

Automatic Powder Spray Gun Extruded Support Kits

Introduction

This product manual applies to the 40 mm vertical powder spray gun support kits, mounting bars and mounting kits for tube- and bar-mount automatic powder spray guns. These kits can be used on gun movers (oscillators or reciprocators) or on fixed gun stands with guns spaced 15 in. (38.1 cm) horizontally. The support kits and mounting bars are sold separately to accommodate a variety of applications.

Description

These kits include the parts shown in Figures 1 and 2, other than the optional gun mount bars and the base to which the brackets attach.

Vertical Support Kits

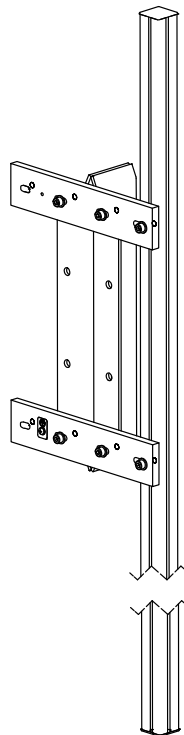


Figure 1 Single Vertical Extruded Support Kit

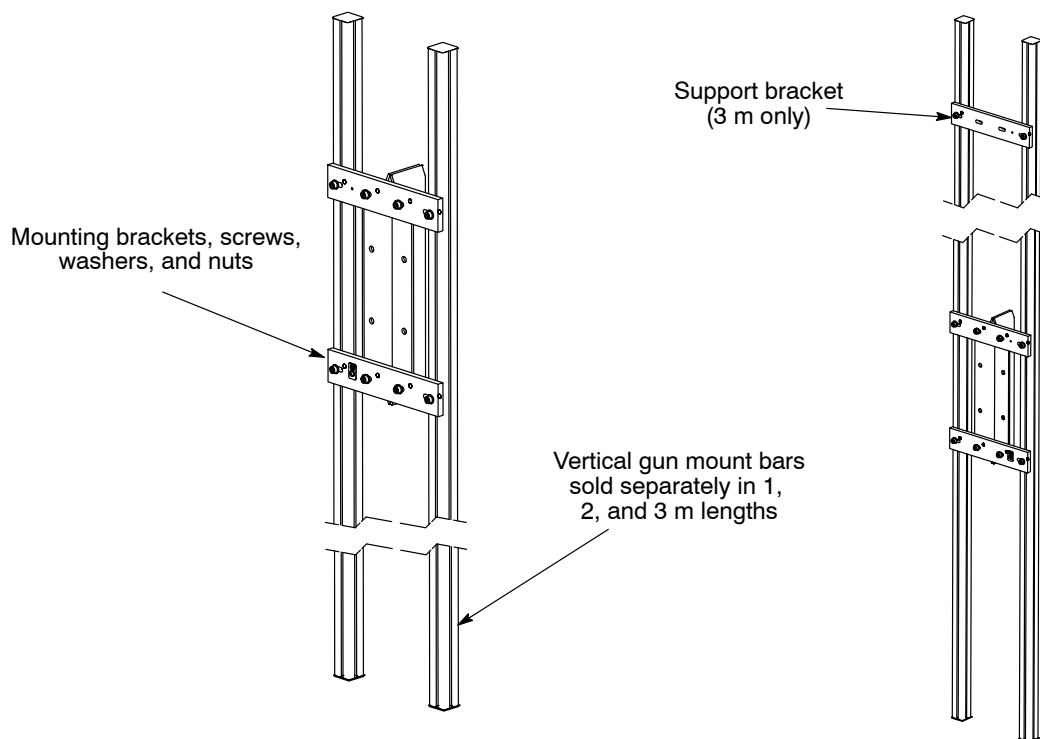


Figure 2 Dual Vertical Extruded Support Kit

Extruded Mounting Bars

Mounting bars provide the base for tube-mount gun mounts. The mounting bars are 40 mm x 40 mm (1.575 in.) extruded aluminum and are available in the following lengths:

- 1 m (3.2 ft)
- 2 m (6.5 ft)
- 3 m (9.8 ft)

Tube-Mount and Bar-Mount Kits

The bar-mount kits are used for vertical gun mounting. For tube-mount guns, different mounts are used for horizontal and vertical gun mounting.

Installation

Support Kit Mounting

Mounting Bracket Kit Installation

To assemble and install the kits, refer to Figure 3, 4, or 5 on the following pages and follow the instructions below. Initially hand-tighten all hardware, align the components, and then tighten all screws.

1. Attach the mount brackets (1) to the oscillator or reciprocator gun carriage (10) using items 2, 3, and 5.
2. Install the bar caps (7) on the ends of the mounting bars (9).
3. Attach the mounting bars (9) to the mount brackets (1) using items 2, 4, and 6. If installing the 3 m bars, install the third mounting bar.
4. Install the ground wire to either mounting bar using the ground hardware (8) (screw, lock washer, flat washer, and tag).

Dual-Bar 1 m and 2 m Gun Support Kit Assembly

See Figure 3. The dual-bar kit accommodates two vertical mounting bars. The kit includes fasteners to install the mounting bracket on the oscillator or reciprocator gun carriage. Guns will be 15 in. (38.1 cm) apart when two are mounted.

