Advanced Adhesive Spray Systems Guide

FAST & EASY ADHESIVE SPRAY SYSTEMS

Superior, Economical Adhesive Spray Systems for Cabinetmakers, Manufacturers, Contractors, Installers and DIY.

www.binks.com
With nearly 220 years of collective leadership in the spray finishing industry, Binks and DeVilbiss continue to set standards that other brands strive to achieve.

Our Binks and DeVilbiss team of experts — engineers, designers, technicians and our customer service group — are constantly working to bring you the Quality, Efficiency, Performance and Value you expect from the world’s premier spray finishing brands.

**WARNING**

Warning: Never spray different types of materials into the same filter. Spraying different coating types into the same filter and mishandling used filters can result in self-ignition of the filter material. Refer to consensus fire safety standards such as NFPA33, local fire safety codes and coating manufacturers regarding proper handling and disposal of used filters. Binks assumes no responsibility for damages caused by improper filter use.

When disposing of filters, place in a water-filled metal container and dispose of at the close of the day’s operation or until such time that the disposal of the filters can be properly administered.

For plant and personnel protection, use and dispose of filters in accordance with NFPA33, OSHA 1910.107, EPA regulations, and any city, state or area code.

**CAUTION** Disposal Instructions

Discard used Paint Arrestors the same as any paint-impregnated waste material. Store used Paint Arrestors in water-filled container until disposal of. Some paint residues are considered hazardous and disposal must be in accordance with EPA regulations 40CFR Parts 260-262 and other pertinent regulations.

**CAUTION** Use Instructions

For plant and personnel protection, booths, guns and procedures should comply with NFPA Standard # 33, OSHA Regulation 1910.07, appropriate EPA regulations and any city or state codes.

**CAUTION** Use & Disposal

All use and disposal of this media must be conducted in accordance with the requirements of all applicable Federal, State and Local environmental, fire protection and workplace safety laws and regulations, such as EPA Regulations 40CFR Parts 260-262. Store used Paint Arrestors in water-filled containers until disposed of.

**DANGER** Storage Instructions

Avoid exposure to open flame, stacking against exposed incandescent bulbs, or direct contact with burning, smoking material or welded sparks.
The Adhesives Industry touches all facets of our lives... it also touches almost all markets.

- **Construction Industry:**
  - Insulation Panels
  - Mobile Homes
  - Laminate Tub and Shower Kits
  - Ceramic Tile

- **Furniture Industry:**
  - Laminate Counter Tops
  - Tables and Chairs

- **Transportation Industry:**
  - Dashboards
  - Auto Interior Insulation
  - Seating
  - Auto Glass

- **Packaging Industry:**
  - Tape
  - Labels
  - Cartons

- **Food Industry:**
  - Packaging

## Spray Application Processes

### Atomization Technology Options

Conventional and HVLP are types of Atomization technology, each has slightly different operating parameters.

#### Conventional Air Atomizing

The most established method of air atomizing, used on spray guns for decades. It uses high velocity air jets to produce a very high atomization power. However, this speed results in low transfer efficiency due to considerable “bounce-back” and overspray. Air pressure exiting the air cap during use is typically 30 to 60 psi (2 to 4 bar) with typical air consumption of 6 to 25 cfm (170 to 700 l/min).

#### High Volume Low Pressure (HVLP)

Although not new, this method first became important in the early 1990s when environmental legislation started to be introduced. It uses larger air volumes (11 to 30 cfm or 300 to 840 l/min) at low pressure to atomize the coating. HVLP has a much higher transfer efficiency than conventional air atomizing due to the lower air pressures. The droplet sizes produced tend to be slightly larger, sometimes resulting in a lower quality finish. Officially HVLP is limited by Government Environmental Legislation to a maximum of 10 psi (0.7 bar) atomizing pressure measured at the air cap.

For more information on Atomization Technology Options please reference the Binks website at www.binks.com.

### Fluid Delivery Options (Recommended For Adhesive Applications)

#### Pressure-Feed

This option uses an external pressure source (pressure tank, piston pump, or diaphragm pump) to force air and fluid to the spray gun nozzle. Air and fluid are then mixed outside the nozzle (external mix air caps).

*Advantages:* This method delivers higher volumes of fluids than other gun set ups, and will spray a wider range of materials. It also enables independent control of fluid pressures.

---

For more information, please visit the Binks website at www.binks.com.
Choosing The Right Equipment

**Working Faster & Smarter**

**Binks 2100 Spray Gun**
- A conventional spray gun that’s ergonomic and balanced
- Stainless steel fluid passage makes this an ideal choice for waterborne or solventborne materials

**Binks 95 Conventional Spray Gun**
- A high production spray gun that can be used with most coatings while providing superior performance
- Stainless steel fluid passage makes this an ideal choice for waterborne or solventborne materials

**Binks Mach 1 Spray Gun**
- A full size HVLP spray gun with special nozzles and modifications that allow it to operate high transfer efficiencies
- Designed to stand up under hard, continuous use
- Stainless steel fluid passage makes this an ideal choice for waterborne or solventborne materials

