

Encore XT Manual Gun Upgrade Kit 1600834

Introduction

Follow these instructions to upgrade your Encore manual spray gun to the improved design of the Encore XT spray gun. This kit can be used on the following guns:

1083120
1087278
1102650

NOTE: Please note that these guns should all have upgraded display modules installed. The latest version has a silver colored bezel around the module. If your spray gun has not been upgraded, please refer to the instructions on page 7.

Gun Disassembly

NOTE: Refer to the exploded view in Figure 1 while disassembling your spray gun.

1. Disconnect the powder hose and air tubing from the gun handle. Disconnect the gun cable from the interface module.
2. Remove the nozzle nut (20), nozzle (19), and electrode assembly (18).
3. See Figure 1. Remove the two screws (1) securing the display module (4) to the gun with a Philips head screwdriver. Remove the bezel (2) and hook (3) and carefully pull the display module away from the gun. Save the screws, bezel, and hook.
4. Insert a small flat-bladed screwdriver into the display module (J3) and power supply (J2) connectors and disconnect them from the gun cable.
5. Peel the adhesive support pad (5) off the display module and disconnect the trigger switch header from the display module. Place the display module aside.
6. Remove the black nylon M5 screw (7) from the gun body (8) with a Philips head screwdriver. Discard the screw.
7. Grasp the handle (9) in one hand and the gun body in the other. Press the thumbs of each hand together while pulling in opposite directions to separate the gun body from the handle. The clear air tubing (10) will keep them connected.

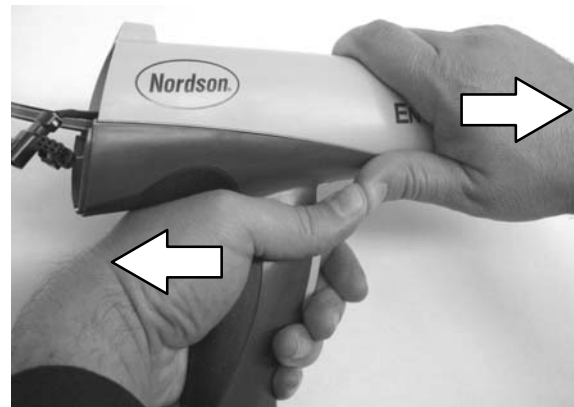
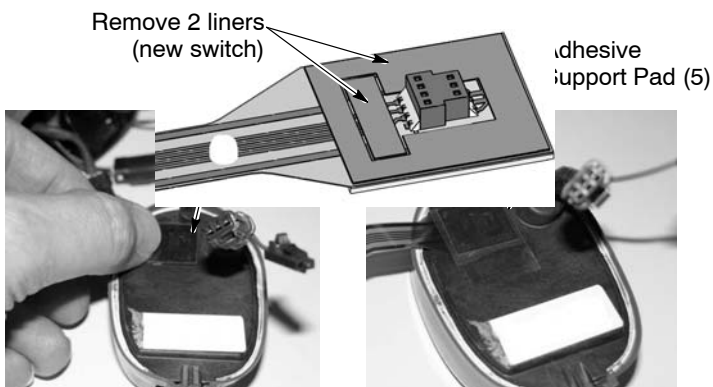
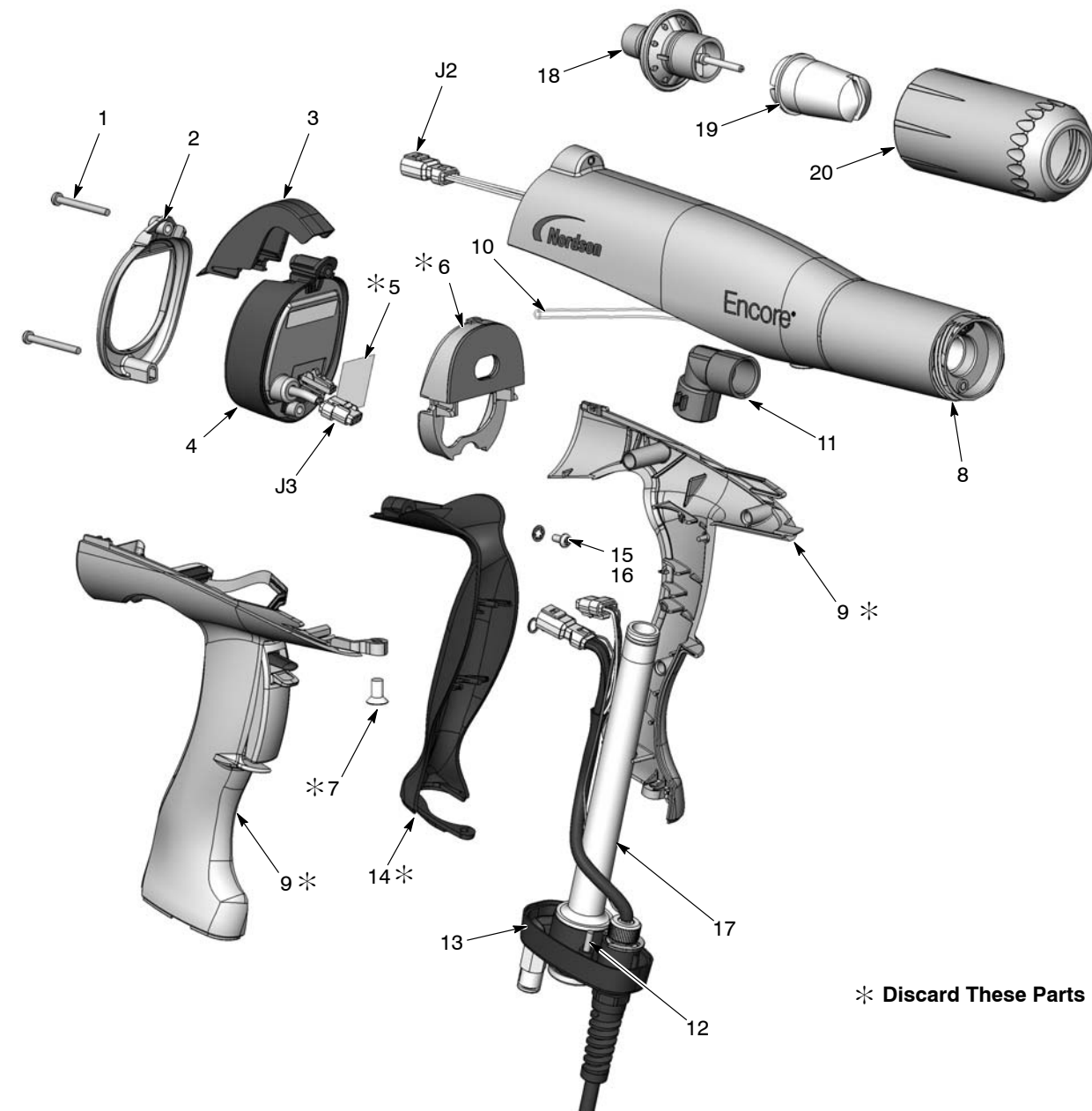


