

Mobile Powder Spray System

Dolly with Hopper for Cable-Fed Systems



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

1. Introduction

This instruction sheet covers the dolly used with the following mobile powder spray system components:

- Versa-Spray cable-fed electrostatic powder spray handgun
- EXP-100M power supply
- powder pumps
- HR-2-50 or HR-2-80 round powder feed hopper

Use this instruction sheet to order replacement parts for the dolly only. For information on other components of your system, refer to the manual for each component.

Dolly Configurations

The dolly frame is either a one- or two-piece design.

- The two-piece dolly frame is obsolete. Refer to *Two-Piece Dolly in Parts* if you need to order replacement hardware for a two-piece dolly frame.
- Refer to *One-Piece Dolly in Parts* if you need to order replacement hardware or a new dolly frame.

2. Installation



WARNING: All conductive equipment in the spray area must be connected to a true earth ground. Ungrounded, or poorly grounded equipment used in a powder spray area can become electrically charged. This charge can deliver a severe shock, or create sparks hot enough to cause a fire or explosion.

The system is shipped with the hopper, control unit, and dolly ground cable installed.

Refer to Table 1 for a list of components that must be installed after unpacking.

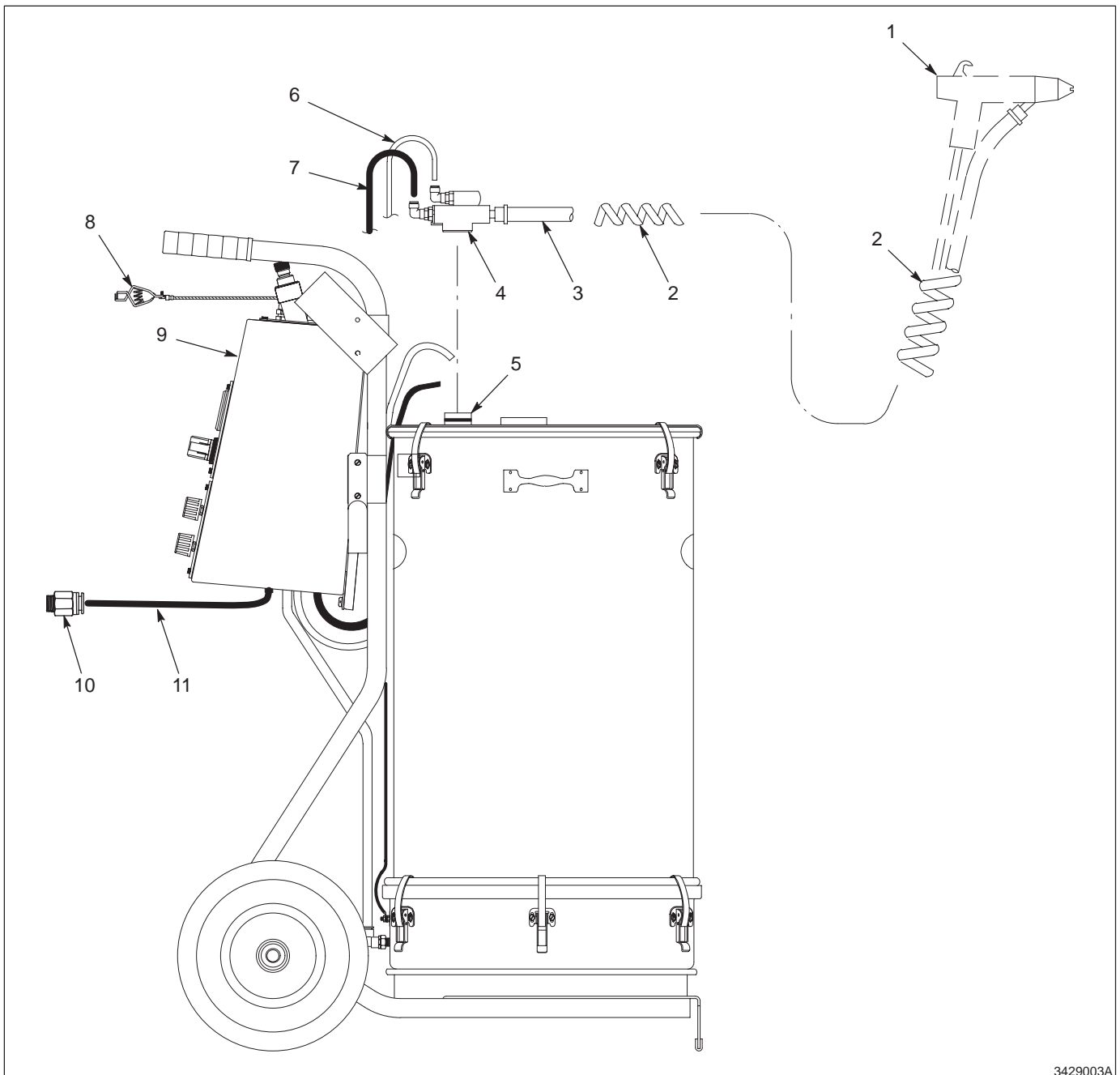
See Figure 1.

