

# Mobile Powder Spray System Dolly with Hopper



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

## Introduction

AeroCharge, Sure Coat, Tribomatic II, and Versa-Spray II mobile powder spray systems consist of the following equipment mounted on a two-wheel dolly:

- manual powder spray gun
- control unit
- one or two powder pumps
- HR-2-50 or HR-2-80 round powder feed hopper

This instruction sheet covers system installation and replacement parts for the dolly. The other components of the system are covered in separate instruction sheets or manuals.

## Dolly Configurations

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

- The two-piece dolly frame has been discontinued. 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.

## 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; pump adapter and pick-up tube; air tubing; and ground cable installed.

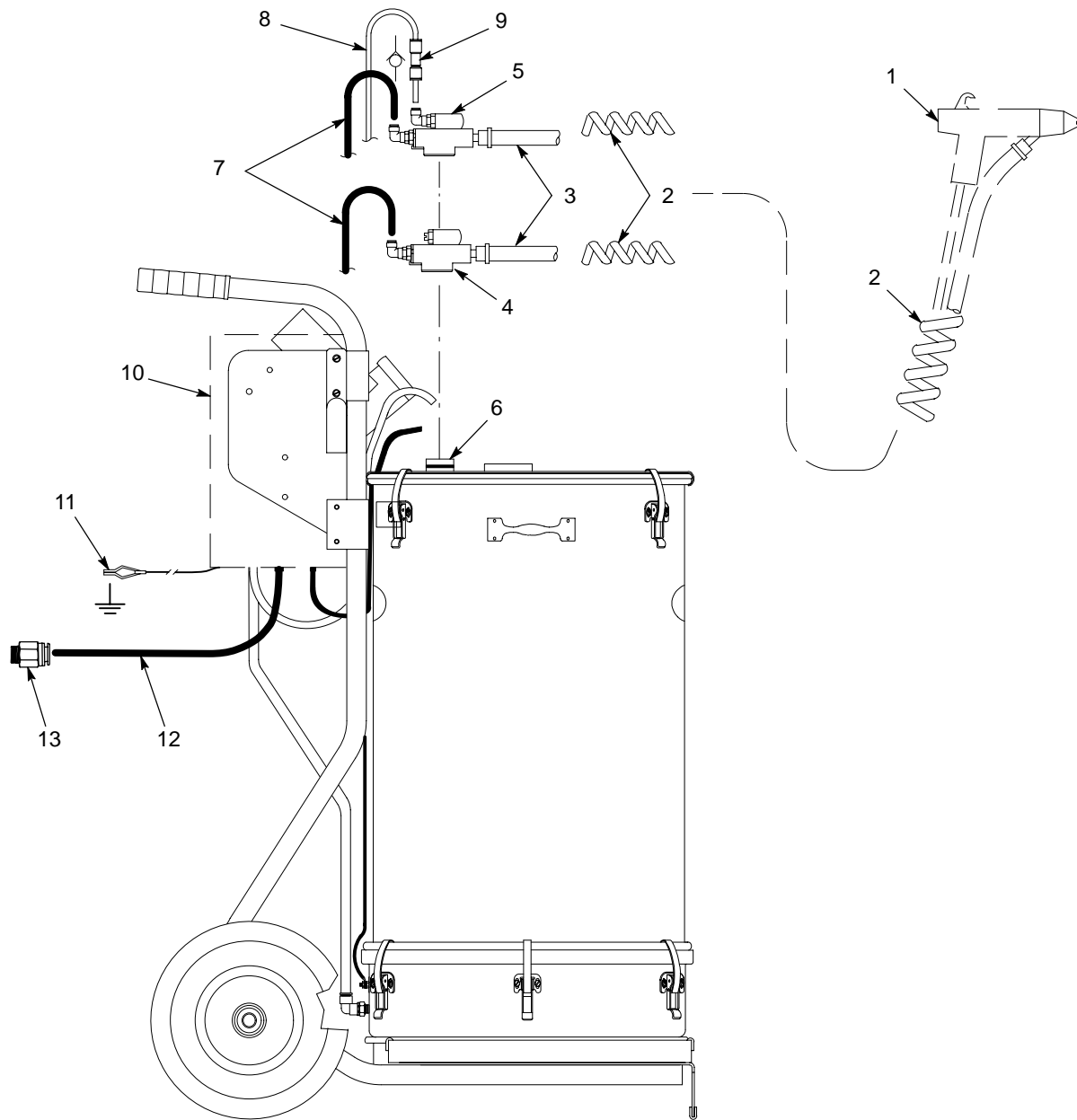
## Installation *(contd)*

See Figure 1.

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

Table 1 Installation Procedures

Component	Procedure
Powder Pump	<ol style="list-style-type: none"> <li>1. Install the pump (4 or 5) on the pump adapter (6).</li> <li>2. Make the following connections for the appropriate spray gun: <ul style="list-style-type: none"> <li><b>AeroCharge spray guns:</b> <ul style="list-style-type: none"> <li>• powder feed tubing (3) to the pump outlet</li> <li>• atomizing (blue) air tubing (8) to the pump fitting marked A; the end of the tubing with the check valve (9) must be closest to the pump</li> <li>• flow rate (black) air tubing (7) to the pump fitting marked F</li> </ul> </li> <li><b>Sure Coat and Versa-Spray II IPS spray guns:</b> <ul style="list-style-type: none"> <li>• powder