

Cup Gun Kit for Sure Coat[®] Manual Powder Spray Guns



WARNING: Allow only qualified personnel to perform the following tasks. Observe and follow the safety instructions in this document and all other related documentation.

1. Introduction

The cup gun kit attaches to a Nordson Sure Coat manual powder spray gun. The kit is used for testing new powder coatings or for coating a few small parts with a powder coating different than that in your full-sized feed hoppers.

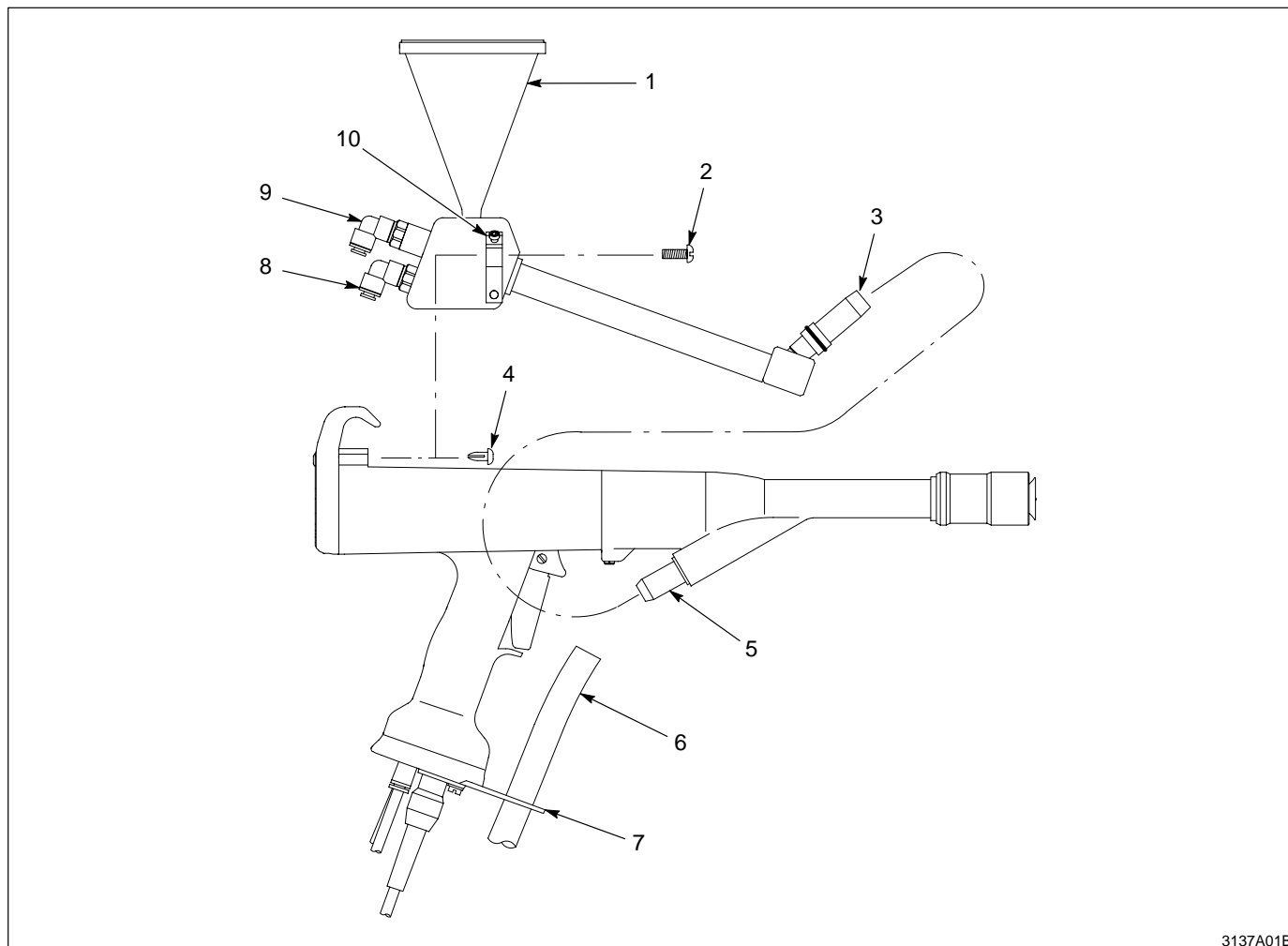
2. Installation

See Figure 1.