Table 1 Installation Procedures

Description	Procedure
Powder Pump	<ol style="list-style-type: none"> 1. Install the powder pump (4) on the pump adapter (5). 2. Connect the atomizing (blue) (6) and flow-rate (black) (7) air tubing between the control unit (9) and the pump fittings. The fittings are marked F and A for flow rate and atomizing air.
Powder Feed Tubing	Install powder feed tubing (3) between the pump outlet and the gun inlet.
Spray Gun	Refer to your powder spray gun (1) manual for installation instructions.
Dolly Ground Cable	Connect the dolly ground cable (8) to a true earth ground.
Spiral-Cut Tubing	<ol style="list-style-type: none"> 1. Cut the spiral-cut tubing (2) into short pieces about 10-cm (4-in.) long. 2. Use the tubing to bundle together the air tubing, cable, and powder feed tubing from the gun dolly. Install one piece near the gun handle, one near the pump inlet, and the others at regular intervals to prevent strain and kinking.
Supply Air Tubing	Connect 10-mm tubing (11) from a source of clean, dry air to the control unit IN port. The air supply must be clean and dry, with a maximum pressure of 7 bar (100 psi). If necessary, use the male connector (10).

3. Operation

Refer to the other manuals for your system's components for startup and shutdown procedures.



3429003A

Fig. 1 Installing the Dolly System

- | | | |
|-----------------------|-------------------------|-----------------------------|
| 1. Spray gun | 5. Pump adapter | 9. Control unit |
| 2. Spiral-cut tubing | 6. Atomizing air tubing | 10. Male connector |
| 3. Powder feed tubing | 7. Flow-rate air tubing | 11. 10-mm supply air tubing |
| 4. Powder pump | 8. Dolly ground cable | |

