

HBE Atomizer & Cartridge System

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

Product Description



Canusa Atomizer Gun

HBE Atomizer Cartridge 3:1 (1000mL)

Atomizer Mixing Tip



Canusa Atomizer Gun

Liquid Epoxy Type Atomizer Cartridge 4:1 (940mL)

Atomizer Mixing Tip

Surface Preparation



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.

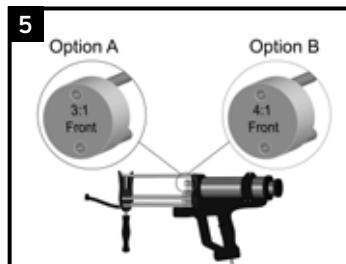


Thoroughly clean the cutback area to "near white metal" SIS Sa 2½ (SSPC-SP10) or equivalent. Materials used for abrasive blasting shall produce an angular surface profile of 2.5-5 mils (64-127 µm). Lightly abrade at least 50mm (2") of the line coating on each side of cutback area.



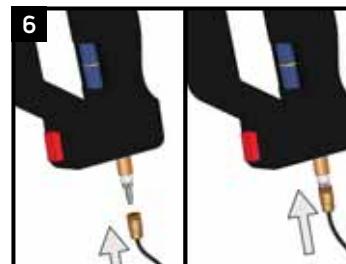
Wipe clean with a lint-free cloth or air blast the steel and pipe coating to remove foreign contaminants. Surface must be clean and dry prior to application of HBE products.

Ejector Plate Setup

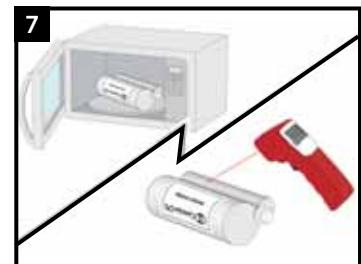


Make sure the correct ejector plate is mounted on the top piston of the Atomizer Gun. Option A requires the 3:1 mount plate and Option B requires the 4:1 mount plate. (Mount plates, screws and allen key included with Atomizer Gun.)

Attach Air Supply



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.



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

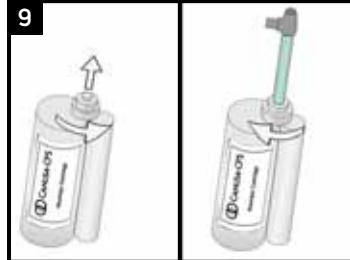
If using a microwave, a rotating 700 watt microwave is recommended. Presuming the starting temperature of the cartridge is 25°C (77°F), heat the cartridge for 1:00 minute on both sides of the cartridge for a total heating duration of 2:00 minutes. Use an infrared temperature gun to check the cartridge (in multiple locations - top, middle, bottom) to ensure the Base side is 50-57°C (122-135°F).

Lightly Shake Cartridge



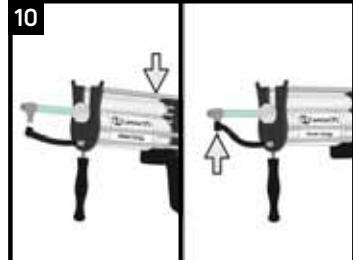
Once heated, the viscosity of the cure side will be very low. Holding the base side of the cartridge, shake the cartridge up and down and side to side to lightly redistribute the pigment colour in the cure side of the cartridge.

Install Mixing Tip



Hold the cartridge with end cap facing up. Remove the cartridge end cap by unscrewing (counter-clockwise) and pulling up. Fit the mixing tip end over the cartridge outlet and screw the mixing tip cap to securely lock the cartridge and mixing tip together. Mixing tips are intended for one time use only.

Insert Cartridge & Attach Air Connector



Slide the cartridge into the Atomizer gun with the Base side of the cartridge (large end) down first. The two ejector plates of the gun should match the piston seal area of the cartridge. Once the cartridge is placed securely into the gun chamber, attach the quick lock air hose to the mixing tip nozzle end by 'snapping' it in place.

Adjust Fluid Control Dial



Adjust the fluid control dial to a setting of #3 +/- 1 by scrolling up or down. The dial is located on the side of the gun handle, behind the trigger. This setting regulates the speed/pressure of the two pistons. This setting may vary depending on temperature of product and input air supply pressure.

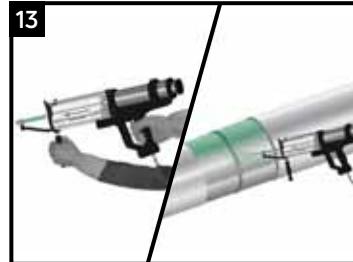
Adjust Air Pressure Dial



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 & Spray Surface



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 half-way to stop the fluid ejector pistons. Release the trigger completely to stop the atomizing air (stop spraying) or when cartridge is empty.

Remove Used Cartridges



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

Storage & Safety Guidelines

To ensure maximum performance, store Canusa products in a dry, ventilated area. Keep products sealed in the original cartons and avoid exposure to direct sunlight, rain, snow, dust or other adverse environmental elements. Avoid prolonged storage at temperatures above 40°C (104°F) or below 5°C (41°F). Product installation should be done in accordance with local health and safety regulations. Appropriate PPE should be worn in compliance with the requirements of the material Safety Data Sheet and local health and safety regulations and should include the use of a full face shield.

These installation instructions are intended as a guide for standard products. Consult your Canusa representative for specific projects or unique applications.

Western Hemisphere

SFL Canusa - WH
4757 93rd Ave NW
Edmonton, Alberta T6B 2T6
Canada

Tel: +1 587-754-8701

Europe

SealForLife Industries
Nijverheidstraat 13
B-2260 Westerlo
Belgium

Middle East

SFL Canusa Middle East PPTS LLC
KLP5, Block B, Unit B-01,
Sector no.: KHIA8, Al Ma'mourah
PO Box 2621, Abu Dhabi,
The United Arab Emirates

Quality Management system registered to ISO 9001

Canusa warrants that the product conforms to its chemical and physical description and is appropriate for the use stated on the installation guide when used in compliance with Canusa's written instructions. Since many installation factors are beyond our control, the user shall determine the suitability of the products for the intended use and assume all risks and liabilities in connection therewith. Canusa's liability is stated in the standard terms and conditions of sale. Canusa makes no other warranty either expressed or implied. All information contained in this installation guide is to be used as a guide and is subject to change without notice. This installation guide supersedes all previous installation guides on this product. E&OE

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