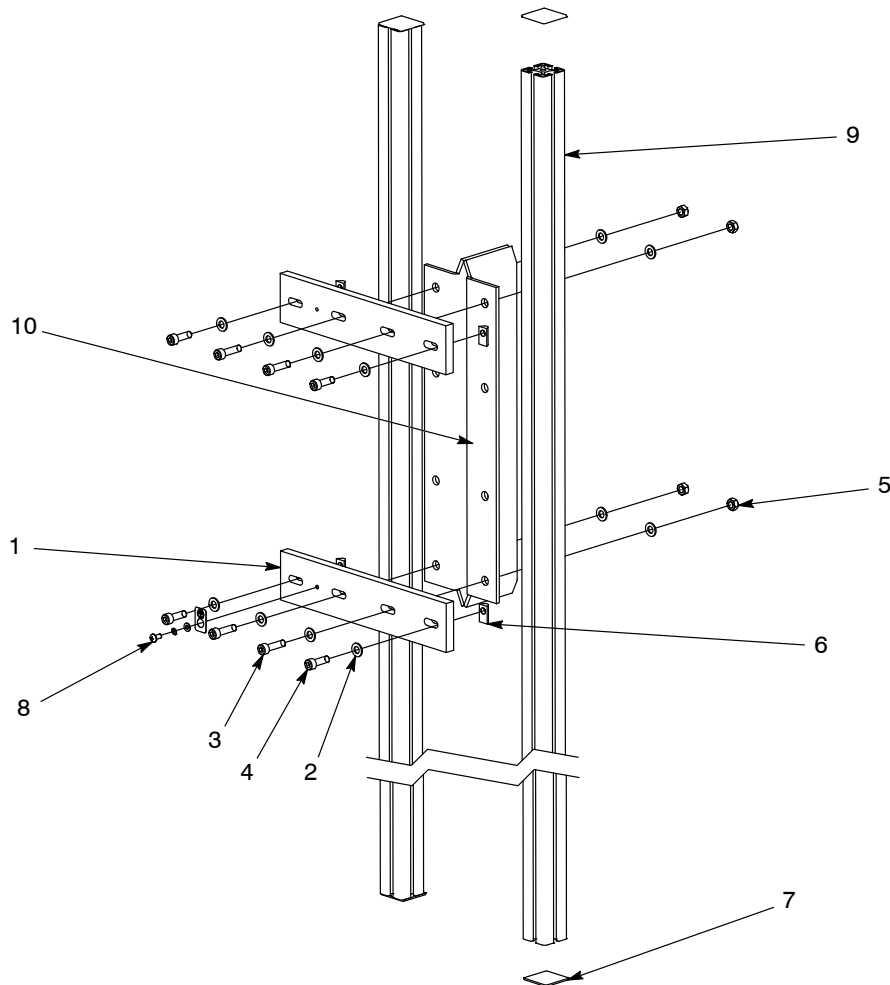


Figure 3 Dual-Bar Gun Support Assembly

- | | | |
|---------------------------------------|---------------------------------------|-----------------------------|
| 1. Mount brackets (2) | 4. M8 x 25 socket head cap screws (4) | 7. Bar caps (4) |
| 2. M8 flat washers (12) | | 8. Ground hardware |
| 3. M8 x 30 socket head cap screws (4) | 5. M8 hex nuts (4) | 9. Mounting bars (1 or 2 m) |
| | 6. T-nuts (4) | 10. Gun carriage |

Note: The mounting bars (9) must be ordered separately. The gun carriage (10) is included with the gun movers.

Single-Bar Gun Support Kit Assembly

See Figure 4. The single-bar kit accommodates only one vertical mounting bar. The kit includes fasteners to install the mounting bracket on the oscillator or reciprocator gun carriage.

