

Nozzle Extension Installation for Versa-Spray® and Versa-Spray® II Manual Guns used with Versa-Spray® II Control Units

1. Introduction

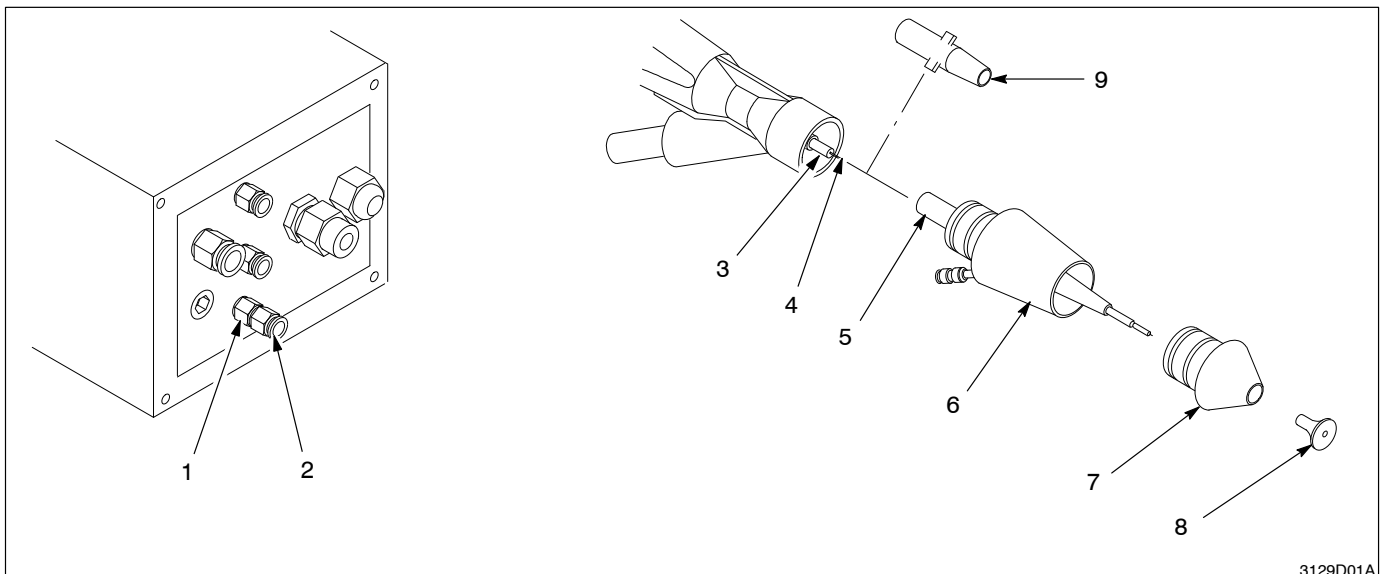
This instruction sheet covers the installation of the kit listed below. With this kit, you can install a nozzle extension on a gun and supply the extension with air at the correct pressure. Air flows through the extension and out around the electrode, preventing some powder coatings, such as metallics, from collecting on the electrode.

183 328

Gun air kit

2. Installation

1. See Figure 1. Remove the plug from the control unit GUN port. Wrap the orifice (restrictor) (1) threads with PTFE tape and install it in GUN port.
2. Install the connector (2) into the restrictor.
3. Remove the deflector (8), nozzle (7), and wear sleeve (9) from the gun.



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Fig. 1 *Installing gun air kit (Versa-Spray II conical nozzle shown)*

- | | | |
|------------------------|---------------------------------|----------------|
| 1. Restrictor | 4. Electrode | 7. Nozzle |
| 2. 6-mm tube connector | 5. Nozzle extension wear sleeve | 8. Deflector |
| 3. Resistor probe | 6. Nozzle extension | 9. Wear sleeve |

2. Installation (contd.)

4. Install the nozzle extension (6) onto the gun. The resistor probe (3) goes inside the nozzle extension wear sleeve (5). Be careful not to damage the electrode (4).
5. Install the nozzle and deflector on the nozzle extension.
6. Install 6-mm air tubing between the connector (2) and the nozzle extension. The tubing should be approximately 1 ft. (.304 meter) longer than the gun cable. Tubing must be ordered separately. Refer to the parts lists in this sheet for the tubing part number.

