

Enduser Manual








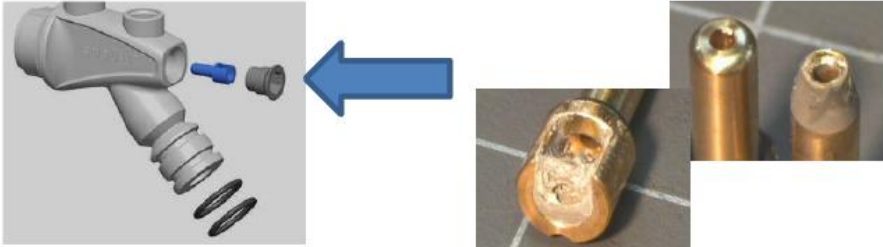

Version 1.3



Your global partner for high quality powder coating

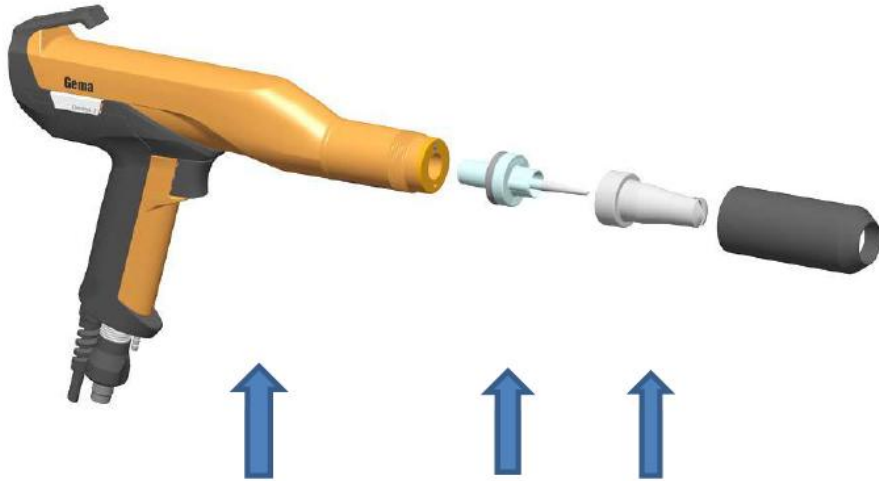



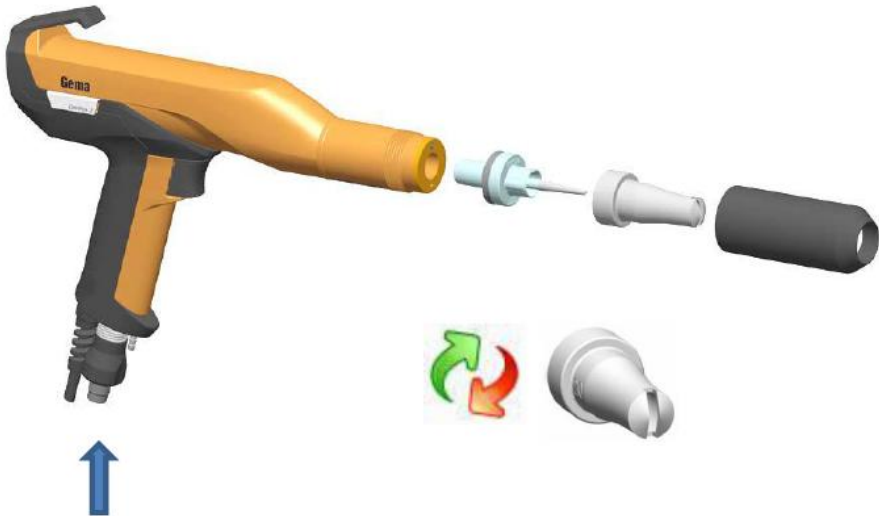





OptiFlow Powder injector (type IG06)



Cleaning / Check Injector sleeve	Daily
 <p>1006 485 [OptiFlow IG06]</p> <p>1005 587 [OptiFlow IG05]</p>	  
Check Filters of Check valves (oil , dirt)	Weekly
	 
