

Mini NC needle module, Air Open Air Closed (AOAC), with a .040 orifice. Replaces Nordson 1121484 in MiniBlue (MB2) and slim line guns.

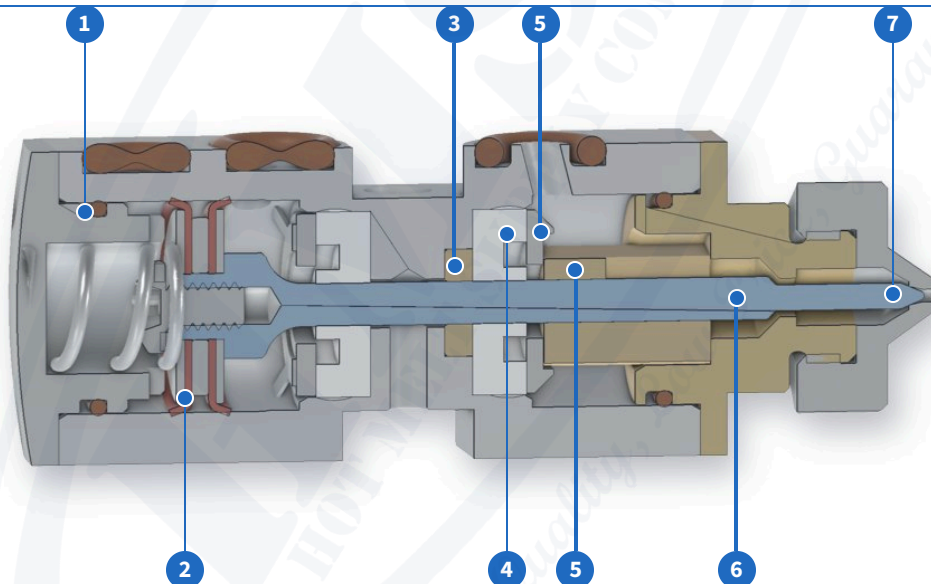
Specifications

Replaces Nordson	1121484
Module family	Mini NC
Fits	MiniBlue (MB2) and slim line guns
Actuation	Air Open Air Closed (AOAC)
Shut off	Needle point at the orifice
Orifice	.040 in
Filter	None
Nozzle, installed	Stainless steel, 45 in-lb torque
Gun code, module type	NC

Identification

- All mini modules are Air Open Air Closed (AOAC). There is no AOSC mini module.
- To tell the two mini types apart, remove the nozzle with the system cooled and pressure relieved.
- NC: a sharp needle point sticks out with the nozzle off.
- Standard (ball and seat): no needle is visible with the nozzle off.

Construction and features



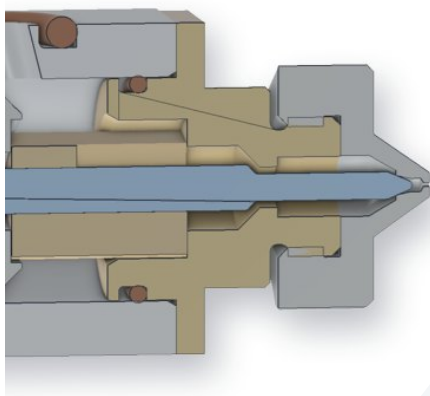
Cutaway of the mini NC module, stainless steel nozzle at the right end. Needle shown in blue. Numbers match the features below.

- 1 Stroke limiting air cap.** The air cap limits needle stroke. Less travel means less wear on the needle and seals.
 - 2 Rulon air piston seals.** Rulon seals on the air piston.
 - 3 Precision wiper.** Sits after the hydraulic seal. If the seal ever fails, it limits contamination reaching the pneumatics.
 - 4 PTFE spring seals.** Spring loaded PTFE seals in every module.
 - 5 Pressure reduction system.** Our proprietary brass triangle spacer and precision washer lower the pressure on the hydraulic seal.
 - 6 NiOx coated needle.** Coated for a smoother surface and longer life.
 - 7 Needle and seat design.** The needle and seat design reduces nozzle clogs and clears them as they occur.
- **Swiss CNC machined.** Components are cut on Swiss CNC machines for precision and finish.

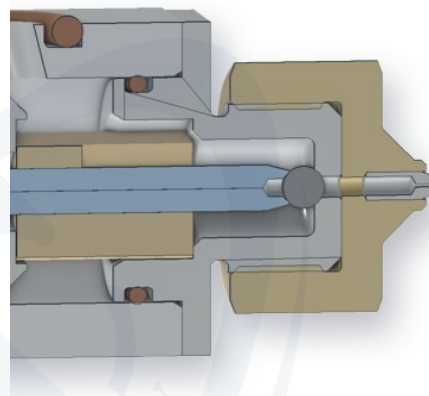




Nozzle end, mini NC and mini ball and seat



Mini NC: stainless steel nozzle (silver), the needle point seals at the orifice (this module)



Mini ball and seat: brass nozzle (yellow), a ball on the needle closes against a seat

Minimum applicator air pressure

To operate at this hydraulic pressure	Minimum applicator air
550 to 1,300 psi (38 to 90 bar)*	55 psi (3.8 bar)*
400 to 1,300 psi (28 to 90 bar)	65 psi (4.5 bar)
250 to 1,300 psi (17 to 90 bar)	75 psi (5.2 bar)

*HMSC factory setting. 60 psi (4.1 bar) is the nominal standard solenoid air pressure.

Set the applicator air at or above the minimum for your hydraulic pressure. Too little air pressure can keep the module from opening fully.

How we build and test every module

- 1 Precision machined.** All machined components are made in an ISO 9001 certified machine shop and fully dimensionally inspected.
- 2 Hand assembled.** Every module is assembled by hand, following our shop assembly procedure.
- 3 Opening pressure test.** Every module is tested to make sure it opens at the minimum opening pressure.
- 4 Functionality and flow test.** Our proprietary testing process checks that each module operates at high speed and fully opens and closes.
- 5 Complete seal test.** A final proprietary test makes sure the module seals completely when closed.

Safety. Modules run at melt temperature and hold hydraulic and air pressure. Before removing a module or nozzle, relieve system pressure, shut off air to the gun and use heat resistant gloves and eye protection.

Related modules

HMS-M-1121479 (.008)

HMS-M-1121480 (.012)

HMS-M-1121481 (.016)

HMS-M-1121482 (.020)

HMS-M-1121483 (.032)

HMS-M-1095703 (ball and seat)