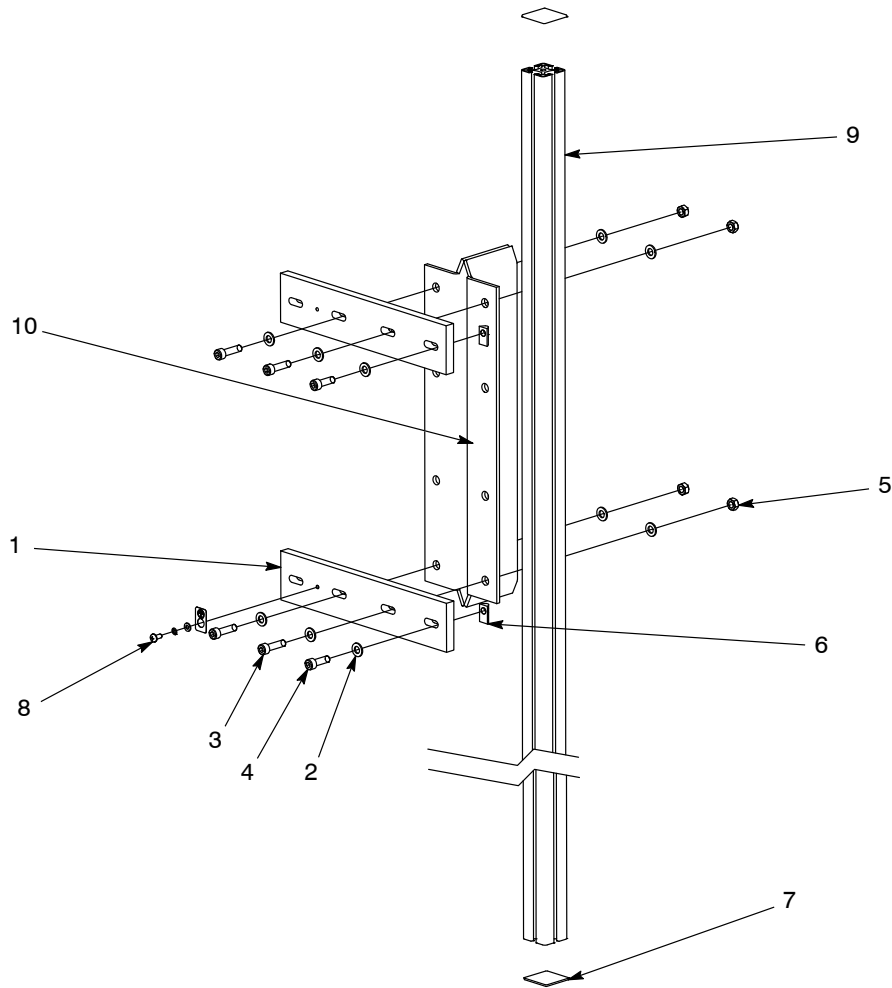


Figure 4 Single Bar Gun Support Assembly

- | | | |
|---------------------------------------|---------------------------------------|----------------------------|
| 1. Mount brackets (2) | 4. M8 x 25 socket head cap screws (4) | 7. Bar caps (2) |
| 2. M8 flat washers (12) | 5. M8 hex nuts (4) | 8. Ground hardware |
| 3. M8 x 30 socket head cap screws (4) | 6. T-nuts (4) | 9. Mounting bar (1 or 2 m) |
| | | 10. Gun carriage (2) |

Note: The mounting bar (9) must be ordered separately. The gun carriage (10) is included with the gun movers.

Three-Meter Gun Support Kit Assembly

See Figure 5. The three-meter gun support kit accommodates two vertical mounting bars and includes an extra bracket for lateral support. The kit includes fasteners to install the mounting bracket on the oscillator or reciprocator gun carriage. Guns will be 15 in. (38.1 cm) apart when two are mounted.

