|----------------------------|----------------------------------|
| 1. Gravity cup | 3. Atomizing air regulator | 5. Cup fitting |
| 2. Material flow regulator | 4. Fan pattern regulator | 6. Air quick-disconnect coupling |
| 2a. Lock nut | | |

Atomizing Air Adjustment

See Figure 1 and Figure 2. Use the atomizing air regulator (3) to adjust atomizing air flow.

- Rotate the regulator to the right (clockwise) to decrease atomizing air.
- Rotate the regulator to the left (counterclockwise) to increase atomizing air.

Material Flow Adjustment

See Figure 1 and Figure 2. The material flow regulator (2) adjusts the material flow rate. Loosen the lock nut (2a) before adjusting the flow.

- Rotate the regulator to the right (clockwise) to decrease material flow.
- Rotate the regulator to the left (counter-clockwise) to increase material flow.

Fan Pattern Adjustment

See Figure 1 and Figure 2. The fan pattern regulator (4) adjusts the shape of the spray pattern from flat to round.

- Rotate the regulator to the right (clockwise) for a round pattern.
- Rotate the regulator to the left (counter-clockwise) for a flat pattern.

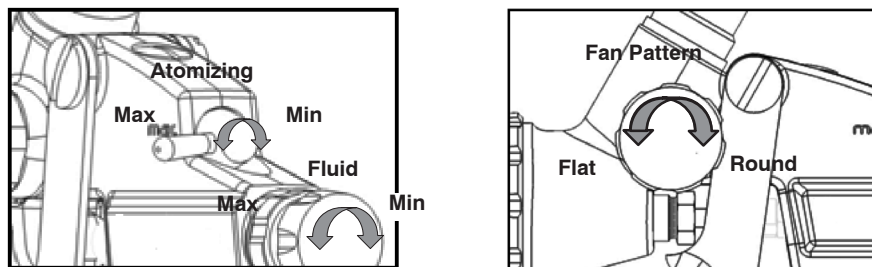


Figure 2 Spray Controls

Air Cap Adjustment

See Figure 3. The position of the atomization air cap and the nozzle determines the orientation of the fan pattern. The air cap retainer has a 1/4 turn bayonet lock for quick change and adjustment.

1. Turn the air cap retainer 1/4 turn clockwise.
2. Rotate the air cap to the desired position, hold it in position, then turn the retaining ring 1/4 turn counterclockwise.

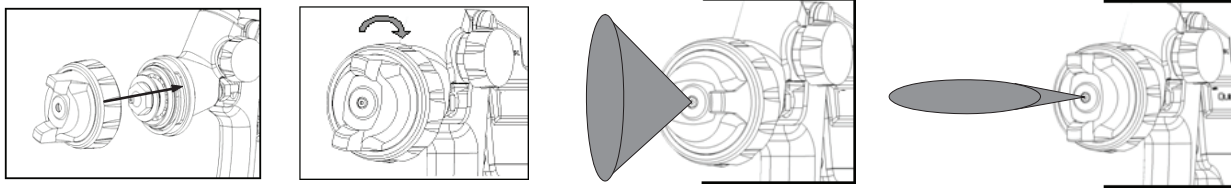


Figure 3 Air Cap Installation and Adjustment

Coating Tips

See Figure 4. Use these tips to help you obtain a quality coating:

- Hold the spray gun at a 90 degree angle to the surface being coated. If held at a different angle, the coverage will be uneven and flawed.
- Use your arm, not your wrist, to move the gun parallel to the surface. Do not wave the gun with your wrist.
- Begin moving the spray gun before pulling the trigger. Move the gun back and forth at an even speed. This will ensure even, smooth overlapping patterns without any buildup where the trigger is pulled.
- Release the trigger before stopping arm movements.
- Immerse the gun nozzle in solvent or waterborne cleaning solution during pauses in production to prevent coating material from hardening on the nozzle.

