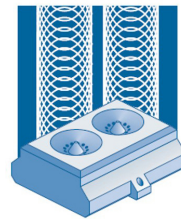
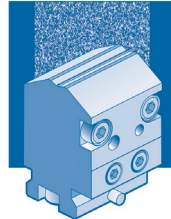
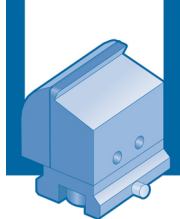
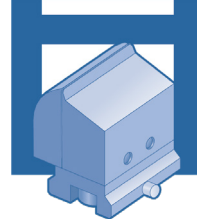
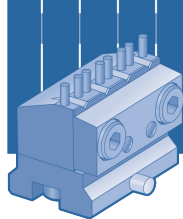
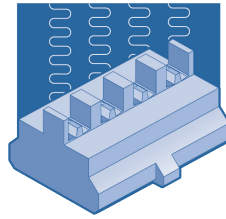
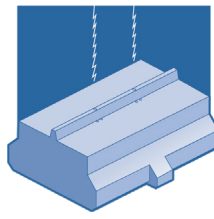
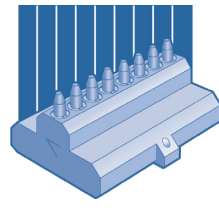
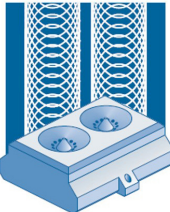

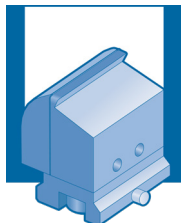
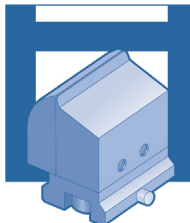
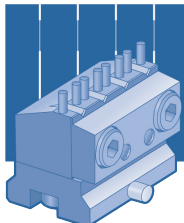
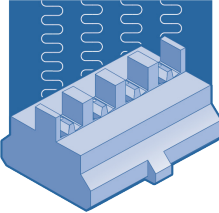
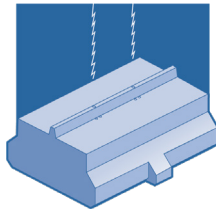
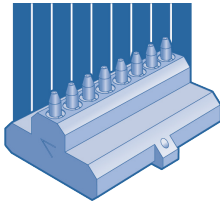


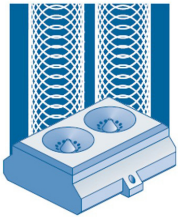

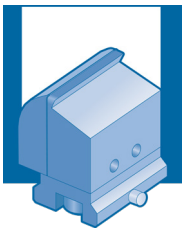

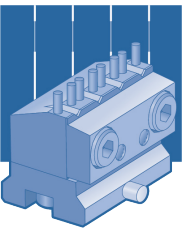
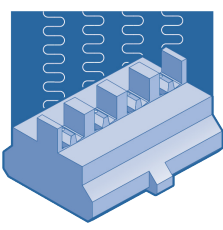
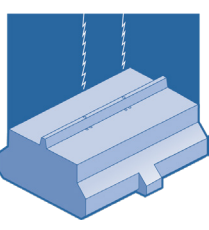
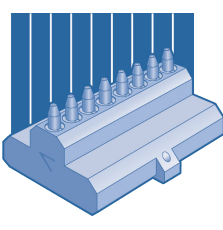
Product Comparison: Universal Nozzles - Other Spray and Slot Offerings

	Dual CF® Nozzles	Control Coat Nozzles	Continuous Contact Slot Nozzles	Intermittent Contact Slot Nozzles	Contact V-Slot Nozzles	Control Seam Nozzles	Control Stitch Nozzles	MiniBead Nozzles
Nozzle								
Key Attributes	Overlapping spirals	Uniform			Coating of elastic	Non-crossing pattern	Fine-stitch beads	Fine beads
Module Compatibility	Universal module clamping feature							
Materials of Construction	Brass with hard-release coating	Stainless steel	Steel			Brass with hard-release coating. Available in steel	Brass with hard-release coating	Brass with hard-release coating. Available in steel
Edge Control	±4 mm (±0.16 in.)	±1.5 mm (±0.06 in.)	±1 mm (±0.04 in.)	±1 mm (±0.04 in.)	N/A	±2 mm (±0.08 in.)	N/A	N/A
Coating Width (per nozzle)	Full coverage 22 to 25 mm	Full coverage 22 to 25 mm coverage, or partial coverage (side or center justified)			Quantity of strands with pin - up to 5 without pin - up to 10	Full coverage 22 to 25 mm coverage, or partial coverage (side or center justified)	N/A	N/A
Nozzle Orifice Sizes (22 and 25 mm)	0.305 to 0.762 mm (0.012 to 0.030 in.)	0.1 mm (0.004 in.) wide slot	0.2 mm to 0.3 mm (shim)	0.15 mm (shim)	i=0.2 mm (shim) c=0.4 mm (shim)	25 mm nozzles 0.46 mm (0.018 in.) 22 mm nozzles 0.51 mm (0.020 in.)	0.46 mm (0.018 in.)	0.305 to 0.762 mm (0.012 to 0.030 in.)
Nozzle-to Substrate Distance	12 to 75 mm (0.5 to 3.0 in.)	10 to 30 mm (0.38 to 1.2 in.)	Contact			10 to 20 mm (0.38 to 0.79 in.) 15 mm recommended	10 to 20 mm (0.38 to 0.79 in.) 15 mm recommended	3.8 to 6.5 mm (0.15 to 0.25 in.) 3.8 mm recommended
Maximum Hydraulic Flow	100 grams per minute per nozzle at 10,000 cps	50 grams per minute per nozzle at 10,000 cps, 14 GSM @ 300 m/min	50 grams per minute per nozzle at 10,000 cps, 14 GSM @ 300 m/min (Dependant on chosen shim’s thickness)			100 grams per minute per nozzle at 8,000 cps	100 grams per minute per nozzle at 8,000 cps	100 grams per minute per nozzle at 10,000 cps

