You have selected a reliable, high-quality dispensing system from Nordson EFD, the world leader in fluid dispensing. 2K dispense guns with built-in retainers were designed specifically for industrial dispensing and will provide you with years of trouble-free, productive service.

This manual will help you maximize the usefulness of your 2K dispense guns.

Please spend a few minutes to become familiar with the controls and features. Follow our recommended testing procedures. Review the helpful information we have included, which is based on more than 50 years of industrial dispensing experience.

Most questions you will have are answered in this manual. However, if you need assistance, please do not hesitate to contact EFD or your authorized EFD distributor. Detailed contact information is provided on the last page of this document.

The Nordson EFD Pledge

Thank You!

You have just purchased the world’s finest precision dispensing equipment.

I want you to know that all of us at Nordson EFD value your business and will do everything in our power to make you a satisfied customer.

If at any time you are not fully satisfied with our equipment or the support provided by your Nordson EFD Product Application Specialist, please contact me personally at 800.556.3484 (US), 401.431.7000 (outside US), or Srini.Subramanian@nordsonefd.com.

I guarantee that we will resolve any problems to your satisfaction.

Thanks again for choosing Nordson EFD.

Srini Subramanian
Srini Subramanian, General Manager
Introduction

Manual and pneumatic 2K dispense guns with built-in aluminum retainers are used for the dispensing of filled Film-Pak® collapsible cartridges. Manual guns are available in two thrust ratios for the dispensing of thicker materials. Pneumatic guns include an adjustable heavy duty aluminum air regulator and an air dump valve which stops material flow instantly.

Both manual and pneumatic guns include a spring-loaded latch system with a swing plate to securely hold Film-Pak cartridges, a fluid level indicator, and built-in aluminum cartridge retainers.
Safety

2K dispense guns are designed for heavy duty cycles over extended operating periods. Because they are powered by compressed air, operator fatigue is minimal, but users must be aware that compressed air can be dangerous when used incorrectly.

⚠️ CAUTION

Use caution when operating a dispense gun powered by compressed air. When used incorrectly, compressed air can cause whipping, impact, material ejection, or other related injuries.

General

• Read and understand these operating instructions before using a dispense gun.
• Compressed air can be dangerous when used incorrectly.
• Modifications made by the user to the dispense gun will void the warranty and can cause personal injury.

Always:

• Use protective eye and ear equipment when operating a dispense gun.
• Wear a face mask or respirator when operating a dispense gun.
• Test the forward / reverse function before loading a cartridge.
• Disconnect the air supply before starting any service tasks.
• Ensure that cartridges are properly loaded (refer to the correct cartridge loading procedure in these instructions for your dispense gun).
• Use a new static mixer.
• Read the material manufacturer's instructions carefully.
• Ensure that no cross-contamination of the content of the two cartridges has occurred; material can cure in one of the sides.
• Keep hands and fingers clear of moving parts during operation.

Do not:

• Connect the dispense gun to an air supply that can exceed 8 bar (115 psi).
• Immerse the dispense gun in solvent.
• Operate the dispense gun with loose, broken, or missing parts. They could come loose unexpectedly and create a whipping / impact hazard.
• Carry the dispense gun by the air hose.
• Use damaged cartridges or the wrong type of cartridge.
• Point the dispense gun at another person.
• Disassemble the handle and adjust the safety valve inside.
• Use a static mixer that contains cured material.
• Use a partially extruded cartridge, unless using a new static mixer in which there is no cross-contamination.
• Use expired material or material that has cured.
• Continue use if you notice any abnormal noise or vibration when operating.
• Continue use if you are on unstable footing, have lost your grip, or have fallen.
Operating Features

Manual Dispense Gun

Pneumatic Dispense Gun
Install the Cradle-Support Handle

Note: The handle can be installed on the left or right side of the gun. Some guns also support bottom installation.

Connect the Air Supply (Pneumatic Guns Only)

1. Check the plant air supply pressure. For optimum performance the supply pressure must be greater than 7 bar (100 psi) and less than 8 bar (115 psi).
   
   Note: The dispense gun will work at lower supply pressures, but flow rates could be reduced and may vary.

2. Using the supplied coupler fitting, connect clean, dry air to the 1/4 NPT male threaded air input fitting.

Filling Cartridges

Contact your Nordson EFD representative for assistance with the filling of Film-Pak cartridges.
Removing or Loading Cartridges: Manual Guns

1. Depress the thumb release plate and pull back on the drive rod knob to retract the drive rods.

2. Release the spring-loaded lock and then open the swing plate (loaded gun shown).

3. If applicable, remove spent cartridges.

4. Slide filled Film-Pak cartridges into the aluminum retainers.

5. Close the swing plate and engage the spring-loaded lock.

6. Attach the static mixer. If applicable, add the retaining nut.
**Dispensing Material: Manual Guns**

1. Purge air from the cartridge by (a) pointing the gun up and (b) slowly dispensing material into the static mixer. Then dispense the first 15 cm (6") of unmixed material into a waste container.