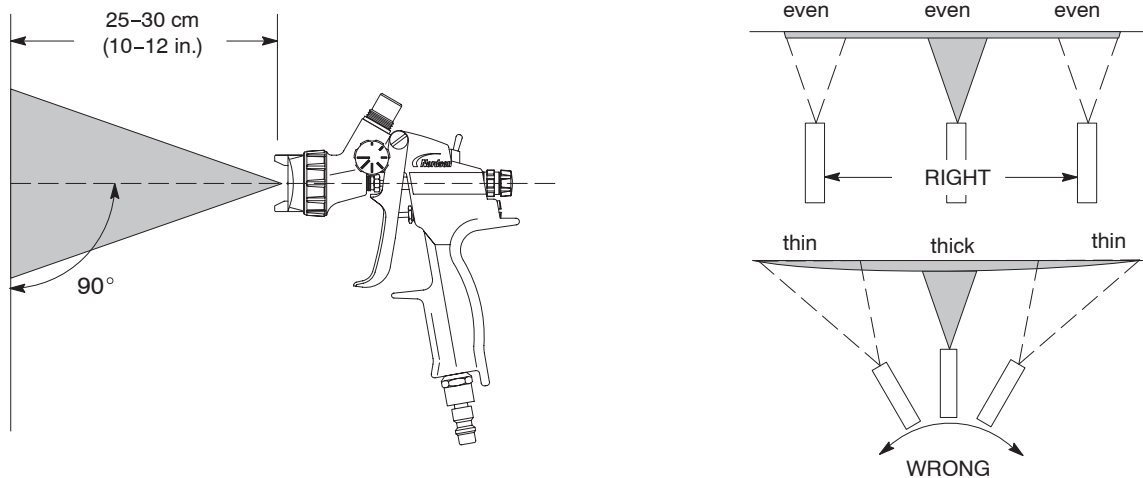


Figure 4 Spray Gun Operation

LVLP Compliance Kit Installation and Use



CAUTION: If your location is subject to VOC emission regulations, make sure your spray gun atomizing pressure is 0.69 bar (10 psi) or less by testing with a compliance air cap. Refer to the chart on the following page for maximum air inlet settings to achieve the 10 psi or less LVLP rating.

NOTE: The gauge kit and the compliance air caps are sold separately. Order one gauge kit, and compliance air caps of the same size as the production caps you normally use.

1. Shut off the fluid delivery system and relieve fluid pressure. This is not required, but it will prevent fluid from spraying while performing the compliance test.
2. Remove the retainer and production air cap from the gun. Install the compliance air cap on the gun and tighten the retainer securely. (The compliance air cap comes with its own retainer.)
3. Connect the gauges to the air cap.
4. Turn the gun atomizing air regulator all the way to MAX.
5. Pull the trigger all the way back to allow full flow of air.
6. Check the air pressure gauges. Both atomizing and horn pressures must be 0.69 bar (10 psi) or less. If either is higher, reduce the pressure.
7. Reinstall the production air cap and paint cup and check the fluid atomization. You can check the atomization with the compliance air cap installed, just make sure the gauge tubing does not impinge the spray or kink.

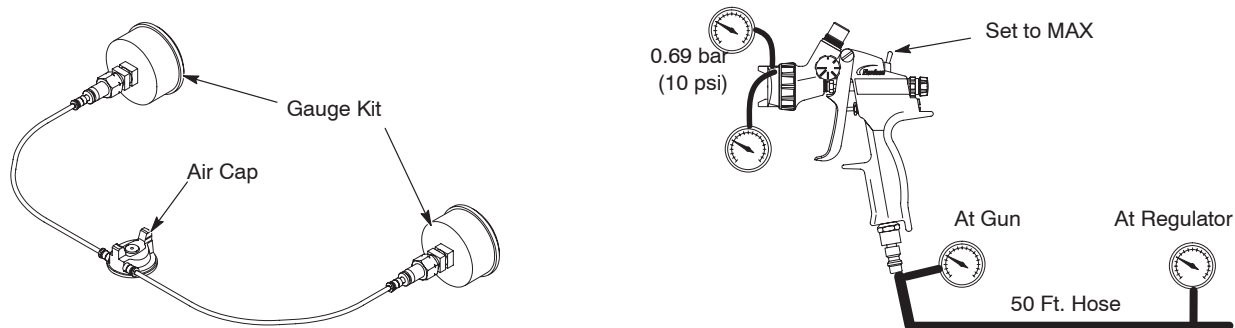


Figure 5 Compliance Air Cap and Gauge Kit Installation and Use

Maximum Inlet Air Pressure for LVLP Compliance

The following table provides air pressure settings to use as approximate starting points. The results can vary; use your compliance kit to ensure that the air output from your spray gun does not exceed 0.69 bar (10 psi).