Check Injector nozzle for wear	Monthly
	

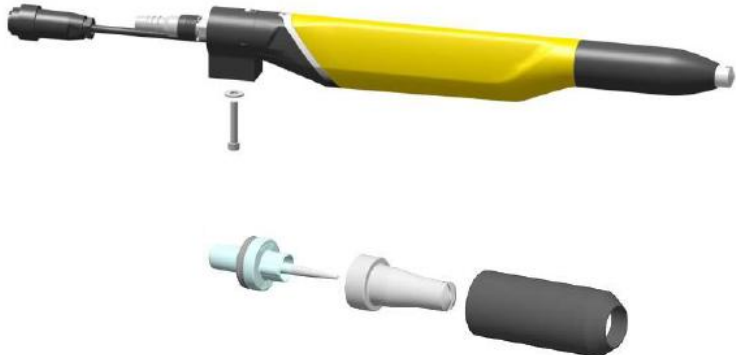



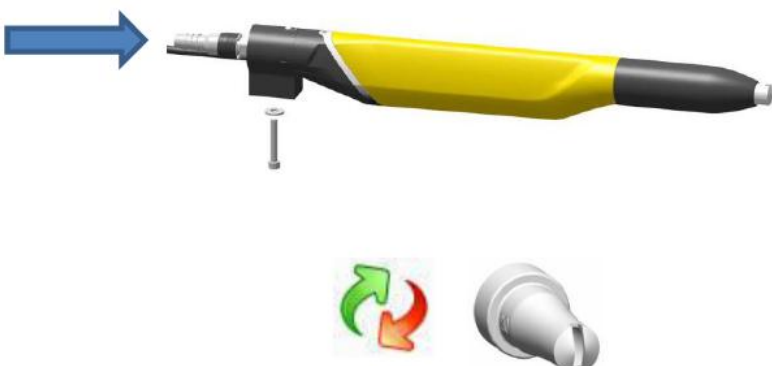





OptiSelect GM03 Manual powder gun



<p>Clean gun and nozzle with compressed air</p> 	<p>Daily</p> <p> 1 x 24 h</p>   <p>No solvents !</p>
<p>Clean gun/ gun tube and nozzle with compressed air Use brush for cleaning if necessary Replace worn nozzles / electrode holders</p> 	<p>Weekly</p>   
<p>Check High voltage of the gun</p> <p>70 – 100kV High Voltage</p> 	<p>Monthly</p> 

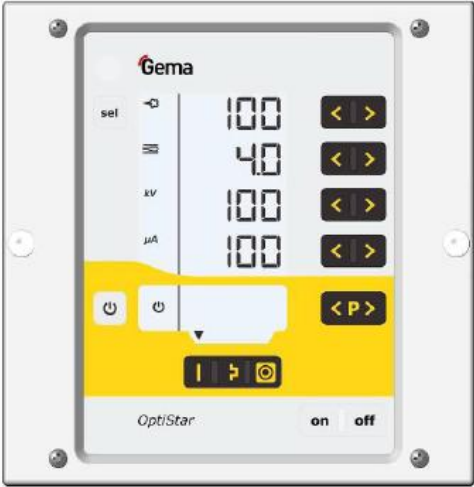


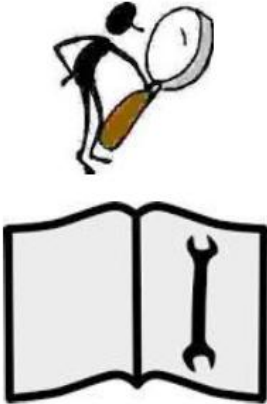
OptiGun GA03 Automatic powder gun



Clean gun and nozzle with compressed air  The image shows the yellow and black OptiGun GA03 with its nozzle assembly disassembled. The nozzle assembly consists of a light blue inner part, a grey middle part, and a black outer part.	Daily  1 x 24 h   No solvents !
Clean gun/ gun tube and nozzle with compressed air Use brush for cleaning if necessary Replace worn nozzles /electrode holders  The image shows the yellow and black OptiGun GA03 with a blue arrow pointing towards the nozzle. Below the gun, there is a green and red circular arrow icon and a grey nozzle component.	Weekly   
Check High voltage of the gun 70 – 100kV High Voltage 	Monthly  The image shows a red digital multimeter with yellow and black test leads connected to a yellow probe.

OptiStar CGxx



<p>Clean the controls with a dry cloth</p> 	<p>Daily</p> 
<p>If an Error occurs: Check the help codes</p> <p>Help codes</p> <p>The error diagnosis codes (help codes) are shown in rot on the A5 display.</p>  <p>T10/T11</p>	<p>Continuous</p> 

Ground



Hanger must be clean / Contact to ground	Daily
	  
Check Ohmic resistance with Ohm-Meter	Weekly
 Max. 1 Meg Ω	
Hanger cleaning	Continuous
 	 



Blow off the outside of the reciprocator with compressed air or clean it with a soft cloth from top to bottom at least once a week.