Figure 1 Gun Disassembly

8. Remove the elbow (11) from the inlet tube (17). Save the elbow.
9. Remove and discard the bulkhead (6).
10. Remove the two screws (12) from the handle base (13), and pull the handle away from the base 1 or 2 inches (25–50 mm). Save the screws.
11. Disconnect the clear air tubing from the barbed fitting in the handle base.
12. Pull the base of the ground pad (14) away from the handle and remove it.
13. Disconnect the gun cable ground wire from the ground pad. Save the screw and lockwasher (15, 16). Discard the ground pad.
14. Separate the handle halves (9) and discard them along with the trigger switch and triggers.
15. Leave the inlet tube, cable, and air fittings installed in the handle base. Inspect the inlet tube and O-rings and replace them if worn or damaged.
16. On the rear of the display module, carefully clean the area around the trigger switch connector with isopropyl alcohol. Dry the surface completely before proceeding.

Gun Re-assembly

See Figure 2. The upgrade kit is shipped with the trigger switch, triggers, bulkhead and bulkhead gasket, and ground pad installed in the handle.

1. Grasp the base of the new ground pad (14) and pull it away from the new handle assembly (9).

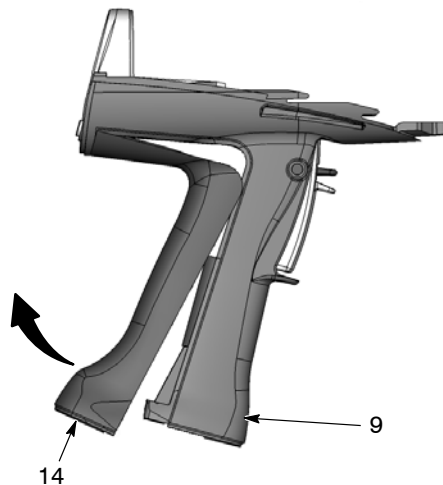


Figure 2 Removing the Ground Pad from the New Handle Assembly

2. See Figure 4. Connect the gun cable ground wire to the new ground pad with the screw and lockwasher (15, 16)
3. See Figure 3. Bring the gun body and handle together, and insert the clear air tubing (10) down into the handle (9), along the back of the trigger housing. There is a small hole in the handle rib for the tubing to pass through.

