

Container Inside Powder Coating Equipment

Description

This instruction sheet provides installation instructions and lists the equipment used for container inside powder coating applications.

- 250, 300, 350-mm lance assemblies for Sure Coat automatic guns
- 12 and 8 hole nozzles at 3, 5, and 7 degrees
- Venturi throats, and 8 and 10-mm tubing adapters, for 100 Plus powder pumps

In addition, a special powder feed hopper with a vibrator motor and agitator is available. It is designed especially for fluidizing the powders used for container coating. It is equipped with pump mountings for four feed pumps, two vent pumps, and two barbed inlet fittings for bulk feed tubing.

Lance Installation

Sure Coat Gun Parts Removal

1. See Figure 1. Remove the spray gun nozzle nut and nozzle.
2. Remove the spray gun electrode support, powder tube, and hose connector assembly.

Refer to the Sure Coat Automatic Spray Gun manual 334627 for instructions.

NOTE: If you have a tube mount gun, the tie bar and tension nut must be left in place to hold the gun together. The powder tube is installed inside the tie bar.

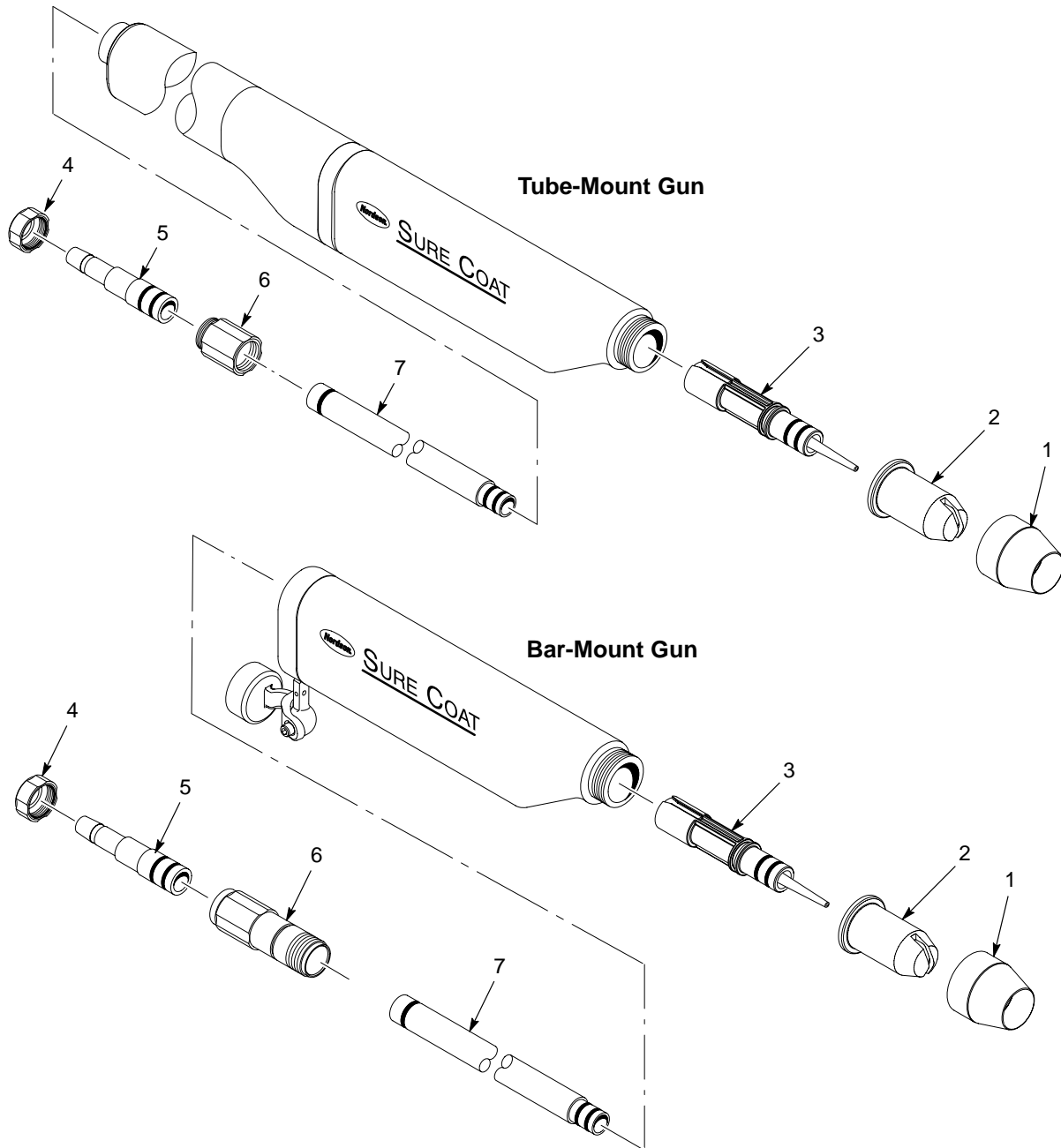


Figure 1 Removing Standard Gun Parts

- | | | |
|----------------------|-----------------------|------------------------|
| 1. Nozzle nut | 4. Hose connector nut | 6. Hose connector body |
| 2. Nozzle | 5. Hose connector | 7. Powder tube |