feed tubing (3) to the pump outlet</li> <li>• atomizing (blue) air tubing (8) to the pump fitting marked A</li> <li>• flow rate (black) air tubing (7) to the pump fitting marked F</li> </ul> </li> <li><b>Tribomatic II spray guns:</b> <ul style="list-style-type: none"> <li>• powder feed tubing (3) to the pump outlet</li> <li>• flow rate (black) air tubing (7) to the pump fitting marked F</li> </ul> </li> </ul> </li> <li>3. Connect the powder pump air tubing to the controller as described in the <i>Installation</i> section of the controller manual.</li> </ol>
Spray Gun	<ol style="list-style-type: none"> <li>1. Connect the powder feed tubing to the spray gun (1) inlet adapter. Use a clamp to secure the tubing to the inlet.</li> <li>2. Make other connections between the spray gun and the control unit (10) as described in your spray gun and control unit manuals.</li> </ol>
Supply Air	Connect 10-mm tubing (12) from a source of clean dry air to the control unit IN port. If necessary, use the $\frac{3}{8}$ -in. tube x $\frac{1}{4}$ -in. NPT male connector (13) to connect the tubing to the air supply. The air supply must be clean and dry, with a maximum pressure of 7 bar (100 psi).
Spiral-Cut Tubing	<ol style="list-style-type: none"> <li>1. Cut the spiral-cut tubing (2) into short pieces about 10 cm (4 in.) long.</li> <li>2. Use the tubing to bundle together the air tubing, cable, and powder feed tubing from the gun to the dolly. Install one piece near the gun handle, one piece on the powder feed tubing at the pump outlet, and the others at regular intervals to prevent strain and kinking.</li> </ol>
Dolly Ground Cable	Connect the dolly ground cable (11) attached to the control unit to a true earth ground.