Size	Pattern Setting	Inlet Pressure		Air Cap Atomizing Pressure
		At Gun	At Regulator (A)	
A	Flat	1.9 bar (27.5 psi)	1.8 bar (25.5 psi)	0.69 bar (10 psi)
	Round	1.7 bar (25 psi)	2.3 bar (32.5 psi)	0.69 bar (10 psi)
B	Flat	2.3 bar (33 psi)	2.6 bar (37 psi)	0.69 bar (10 psi)
	Round	2.6 bar (38 psi)	2.9 bar (41.5 psi)	0.69 bar (10 psi)

NOTE: A. Pressure readings at regulator made using 50 ft of 3/8 in. hose.

Cleaning

1. Flush the spray gun as described on page 6.
2. Relieve the air pressure.
3. Remove the air cap and clean the fluid nozzle with the supplied cleaning brush and solvent or waterborne cleaning solution compatible with the paint you are using.

NOTE: Use only properly sized tools designed for nozzle cleaning to clean the nozzle orifice. Contact your Nordson representative for nozzle cleaning kits.

Lubrication

See Figure 7. The trigger pin (8), valve pin (15), and paint needle (24) should be lubricated with silicone-free oil daily.

Troubleshooting



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

If you need help to solve a problem with your spray gun, contact your Nordson representative or call the Industrial Coating Systems Customer Support Center at (800) 433-9319. See Figure 3 for service parts.

Problem	Possible Cause	Corrective Action
1. Irregular Pattern	Air cap not tightened correctly or dirty	Check air cap (2), clean if necessary.
	Fluid nozzle installed incorrectly	Check fluid nozzle (4).
	Fluid nozzle not tightened correctly	Tighten fluid nozzle.
	Fluid nozzle cracked at orifice	Replace fluid nozzle.
2. Paint leaking from packing gland	Packing gland not tightened correctly	Tighten packing gland (23) gradually until leaking stops.
	Needle seals worn	Replace seals (18, 19).
3. Paint dripping from nozzle	Fluid nozzle loose, cracked, or worn	Tighten nozzle (4), replace nozzle if cracked or worn.
	Needle seals worn	Replace seals (18, 19).
	Needle pressure spring weak	Replace spring (25).
4. Spray gun leaking air	Air seal or valve is worn	Replace seal (14) and air valve (15).
5. Spray gun leaking air from fan adjustment screw	Fan adjustment screw worn	Replace fan adjustment screw (12).

Repair



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

Nozzle and Air Cap Replacement

1. See Figure 7. Turn the air cap retainer (1) 1/4 turn counterclockwise and remove it and the air cap from the gun.

NOTE: There is a slide seal between the retainer and the air cap that allows the air cap to rotate easily inside the retainer. Do not lose this seal.

2. Remove the nozzle seal (3). Replace the seal if damaged.
3. Unscrew the fluid nozzle (4).
4. Screw a new nozzle into the gun and tighten it securely.
5. Press the seal (3) into the bottom of the air cap, then install the air cap onto the nozzle. Turn the air cap retainer 1/4 turn clockwise to secure it.

Needle Replacement

See Figure 6 and Figure 7. The material flow regulator is an assembly consisting of a retaining collar, lock nut, and needle adjustment screw (26, 27, 28). It allows you to change the needle without losing your material flow setting.

