

# GS-2K-E

External Mix-Dual  
Component Gun  
for Sprayable Adhesives



**Coating Equipment Technology, Inc**  
Quality Spray Equipment | Industry Leading Customer Service

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## Important:

This manual contains important information, instructions and warnings:

The equipment or devices mentioned in this handbook are intended for spray purposes only and can not be used for other applications.

Users should familiarize themselves with requirements specified in this manual to ensure careful and correct operation. This manual is for reference purpose only, please read prior to use.

## Technical Data:

Max Pressure	5 BAR
Max Temperature	5°C-40°C
Noise Level	78.7 dB (A)
Country of Origin	China

## Spray Gun Parameters:

Adhesive Nozzle Diameter (mm)	1.3 (Other sizes available upon request)
Activator Liquid Nozzle Diameter (mm)	0.3 (Other sizes available upon request)
Amount of Adhesive Sprayed (ml/min)	0-550
Activator Discharge Volume (ml/min)	0-220
Activator Liquid Control Mode	Front Valve

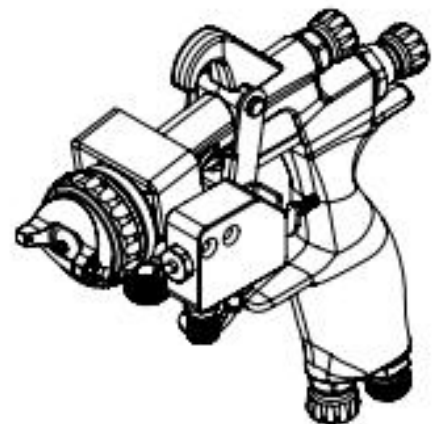
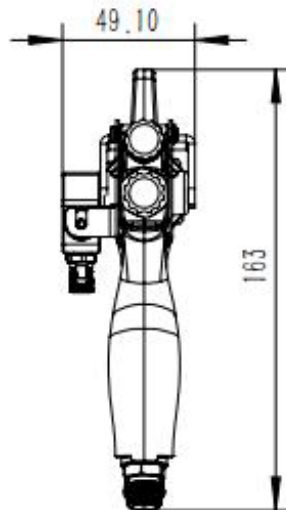
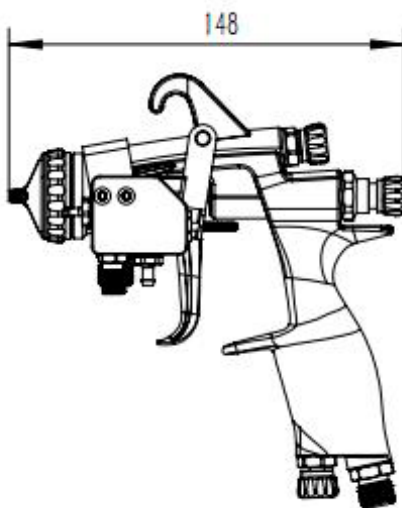
This spray gun is designed for two-component water-based adhesives, also know as a 2K spray gun. Each component of the spray gun has an independent flow channel design, allowing the gun to simultaneously process and mix both components of the adhesive. This prevents the components from mixing and solidifying inside the body of the spray gun. To assist customers in using this spray gun correctly, we have detailed the operation requirements, maintenance, inspection, common issues and spare parts.

# Scope of Application

This spray gun for two-component water-based adhesives is used in the bonding of wooden furniture, polyurethane foam, thermal insulation materials, car seat materials, sponges, leather, fabrics and other materials. These materials all require the use of two-component water-based adhesives for bonding or sealing to ensure product quality and performance.

## Operational Requirements

1. Connect the glue line before connecting the air line
2. Open the glue line, turn the A glue knob on the gun counter clockwise and adjust it to the maximum.
3. Pull the trigger, adjust the A glue outlet valve, observe the A glue spray distance. Ensure the distance is between 200 mm and 300 mm.
4. Adjust the B glue valve so it intersects with the A glue pattern between 5 mm and 10 mm.
5. Connect the air line and adjust the air regulator valve so the material is not spitting. Typically, the air pressure should be set around 4.5 pounds.
6. Turn the width adjustment valve until the B glue stream is atomized. The spray distance should be between 150 mm and 300 mm.