Daily/ weekly



 **1 x 24 h**



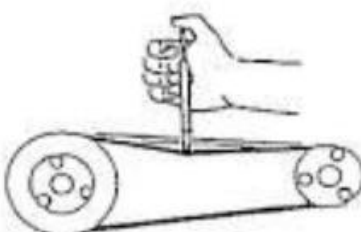





Check the drive unit gearbox for leakage of oil
Check the motor case in the reciprocator base for deposits of powder dust and if present, clean it

Monthly



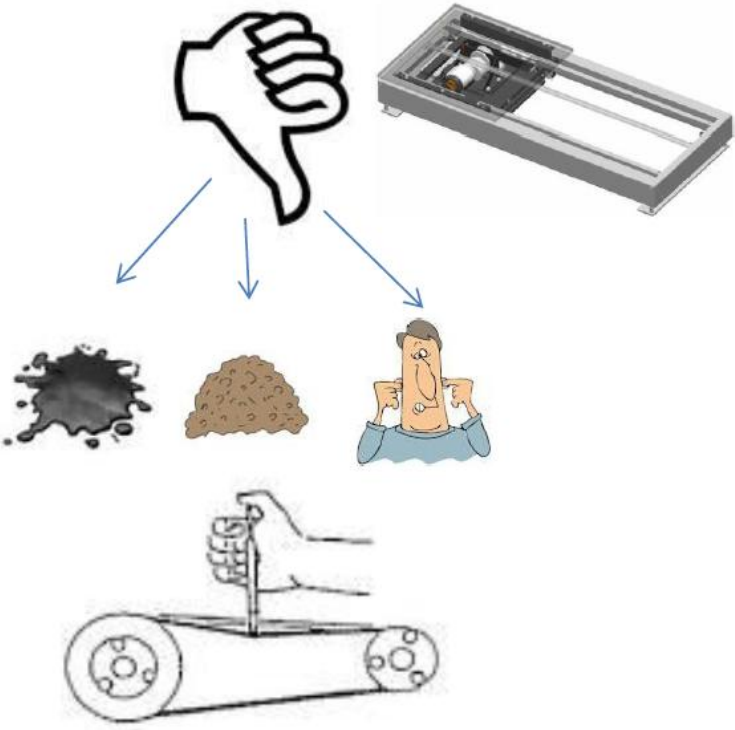





<p>Remove lateral panels Clean the column and check wear.</p> <p>Check the drive belts for wear and tension</p> <p>Check the rollers on the Z carriage for free movement and wear.</p>	<p>Every 6 months</p>
  	  



Reciprocator XTxx

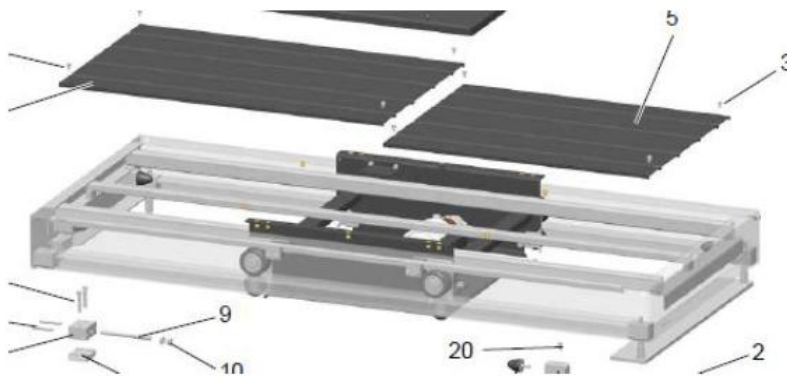
<p>Coarse cleaning Check operating conditions Clean the running surface</p>	<p>Weekly</p>
	
<p>Check the toothed belt tensioning</p>	<p>Monthly</p>
	

Reciprocator XTxx



Remove the covers and clean the guide profiles
Remove dirt and foreign objects below the axis

Every 6 months



Light grid



Clean light grid surface with clean soft cloth	Daily
	
Check alignment (mechanical damage)	Weekly
<p>Aligned</p>   	 



Before switching off the plant, the OptiSpeeder must be emptied and cleaned.