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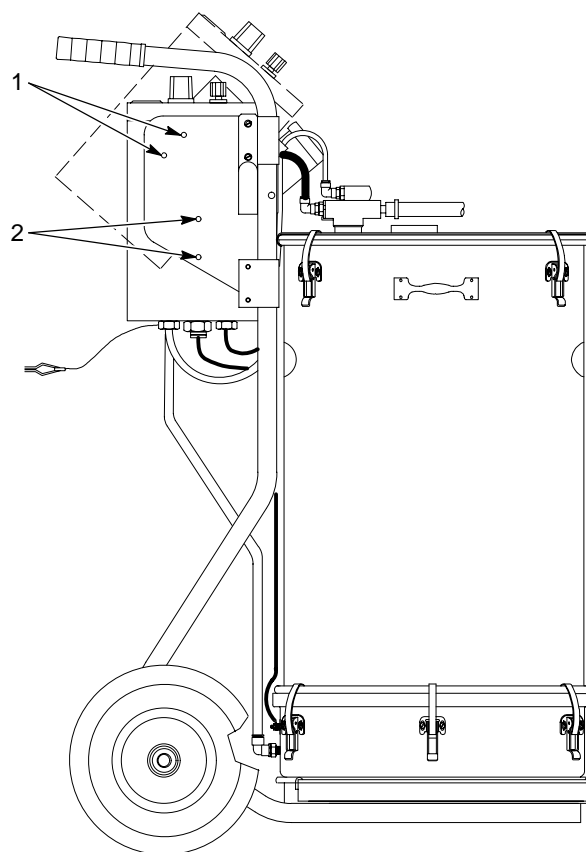
Figure 1 System Installation

- |   |                                  |                             |
|---|----------------------------------|-----------------------------|
| 1. Spray gun                                | 6. Pump adapter                  | 10. Control unit            |
| 2. Spiral-cut tubing                        | 7. Flow rate (black) air tubing  | 11. Dolly ground cable      |
| 3. Powder feed tubing                       | 8. Atomizing (blue) air tubing   | 12. 10-mm supply air tubing |
| 4. Tribomatic pump                          | 9. Check valve (AeroCharge only) | 13. Male connector          |
| 5. AeroCharge/Sure Coat/Versa-Spray II pump |                                  |                             |

## Optional Control Unit Position

See Figure 2.

Versa Spray II and Tribomatic II systems are shipped with the control unit attached to the dolly bracket in a vertical position. To move the control unit to a tilted position (shown by the dashed-line profile), remove the four mounting screws (2), tilt the control unit, and move the screws to the top set of holes (1) in the bracket to secure the unit.



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Figure 2 Optional Versa-Spray II and Tribomatic II Control Unit Position

1. Tilt position holes

2. Mounting screws

## Operation

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

## Parts

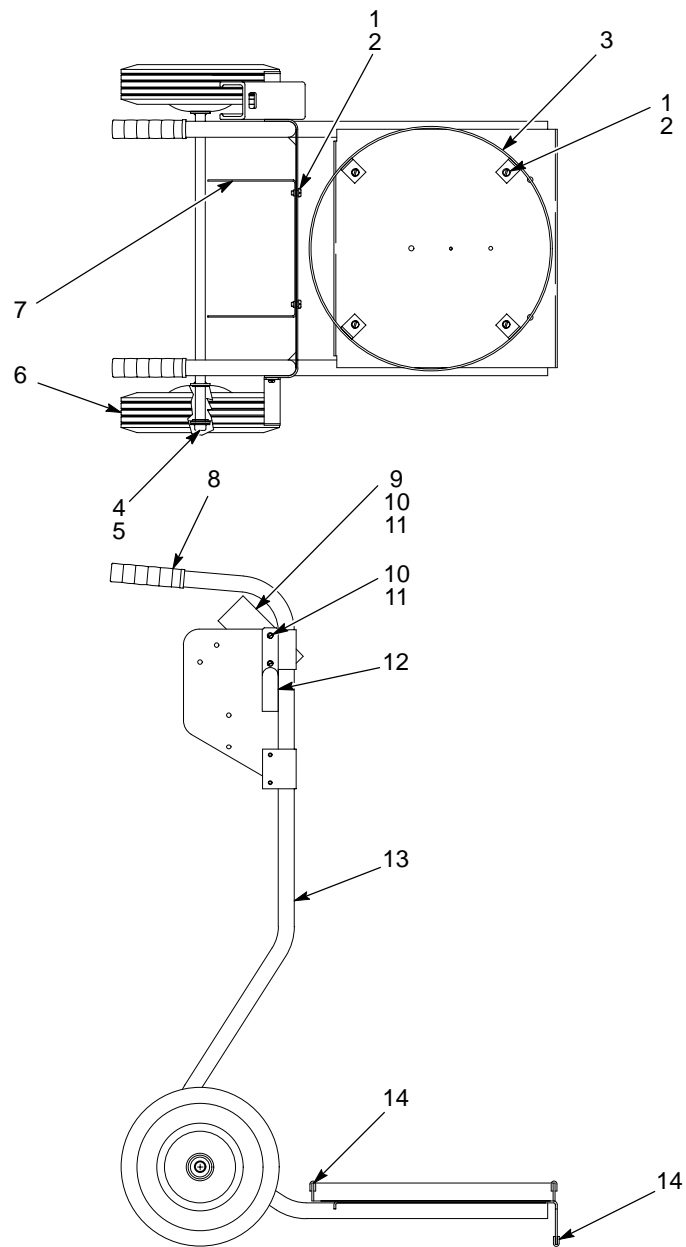
To order parts for Nordson equipment, call the Nordson Customer Service Center or your Nordson service representative.

