

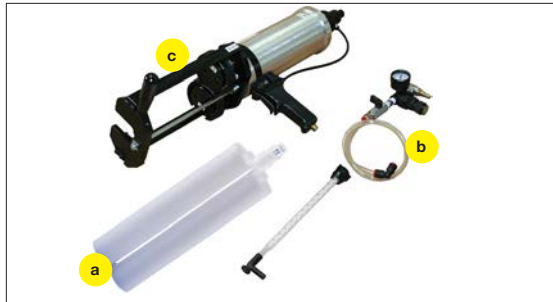
High Solid Spray (HSS) System

Instructions



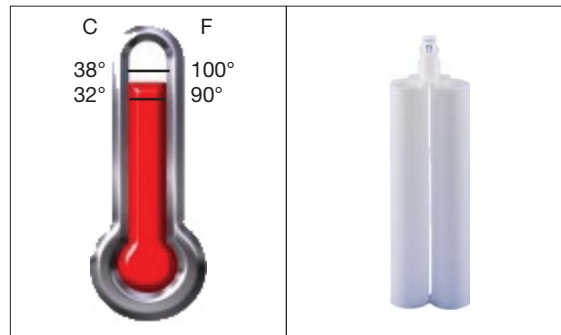
1 Equipment required:

- a Filled cartridges
- b HSS static mixer spray nozzle and air regulator kit
- c HSS pneumatic spray gun



2

If recommended by the product manufacturer, pre-heat the cartridge for 1–2 hours at 32–38° C (90–100° F). Do not exceed 49° C (120° F), as this will affect the integrity of the cartridge.



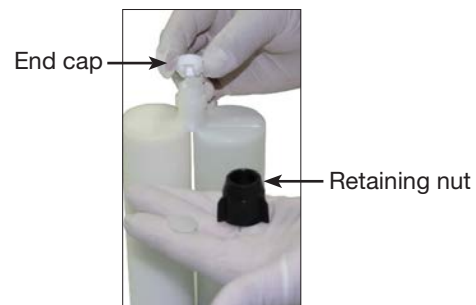
3

Important: Consult with the product manufacturer to determine whether shaking is required. If shaking is required, gently agitate / shake new or partially used cartridges for at least two minutes prior to application.



4

Remove the retaining nut, compression disc, and end cap(s) from the cartridge outlet.



5

If required, insert a flow restrictor.

Note: Some products require the use of a flow restrictor to equalize material flow. Flow restrictors are ordered separately. Contact your Nordson EFD representative for the proper flow restrictor and for installation assistance.



6

Seat an HSS static mixer spray nozzle on the cartridge outlet, ensuring that the bell housing sits flush on the tip of the outlet. If required, install a retaining nut.

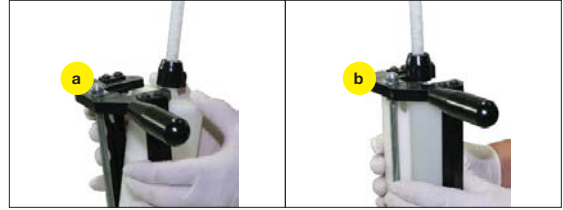
Note: Integral nut mixers do not require a retaining nut; bell mixers do require a retaining nut.



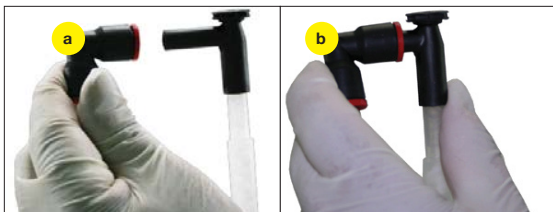
- 7** If applicable, hand-tighten the retaining nut securely on the cartridge outlet threads (do not over-tighten).



- 8** Insert the cartridge (or cartridge / retainer — not shown) in the dispense gun, referring to the applicable dispense gun instructions as needed.



- 9** Attach the air line of the HSS air regulator kit to the HSS static mixer spray nozzle.

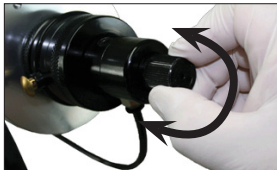


- 10** On the HSS regulator, place the ball valve lever (a) in the closed position; then connect the plant air supply (b) to the HSS regulator.



- 11** On the dispense gun, turn the fluid pressure regulator knob counterclockwise until it will no longer turn; then turn the knob 1–2 rotations clockwise.

Note: Steps 11–12 purge air from the cartridge.



Fluid pressure regulator knob on the dispense gun

- 12** Point the gun up (a) and slowly dispense material into the static mixer. Then dispense the first 15 cm (6") of unmixed material into a waste container (b). Perform this process for each new or partially used cartridge.



Point the cartridge up

Dispense unmixed material

- 13** **Important:** Before increasing the fluid pressure, verify that both material components are traveling equally through the mixer. As needed, dispense unmixed material into a waste container.

With the ball valve lever (a) in the closed position, set the HSS regulator (b) to 1.7 bar (25 psi); then slowly move the ball valve lever to the open position to supply the spray nozzle with atomizing air. Adjust the HSS regulator and ball valve lever until the desired operational settings are achieved.

Depending on the material, the material temperature, and the desired finish, adjust the fluid pressure regulator knob on the gun (c) as needed.



HSS regulator air pressure Fluid pressure adjustment



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