# Maintenance and Inspection

## Warnings

- Avoid contact with the needle tip to avoid damage or risk to personal safety.
- Allow only skilled and experienced operators to inspect and repair the spray gun.

## Caution

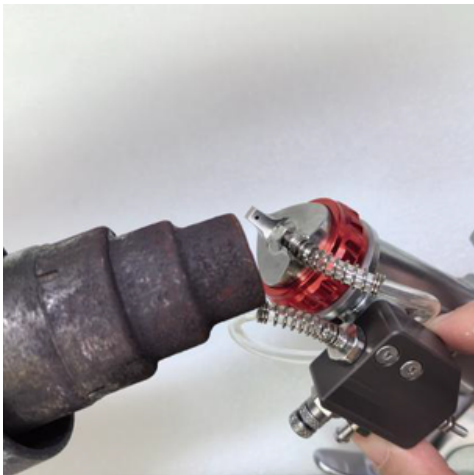
- Only use original spare and replacement parts.
- Never immerse the entire spray gun in any liquid such as thinner.
- Avoid leaving the air cap in solvent for an extended period of time. Prolonged submersion may cause defects in the spray pattern.
- Do not damage air cap holes, liquid nozzle, B glue nozzle or gun needle.

## Inspections

1. Each orifice of the air cap and fluid nozzle
  - Replace if orifices are dirty or damaged
2. Packings and O-rings
  - Replace if deformed or worn out
3. If leakage from seat section between fluid nozzle and fluid needle set occurs:
  - Replace fluid needle and nozzle if leakage persists after cleaning. Be sure to match the size of the needle and nozzle to prevent further leakage.
4. B component switch seats and O-rings
  - Replace when damaged
5. Component B fluid passage
  - Replace gun
6. Component B nozzle
  - Use a heat gun to break thread locking agent on the atomizing cap, remove it with a wrench and replace it.