1. Clean the gun according to the instructions in the gun manual. Shut off the gun control unit and ground the gun electrode to dissipate any residual voltage.
2. A mounting screw and two 8-mm to 6-mm reducer fittings are shipped with the kit in a plastic bag inside the funnel (1). Remove the lid from the funnel and remove the bag.
3. Remove the black plastic snap rivet (4) from the shoulder of the gun body.
4. Disconnect the powder feed hose (6) from the hose adapter (5). Pinch the hose and remove it from the hose bracket.
5. Remove the hose adapter from the gun.
6. Position the cup gun bracket (10) on the gun body and secure it in place with the mounting screw (2).
7. Install the cup gun hose adapter (3) into the gun.

2. Installation (contd.)

8. Disconnect the flow-rate and atomizing air tubing from the control unit tube fittings. Install the 8-mm to 6-mm reducer fittings into the tube fittings.
9. Connect the two lengths of 6-mm tubing shipped with the kit to the reducer fittings. Use the blue tubing for atomizing air and the black tubing for flow-rate air. Connect the other end of the tubing to the cup gun air tube fittings (8, 9) as shown.



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Fig. 1 Installing the Cup Gun Kit on the Spray Gun

- | | | |
|-------------------------|---------------------|-------------------------------|
| 1. Funnel | 5. Hose adapter | 8. Atomizing air tube fitting |
| 2. Mounting screw | 6. Powder feed hose | 9. Flow-rate air tube fitting |
| 3. Cup gun hose adapter | 7. Hose bracket | 10. Cup gun bracket |
| 4. Snap rivet | | |

3. Operation

NOTE: Pressure settings will vary depending on powder type and spraying conditions.

1. Fill the funnel with powder.
2. Turn the control unit on and adjust the atomizing air pressure to 1.7 bar (25 psi). Set the flow-rate air pressure to zero.
3. Trigger the gun and slowly increase the flow-rate air pressure until you obtain the desired flow rate and spray pattern.

4. Maintenance



WARNING: Shut off electrostatic voltage at the control unit and ground the gun electrode before cleaning the cup gun components.



CAUTION: When cleaning a powder system component with compressed air, make sure powder does not get blown back through air tubing into pressure regulators, gauges, or other control devices. Either disconnect the air tubing at the component or set the air pressure in the tubing higher than the cleaning air pressure.

Light Cleaning

1. [See Figure 2](#). Empty the funnel (2) and set the atomizing air pressure to 3.4 bar (50 psi).
2. Remove the flow-rate air fitting (6) and venturi nozzle (4) as one piece and blow out the cup gun kit with low-pressure compressed air.

Heavy Cleaning

1. [See Figure 2](#). Perform the light cleaning procedure.
2. Disconnect the hose adapter (12) from the gun and the venturi throat (8) from the cup gun body (7). Remove the funnel from the cup gun body.
3. Clean the hose adapter, hose (11), venturi throat, cup gun body, and funnel with low-pressure compressed air. Wipe down all exposed surfaces with a clean, lint-free cloth.
4. Inspect all parts for wear or damage, especially the venturi throat. Replace any worn or damaged parts. Use only genuine Nordson replacement parts.

5. Parts

See Figure 2.