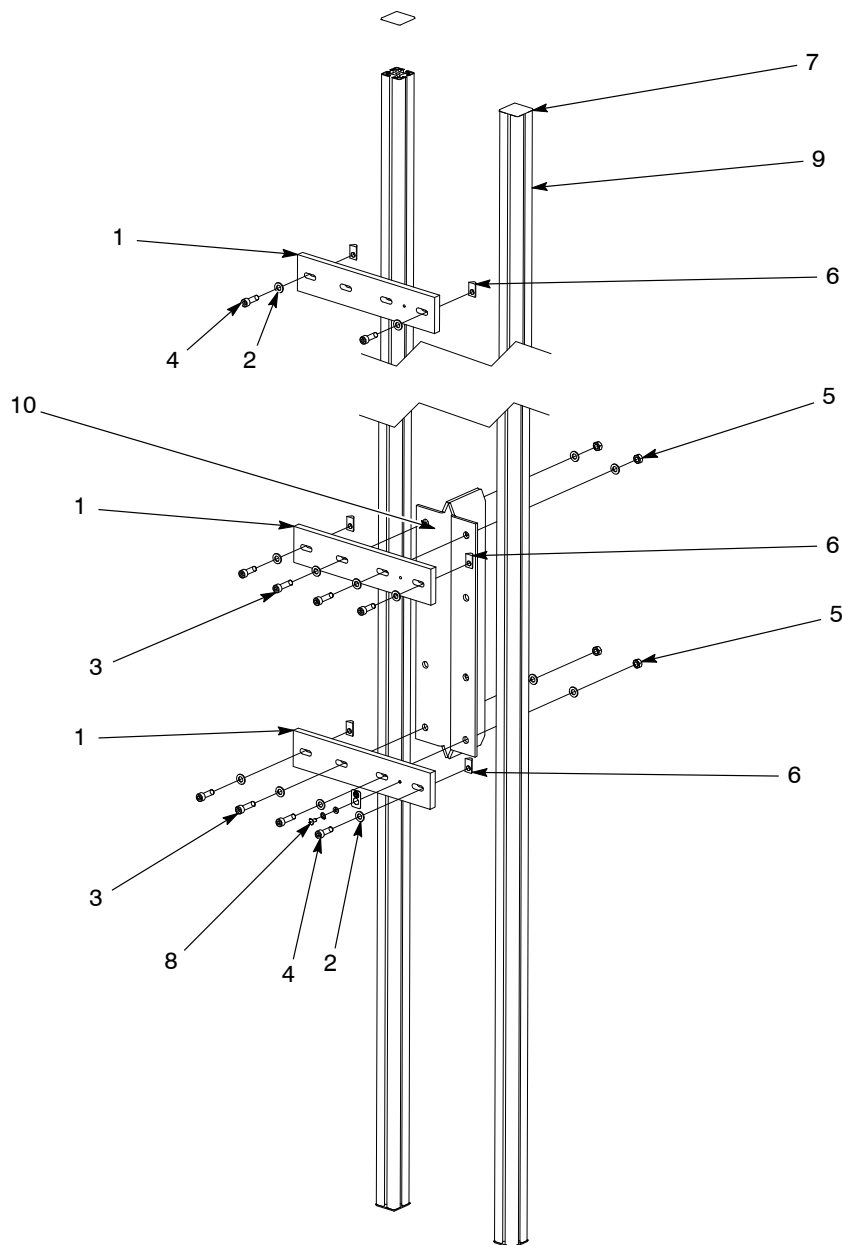


Figure 5 Three-Meter Gun Support Assembly

- | | | |
|---------------------------------------|---------------------------------------|------------------------|
| 1. Mount brackets (3) | 4. M8 x 25 socket head cap screws (4) | 7. Bar caps (4) |
| 2. M8 flat washers (12) | 5. M8 hex nuts (4) | 8. Ground hardware |
| 3. M8 x 30 socket head cap screws (4) | 6. T-nuts (4) | 9. Mounting bars (3 m) |
| | | 10. Gun carriage (2) |

Note: The mounting bars (9) must be ordered separately. The gun carriage (10) is included with the gun movers.

Grounding



CAUTION: It is very important to provide a complete circuit for the gun current. A break in the circuit conductors (conveyor, booth, braided ground cables, or controller) can cause voltage to increase on the conductors to the maximum output of the spray gun voltage multiplier (up to 100 kV). The voltage will eventually discharge in a high frequency arc and cause damage to the controller electronics (gun driver board and power supply).

See Figure 6. Two ring-tongue terminals and a 7.6 m (25 ft) flat, braided ground wire are included in each support kit. Mounting plates include one ground screw, lock washer, flat washer, and tab. Use the ground wire to ground the mounting plate to a true-earth ground. Typically, this is a ground stud on the in/out positioner or gun stand.

1. Cut the ground wire to the required length, allowing the gun maximum movement.
2. Crimp the ring-tongue terminals to the ground wire.
3. Connect one end of the ground wire to the mounting plate ground, using the supplied screw, lock washer, and brass washer.
4. Connect the other end of the ground wire to the earth ground and secure the ground wire so that it will not be pulled loose or severed by gun and support movement.

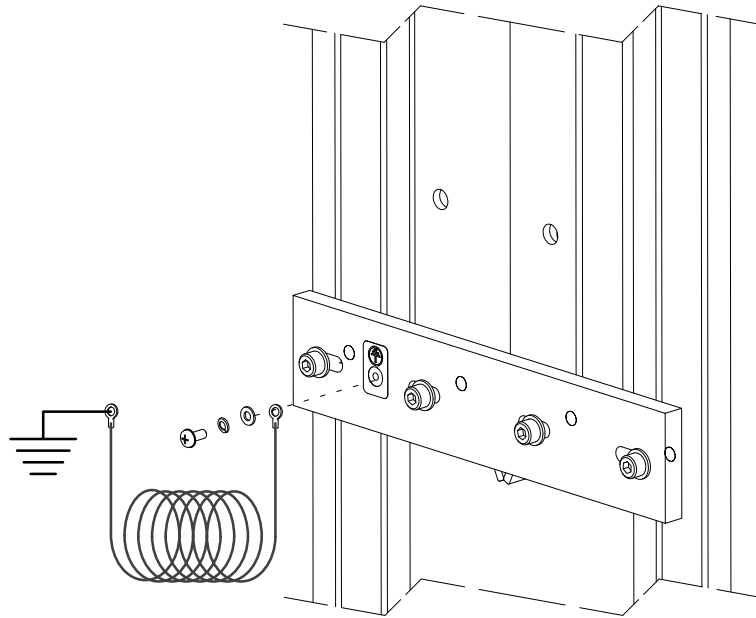


Figure 6 Grounding Procedure

Parts Lists

To order parts, call the Nordson Industrial Coating Systems Customer Support Center at (800) 433-9319 or contact your local Nordson representative.

Dual-Bar 1 m and 2 m Gun Support Kit

See Figure 7.

