Introduction

The 740V-HL (#7021209) hand-operated dispense gun is a rugged industrial lever-actuated fluid dispensing valve. The valve incorporates a quick-change fluid body for fast and easy cleaning. The fluid inlet fitting for 1/4” OD feed tubing and an assortment of dispensing tips are included.

Getting Started

1. Install the feed tube from the fluid reservoir to the inlet fitting and tighten the compression nut to secure. The fluid body may be rotated up to 1/2 turn to locate the fluid inlet fitting in a comfortable position.

2. Apply air pressure to the fluid reservoir. Start with a low setting of 1.4 bar (20 psi). If using a Nordson EFD fluid reservoir, refer to the operating manual for further instructions.

3. Install an appropriate size dispensing tip on the outlet tip adapter. Use large tips for high viscosity materials and small tips for low viscosity.

4. Press the hand lever to begin fluid flow. Release the lever to stop fluid flow.

5. To achieve the desired flow, change the size of the dispensing tip or adjust the reservoir fluid pressure.

Typical System Setup

- **#7002002**
  5-micron filter / regulator for clean, dry filtered factory air

For dispensing with cyanoacrylates, order **#7016548** with coalescing filter

- **#7020015**
  Hand-lever valve stand

- **#7010004**
  1.0 liter tank accommodates a one pound bottle

- **Shutoff valve**
Service

**CAUTION**

Check the reservoir pressure gauge prior to performing any maintenance to ensure that the pressure is zero (0). To confirm this on EFD tanks, slide the shutoff valve on the air hose away from the tank, then open the pressure relief valve on the tank.

Normal cleaning is accomplished by purging with a solvent appropriate for the material being dispensed.

**To thoroughly clean valve body and replace needle packings:**

1. Remove the fluid inlet fitting and tip adapter / needle seat assembly from the fluid body.

2. Remove the fluid body from the air cylinder body by turning counterclockwise until free. Then remove the O-ring from the fluid body.

3. Remove the needle packings from the fluid body, using tool #7021552 supplied with the valve. Insert through outlet end of fluid body and push out the packings. See Figure 1.
Service (continued)

To thoroughly clean valve body and replace needle packings (continued):

4. Remove any remaining packings and the packing spring from the needle.
5. Clean the needle with a cloth dampened with solvent.
6. Lubricate the needle with Nye Lubricants #865 grease and reinstall the needle packing spring and a new packing kit. See Figure 2.
7. Install a new O-ring (#7014686) on the fluid body. Screw the air cylinder onto the fluid body. Hand tighten only. The body can be turned back out up to 1/2 turn to orient the fluid inlet fitting to the desired position.
8. Reinstall the tip adapter / seat assembly.

To replace the piston and needle assembly:

1. Remove the air cylinder cap by turning counterclockwise until free.
2. Remove the piston return spring, thrust washers, and snap ring.
3. Pull the piston and needle assembly out of the air cylinder, using small pliers on the spring pilot at the top of the piston.

4. Clean the air cylinder body wall and lubricate with Nye Lubricants #865 grease.
5. Lubricate the needle with Nye Lubricants #865 grease, then reinstall in the air cylinder.
6. Reinstall the snap ring.
7. Reinstall thrust washers, spring and air cylinder cap. See Figure 3.

To replace the piston and needle assembly (continued):

1. Remove the air cylinder cap by turning counterclockwise until free.
2. Remove the piston return spring, thrust washers, and snap ring.
3. Pull the piston and needle assembly out of the air cylinder, using small pliers on the spring pilot at the top of the piston.

4. Clean the air cylinder body wall and lubricate with Nye Lubricants #865 grease.
5. Lubricate the needle with Nye Lubricants #865 grease, then reinstall in the air cylinder.
6. Reinstall the snap ring.
7. Reinstall thrust washers, spring and air cylinder cap. See Figure 3.