### One-Piece Dolly

See Figure 3.

Item	Part	Description	Quantity	Note
—	-----	DOLLY, IPS/Tribomatic, round hopper	1	
1	982499	• SCREW, pan head, slotted, M6 x 12, zinc	8	
2	983128	• WASHER, lock, internal, M6, zinc	8	
3	163609	• RING, mounting, hopper, HRS	1	
4	1004373	• CAP, push, $\frac{5}{8}$ -in. shaft	2	
5	983090	• WASHER, flat, e, 0.565 x 1.312 x 0.095 in.	2	
6	901601	• WHEEL, 10 x 2.75 in.	2	
7	231991	• BRACKET, cabinet dolly, IPS	1	A
8	1004372	• GRIP, handlebar, 1-in. tube	2	
9	231989	• BRACKET, gun, dolly system	1	
10	126336	• SCREW, pan head, slotted, M5 x 12, zinc	6	
11	983127	• WASHER, lock, internal, M5, zinc	6	
12	164578	• BRACKET, cable/hose	2	
13	1004268	• FRAME, universal dolly	1	
14	246388	• GASKET	AR	
NOTE A: Not used on AeroCharge and Sure Coat systems.				
AR: As Required				

**One-Piece Dolly** (contd)



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Figure 3 One-Piece Dolly Parts