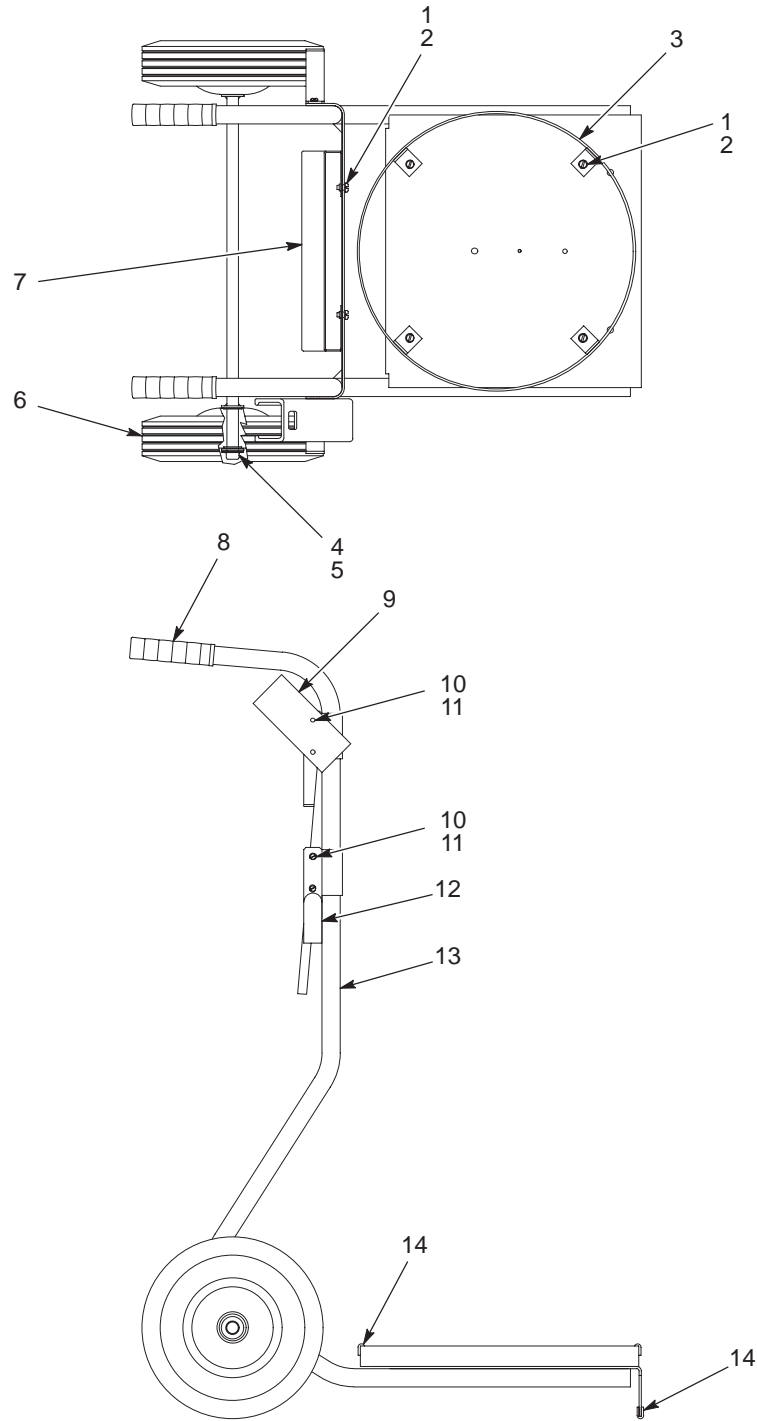
4. Parts

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

One-Piece Dolly

See Figure 2.

Item	Part	Description	Quantity	Note
—	-----	Dolly, cable fed, round hopper	1	
1	983 128	• Washer, lock, internal, M6, zinc	8	
2	982 499	• Screw, pan head, slotted, M6 x 12, zinc	8	
3	163 609	• Ring, mounting, hopper, HRS	1	
4	100 4373	• Cap, push, $\frac{5}{8}$ in. shaft	2	
5	983 090	• Washer, flat, e, 0.562 x 1.312 x 0.095 in.	2	
6	901 601	• Wheel, 10 x 2.75 in.	2	
7	163 611	• Bracket, cabinet,, dolly, EXP	1	
8	100 4372	• Grip, handlebar, 1 in. tube	2	
9	231 989	• Bracket, gun, dolly system	1	
10	983 127	• Washer, lock, internal, M5, zinc	6	
11	126 336	• Screw, pan head, slotted, M5 x 12, zinc	6	
12	164 578	• Bracket, cable/hose	2	
13	100 4268	• Frame, universal, dolly	1	
14	246 388	• Gasket	AR	
AR: As Required				