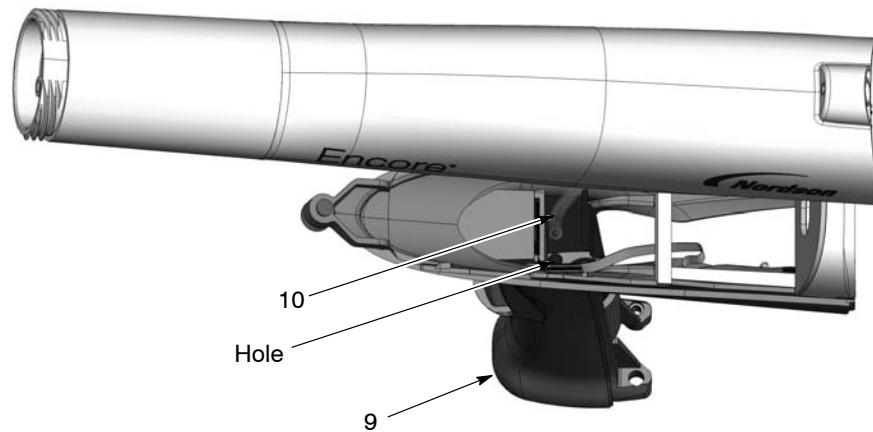


Figure 3 Inserting the Clear Air Tubing into the New Handle

4. See Figure 4. Orient the handle base assembly (13) so the cable will be to the rear after assembly.
5. Insert the inlet tube (17) into the handle and push it through until the handle base (13) is close enough to the handle (9) that you can connect the clear air tubing (10) to the barbed fitting.