3. Nozzle Extension Repair

1. See Figure 2. Push on the wear sleeve (3) to get the wear sleeve/spider/resistor holder assembly (3, 4, 5, 6) out of the nozzle adapter (2).
2. Unscrew the wear sleeve (3) and resistor holder (6) from the spider (4).
3. Remove the resistor (5) from the resistor holder.
4. Test the resistor continuity and resistance with a megohm meter. The megohm meter should read between 18 and 22 megohms at 500 volts. If the reading is out of this range, replace the resistor.
5. Replace any worn or damaged parts.
6. Install the resistor in the resistor holder.
7. Install the wear sleeve and resistor holder onto the spider.
8. Align the small pin (7) on the spider with the slot (8) in the nozzle adapter. Press the spider/resistor holder assembly (3, 4, 5, 6) back into the nozzle adapter.

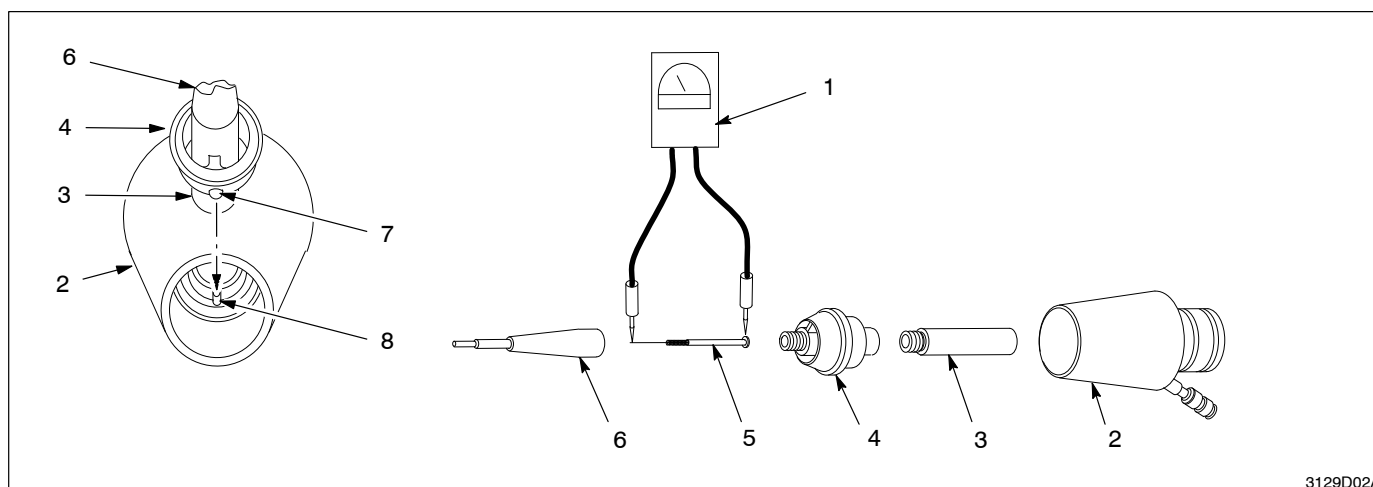


Fig. 2 Nozzle extension repair

1. Megohm meter
2. Nozzle adapter
3. Wear sleeve

4. Spider
5. Resistor
6. Resistor holder

7. Pin
8. Slot

4. Parts Lists

Gun Air Kit

See Figure 3.

