

SIMALFA®

WATER BORNE ADHESIVES



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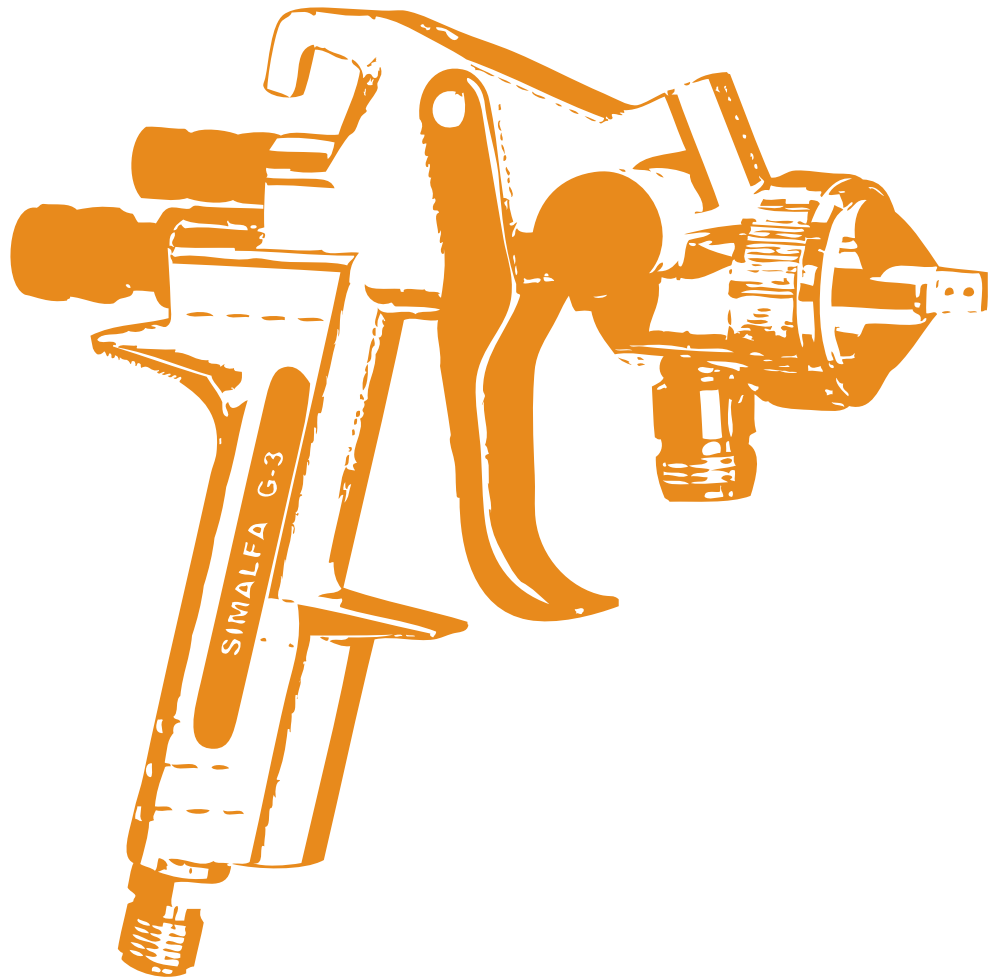
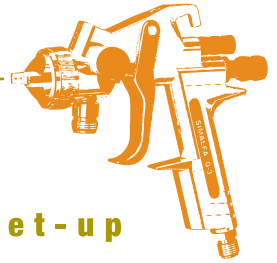
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G3 HVLP

spray gun set-up



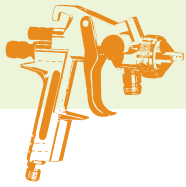
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Spray Gun Controls + Inputs

A. Air Flow Regulator

The Air Flow Regulator adjusts the level of atomization air being dispersed by the gun. Turning the knob to the left will decrease the atomization air, while turning to the right will increase it. For best results and optimal control, use this knob in conjunction with a wall regulator for proper atomization.

B. Needle Knob

The Needle Knob controls how much glue will come out of the gun with a full trigger squeeze. As the knob is threaded into the gun (tightened), the maximum adhesive amount is reduced. As the knob is unthreaded (loosened), the maximum adhesive amount is increased.

As a general rule, less threads = less adhesive, more threads = more adhesive.

C. Atomization Air Input

This is where the atomization air line is attached. We suggest using both the Air Flow Regulator (A) and a wall regulator to insure proper atomization.

Learn about setting the proper atomization air in the next section titled "Setting Atomization Air Pressure".

D. Trigger

Controls the amount of adhesive exiting the spray gun. It's similar to a gas pedal on a car, the further you pull the trigger the more adhesive exiting the spray gun.