Item	Part	Description	Quantity	Note
–	1603215	KIT, mount assembly, gun bar dual, 1 m & 2 m		A
1	-----	• BRACKET, mount, gun bar	2	
2	-----	• WASHER, flat, m, reg, 8, sstl	12	
3	-----	• SCREW, socket, M8x30, BL	4	
4	-----	• SCREW, socket, M8x1.25x25, BL	4	
5	-----	• NUT, hex, M8, steel, zinc	4	
6	-----	• NUT, T-slot, steel, M8	4	
7	-----	• CAP, 40x40, black	4	
8	-----	• TAG, ground	1	
9	-----	• WASHER, flat, E, regular, 0.203x0.406x0.040, brass	1	
10	-----	• SCREW, pan, rec, M5x12, w/int lkw, BZN	1	
12	-----	• PLATE ADAPTER, support, gun BA	1	NS
13	-----	• WIRE, braided, flat, flexible	25 ft	NS
14	-----	• TERMINAL, ring-tongue, non, 12–10, 10	2	NS
15	-----	• WASHER, lk, M, spt, M5, stl, zn	1	
NOTE A: Installation required by Nordson				
NS: Not Shown				

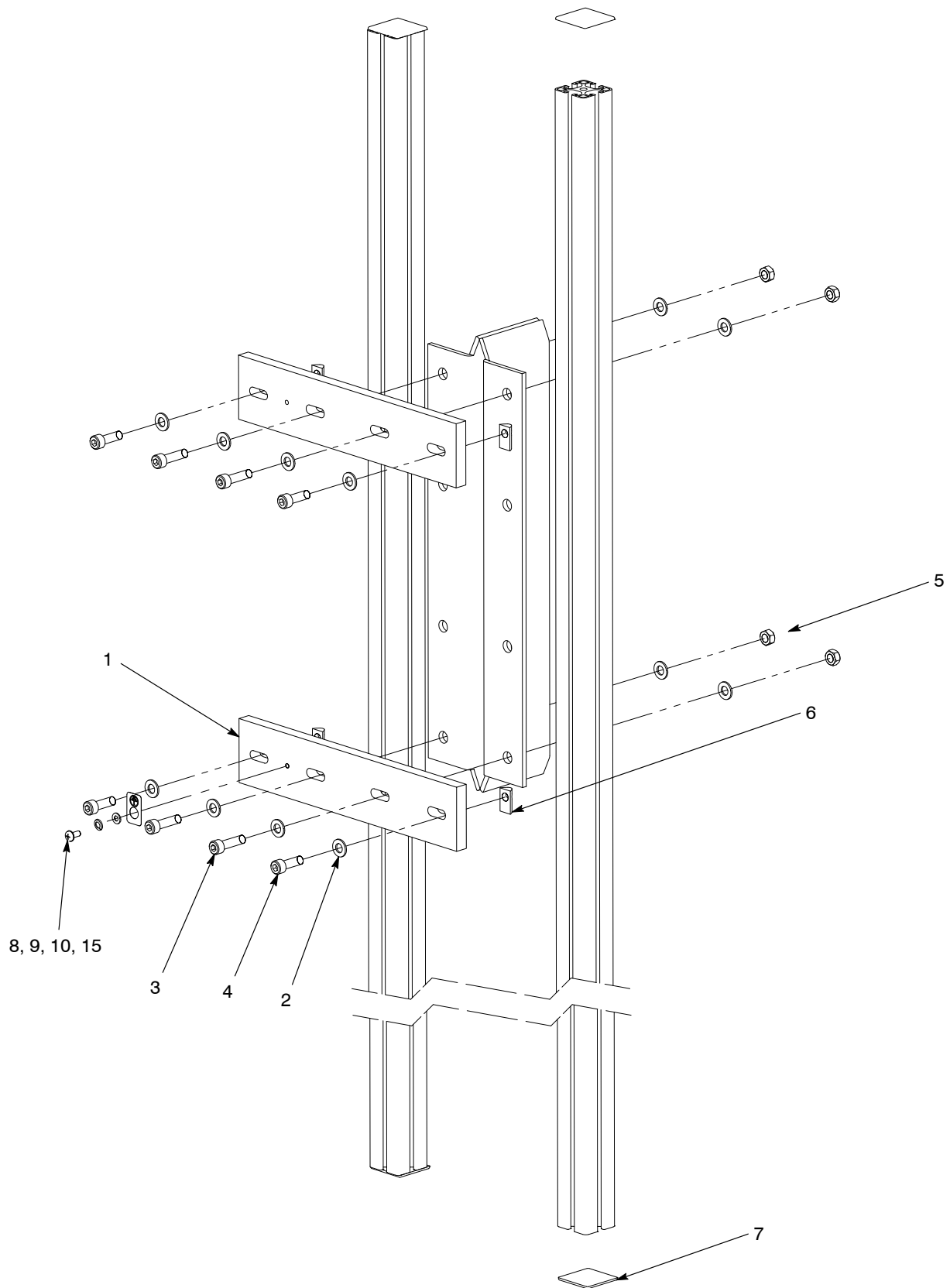


Figure 7 Dual-Bar 1 m and 2 m Gun Support Kit

Single-Bar Gun Support Kit

See Figure 8.