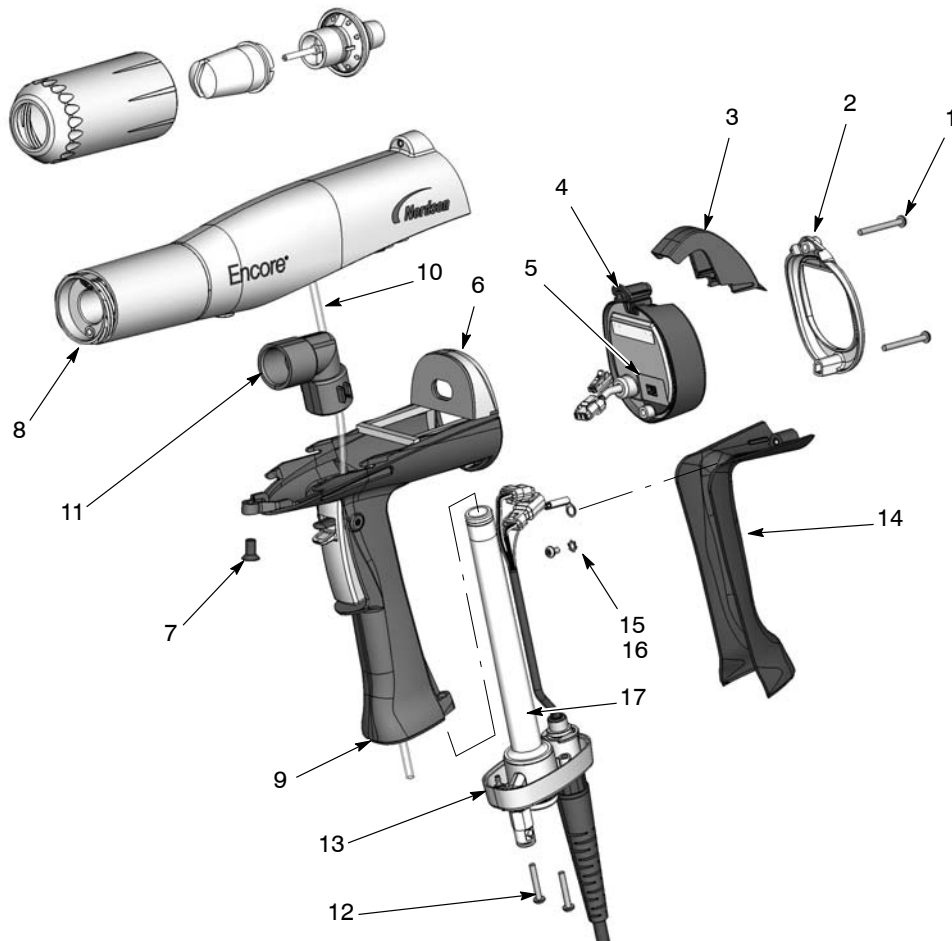


Figure 4 Gun Re-assembly with Upgrade Kit

6. Insert the cable connectors through the bottom of the bulkhead and out the back of the handle.
7. Hook the top of the ground pad (14) to the handle, then rotate the ground pad onto the handle. Make sure the cable wires are not pinched or trapped.
8. Push the handle base onto the handle and ground pad. Secure the base to the handle with the two M3 x 20 screws (12).
9. Install the elbow (11) onto the inlet tube.
10. Route the trigger switch tail and header connector through the bottom of the bulkhead and out the back of the handle.
11. See Figure 5. Push the outlet tube forward so that the front end of the tube is flush with the front end of the gun body.

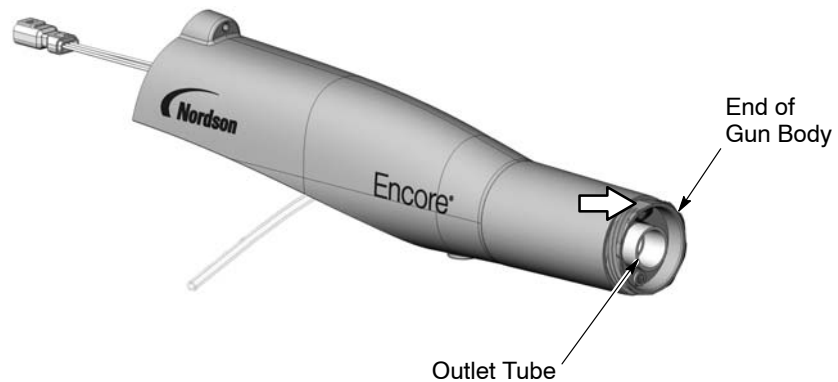


Figure 5 Positioning the Outlet Tube Prior to Installing the Gun Body on the Handle

12. See Figure 6. Align the gun body with the handle, and feed the power supply harness through the top hole in the bulkhead. Slide the gun body and handle together, engaging the internal ribs of the gun body with the handle tabs.

NOTE: Make sure that the power supply harness is not pinched between the bulkhead and the power supply.

13. Insert your finger into the outlet tube at the front of the gun and align the inside end of the tube with the elbow, then push on the tube to seat it in the elbow.

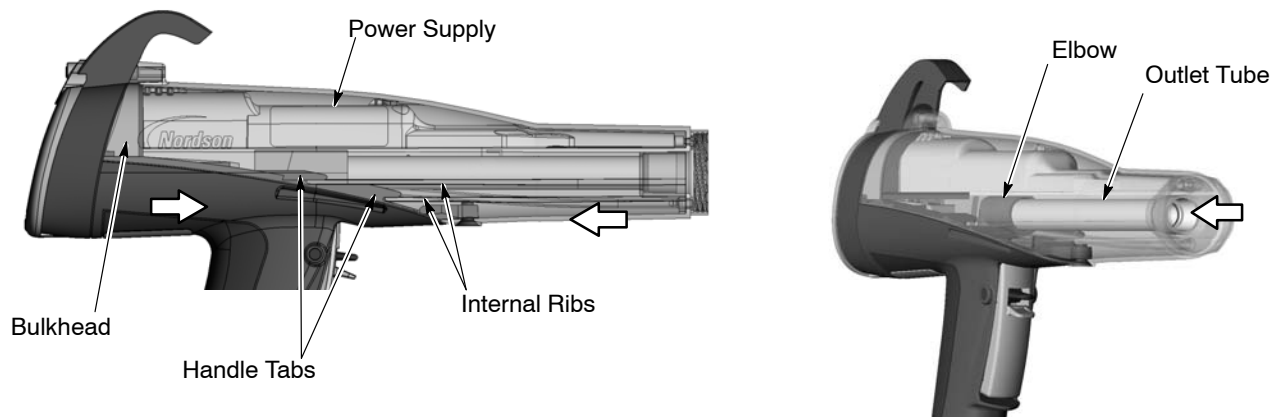


Figure 6 Mating the Gun Body with the Handle and Connecting the Outlet Tube to the Elbow

14. Install the new nylon screw (7) included in the upgrade kit through the handle and gun body and tighten it securely.
15. Connect the power supply harness to the gun cable, then tuck both through the bottom hole in the bulkhead, into the gun body.
16. See Figure 7. Remove the liners from the connector side of the trigger switch header, then plug the trigger switch header into the display module.
17. Peel the liner from the new adhesive support pad included in the kit and install it over the trigger switch header.