E. Adhesive Input

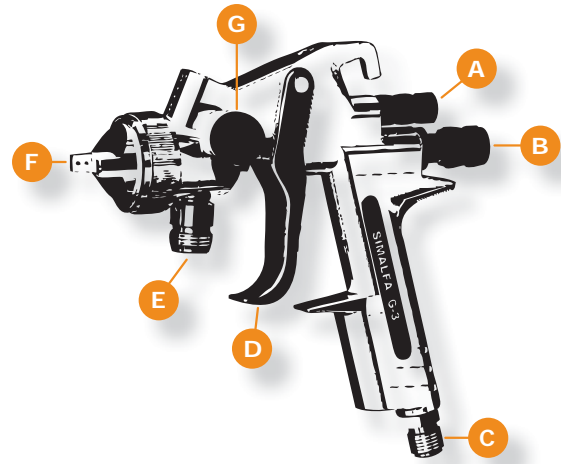
This is where the fluid hose is attached. 1/2" Fluid Hose and Stainless Steel Connector required.

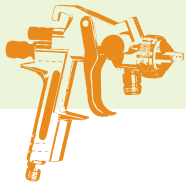
F. Adhesive Exit Point

Point where all settings such as adhesive volume, pattern width, atomization pressures come together for application.

G. Pattern Width Control Knob

This knob controls how Simalfa will come out of the gun. As the knob is threaded into the gun (tightened), the fan pattern will narrow. As the knob is unthreaded (loosened), the fan pattern will become wider. It is important to note that as the fan pattern becomes wider, the air pressure must also increase to accommodate this.





Setting Atomization Air Pressure

Airflow Reduction Technology (ART)

The Simalfa G3 HVLV Spray Gun is lightweight and utilizes Airflow Reduction Technology (ART). This revolutionary technology maximizes airflow through the spray gun by minimizing air turbulence. This advancement eliminates overspray, increases transfer efficiency, and reduces adhesive costs.

Atomization Air Pressure

The key to correctly setting atomization air pressure is understanding the relationship between both the desired fluid volume and the spray pattern needed for an application. Factors such as a users' process, speed of application, and the component being built will dictate the required fluid volume and pattern width. For example, a mattress manufacturer will require different settings than that of a company producing protective packaging for a computer hard drive.

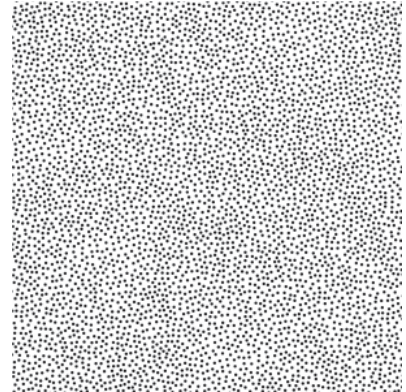
Average Settings

On average, our customers have atomization air pressures set in the range of (15psi-40psi / about 1-2.75 Bar).

General Setting Concepts

As the need for fluid volume increases so will the requirement for atomization air pressure. In addition, as pattern width increases so will the need for atomization air pressure.

Adjust the air pressure to where the adhesive appears in very fine droplets. The diagrams on the right illustrate CORRECT and INCORRECT atomization air pressure as it relates to fluid volume and pattern width.



A



B

Correct Atomization Air Pressure (A)

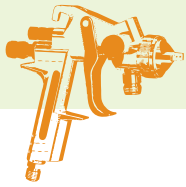
Atomization air is set correctly for the fluid volume and pattern width. Adhesive appears in fine droplets to maximize the efficiency and performance of Simalfa.

Incorrect Atomization Air Pressure (B)

Droplets too coarse for the pattern width and fluid volume. Simalfa will not perform as designed.

SOLUTION: Increase air pressure so droplets appear fine, and/or decrease pattern width, and/or decrease fluid volume so adhesive appears in fine droplets as in diagram A.





Recommended Spray Techniques

Distance from Substrate

When applying Simalfa the spray gun should be held at a distance between 4"-10" (10cm - 25cm) from the substrate.

Pattern Width

Keep it narrow. A narrow spray pattern gives greater control over where the adhesive is applied. Wide spray patterns create waste, mess and possible over spray.

Angle to Substrate

Spray Simalfa directly at the substrate, not across or on an angle. This will insure the most economical application and reduce any potential for over spray.

User Motion

The user should have a sweeping motion left to right and right to left. A single pass of a light even coverage should be sufficient. A short pulsating technique will waste adhesive and cause inconsistencies in the final bond.

Application

Application amount is determined by the handling strength required during the production process and/or the complexity of the application itself. SIMALFA can be sprayed lighter on easier applications or heavier on more difficult applications. It is important not to over apply SIMALFA as this creates waste.

Recommended Training Aids

Understanding Overspray