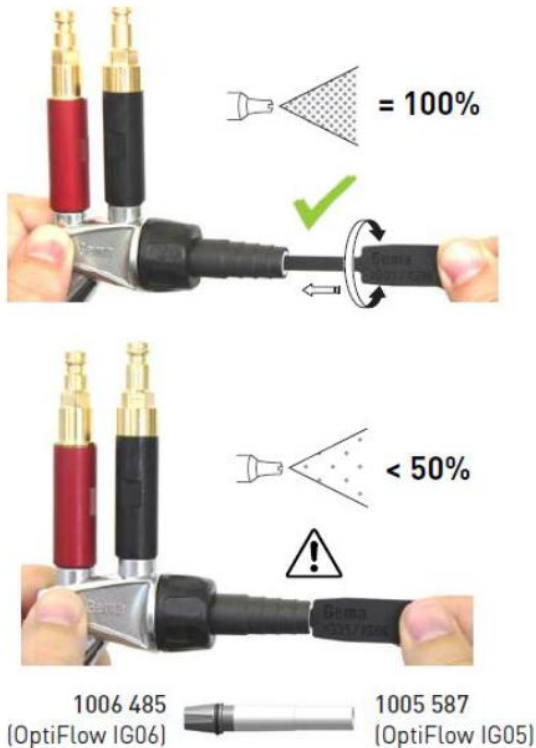


Daily



Check the injector nozzles and replace them, if necessary

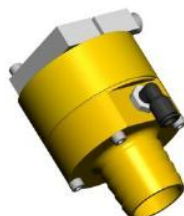
Weekly



Disassemble Airmover and clean it (Interval depending on the powder)

Weekly

Airmover

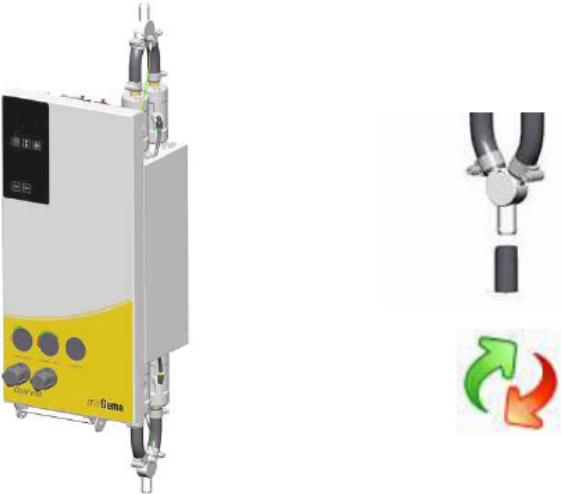



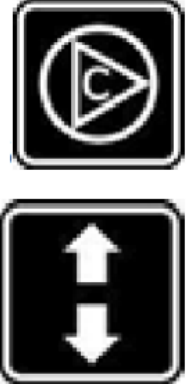







Check: Fluidising plates, Pinch valves	Anual
<div data-bbox="121 357 928 821"></div>	<div data-bbox="1063 299 1228 473"></div> <div data-bbox="1071 579 1235 743"></div> <div data-bbox="1092 869 1199 975"></div>
Fluidplate Rectangular hopper	Anual
<div data-bbox="92 1333 485 1593"></div> <div data-bbox="549 1323 942 1632"><p>Fluid Plate</p><div data-bbox="614 1439 856 1622"></div></div>	<div data-bbox="1099 1420 1213 1526"></div>

OptiFeed PP06



<p>Clean the powder pump with a dry cloth and check the connection points of the powder hoses. Replace the powder hoses, if necessary.</p>	<p>Daily</p>
	<p> 1 x 24 h</p> 
<p>Rinse the powder pump in conveying direction and in suction direction by using the rinsing program. This cleans the filter elements and prevents potential, unintended powder deposits in the powder pump and in the powder hoses.</p>	<p>Weekly</p>
	





The OptiFeed PP06 powder pump indicates it is time for maintenance by changing the maintenance indicator from  to . If the recommended operating time is exceeded, the indicator changes to .