**Binks Mach 1SL Spray Gun**
- A lightweight, top quality, high performance spray gun
- Superbly balanced forged aluminum body with a compact grip size, offering the operator extra comfort and control
- Designed to stand up under hard, continuous use
- Stainless steel fluid passage makes this an ideal choice for waterborne or solventborne materials

### FLUID NOZZLE GUIDE

<table>
<thead>
<tr>
<th>Spray Gun</th>
<th>Fluid Nozzle</th>
<th>Part #</th>
<th>Orifice</th>
</tr>
</thead>
<tbody>
<tr>
<td>2100 / 95</td>
<td>L3ASS</td>
<td>45-6313</td>
<td>.040 (1.0 mm)</td>
</tr>
<tr>
<td>2100 / 95</td>
<td>L3BSS</td>
<td>45-6329</td>
<td>.046 (1.2 mm)</td>
</tr>
<tr>
<td>2100 / 95</td>
<td>L6BSS</td>
<td>45-6321</td>
<td>.046 (1.2 mm)</td>
</tr>
<tr>
<td>2100 / 95</td>
<td>66BSS</td>
<td>45-6605</td>
<td>.070 (1.8 mm)</td>
</tr>
<tr>
<td>2100 / 95</td>
<td>66SS</td>
<td>45-6601</td>
<td>.070 (1.8 mm)</td>
</tr>
<tr>
<td>2100 / 95</td>
<td>68SS</td>
<td>45-6801</td>
<td>.110 (2.8 mm)</td>
</tr>
<tr>
<td>Mach 1 &amp; 1SL</td>
<td>94S</td>
<td>45-9404</td>
<td>.055 (1.4 mm)</td>
</tr>
<tr>
<td>Mach 1 / 1SL</td>
<td>66XSS</td>
<td>45-6608</td>
<td>.040 (1.0 mm)</td>
</tr>
<tr>
<td>Mach 1 &amp; 1SL</td>
<td>97S</td>
<td>45-9704</td>
<td>.070 (1.8 mm)</td>
</tr>
<tr>
<td>Mach 1 &amp; 1SL</td>
<td>909</td>
<td>45-9090</td>
<td>.111 (2.8 mm)</td>
</tr>
</tbody>
</table>

### AIR NOZZLE GUIDE

<table>
<thead>
<tr>
<th>Spray Gun</th>
<th>Air Nozzle</th>
<th>Part #</th>
<th>Cfm @ 50 Psi</th>
<th>Max. Fan @ 8&quot;</th>
</tr>
</thead>
<tbody>
<tr>
<td>2100 / 95</td>
<td>66SD-3</td>
<td>46-6092</td>
<td>15</td>
<td>9-10&quot;</td>
</tr>
<tr>
<td>2100 / 95</td>
<td>66SDJG</td>
<td>46-6103</td>
<td>15</td>
<td>8-9&quot;</td>
</tr>
<tr>
<td>2100 / 95</td>
<td>68PB</td>
<td>46-6032</td>
<td>14</td>
<td>12&quot;</td>
</tr>
<tr>
<td>2100 / 95</td>
<td>63PR</td>
<td>46-6079</td>
<td>15</td>
<td>18&quot;</td>
</tr>
<tr>
<td>2100 / 95</td>
<td>63PH-1</td>
<td>46-6061</td>
<td>17</td>
<td>18&quot;</td>
</tr>
<tr>
<td>Mach 1 &amp; 1SL</td>
<td>95AS</td>
<td>46-9502</td>
<td>22</td>
<td>12&quot;</td>
</tr>
<tr>
<td>Mach 1 &amp; 1SL</td>
<td>905P</td>
<td>46-9050</td>
<td>22</td>
<td>13&quot;</td>
</tr>
</tbody>
</table>

### GUN & NOZZLE SELECTION GUIDE

**Spray Gun (Conventional)**
- Fluid / Air Nozzle Set-Up
- Application

**To Minimize Build-Up on Air Nozzle (Smoking) the Following Optional Set-Ups are Available**
- Fluid Nozzle
- Air Nozzle
- Application

**Specialty Fluid Nozzles & Air Caps**
- Fluid Nozzle
- Air Nozzle
- Application

**Spray Gun (HVLP)**
- Fluid / Air Nozzle Set-Up
- Application

---

**Binks 2100 Spray Gun**

**Binks 95 Conventional Spray Gun**

**Binks Mach 1 Spray Gun**

**Binks Mach 1SL Spray Gun**

---

**FLUID NOZZLE GUIDE**

**AIR NOZZLE GUIDE**

**GUN & NOZZLE SELECTION GUIDE**
Multiple Applications / Options

2-Gallon Pressure Tank Outfits for Solvent based & Waterborne Adhesives

Ideal for all types of high-volume adhesive applications, Binks Advanced Adhesive Spray Systems deliver all the advantages necessary for a full range of adhesives. They’re easy to operate and consistently apply the essential thin layer of today’s adhesives. The result: ideally strong and lightweight fastening of substrate materials — giving you all the advantages of speed, flexibility, versatility — and the labor savings you need.