1. Tighten the lock nut (27) up against the retaining collar (26).
2. Press in on needle adjustment screw (28) and rotate it 1/4 turn counterclockwise. The spring pressure should push the assembly out of the gun body.
3. Remove the pressure spring (25) and needle (24).
4. Install a new needle and pressure spring into the gun.
5. Orient the material flow regulator assembly as shown with a bayonet slide at the 11 o'clock position. Press in the regulator and turn it 1/4 turn clockwise to lock it in place.

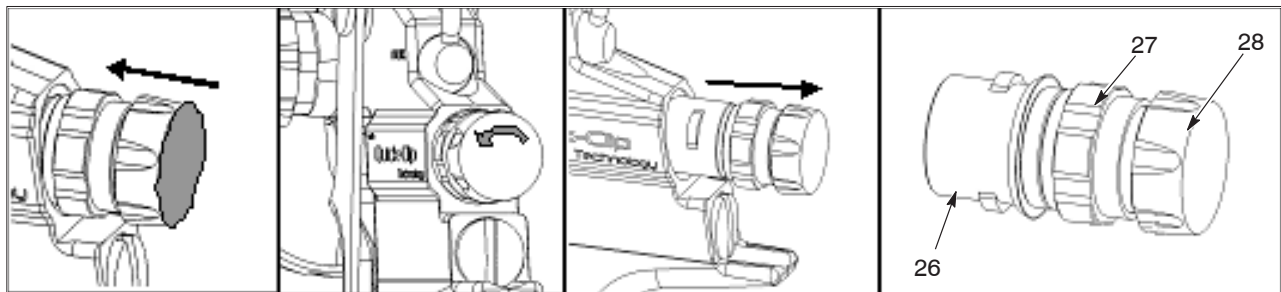


Figure 6 Removing Material Flow Regulator Assembly

Needle Seat Replacement

1. See Figure 7. Remove the needle as described in *Needle Replacement*.
2. Remove the air cap and nozzle as described in *Nozzle and Air Cap Replacement*.
3. Remove the trigger screw (9), then remove the axle (8) and trigger (10).
4. Unscrew the packing gland (23) and remove the pressure spring (22) and pressure disc (21).
5. With a hex wrench, remove the needle guide (20) from the front of the gun. Replace the two O-rings and two seals (18, 19), then reinstall the needle guide into the gun body.
6. Install the pressure disc and pressure spring into the gun body, then thread the packing gland into the gun body.
7. Install the needle into the gun, then tighten the packing gland slightly. The needle must be movable by hand, without allowing fluid through the seal. No further adjustment should be required as the seal is self-adjusting.
8. Install the trigger on the gun.
9. Install the pressure spring and the material flow regulator as described in *Needle Replacement*.
10. Install the nozzle and air cap as described in *Nozzle and Air Cap Replacement*.

Air Valve Seal Replacement

1. See Figure 7. Remove the trigger.
1. Unscrew the valve packing gland (13).
2. Remove the valve seal (14) and install a new one.
3. Install the valve packing gland and seal.

Air Valve Replacement

1. See Figure 7. Remove the retaining screw (17) from the gun body.
2. Remove the pressure spring (16) and valve pin (15).
3. Install a new valve pin on the pressure spring, install both in the gun body, and secure them with the retaining screw.

Parts

To order parts, call the Nordson Finishing Customer Support Center at (800) 433-9319 or contact your local Nordson representative. For customers outside the USA, refer to the list of Nordson Global Locations at www.nordson.com. Refer to the parts illustrations and lists on the following pages for gun parts and options.