| 3. Electrode support | | |

Lance Installation

1. See Figure 2. Slide the 8 or 10-mm powder tubing (2) through the spray gun body (1) from the rear and out the front.
2. Connect the powder tubing to the barbed end of the lance assembly (3).



Figure 2 Connecting Powder Tubing to Lance Extension

- | | | |
|-------------|------------------|-------------------|
| 1. Gun body | 2. Powder tubing | 3. Lance assembly |
|-------------|------------------|-------------------|

3. See Figure 3. Install the lance assembly (3) into the end of the spray gun body (1) while pulling the powder tubing slack out of the rear of the gun.
4. Install the nozzle nut over the lance assembly and up against the shoulder of the lance housing assembly, then thread the nut onto the gun and tighten it finger tight.
5. Install a nozzle on the end of the lance assembly, making sure the electrode and black conductive O-ring are installed inside the nozzle.

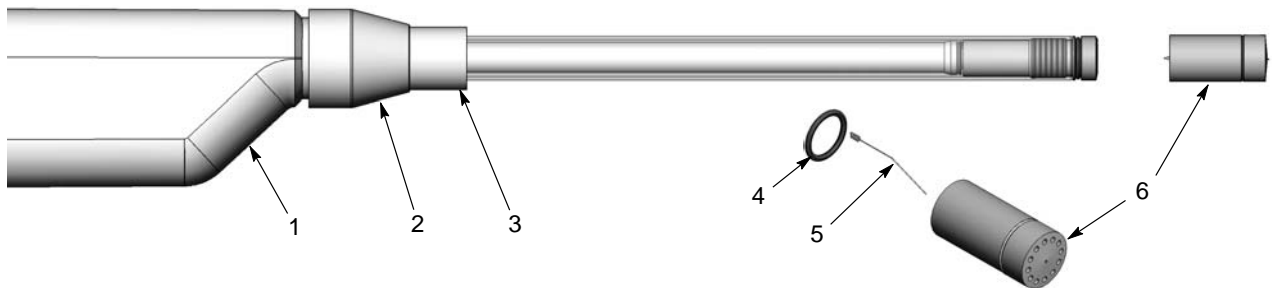


Figure 3 Installing Lance Extension and Nozzle

- | | | |
|---------------|--------------------|----------------------|
| 1. Gun body | 3. Lance extension | 5. Conductive O-ring |
| 2. Nozzle nut | 4. Nozzle | 6. Electrode |

Pump Throat and Hose Adapter Installation

See Figure . Remove the standard pump throat and hose adapter and install a container coating throat and 8 or 10-mm tubing adapter.