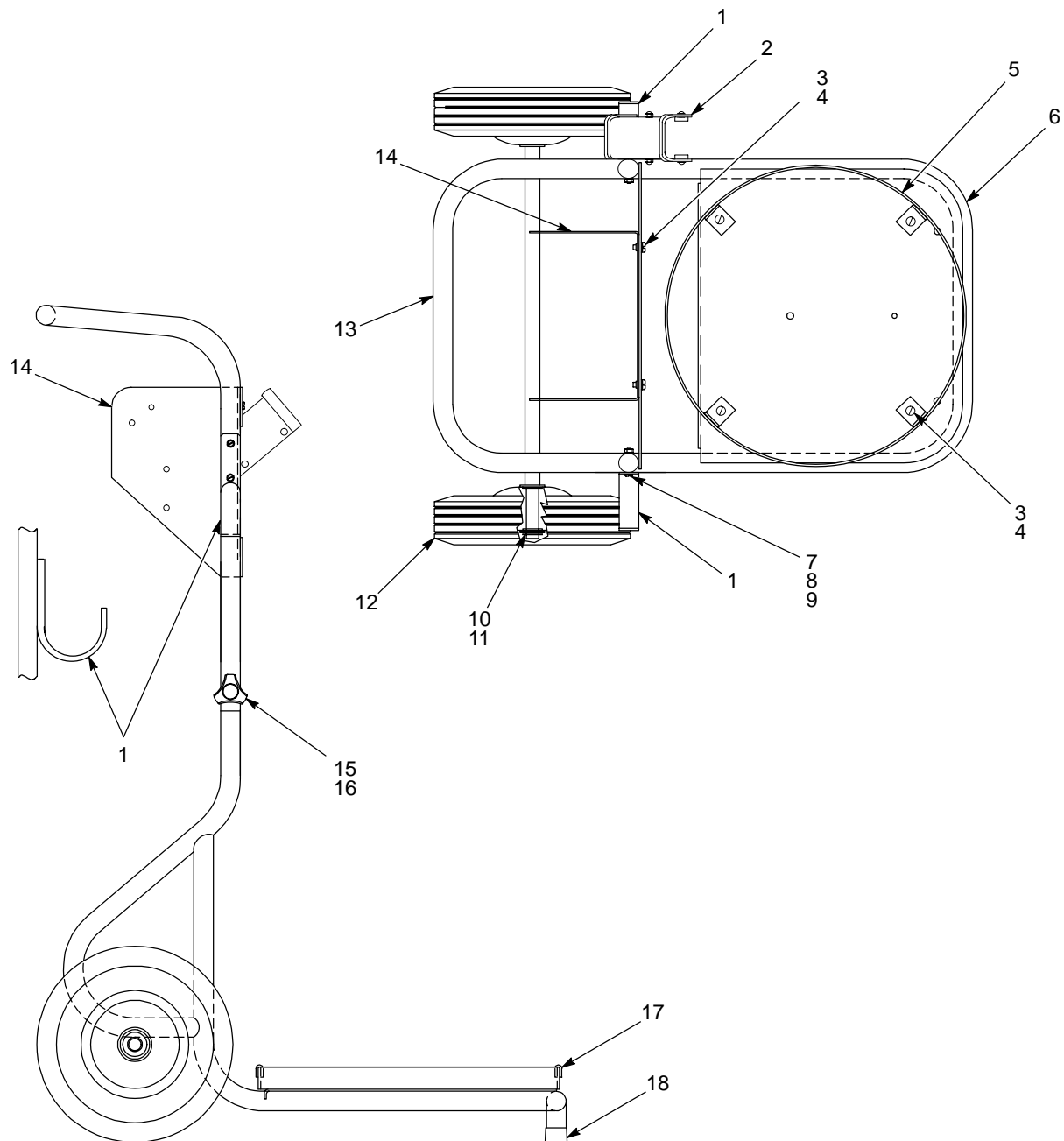
## Two-Piece Dolly

See Figure 4.

The two-piece dolly assembly has been discontinued. 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, IPS/Tribo, round hopper	1	
1	164578	• BRACKET, cable/hose	2	
2	231989	• BRACKET, gun, dolly system	1	
3	982499	• SCREW, pan head, M6 x 12	8	
4	983128	• WASHER, lock, internal, M6	8	
5	163609	• RING, mounting, hopper, HRS	1	
6	-----	• FRAME, lower, dolly	1	
7	982244	• SCREW, pan head, M5 x 35	6	
8	983127	• WASHER, lock, internal, M5	6	
9	984706	• NUT, hex, M5	6	
10	986111	• RING, retaining, external, 62, inverted	2	
11	983090	• WASHER, flat	4	
12	901601	• WHEEL, 10 x 2.75 in.	2	
13	-----	• FRAME, upper, universal dolly	1	
14	231991	• BRACKET, cabinet, dolly, IPS	1	A
15	133415	• KNOB, mount	2	
16	983414	• WASHER, flat, narrow, M8	2	
17	246388	• GASKET	AR	
18	152235	• CAP, tube-bearing, 1.00 in.	1	
NOTE A: Not used on AeroCharge and Sure Coat systems.				
AR: As Required				

## Two-Piece Dolly (contd)



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Figure 4 Two-Piece Dolly Parts

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