Item	Part	Description	Quantity	Note
–	1603216	KIT, mount assembly, gun bar single, 1 m & 2 m		A
1	-----	• BRACKET, mount, gun bar	2	
2	-----	• WASHER, flat, m, reg, 8, sstl	10	
3	-----	• SCREW, socket, M8x30, BL	4	
4	-----	• SCREW, socket, M8x1.25x25, BL	2	
5	-----	• NUT, hex, M8, steel, zinc	4	
6	-----	• NUT, T-slot, steel, M8	2	
7	-----	• CAP, 40x40, black	2	
8	-----	• TAG, ground	1	
9	-----	• WASHER, flat, E, regular, 0.203x0.406x0.040, brass	1	
10	-----	• SCREW, pan, rec, M5x12, w/int lkw, BZN	1	
12	-----	• PLATE ADAPTER, support, gun BA	1	NS
13	-----	• WIRE, braided, flat, flexible	25 ft	NS
14	-----	• TERMINAL, ring-tongue, non, 12–10, 10	2	NS
15	-----	• WASHER, lk, M, spt, M5, stl, zn	1	
NOTE A: Installation required by Nordson				
NS: Not Shown				

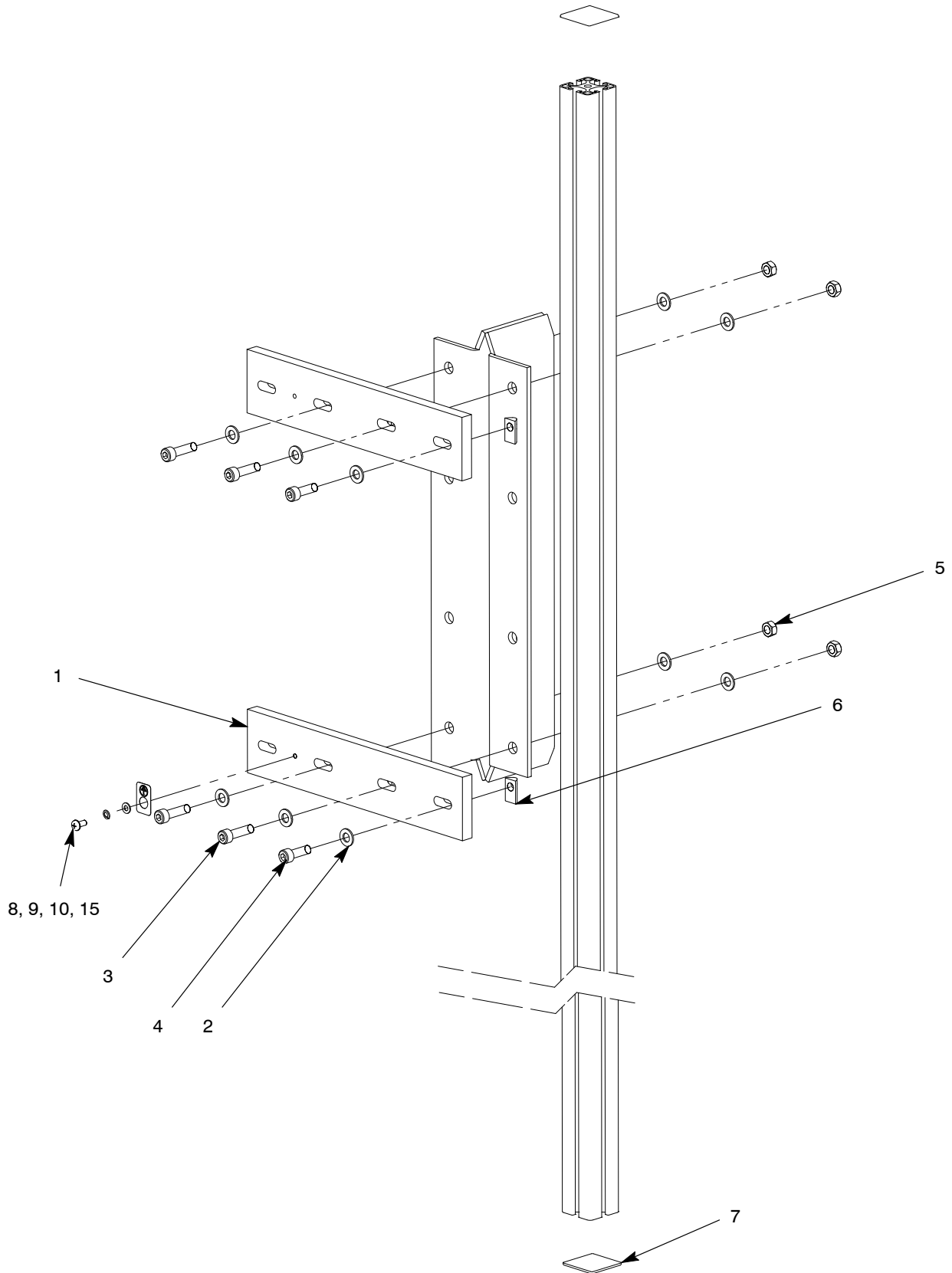


Figure 8 Single-Bar Gun Support Kit

Three-Meter Bar Gun Support Kit

See Figure 9.