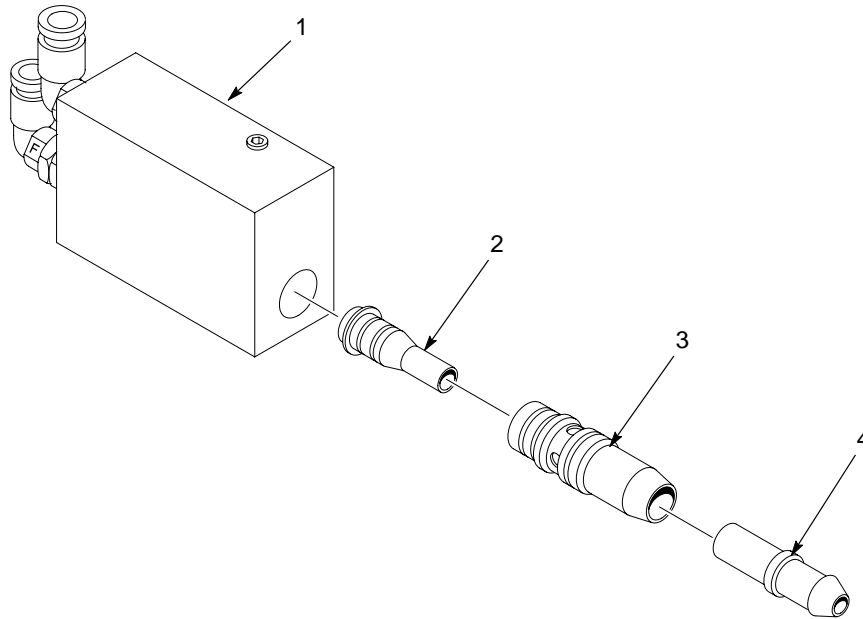


Figure 4 Installing Container Coating Venturi Throat and Powder Tubing Adapter

- | | | |
|----------------------------|------------------|-------------------|
| 1. Pump body | 3. Throat holder | 4. Tubing adapter |
| 2. Venturi throat assembly | | |

Parts

250 mm Lance Assembly

See Figure 5 for lance assembly parts.

Item	Part	Description	Quantity	Note
-	1092746	KIT, container lance extension, 250 mm	1	
1	1092357	• KIT, electrode support, container lance extension	1	
1A	940163	• • O-RING, silicone, 0.625 x 0.75 x 0.063	2	
1B	941162	• • O-RING, silicone, 0.75 x 0.937 x 0.094		
2	1092535	• HOUSING assembly, container lance extension, 250 mm	1	
3	1092701	• TUBE, w/electrode, powder, container lance, 250 mm, packaged	1	
4	1092801	• HOLDER assembly, nozzle, container lance	1	
5	1092446	• • ELECTRODE spring, holder, container lance	1	
6	940015	• • O-RING, silicone, conductive, 0.562 x 0.687	1	

300 mm Lance Assembly

Item	Part	Description	Quantity	Note
-	1092747	KIT, container lance extension, 300 mm	1	
1	1092357	• KIT, electrode support, container lance extension	1	
1A	940163	• • O-RING, silicone, 0.625 x 0.75 x 0.063	2	
1B	941162	• • O-RING, silicone, 0.75 x 0.937 x 0.094		
2	1092537	• HOUSING assembly, container lance extension, 300 mm	1	
3	1092702	• TUBE, w/electrode, powder, container lance, 300 mm, packaged	1	
4	1092801	• HOLDER assembly, nozzle, container lance	1	
5	1092446	• • ELECTRODE spring, holder, container lance	1	
6	940015	• • O-RING, silicone, conductive, 0.562 x 0.687	1	

350 mm Lance Assembly

Item	Part	Description	Quantity	Note
-	1092748	KIT, container lance extension, 350 mm	1	
1	1092357	• KIT, electrode support, container lance extension	1	
1A	941162	• • O-RING, silicone, 0.75 x 0.937 x 0.094	1	
1B	940163	• • O-RING, silicone, 0.625 x 0.75 x 0.063	2	
2	1092538	• HOUSING assembly, container lance extension, 350 mm	1	
3	1092703	• TUBE, w/electrode, powder, container lance, 350 mm, packaged	1	
4	1092801	• HOLDER assembly, nozzle, container lance	1	
4A	1092446	• • ELECTRODE spring, holder, container lance	1	
4B	940156	• • O-RING, silicone, 0.563 x 0.688 x 0.063	1	