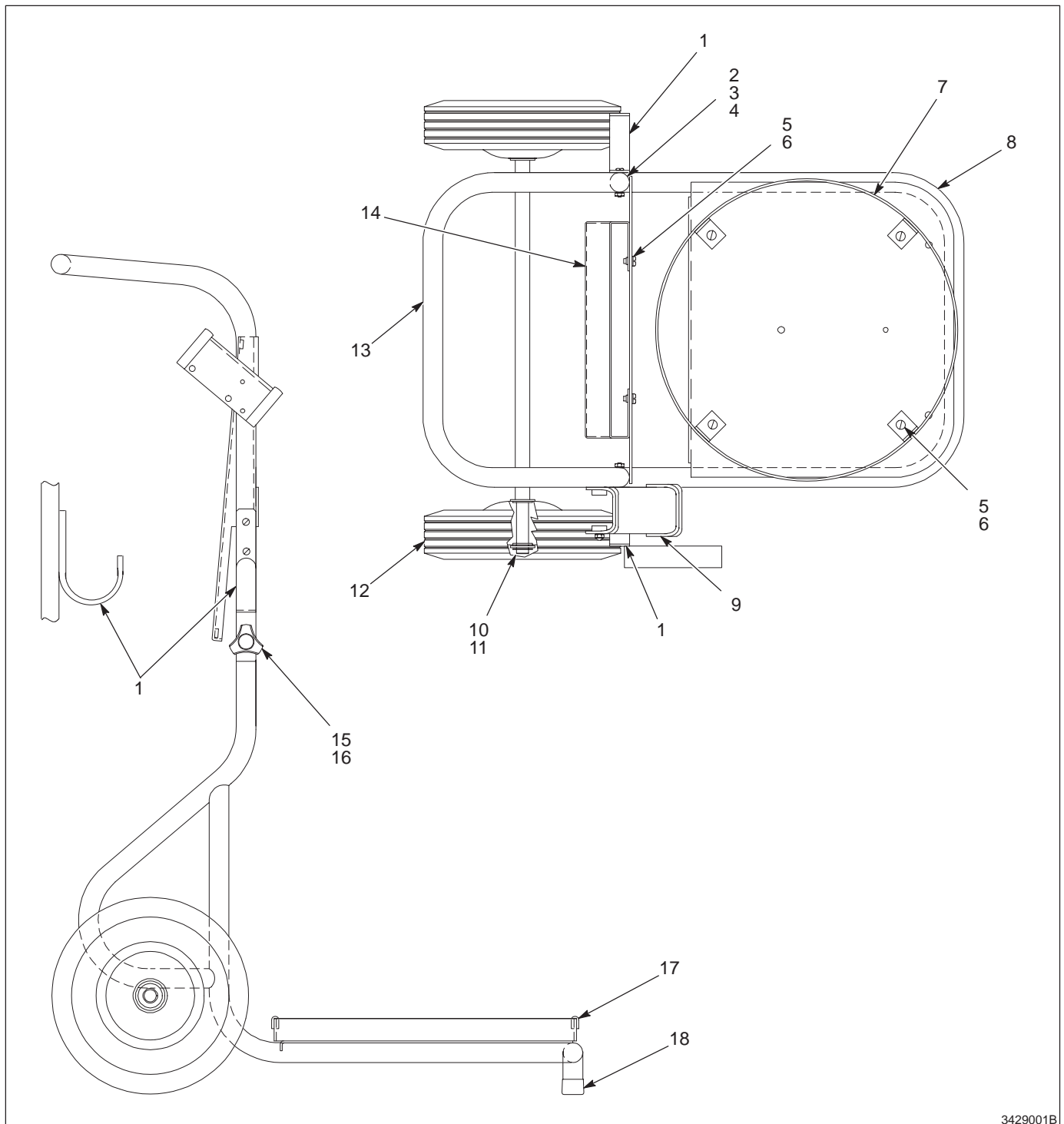
3429002A

Fig. 2 One-Piece Dolly Frame

Two-Piece Dolly

See Figure 3. The two-piece dolly assembly is obsolete. Use the following parts list to order replacement components for an existing dolly. To order major components, such as a new dolly frame, refer to *One-Piece Dolly* in this instruction sheet.

Item	Part	Description	Quantity	Note
—	-----	Dolly, two piece, cable-fed, round hopper	1	
1	164 578	• Bracket, cable/hose	2	
2	982 244	• Screw, pan head, M5 x 35	6	
3	983 127	• Washer, lock, internal, M5	6	
4	984 706	• Nut, hex, M5	6	
5	982 499	• Screw, pan head, M6 x 12	8	
6	983 128	• Washer, lock, internal, M6	8	
7	163 609	• Ring, mounting, hopper, HRS	1	
8	-----	• Frame, lower, dolly system	1	
9	231 989	• Bracket, gun, dolly system	1	
10	986 111	• Ring, retaining, external, 62, inverted	2	
11	983 090	• Washer, flat	4	
12	901 601	• Wheel, 10 x 2.75 in.	2	
13	-----	• Frame, upper, dolly system	1	
14	163 611	• Bracket, cab, dolly, EXP	1	
15	133 415	• Knob, gun mount	2	
16	983 414	• Washer, flat, narrow, M8	2	
17	246 388	• Gasket	AR	
18	152 235	• Cap, tube-bearing, 1.00 in.	1	
AR: As Required				
NS: Not Shown				



3429001B

Fig. 3 Two-Piece Dolly Frame

Original copyright date 1994. Nordson, the Nordson logo, and Versa-Spray are registered trademarks of Nordson Corporation.