Item	Part	Description	Quantity	Note
–	1603219	KIT, mount assembly, gun bar dual, 3 m		A
1	-----	• BRACKET, mount, gun bar	3	
2	-----	• WASHER, flat, m, reg, 8, sstl	14	
3	-----	• SCREW, socket, M8x30, BL	4	
4	-----	• SCREW, socket, M8x1.25x25, BL	6	
5	-----	• NUT, hex, M8, steel, zinc	4	
6	-----	• NUT, T-slot, steel, M8	6	
7	-----	• CAP, 40x40, black	4	
8	-----	• TAG, ground	1	
9	-----	• WASHER, flat, E, regular, 0.203x0.406x0.040, brass	1	
10	-----	• SCREW, pan, rec, M5x12, w/int lkw, BZN	1	
12	-----	• PLATE ADAPTER, support, gun BA	1	NS
13	-----	• WIRE, braided, flat, flexible	25 ft	NS
14	-----	• TERMINAL, ring-tongue, non, 12–10, 10	2	NS
15	-----	• WASHER, lk, M, spt, M5, stl, zn	1	
NOTE A: Installation required by Nordson				
NS: Not Shown				

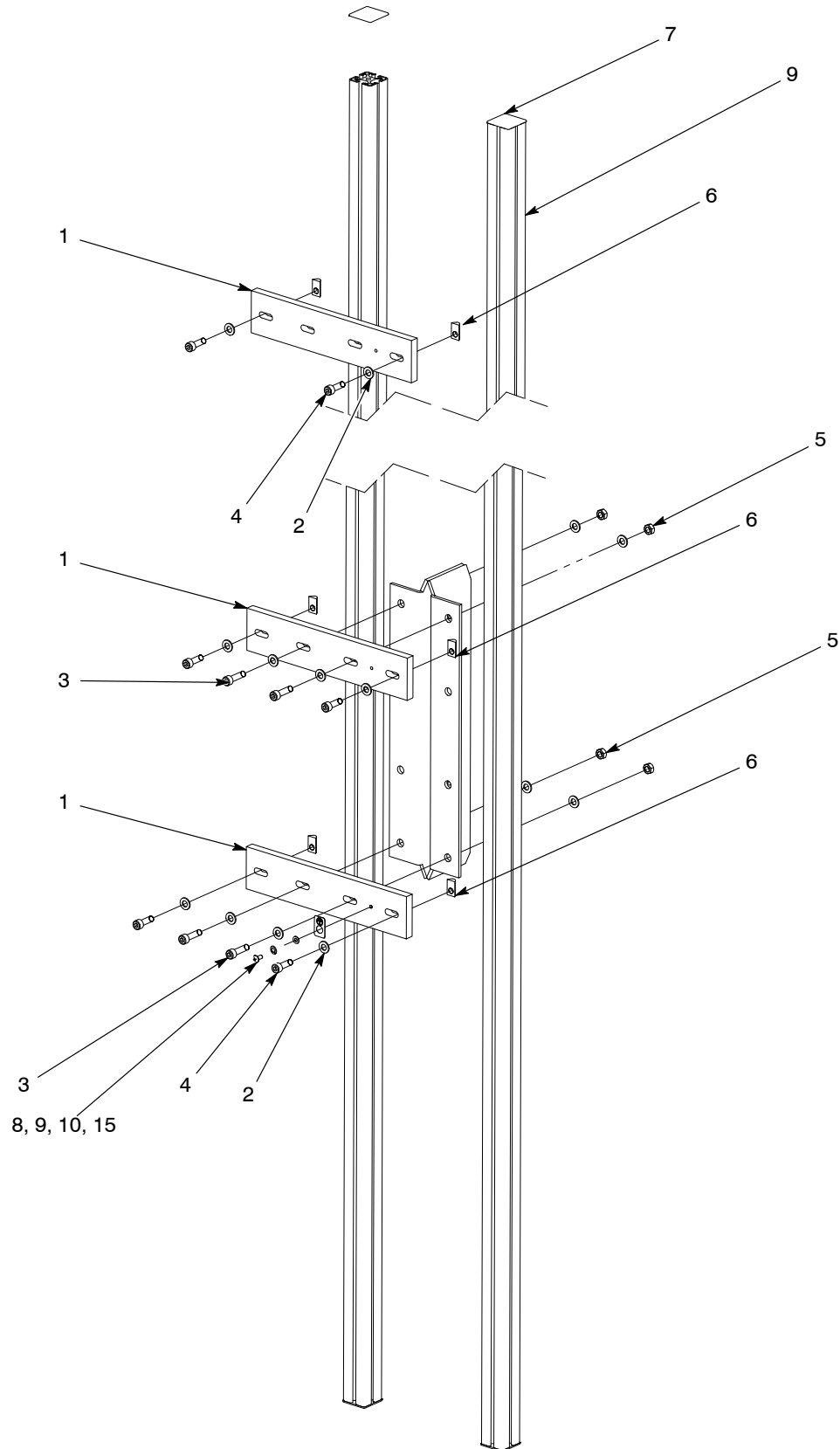


Figure 9 Three-Meter Bar Gun Support Kit

Mounting Bars

Mounting bars are not included in gun support kits. Order the number and size of mounting bars required for your application.

Part	Description	Note
1603223	BAR, gun support, 40 mm/1.5748 in. square x 1 m long	A
1603224	BAR, gun support, 40 mm/1.5748 in. square x 2 m long	A
1603225	BAR, gun support, 40 mm/1.5748 in. square x 3 m long	A
NOTE A: Installation required by Nordson		

Gun Mounts

Vertical Bar Gun Mount for Sure Coat® and Encore® Tube-Mount Guns

See Figure 10. Use when mounting a **tube-mount** gun to extruded gun supports.