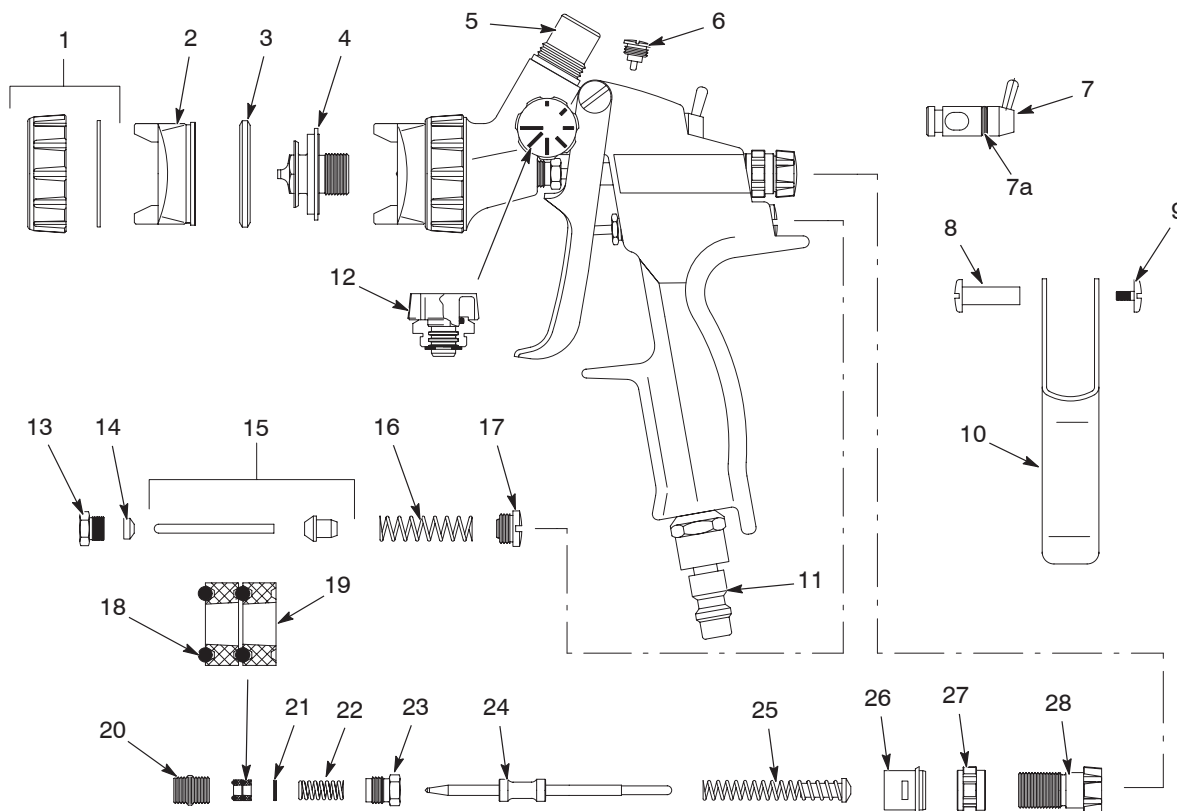


Figure 7 Trilogy GP AS and LVLP Spray Guns

14 Trilogy® GP Air Spray and LVLP Gravity Fed Manual Spray Guns

Item	Part	Description	Quantity	Note
–	1600762	Gun, manual, NES, Trilogy GP-AS	1	
–	1601125	Gun, manual, NES, Trilogy GP-LVLP	1	
1	-----	• Retainer, w/seal, air cap, AC/GP, Trilogy NES	1	
2	-----	• Air cap	1	A
3	-----	• Seal	1	A, B, C
4	-----	• Nozzle, 1.0 mm, GP, Trilogy NES	1	A
5	1600858	• Fitting, cup, Trilogy NES	1	
6	1600856	• Screw, retaining, AC/GP, Trilogy NES	1	
7	1600853	• Regulator, air, AC/GP, Trilogy NES	1	
7a	-----	• • O-ring, 7 x 1.5	1	B, C
8	-----	• Axle, trigger	1	C
9	-----	• Screw, trigger	1	C
10	1600848	• Trigger, AC/GP, Trilogy NES	1	
11	1600845	• Coupling, air, QC, swivel, US, Trilogy NES	1	D
11	1600844	• Coupling, air, QC, swivel, EU, Trilogy NES	1	E
11	1600846	• Coupling, air, QC, swivel, Asia, Trilogy NES		G
12	1601132	• Regulator, fan, gage, AC, Trilogy NES	1	
13	-----	• Gland, packing, air valve	1	C
14	-----	• Seal, packing gland, air valve	1	B, C
15	-----	• Pin, valve, trigger air, Trilogy NES	1	F
16	-----	• Spring, pressure	1	C, F
17	-----	• Screw, retaining, valve, AC/GP, Trilogy NES	1	F
18	-----	• O-ring, 4.0 x 1.2 mm, Viton	2	B, C
19	-----	• Seal	2	B, C
20	-----	• Guide, needle	1	B, C
21	-----	• Disc, pressure	1	C
22	-----	• Spring, pressure	1	C
23	-----	• Gland, packing, needle	1	C
24	-----	• Needle, 1.3 mm, GP, Trilogy NES	1	A
25	-----	• Bolt, distance, w/pressure spring	1	C
26	1600851	• Collar, retaining, QC, Trilogy NES	1	
27	1600849	• Nut, lock, quick clip, Trilogy NES	1	
28	1600850	• Screw, needle adjustment, QC, Trilogy NES	1	