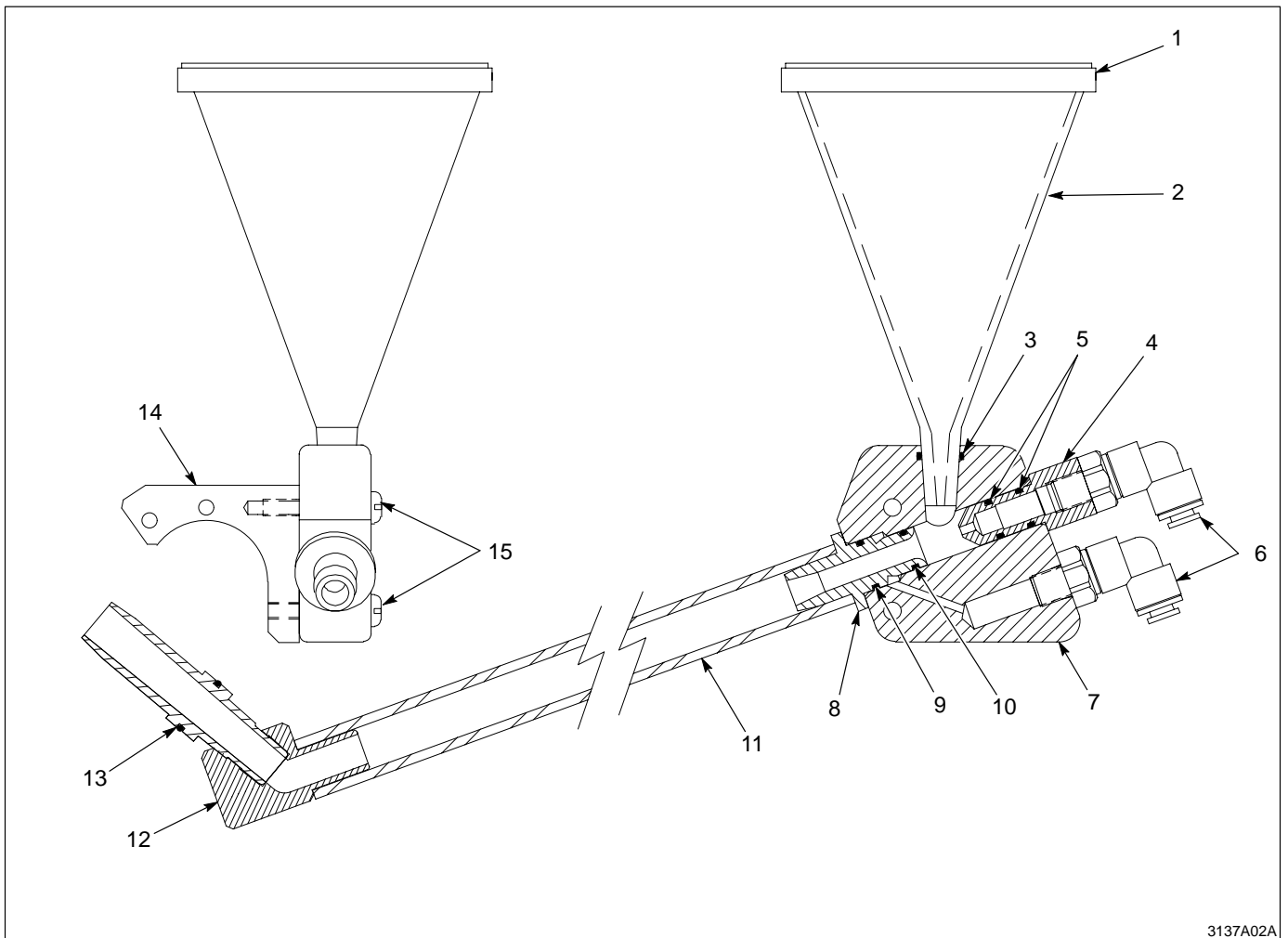
Item	Part	Description	Quantity	Note
—	305 782	Kit, cup gun, Sure Coat, packaged	1	
1	183 453	• Lid, funnel, cup gun	1	A
2	183 451	• Funnel, molded, cup gun	1	A
3	940 137	• O-ring, silicone, 0.437 x 0.562 x 0.063 in.	1	
4	183 462	• Nozzle, venturi, with O-rings	1	
5	940 126	• • O-ring, silicone, 0.375 x 0.500 x 0.063 in.	2	
6	183 456	• Fitting, swivel, elbow, 6 mm tube x $\frac{1}{8}$ in. BSPT	2	
7	305 794	• Body, pump, Sure Coat, cup gun	1	
8	183 458	• Throat, venturi, with O-rings	1	
9	940 142	• • O-ring, silicone, 0.500 x 0.625 x 0.063 in.	1	
10	940 126	• • O-ring, silicone, 0.375 x 0.500 x 0.063 in.	1	
11	900 648	• Tubing, powder, 11 mm, 0.44 in. ID, blue, 7 in. long	AR	B
12	302 069	• Adapter, hose, cup gun, packaged	1	
13	940 163	• • O-ring, silicone, 0.625 x 0.750 x 0.063	1	
14	305 795	• Bracket, cup gun, Sure Coat	1	
15	982 979	• Screw, pan head, M5 x 30, black	2	
NS	981 124	• Screw, pan head, M4 x 20	1	
NS	972 286	• Reducer, 8 mm stem x 6 mm tube	2	
NS	900 586	• Tubing, polyethylene, 6 mm OD x 4 mm ID, blue	AR	B
NS	900 615	• Tubing, polyethylene, 6 mm OD x 4 mm ID, black	AR	B

NOTE A: Included in the funnel kit with lid and cap, part 183 464.

B: Bulk part number. Order quantity required in increments of one meter.

AR: As Required

NS: Not Shown



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Fig. 2 Cup Gun Kit Parts

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