Note: Add fresh thread locking to replacement atomizing cap

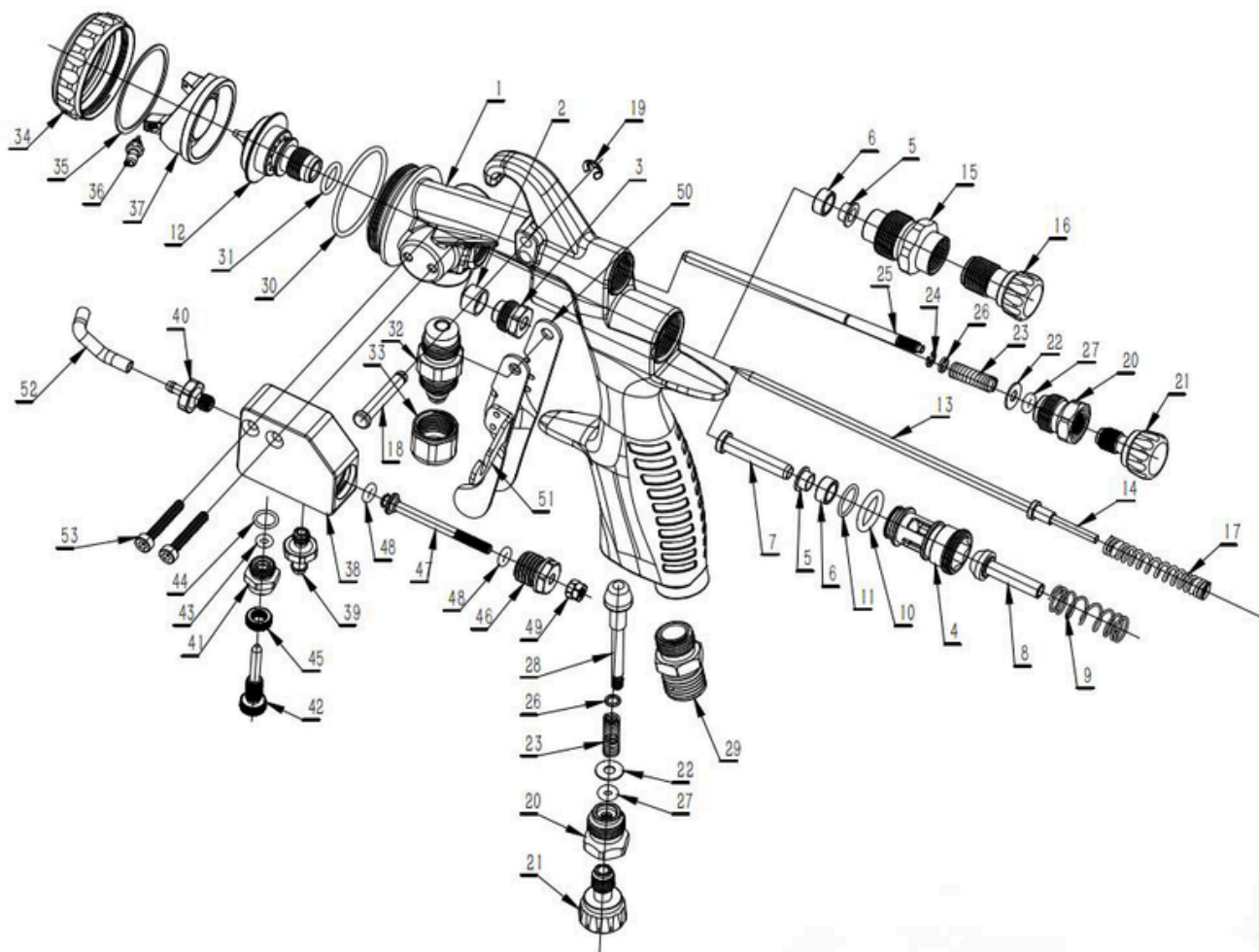
Replacement of B component:



# Common Faults and Corrective Actions

Problem	Faulty component	Parts to be checked	Reason	Measures			
				R1	R2	R3	R4
Air leakage (From the top of the air cap)	Air Valve Kit	Air valve	Dirty or damaged seat slot			✓	✓
		Air valve seat groove assembly	Dirty or damaged seat slot			✓	✓
			Air valve spring wear				✓
		O-ring	Damage or thinning				✓
Paint leakage	Adhesive nozzle	Adhesive nozzle ~ liquid gun needle assembly	Dirty, worn or damaged seat slot			✓	✓
			Loose flow regulating valve		✓		
			Needle spring worn				✓
		Adhesive nozzle ~ gun body	No tightening	✓			
			Dirty or damaged seat slot			✓	✓
		Adhesive gun needle ~ pressing assembly	Needle failure to return due to tightness of tightening kit		✓		✓
			The adhesive gun needle cannot be returned due to paint blockage		✓	✓	
	Adhesive gun needle	Tightening kit ~ needle assembly	Abrasion	✓			✓
			No tightening	✓			
	B glue thimble	O-ring 6.5 * 1.8	Abrasion				✓
	Component B pipeline	Component B pipe 4 * 2.5	Breakage				✓
	Component B small nozzle	Component B small nozzle	Breakage				✓
	Screw tooth	Gun body	Damage				✓
No discharge	Adhesive nozzle	Flow regulating valve	Not fully opened		✓		
		Nozzle mouth	Blockage			✓	
		Paint filter	Blockage			✓	✓
A and B flow channels are not synchronized	Nut M3	Nut M3	Abrasion		✓		✓