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

   **Note:** Perform this process for each new or partially used cartridge.

2. Squeeze the handle using normal pressure to dispense material.

3. Throughout the dispensing process, check the fluid level indicator to see how much material remains in the cartridges.
Removing or Loading Cartridges: Pneumatic Guns

1. (a) Push the Forward / Reverse air toggle to the REVERSE position; then (b) pull the trigger.

2. Release the spring-loaded lock and then open the swing plate (loaded gun shown).

3. If applicable, remove spent cartridges.

4. Slide filled Film-Pak cartridges into the aluminum retainers.

5. Close the swing plate and engage the spring-loaded lock.

6. Attach the static mixer. If applicable, add the retaining nut.
Dispensing Material: Pneumatic Guns

1. Place the Forward / Reverse air toggle in the FORWARD position.

   **Note:** The first three steps of this procedure will purge air from the cartridge.

2. Turn the fluid pressure regulator knob counterclockwise until it will no longer turn; then turn the knob 1–2 rotations clockwise.

3. Purge air from the cartridge by (a) pointing the gun up and (b) slowly dispensing material into the static mixer. Then dispense the first 15 cm (6") of unmixed material into a waste container.

   **Note:** Perform this process (steps 1–3) for each new or partially used cartridge.

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

   Adjust the fluid pressure regulator knob to the desired setting for normal operation.

5. Pull the trigger to dispense material.

   **Note:** This builds up a cushion of compressed air inside the gun, which starts the flow of material. When you release the trigger, material flow ceases as the compressed air escapes rapidly through a quick exhaust valve at the rear of the gun.

6. Throughout the dispensing process, check the fluid level indicator to see how much material remains in the cartridges.
Service

<table>
<thead>
<tr>
<th>Interval</th>
<th>Action</th>
</tr>
</thead>
<tbody>
<tr>
<td>Daily</td>
<td>Wipe the dispense gun using a clean rag or the material manufacturer’s recommended solvent before any material on the gun has had time to set. Ensure that the insides of the retainers and plungers are free of residue.</td>
</tr>
<tr>
<td>Weekly</td>
<td>Check all external bolts and screws and tighten loose components as required.</td>
</tr>
</tbody>
</table>
| (Pneumatic guns only) Monthly | Lubricate the internal pistons and seals as follows:  
1. Disconnect the air supply from the air input fitting.  
2. Place three (3) drops of air tool oil in the air inlet of the gun.  
3. Reconnect the air supply line. When next operated, the compressed air will blow the oil into the inner components of the gun. |

Part Numbers

<table>
<thead>
<tr>
<th>Part #</th>
<th>Volume</th>
<th>Cartridge Size</th>
<th>Ratio</th>
<th>Description</th>
<th>Weight (lb / kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>7661494</td>
<td>600mL</td>
<td>300 x 300</td>
<td>1:1</td>
<td>Manual dispense gun with built-in retainers, 26:1 thrust ratio</td>
<td>5.7 / 2.6</td>
</tr>
<tr>
<td>7661495</td>
<td>600mL</td>
<td>300 x 300</td>
<td>1:1</td>
<td>Manual dispense gun with built-in retainers, 34:1 thrust ratio</td>
<td>5.7 / 2.6</td>
</tr>
<tr>
<td>7661613</td>
<td>600mL</td>
<td>300 x 300</td>
<td>1:1</td>
<td>Pneumatic dispense gun with built-in retainers, 499 kg at 7 bar (1,100 lb at 100 psi) nominal thrust</td>
<td>9.7 / 4.4</td>
</tr>
</tbody>
</table>

Troubleshooting

<table>
<thead>
<tr>
<th>Problem</th>
<th>Possible Cause</th>
<th>Corrective Action</th>
</tr>
</thead>
</table>
| Air leaking from the dispense gun handle     | Air supply exceeding 8 bar (115 psi), causing the safety valve to bleed off excess air | CAUTION: Risk of equipment damage. Do not disassemble the handle and adjust the safety valve.  
1. Ensure that the air supply is lower than 8 bar (115 psi).  
2. Inspect cartridges for damage or leaking. Damaged or leaking cartridges can prematurely fail.  
3. For the material being dispensed, read all of the instructions and warnings for other possible risks. Contact the material manufacturer for clarification as needed. |
NORDSON EFD ONE YEAR LIMITED WARRANTY

Nordson EFD products are warranted for one year from date of purchase to be free from defects in material and workmanship (but not against damage caused by misuse, abrasion, corrosion, negligence, accident, faulty installation or by dispensing material incompatible with equipment) when the equipment is installed and operated in accordance with factory recommendations and instructions. Nordson EFD will repair or replace free of charge any part of the equipment thus found to be defective, on authorized return of the part prepaid to our factory during the warranty period. In no event shall any liability or obligation of Nordson EFD arising from this warranty exceed the purchase price of the equipment. This warranty is valid only when oil-free, clean, dry, filtered air is used.

Nordson EFD makes no warranty of merchantability or fitness for a particular purpose. In no event shall Nordson EFD be liable for incidental or consequential damages.