

INSTALLATION AND SERVICE

Arc Spray Extension Nozzle

Installation, operation and service information for the arc spray extension nozzle.



MANUAL

Product document

VERIFIED

Source retained

LIVE LINKS

Website and support

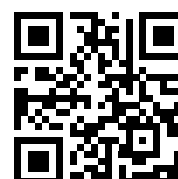
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BALAJI UDYOG
THERMAL SPRAY EQUIPMENTS

ARC SPRAY EXTENSION NOZZLE

**BALAJI UDYOG JODHPUR
RAJASTHAN**

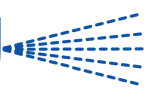
INSTALLATION, OPERATION AND SERVICE INFORMATION



Throughout this manual Statements indicating precautions necessary to avoid equipment failure are Referenced in a Note Statements Indicating potential hazards that could result in personal injury or property damage are referenced in a caution! Box



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Before using the equipment,
read and understand
this operating manual.
In particular, refer to the
Safety precautions.

Under NO circumstances
should any modifications be
made to the equipment
without prior written approval
from

BALAJI UDYOG.

BEFORE BEGINNING – TURN OFF ARC POWER AND AIR SUPPLY TO GUN

1. Remove front cover assembly from front of arc spray gun.
2. Removing alignment housing from wire drive unit by removing the three-alignment housing mounting screws. Keep these screws. Also remove the screw fastening the bus bars to the contact tubes.
3. Insert the three screws into place by putting the two short screws toward the front and the longer one towards the rear, this holds the I.D Extension in place.
4. The same front cover assembly used with the BU-8850 standard arc spray gun can now be placed over the end of the ID Sprayer.

OPERATING INSTRUCTIONS FOR I.D. EXTENSION

Wire loading and operation is the same as with the standard Model BU-8850 arc spray gun. The ID sprayer has some restriction on the allowable operating range. The maximum operating amperage is 300 amps with all materials. The minimum operating amperage is different for all materials, but the generally higher than with the standard BU-8850 alignment housing.

OPERATOR PROTECTION

The arc spray process is noisy; generates dust and fumes; produces spatter and radiations similar to arc welding. When observing or operating the BALAJI UDYOG Arc Spray gun, be sure that adequate eye, ear and respiratory protection are used. Carefully read the "SAFETY" Section of ARCJET BU-8850 Operating Manual for specific requirements.

PRE-SPRAYING ADJUSTMENTS WITH I.D SPRAYER ATTACHED TO BU-8850 GUN

This unit need not be adjusted prior to spraying. Be sure that contact tip diameter matches diameter of wire being sprayed.

Switch on "console power" switch located on the left bottom of the console faceplate.

This will supply atomizing air only. Set the "SPRAY PRESSURE" gauge on the front of the console, using the adjacent regulator, at 60-100 psi depending upon desired coating.

TO START SPRAYING WITH BU-8850 GUN

- Switch on the dust collecting and exhaust system.
- Load wire into id sprayer
- Close wire roller release lever.
- Adjust voltage.

The voltmeter will now register the potential on the contact tubes and wires. It should be adjusted as per Table below to read the required voltage. Adjust the voltmeter knob on the front of the console to set the voltage as indicated below for the wire type used. The voltage given below is the approximate minimum requirement when the gun is spraying. (The voltage setting before spraying must allow for a voltage drop of 1.5-2.0 volts for each 100 amps.)



Voltage Requirements : (Approximates +1-2 volts)

Wire Type	Load Volts When Spraying
Steel	28-32
Zinc	20-30
Bronze/SS/Monel	28-32
Aluminum	29-32
Al/Bronze	22-24
Bond Arc	28-32

Note: If wires are touching when "ARC POWER" switch is depressed, they will melt off with slight pop.

Amperage ranges

Aluminum	70-300 amps.
Zinc	70-300 amps.
Bond Arc	120-300 amps.
Chrome Steel	120-300 amps.

TO STOP SPRAYING (FOR A SHORT PERIOD)

- Push off on remote pendant.

TO RE-START (AFTER A SHORT PERIOD)

- Press "ON" button on remote pendant or pull trigger.

TO STOP SPRAYING (FOR A LONG PERIOD)

- Release trigger control on gun or push "OFF" on the remote pendant.
- Switch "console power" to off position located on the console faceplate.
- Turn off exhaust system.
- For very long periods (end of shift or day) turn off power and air at source.

Note: New spray gun or guns, which have set idle for a long period of time, may require a run-in period to allow for normal operation.

- Open wire roller release lever so no wire will feed.
- Press "ON" and "AUTO" buttons on the console.
- Press "ON" switch on the remote pendant and let run for one hour.

REPLACEMENT OF CONTACT TIPS

1. Shut off the "CONSOLE POWER" button on the console supply.
2. Remove the four screws with a 2.5mm hex wrench (provided), which hold the brass air nozzle to the front of the gun. If there is any notice of build up on the air outlet ("U" groove), remove with either Scotch Brite or fine sandpaper. Remove the round nozzle positioner.
3. Remove and replace tips with special wrench provided with tool kit.
4. Make sure tips are even with each other and fully seated in the contact block.
5. Replace nozzle positioner making sure that it is oriented with the orifice between the plane of the wires and the side of the air nozzle with the orifice ("U" groove).
6. Re-attach brass air nozzle with the four screws.
7. Replace o-ring on nozzle if it is damaged.