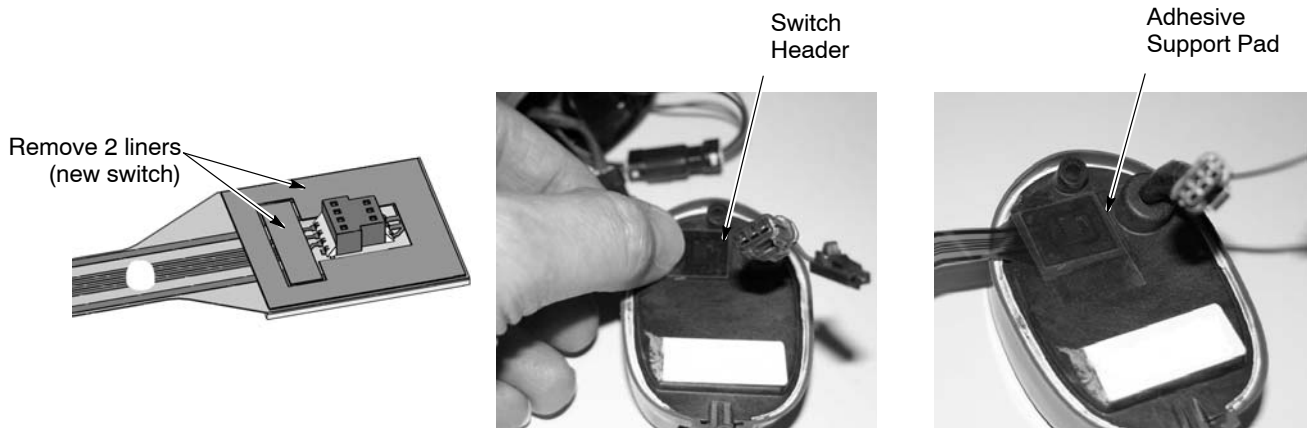


Figure 7 Connecting the Trigger Switch to the Display Module

18. See Figure 4. Connect the cable connector to the display module.
19. Tuck the cable and trigger switch tail through the bottom of the bulkhead, into the gun body.
20. Install the display module, hook, and bezel and secure them with the two M3 x 35 screws.
21. Install the electrode support, nozzle, and nozzle nut.
22. Connect the air tubing to the handle base, and connect the gun cable to the interface module.

Instructions for Spray Guns Not Previously Upgraded

If your spray gun has not been previously upgraded, the gun cable ground is connected to the handle base and there is no silver bezel around the display module. To upgrade these guns to the Encore XT gun, you must order the following parts along with the upgrade kit:

- 1600745 Cable assembly, handgun, 6 meter, Encore LT/XT
 - 1102648 Bezel, shield, plated
 - 345071 Screw, pan head, recessed, M3 x 35 (quantity 2)
 - 983520 Lock washer, internal, M3
 - 982427 Screw, pan head, recessed, M3 x 6
1. Disassemble the spray gun as described in steps 1–11 of *Gun Disassembly*. In step 2, discard the screws after removing the display module and hook.
 2. Disregard step 13.
 3. If there is a green ground wire connected to the display module, disconnect it.
 4. Perform step 14.
 5. Use a 1/4-in. socket to remove the nut and lockwasher from the barbed fitting in the handle base and disconnect the ground wire(s) from the fitting. Re-install the nut and lockwasher on the barbed fitting. Discard the display module ground wire (if used).
 6. Remove the retaining ring from the gun cable and remove the cable from the handle base. Discard the cable.
 7. Install the new cable in the handle base and secure it with the retaining ring.
 8. Perform the *Gun Re-assembly* procedure.

Obtaining an Encore XT Manual

After upgrading your spray to an Encore XT gun, go to the Nordson Corporation emanuals web site to obtain a new manual for your gun and system:

<http://emanuals.nordson.com/finishing>

Expand the Powder-US menu, then click on the Encore XT Systems page for a listing of Encore XT and other relevant manuals.

Right click on the 1600820 part number link and select Save Target As to download the Encore XT System manual. Use this manual to order parts for your upgraded spray gun and system.

Issued 4/12

Original copyright date 2012. Encore, Nordson, and the Nordson logo are registered trademarks of Nordson Corporation.