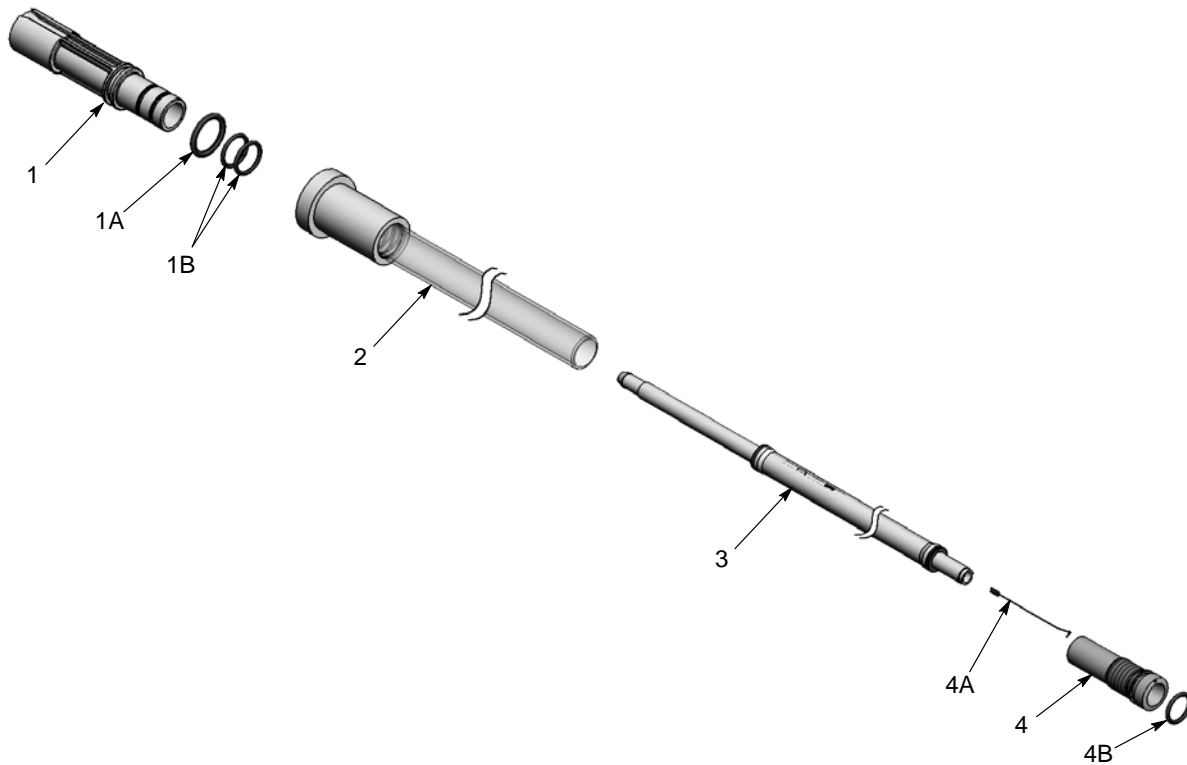


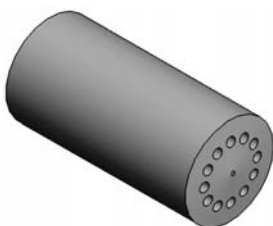
Figure 5 Lance Assembly Parts

Nozzles

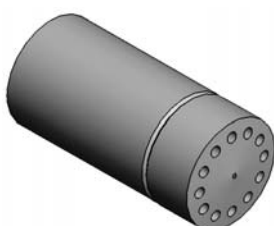
Nozzles are marked with identification grooves as noted in the illustration.

Item	Part	Description	Quantity	Note
-	1092796	KIT, nozzle, 2 mm 12-3 degree, container lance	1	
-	1092795	KIT, nozzle, 2 mm 12-5 degree, container lance	1	
-	1092797	KIT, nozzle, 2 mm 12-7 degree, container lance	1	
-	1092799	KIT, nozzle, 3 mm, 8-5 degree, container lance	1	
-	1092798	KIT, nozzle, 3 mm, 8-7 degree, container lance	1	
1	1091858	<ul style="list-style-type: none"> ELECTRODE spring, 0.070 in. diameter, lance nozzle 	1	A
2	940015	<ul style="list-style-type: none"> O-RING, silicone, conductive, 0.562 x 0.687 	1	A
NOTE A: These parts are included with each nozzle.				

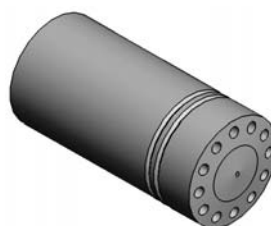
12-Hole Nozzles



**3-Degree
(No Groove)**

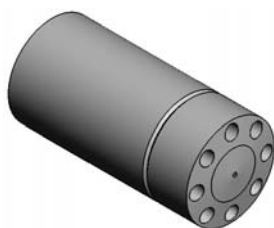


**5-Degree
(One Groove)**



**7-Degree
(Two Grooves)**

8-Hole Nozzles



**5-Degree
(One Groove)**



**7-Degree
(Two Grooves)**

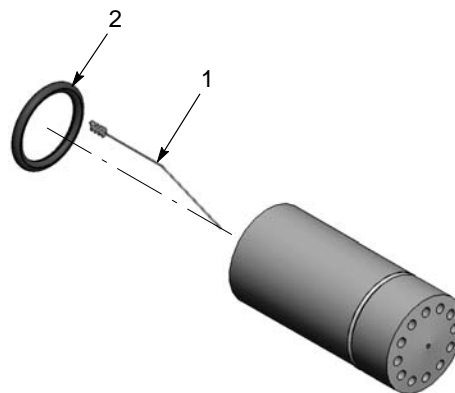


Figure 6 Container Coating Nozzles for Lance Extensions

Pump Venturi Throat and Tubing Adapters

Item	Part	Description	Quantity	Note
1	1092521	THROAT assembly, venturi, 0.149 ID	1	
1A	940126	• O-RING, silicone, 0.375 x 0.50 x 0.063	2	
1B	986100	• RETAINING ring, external, 50, invert	1	
2	1092507	ADAPTER, powder pump, 8 mm tube	1	A
3	1092508	ADAPTER, powder pump, 10 mm tube	1	B

NOTE A: Adapter marked with one identification groove.
B: Adapter marked with two indentification grooves.