R1: Re-tighten R2: adjust R3: clear R4: replace part



No.	Description	QTY	No.	Description	QTY
1	Gun Body	1	28	Volume Control Valve Stem	1
2	Packing Ring	1	29	Inlet Connection	1
3	Packing Ring Screw	1	30	O-Ring 31 * 1.5	1
4	Airlock	1	31	O-Ring 11 * 1.5	1
5	Base Clamp Bottom	2	32	Component A Connector	1
6	Seat Clamp Trigger	2	33	Component A Joint Lock Cap	1
7	Trigger Thimble	1	34	Retainer	1
8	Thimble Air Seal	1	35	Retainer Gasket	1
9	Gas Sealing Pin Spring	1	36	B Component Small Nozzle	1
10	O-Ring 14*2	1	37	Fan Atomizing Cap	1
11	O-Ring 11 * 1	1	38	Component B Switch Valve Seat	1

12	Nozzle	QTY	39	Switch Feed Connectors	QTY
13	Needle	1	40	Switch outlet Connector	1
14	Pin Retaining Nut	1	41	Regulating Valve Base	1
15	Flow Control Valve Base	1	42	Regulating Valve Knob	1
16	Flow Control Valve Bottom	1	43	O-Ring 6*1.5	1
17	Needle Spring	1	44	O-Ring 8*1	1
18	Trigger Bar	1	45	Regulating Valve Locking Ring	1
19	Circlip	1	46	Switch Base	1
20	Width Regulating Valve Base	2	47	Thimble	1
21	Width Control Valve Button	2	48	O-Ring 6.5*1.8	2
22	Flat Gasket	2	49	Nut M3	2
23	Width Regulating Valve Spring	2	50	Trigger Pull Plate	1
24	Width Regulating Valve Clamp Spring	1	51	Trigger	1
25	Width Control Valve Stem	1	52	B Component Pipeline 4*2.5	1
26	Lab Mat	2	53	M3 * 18 Round Head Screw	2
27	O-Ring 6.5*2	2			

# Spare Parts

<b>Kit No.</b>	<b>Part and No. on Breakdown</b>
GS001-2KE Air cap assembly	Retainer (34), Retainer gasket (35), B component small nozzle (36), Fan atomizing cap (37)
Gun body assembly	Gun body (1), Inlet connection (29), O-ring 31 * 1.5 (30), O-ring 11 * 1.5 (31), Component A connector (32), Component A joint lock cap (33), Packing assy., Air seal assy., Width adj. valve assy., Needle nozzle assy., Pneumatic regulator valve assy.
GS003-2KE Packing assembly	Packing ring (2), Packing ring screw (3)
GS004-2KE Air seal assembly	Airlock (4), Base (5), Seat clamp trigger (6), Trigger thimble (7), Thimble air seal (8), Gas sealing pin spring (9), O-ring 14*2 (10), O-ring 11 * 1 (11), Flow control valve base (15), Flow control valve button (16)
GS005-2KE Width adjustment valve assembly	Width regulating valve base (20), Width regulating valve spring (23), Width regulating valve clamp spring (24), Width control valve (25), Stem, Lab mat (26), O-ring 6.5*2 (27)
GS006-2KE Needle nozzle assembly	Nozzle (12), Needle (13), Pin retaining nut (14), Needle spring (17)
GS007-2KE Pneumatic regulator valve assembly	Width regulating valve base (20), Width control valve button (21), Flat gas- ket (22), Width regulating valve spring (23), Lab mat (26), O-ring 6.5*2 (27) Volume control valve stem (28)
GS008-2KE Trigger assembly	Trigger bar (18), Circlip (19), Trigger (50), Trigger pull plate (51)
GS009-2KE Component B assembly	Component B switch valve seat (38), switch feeder fittings (39), Switch outlet fittings (40), Regulating valve base (41), Regulating valve knob (42), O-ring 6 * 1.5 (43), O-ring 8 * 1 (44), Regulating valve locking ring (45), Switch base (46), Thimble (47), O-ring 6.5 * 1.8 (48), Nut M3 (49), B com- ponent pipeline 4 * 2.5 (52), M3 * 18 round head screw (53)
GS010-2KE	Component A material fitting (32)