Product Comparison: Universal Nozzles - Other Spray and Slot Offerings

	Dual CF® Nozzles	Control Coat Nozzles	Continuous Contact Slot Nozzles	Intermittent Contact Slot Nozzles	Contact V-Slot Nozzles	Control Seam Nozzles	Control Stitch Nozzles	MiniBead Nozzles
Nozzle								
Maximum Add-on Weight	30 GSM @ 150 m/min, 15 GSM @ 300 m/min	6.6 GSM @ 300 m/min, 3.3 GSM @ 600 m/min	13.2 GSM @ 300 m/min, 6.6 GSM @ 600 m/min	9.9 GSM @ 300 m/min, 5.8 GSM @ 600 m/min	0.1 g per strand per coated meter	14 GSM @ 300 m/min, 10 GSM @ 400 m/min	14 GSM @ 300 m/min, 10 GSM @ 400 m/min	1.0 to 12.5 grams per strand per min
Production Speed Capability	10 to 350 m/min (33 to 1,148 ft/min)	10 to 600 m/min (33 to 1,968 ft/min)				100 to 400 m/min (330 to 1,312 ft/min)	100 to 600 m/min (330 to 1980 ft/min)	10 to 650 m/min (330 to 2132 ft/min)
Adhesive Fiber Size	50 to 200 microns	25 to 75 microns	100 to 225microns	up to 112.5microns	150 to 300 microns	100 to 150 microns	100 to 150 microns	50 to 200 microns
Adhesive Viscosity (recommended)	4,000 to 8,000 cps	1,000 to 3,000 cps	1,000 to 10,000 cps	1,000 to 8,000 cps	1,000 to 10,000 cps	3,000 to 8,000 cps	3,000 to 8,000 cps	1,500 to 10,000 cps
Operating Temperature	70° to 205° C (160° to 400° F)							
Air Consumption	0.25 to 1 scfm per nozzle	0.5 to 1.5 scfm per nozzle	N/A			0.5 to 1 scfm per nozzle	0.5 to 1 scfm per nozzle	N/A
Air Pressure (typical)	0.3 to 2 bar (5 to 30 psi)	0.5 to 2 bar (7.5 to 30 psi)	N/A			0.5 to 1.5 bar (7.5 to 22.5 psi)	0.5 to 1.5 bar (7.5 to 22.5 psi)	N/A
Working Hydraulic Pressure	13.8 to 55.2 bar (200 to 800 psi)							
Maximum Hydraulic Pressure	89.6 bar (1300 psi)							

Product Comparison: Universal Nozzles - Other Spray and Slot Offerings

	Dual CF® Nozzles	Control Coat Nozzles	Continuous Contact Slot Nozzles	Intermittent Contact Slot Nozzles	Contact V-Slot Nozzles	Control Seam Nozzles	Control Stitch Nozzles	MiniBead Nozzles
Nozzle								
Strengths/ Application Requirements	High-strength bonding	High-speed intermittent, uniform coating	Continuous uniform coating	High-speed intermittent, uniform coating	Ease of use, coating of elastic	High-strength coating	High-strength bonding	High-strength bonding
Intermittent Capability	★	★ ★ ★	N/A	★ ★ ★	★ ★ ★ (i) N/A (c)	★ ★	★ ★	★ ★ ★
Bond Strength	★ ★ ★	★	★ ★	★ ★	★ ★	★ ★ ★	★ ★ ★	★ ★ ★
Robust/ Operating Range	★ ★ ★	★	★ ★ ★	★ ★ ★	★ ★ ★	★ ★	★ ★	★ ★ ★
Edge Control	★ ★	★ ★ ★	★ ★ ★	★ ★ ★	N/A	★ ★	N/A	N/A
Pattern Uniformity	★	★ ★ ★	★ ★ ★	★ ★ ★	N/A	★ ★	★ ★ ★	N/A
Line Speed	★	★ ★ ★	★ ★ ★	★ ★ ★	★ ★ ★	★ ★	★ ★	★ ★ ★
Initial Investment	★ ★ ★	★	★ ★	★ ★	★ ★ ★	★ ★	★ ★	★ ★

★ = Good ★ ★ = Better ★ ★ ★ = Best N/A = Not applicable or not intended to provide this capability

For more information, speak with your Nordson representative or contact your Nordson regional office.

United States
Duluth, Georgia
(800) 683-2314 Phone
(800) 667-3329 Fax

Europe
Luneburg, Germany
(49) 4131-894-0 Phone
(49) 4131-894-149 Fax

Japan
Tokyo, Japan
(81) 3-5762-2700 Phone
(81) 3-5762-2701 Fax

Asia/Australia/Latin America
Amherst, Ohio
(440) 985-4496 Phone
(440) 985-1096 Fax

Find us on:



Nordson Corporation
11475 Lakefield Drive
Duluth, GA 30097-1511
(800) 683-2314
nordson.com/hotmelt

NWL-12-5754
Reissued 03/20
© 2020 Nordson Corporation
All Rights Reserved.
Printed in U.S.A.
Nordson reserves the right to make design changes between printings.

