HBE Atomizer & Cartridge System

For spraying HBE 3:1 (1000 mL) and Liquid Epoxy Types 4:1 (940 mL)

### Product Description

1. **Canusa Atomizer Gun**
   - HBE Atomizer Cartridge 3:1 (1000 mL)
   - Atomizer Mixing Tip

2. **Canusa Atomizer Gun**
   - Liquid Epoxy Type Atomizer Cartridge 4:1 (940 mL)
   - Atomizer Mixing Tip

### Surface Preparation

3. Clean exposed steel and adjacent pipe coating according to SSPC SP 1 to remove the presence of oil, grease, and other contaminants. Ensure that the pipe is at least 3°C (5°F) above the dew point before cleaning.

4. Thoroughly clean the cutback area to "near white metal" SIS Sa 2½ (SSPC-SP10) or equivalent. Materials used for abrasive blasting shall produce an angular surface profile of 2.5-5 mils (64-127 μm) Lightly abrade at least 50mm (2") of the line coating on each side of cutback area.

5. Make sure the correct ejector plate is mounted on the top piston of the Atomizer Gun. Option A requires the 3:1 mount plate and Option B requires the 4:1 mount plate. (Mount plates, screws and alan key included with Atomizer Gun.)

6. Install air inlet fitting to the atomizer gun air inlet 1/4" female thread. Attach the air supply line to the Atomizer inlet fitting. The air supply pressure should be 100 psi (7 bar) and air flow rate shall be minimum 12 CFM. Only clean and dry air should be used.

7. Heat the cartridge by means of microwave oven, convention oven, electrical hot-box etc to a conditioned temperature of 60°C (140°F).

   If using a microwave, a rotating 700 watt microwave is recommended. Presuming the starting temperature of the cartridge is 25°C (77°F), heat the cartridge for 100 minute on both sides of the cartridge for a total heating duration of 2:00 minutes.

   Use an infrared temperature gun to check the cartridge (in multiple locations – top, middle, bottom) to ensure the Base side is 50-57°C (122-135°F).

Wipe clean with a lint-free cloth or air blast the steel and pipe coating to remove foreign contaminants. Surface must be clean and dry prior to application of HBE products.
Adjust the atomizing air pressure dial to #3 +/- 1. This setting may vary depending on the temperature of the product and input air pressure. **Note:** When spraying with a right-angled mixing tip, increased air pressure may be required.

Purge cartridge and mixing tip nozzle by pulling the trigger long enough to just fill the static mixing tip chamber with material. The Atomizer Gun is now ready for spraying. Release trigger halfway to stop the fluid ejector pistons. Release the trigger completely to stop the atomizing air (stop spraying) or when cartridge is empty.

Press the red button to retreat fluid ejector pistons. Remove atomizing air hose from mixing tip and remove cartridge.