Item	Part	Description	Quantity	Note
—	183 328	Kit, manual gun air, VS2 controls	1	
1	972 244	• Orifice, .010 in., 1/8-in. NPT x 1/8-in. NPT, brass	1	
2	972 141	• Connector, male, 6-mm tube x 1/8-in BSPT	1	
3	183 334	• Kit, extension, nozzle	1	
4	183 645	• • Service kit, resistor, w/holder, VS2	1	
5	179 182	• • • Holder, resistor	1	
—	183 646	• • • Service kit, resistor, nozzle extension, VS2	1	
6	-----	• • • • Resistor, nozzle extension, VS2	1	
7	182 255	• • Kit, spider, w/O-ring	1	
8	-----	• • • Spider, air inlet, VS2	1	
9	940 104	• • • O-ring, silicone, .250 x .375 x .063 in.	1	
10	173 179	• • Sleeve, wear, VS2	1	
11	182 254	• • Kit, adapter, nozzle, VS2, w/O-ring	1	
12	-----	• • • Adapter, nozzle, VS2	1	
13	941 181	• • • O-ring, silicone, .875 x 1.063 x .094 in.	2	
14	173 177	• • Fitting, M6, straight	1	
15	971 790	• • Union, straight, 6 mm, plastic	1	

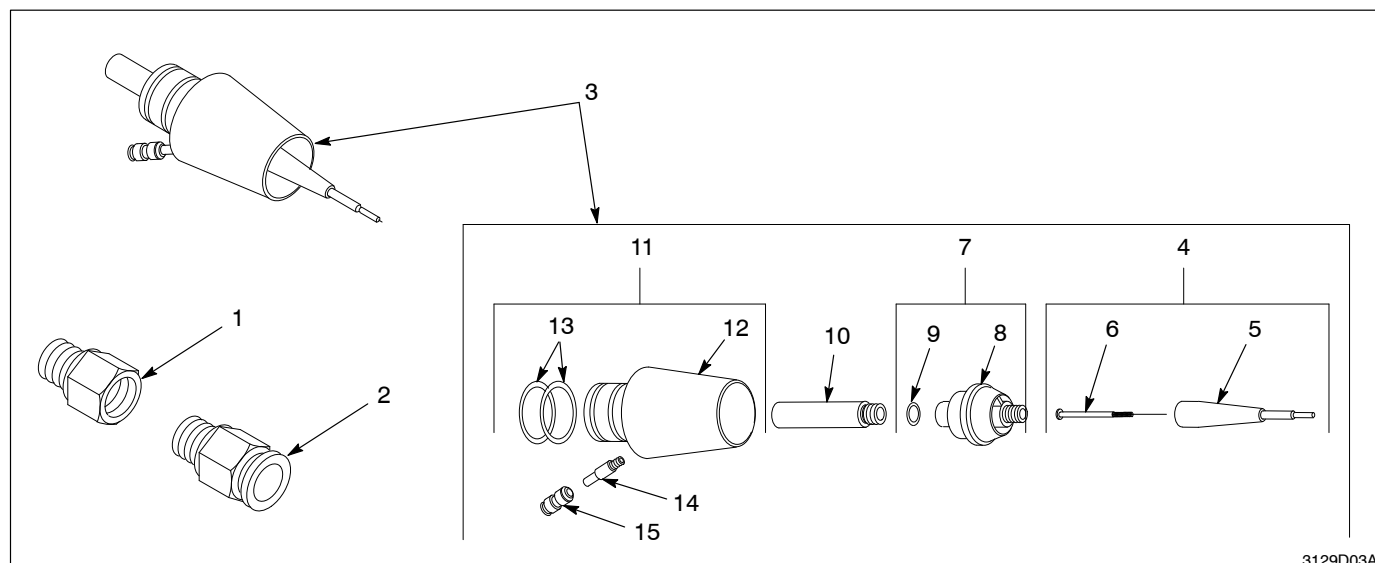


Fig. 3 Gun air kit

4. **Parts Lists** (contd.)

Powder Feed and Air Tubing

Part	Description	Note
900 550	Tubing, powder, 1/2-in. I.D.	A
900 742	Tubing, polyurethane, 6-mm	A
NOTE A: Bulk part numbers. Order in 1-ft increments.		

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