

# Mounting Hole Plug Kit for Encore<sup>®</sup> Automatic Guns

## Description

The mounting hole plug collects ions emitted from the gun's charging electrode instead of allowing them to deposit on the part. This reduces the rate of charge buildup in the powder deposited on the part ion collector and can improve the smoothness and appearance of cured powder coatings.

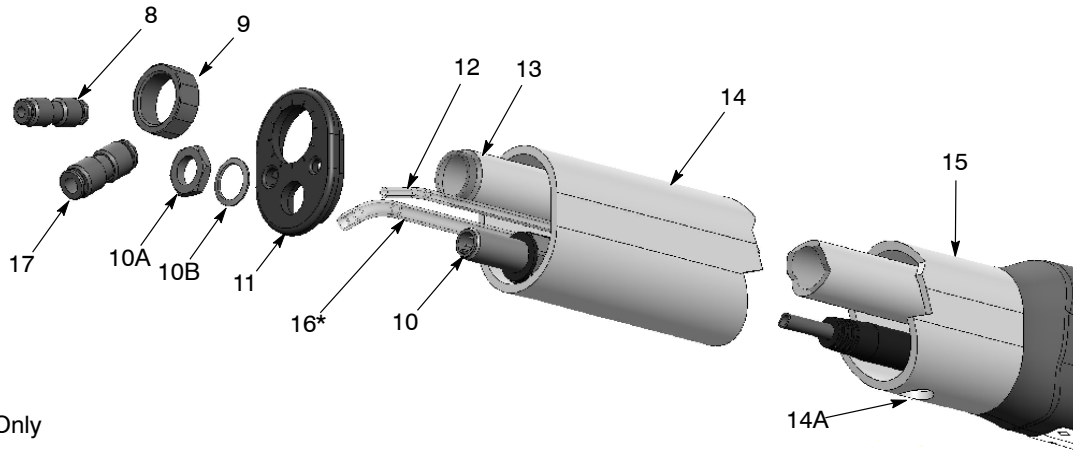
This kit can be used on Encore and Encore HD automatic tube-mount powder spray guns.

## Installation

**NOTE:** The mounting hole in the Encore and Encore HD automatic gun must remain plugged for optimal performance. If the mounting plug is ever removed, replace it with the ion collector kit or a replacement mounting hole plug kit.

### ***Tube-Mount Gun***

1. See Figure 1. Verify that the ion collector mounting hole (14A) is installed towards the front of the gun as shown in Figure 1 and 2. If the ion collector hole is installed towards the far rear, follow the instructions below to position the mounting hole towards the front of the gun. Proper orientation must be implemented to allow access to the grounding plate in the rear body assembly (15). **If mounting hole does not require reorientation, skip to step 9.**
2. If mounting hole requires reorientation, disconnect the gun cable, powder feed hose, and air wash tubing from the gun.
3. Disconnect the 4 mm union (8) from the clear 4 mm tubing (12).
4. For Encore HD Only: Disconnect the 6 mm union (17) from the blue 6 mm tubing (16).
5. Unscrew the clamping tube nut (9) from the clamping tube (13).
6. Remove the nut and lockwasher (10A, 10B) from the cable receptacle (10).
7. Pull the end cap (11) off the mounting tube (14).
8. Pull the mounting tube (14) off the rear body assembly (15) and reverse it, then re-assemble the gun.



\*Encore HD Only

Figure 1 Mounting Tube Disassembly Procedure

- |                            |                       |                        |
|----------------------------|-----------------------|------------------------|
| 8. 4 mm Union              | 11. End cap           | 14A. Mounting hole     |
| 9. Clamping tube nut       | 12. Clear 4-mm tubing | 15. Rear body assembly |
| 10. Cable receptacle       | 13. Clamping tube     | 16. Blue 6 mm tubing*  |
| 10A. Receptacle nut        | 14. Mounting tube     | 17. 6 mm union*        |
| 10B. Receptacle lockwasher |                       |                        |

9. See Figure 2. Insert the cap plug (1) through the mounting hole (14A) and secure it to the grounding plate in the mounting tube (14) with the washer (2) and the socket head screw (3).

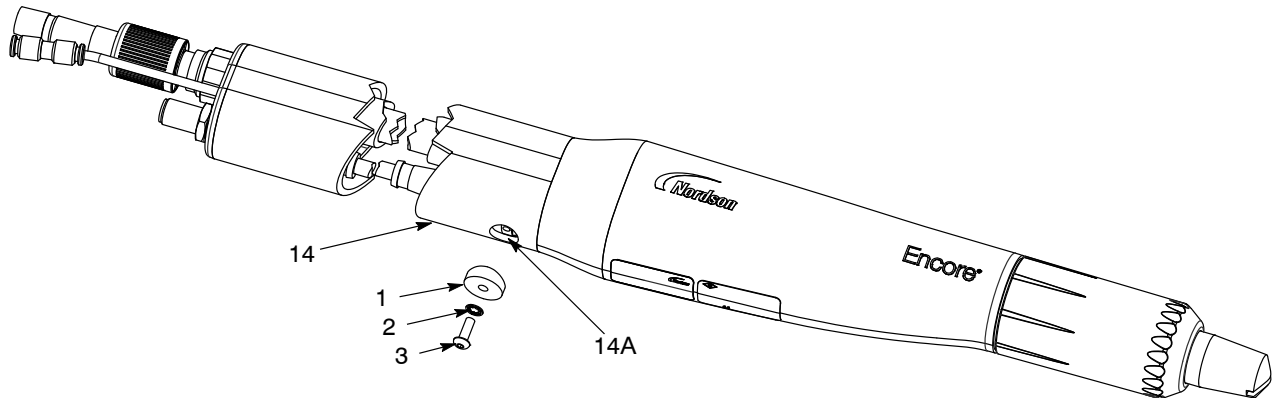


Figure 2 Ion Collector Installation – Tube-Mount Gun

- |             |                      |                    |
|-------------|----------------------|--------------------|
| 1. Cap plug | 3. Socket head screw | 14A. Mounting hole |
| 2. Washer   | 14. Mounting tube    |                    |

## Parts

See Figure 2. To order parts, call the Nordson Industrial Coating Systems Customer Support Center at (800) 433-9319.

Item	Part	Description	Quantity	Note
-	1609314	KIT, cap plug, tube mount, auto, Encore	-	
1	-----	• CAP, plug, tube, mount, auto, Encore	1	
2	982447	• WASHER, lock, M4 x 12, zinc	1	
3	983416	• SCREW, socket head, M4 x 12 mm, zinc	1	

Issued 8/16

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