MANUAL FOR ARC SPRAY TORCH EXTENSION NOZZLE

Fault	Cause	Remedy
sputters or cuts	nozzle, and nozzle	set
out.	positioner	(a.2)Check to make sure correct nozzle positioner is being used
		Changes if worn.
		airflow restriction. Clean with scotch Brite or fine sandpaper
		(a.5)Check tip alignment
	(b) Wire feed is uneven	(b.1)Check for loose, clogged or worn wire rollers
		(b.2)Check that wire reels turn freely.
		conduits.
		Replace if worn.
		kinks.
	(c) Insufficient voltage	(c.1)Adjust voltage
		(c.2)Check that cable terminals are clean and tight.
	(d) SCR failed	(d.1)See power supply section of manual.
	(e) Insufficient air pressure	activate pressure switch.
	(f) Insufficient amperage	(f.1)Be sure amperage is above minimum threshold.
	(g) Blinking "On" Light	(g.1) Turn off your remote switch button.
spraying	(a) Insufficient air pressure	pressure switch.
	(b) No voltage	(b.1)Check if "ARC POWER SWITCH" IS ON.
		(b.2)Main line power switch open or blown fuse.
	wires	Replace worn tip.
	strike arc.	(b.1)Check voltage
		(b.2)Check power supply diodes
	(e) No voltage	(c.1)Check if " ARC POWER SWITCH" IS ON.
		(c.2)Main line power switch open or blown fuse.
Fault	Cause	Remedy
Only one wire feeds	tip.	(a.1)Replace contact tip.
	lever open	(b.2)Close wire roller release lever.
	(c) Loose rollers	(c.1) Tighten set screw on rollers.
Coating too coarse	(a) Insufficient air pressure	(a.1)Check that input air pressure is adequate.
		airflow restriction. Clean with Scotch Brite or fine sandpaper.
Coating too fine	(a) Excessive air pressure	(a.1)Check that air pressure is not too high.

Part No.	Description
01	Adapting Head Assy.
02	Housing Tube
03	ID Contact Tube
04	Wire Transfer Tube
05	Left Contact Block
06	Right Contact Block
07	Air & Arc Transfer Head
08	Brass Air Nozzle
09	O-Ring
10	Cap Screw
11	Cap Screw
12	Socket Head Cap Screw
13	Adaptor
14	Angular Block
15	Contact Tube
16	Brass Nozzle Mounting Screw
17	Flexible Guide
18	Adaptor ID to Gun Or Support Block
19	Connector
20	ID Contact Tip
21	ID Nozzle Positioner

NOTE:-

Part number **(2) Housing tube** is available in three sizes having part number

2-a	1 ft
2-b	2 ft
2-c	3 ft

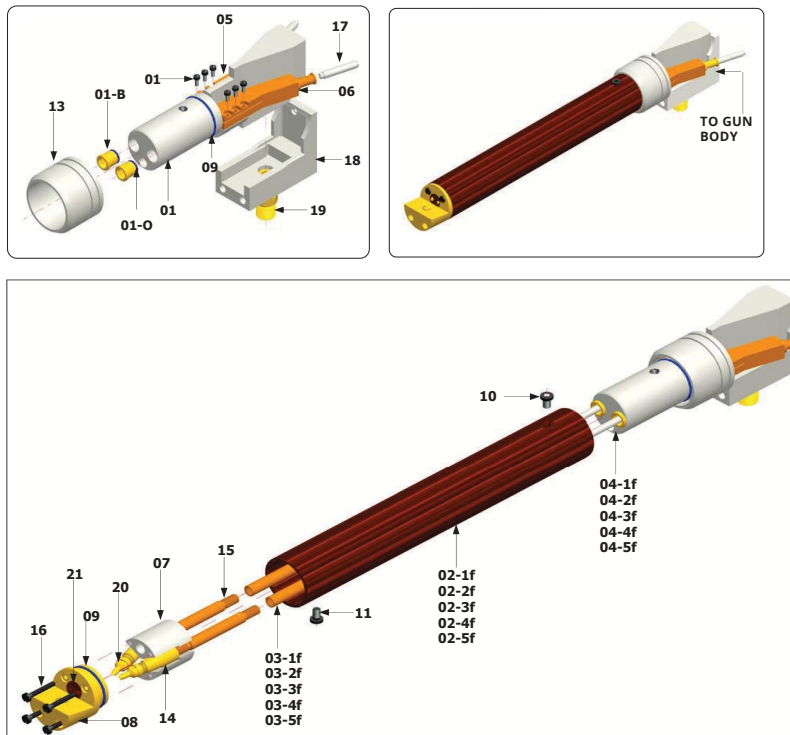
Part number **(3) ID contact tube** is available in three sizes having part number

3-a	1 ft
3-b	2 ft
3-c	3 ft

Part number **(4) wire transfer tube** is available in three sizes having part number

4-a	1 ft
4-b	2 ft
4-c	3 ft

EXPLODED VIEW OF ARC JET -BU-8850 EXTENSION



This publication could include technical inaccuracies or typographical errors. Changes are periodically made to the information herein; these changes will be incorporated in later editions of the publications. BALAJI UDYOG welcomes your suggestions in respect of product quality.

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Metal Spray Equipment

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