NOTE A: Parts included in nozzle kit available in different sizes. Refer to the Options list on page 15.
 B: Included in 1600860 Kit, seal, AC/GP, Trilogy NES (AS and LVLP). Seal kit is also included in repair kit.
 C: Included in 1600861 Kit, repair, AC/GP, Trilogy NES (AS and LVLP). Also includes seal kit.
 D: Included in 1617888 Kit, pin, Trilogy NES.
 E: Used on 1600762 and 1601125 guns.
 F: Used on 1600794 and 1601126 metric guns.
 G: Optional, not included with guns. Must be ordered separately.

Options

Part	Description	Note
Nozzle Kit – Air Spray (includes retaining nut (1) air cap (2), nozzle (4), needle (24) and all required seals)		
1601835	Kit, nozzle, 1.2 mm, AC, Trilogy NES	
1600966	Kit, nozzle, 1.3 mm, AC, Trilogy NES	
1601837	Kit, nozzle, 1.4 mm, AC, Trilogy NES	
Nozzle Kits – LVLP (includes retaining nut (1) air cap (2), nozzle (4), needle (24) and all required seals)		
1601836	Kit, nozzle, 1.2 mm, LVLP, AC, Trilogy NES	
1600967	Kit, nozzle, 1.3 mm, LVLP, AC, Trilogy NES	
1601838	Kit, nozzle, 1.4 mm, LVLP, AC, Trilogy NES	
Cup and Cup Filters		
1600875	Cup, gravity, nylon, 125 ml, Trilogy NES	
1617889	Cup, gravity, aluminum, 750 ml, Trilogy NES	
1601023	Filter, cup, 0.23 mm, quantity 10, Trilogy NES	
1601031	Filter, cup, 0.19 mm, quantity 10, Trilogy NES	
Miscellaneous Options		
1603907	Adapter, PPS, 44, Trilogy NES	
1603920	Adapter, SPA, Trilogy NES	
Air Compliance Caps and Gauge Kit		
1603857	Cap, air, test, Trilogy GP/AC LVLP, size A (0.5–1.2 mm)	C
1603858	Cap, air, test, Trilogy GP/AC LVLP, size B (1.3–1.6 mm)	C
1603912	Kit, pressure gauge, air compliance	
Service Repair Kits		
1600861	Kit, repair, AC/GP, Trilogy NES	
1600860	Kit, seal, AC/GP, Trilogy NES	
1617888	Kit, pin, Trilogy NES	
NOTE: A. Use with 3M PPS System. B. Use with HSM SPA System. C. Order air caps for the nozzle sizes you use (size range in parenthesis).		

EU DECLARATION of Conformity

Product: Trilogy Non-Electrostatic Manual Spray Guns

Model: AAA, LP, GP, AC, AS and LVLP Gravity Fed, AS and LVLP Siphon Fed

Description: These are non-electrostatic manual spray guns, both high pressure and low pressure.

Applicable Directives:

2006/42/EC - Machinery Directive

2014/34/EU - ATEX Directive

Standards Used for Compliance:

EN ISO 12100

EN 1127-1

EN 13463-1

EN 1953

ATEX marking:

- Ex II 2G T60° C X



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Nordson Authorized Representative in the EU

Person authorized to compile the relevant technical documentation.

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DOC13036-01