- Part # 98-1229
  - Economical 2-gallon stainless steel fitted pressure tank
  - Outfit includes 25 ft. fluid / air hose assembly
  - Spray gun not included

- Part # 98Z-358
  - Identical to the 98-1229 – plus it comes complete with a Binks 2100 Gun - 68SS (2.8 mm) x 68PB for heavy glue (white)

Low-Pressure Gemini Diaphragm Pumps (1:1 ratio, 7 GPM)

Binks Gemini Wall Mount Outfit

- Part # 818210
  - Comes complete with two air filter regulators, wall bracket and siphon hose
  - Order spray guns and hoses separately

Binks Gemini Package Bung Mount Outfit

- Part # 818230
  - Comes with a single air filter regulator and a bung mount
  - Order spray guns and hoses separately

Binks Gemini Package Pail Mount Outfit

- Part # 818160
  - Comes with two air filter regulators, plus a fluid regulator, and a 5-gallon pail cover
  - Agitator assembly is available as an option
  - Order spray guns and hoses separately

Binks Gemini Package Drum Mount Outfit

- Part # 818220
  - Comes with two air filter regulators, a 55-gallon drum lid, and an agitator
  - Order spray guns and hoses separately

Binks Stainless Steel Pogo Plus

- Ideally suited for high-volume delivery of low-to-medium viscosity coatings or adhesives

<table>
<thead>
<tr>
<th>PART #</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>812490</td>
<td>SS Pump with UHMW Dynamic Seals</td>
</tr>
<tr>
<td>812491</td>
<td>SS Pump with Teflon Dynamic Seals</td>
</tr>
</tbody>
</table>

Binks Pogo Pump Outfit

- Part # 98-3061 includes one of each:

- 812490  SS Pogo pump (55 Gal.)
- 2100-4308-2  2100 Gun 66SS x 66SD-3
- 41-19931   Air Control
- 71-3303    25' Fluid Hose Assy. 3/8" ID
- 71-1295    25' Air Hose Assy. 5/16" ID

All Hardware Included
**Special Applications**

**Binks Mach 1 PC Gun**
- A two component HVLP spray gun with external catalyst injection
- Catalyst is injected through the air cap with atomizing air
- Stainless steel fluid passage makes this an ideal choice for waterborne or solventborne materials

**Binks 66R Air Nozzle**
- Produces a round pattern for spraying hard-to-reach areas such as crevices, small edges, bed liners, etc.

**Binks 66XSS Fluid Tip**
- Part # 45-6608
  - Allows the user to extrude materials through 2100 or 95 spray guns
  - The 3/8”-24 thread on this extrusion nozzle allows for attachment of customer supplied devices
  - Fluid pressures of up to 200 PSI can be safely used

**Binks 2100 / Flexible Extension**
- Part # 52-2410 (for metal duct work)
  - Sprays thin materials into hard to reach areas
  - Nozzle produces a 360° spray

**Adhesive Accessories**

**Air & Fluid Hoses**

- **Binks Air & Fluid Hose Set**
  - 5/16” I.D. x 25’ Air Hose
  - 3/8” I.D. x 25’ Fluid Hose
  - Part # 6-438

- **Binks 1/4” I.D. x 25’ Fluid Hose**
  - Part # 71-3383

- **Binks 3/8” I.D. x 25’ Fluid Hose**
  - Part # 71-3303

- **Binks 1/4” I.D. x 50’ Fluid Hose**
  - Part # 71-3384

- **Binks 3/8” I.D. x 50’ Fluid Hose**
  - Part # 71-3304

- **Binks 5/16” I.D. x 25’ Air Hose**
  - Part # 71-1205

- **Binks 3/8” I.D. x 25’ Air Hose**
  - Part # 71-1355

- **Binks 3/8” I.D. x 50’ Air Hose**
  - Part # 71-1356

- **Binks 3/8” I.D. x 50’ ErgoFlex™ Air Hose Assy.**
  - Part # 71-31102

**Spray Gun Lubricant**

- **Binks Gunner’s Mate Spray Gun Lubricant**
  - 2 oz bottle (20ct box)
  - Part # 6-429

**Cleaning Kit**

- **Binks Professional Spray Cleaning Kit**
  - Part # 192212

**Gun Repair Kits**

<table>
<thead>
<tr>
<th>GUN REPAIR KITS</th>
<th>Applicable Gun</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part #</td>
<td>6-229 2100 / 2001</td>
</tr>
<tr>
<td>54-3577</td>
<td>Model 95</td>
</tr>
<tr>
<td>54-3605</td>
<td>Mach 1</td>
</tr>
<tr>
<td>54-4278</td>
<td>Mach 1 SL</td>
</tr>
<tr>
<td>102-2720</td>
<td>Mach 1 PC</td>
</tr>
</tbody>
</table>

**Tank Liners**

- **Binks Disposable Tank Liners for 83C and 83Z Binks tank**
  - Box of 10 Liners: Part # PT-78-K10
  - Box of 60 Liners: Part # PT-78-K60

**Scrubs**

- **Binks Scrubs-In-A-Bucket**
  - Part # 29-3100-K6

---

*Contact Technical Support* regarding additional equipment recommendations for external catalyst injection spraying.