Item	Part	Description	Quantity	Note
–	1016515	GUN MOUNT, plate, adapter, support, gun bar assembly		
1	-----	• MOUNT, sleeve, auto gun	1	
2	-----	• PLATE, attachment, support, gun bar	1	
3	-----	• SCREW, socket, 3/8–16 x 1, zinc	3	
4	-----	• SCREW, socket, M8 x 30, zinc	2	
5	-----	• NUT, T-slot, steel, M8	2	

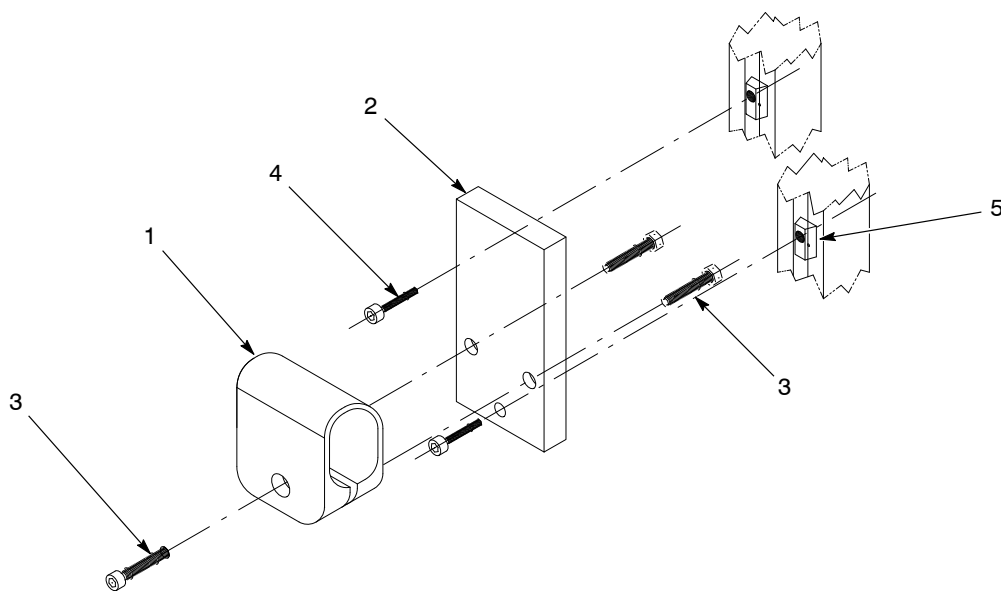


Figure 10 Vertical Bar Gun Mount for Sure Coat and Encore Tube-Mount Guns

Vertical Bar Gun Mount for Sure Coat and Encore Bar-Mount Guns

See Figure 11. Use when mounting a **bar-mount** gun to extruded gun supports.

Item	Part	Description	Quantity	Note
–	1605963	KIT, clamp, bar gun, horizontal, universal		
1	-----	• CLAMP, bar gun, horizontal, universal	1	
2	-----	• PLATE, attachment, support, gun bar	1	
3	-----	• CAP, clamp bar, universal	1	
4	-----	• SCREW, flat, socket, M3x60 steel, black	2	
5	-----	• SCREW, socket, M8 x 30, zinc	2	
NS	-----	• NUT, T-slot, steel, M8	2	

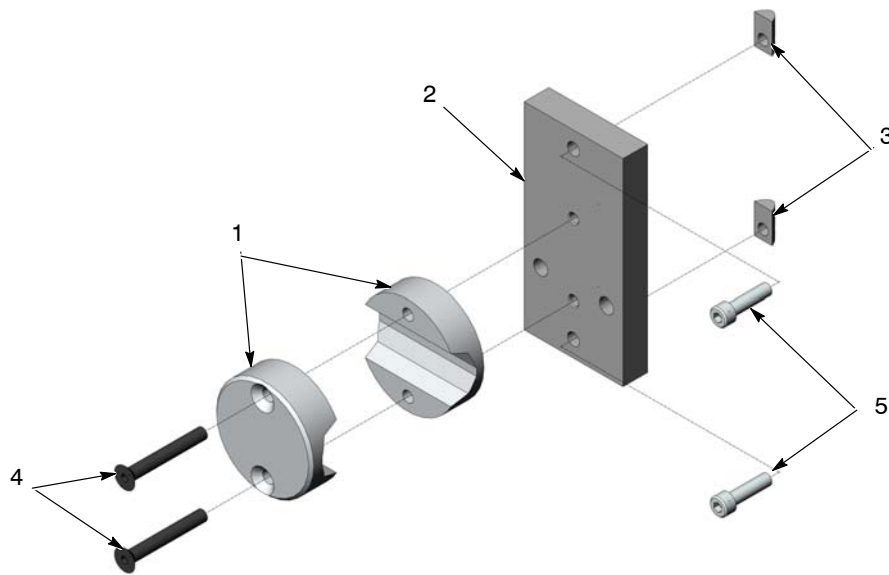


Figure 11 Vertical Bar Gun Mount for Sure Coat and Encore Tube-Mount Guns

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