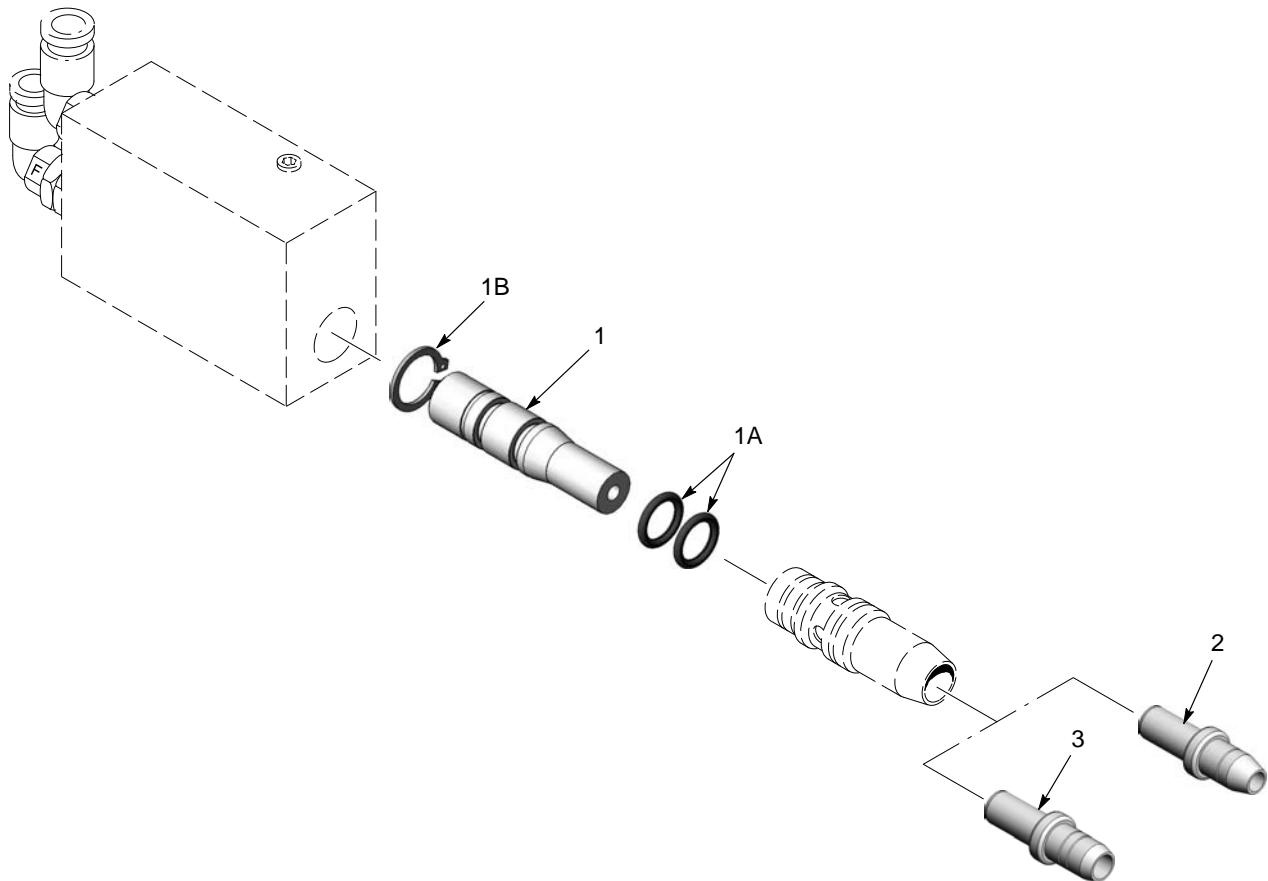


Figure 7 Container Coating Pump Venturi Throat and Tubing Adapters

Powder Feed Hopper

Part	Description	Note
1091703	HOPPER ASSEMBLY, NHR-25, w/agitator	

Issued 12/08

Original copyright date 2008. Sure Coat, Nordson, and the Nordson logo are registered trademarks of Nordson Corporation.