1 shift operation
after 360 days
(continuous operation)
3 shift operation -
after 120 days
(continuous operation)

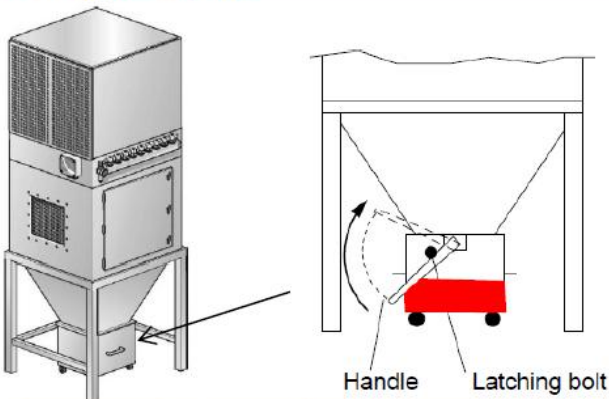
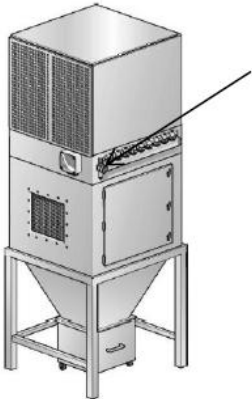


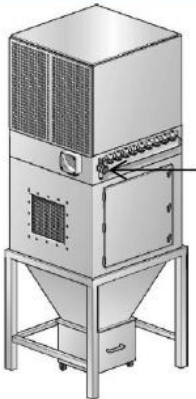




MagicCompact BA04



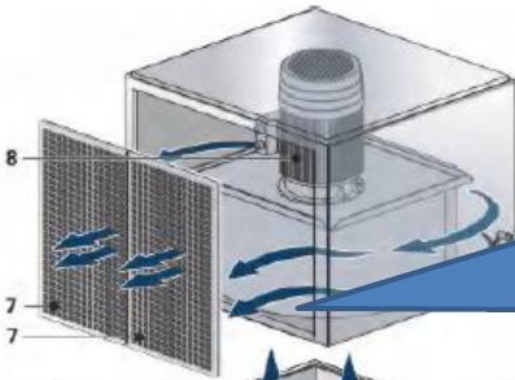



<p>Check all oil separators and if necessary, empty (if oil is present, the compressed air preparation must be checked)</p>	<p>Weekly</p>
	
<p>Clean / Polish booth walls Check floor cleaning</p>	<p>Annual</p>
	

After Filter

<p>Wastepowder box</p>  <p>Handle Latching bolt</p>	<p>Daily</p>
<p>Pressure reducing valve</p>   <div data-bbox="736 701 1115 1097"> <p>No water/oil in the separator</p> <p>Pressure air 4 Bar</p> </div>	<p>Weekly</p> 
<p>Quick opening valve</p>   <div data-bbox="811 1257 1125 1663"> <p>No leaking</p> <p>Same interval to each valve (ca 45sek)</p> </div>	<p>Weekly</p> 

After Filter

<p>Rotating nozzle</p>  <p>Check that all baffle plates (no.12) are open when the filter is running.</p> <p>Baffle plate (no.12) is closed when cleaning is running.</p> <p>Rotation nozzle (no10) is turning</p> <p>No damage on filter (no 13)</p> <p>Baffle plate must close during cleaning process</p>	<p>Monthly</p> 
<p>Filter mat</p>  <p>Filter mat must be clean, no powder inside of engine room.</p> <p>If there is powder = leakage of filter cartridge = Replace filter cartridge</p>	<p>Monthly</p> 

After Filter

Filter control box

Check if Exhaust air is adjusted according to the fancurve

Check Filter resistance for abnormal value

If Error message is active:

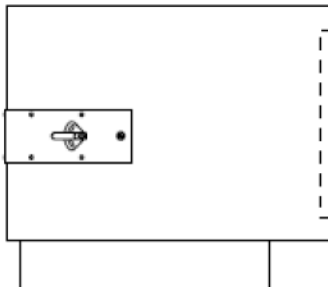
"Fan 1 minimum exhaust air reached"

open flap until message disappears

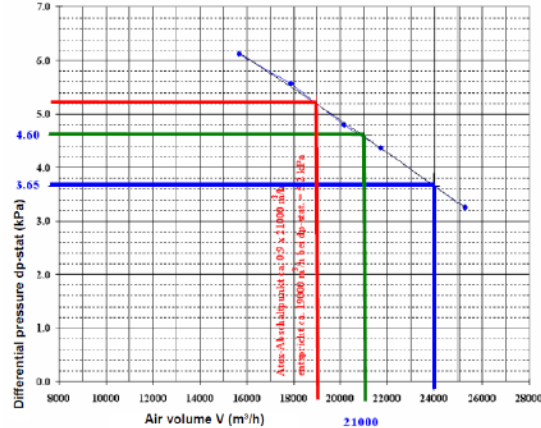
Monthly



BILD STEUERSCHRANK



You need to get the ventilator working curve to do the set up, it looks like this:

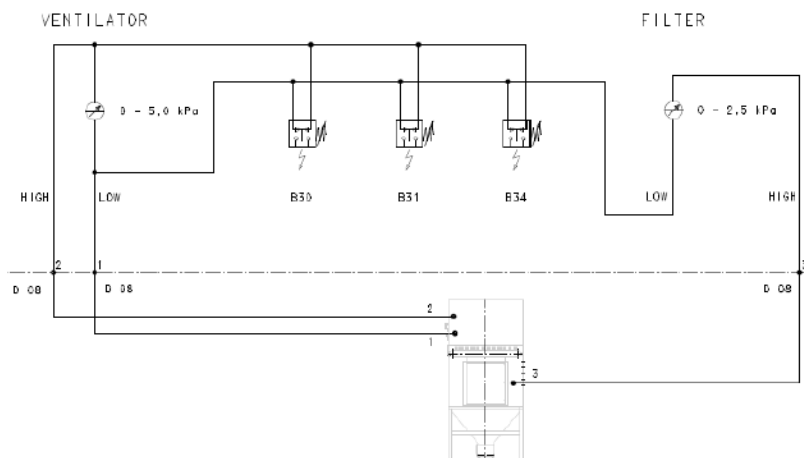


Example:

Maximum air volume (B30) 24000 m³/h = 3.65 kPa

Minimum air volume (B31) 21000 m³/h = 4.6 kPa

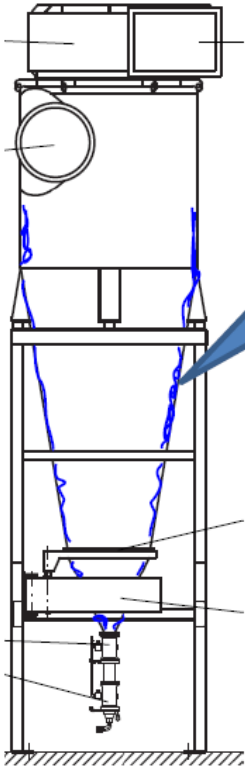



ATEX alarm (B34) 19000 m³/h = 5.2 kPa








Cyclone

<p>Sieve</p> <div data-bbox="244 218 989 374" data-label="Text"> <p>Spare Parts: Sieve insert cpl. 600my 392499 Sieve insert cpl. 400my 395340</p> </div> <div data-bbox="137 388 1043 923" data-label="Image"> </div>	<p>Weekly</p> <div data-bbox="1146 440 1318 624" data-label="Image"> </div>
<div data-bbox="101 1043 434 1400" data-label="Image"> </div> <div data-bbox="519 1047 1090 1387" data-label="Text"> <p>If the sieve insert is wearing very fast, we recommend to use the optional Sieve Protection 1006560</p> </div>	
<p>Sealing</p> <div data-bbox="137 1493 1065 1870" data-label="Image"> </div>	<p>Monthly</p> <div data-bbox="1146 1528 1318 1711" data-label="Image"> </div>

Cyclone

powder agglomeration inside cyclone	Monthly
<div data-bbox="47 363 289 1136">A technical line drawing of a cyclone separator. It shows a vertical cylindrical body with a hopper at the bottom. Blue wavy lines represent powder agglomeration inside the cylinder. A speech bubble points from the agglomeration to a text box.</div> <div data-bbox="468 291 1082 701"><p>The solid powder agglomeration inside the cyclone can be removed with</p><p>Cleaning granulate</p><p>Part Nr 269115</p></div> <div data-bbox="454 792 1120 1136"><p>How to clean? Follow the instruction for the Granulate.</p></div>	<div data-bbox="1176 343 1336 517">A stick figure holding a large circular drum, representing the cleaning process.</div> <div data-bbox="1190 606 1322 736">A high-pressure spray gun, used for cleaning.</div>

Following tests have at least to be carried out :	Monthly
<p>Detector</p> <p>Check of the condition on faulting and damage.</p>  <p>Extinguishing agent pipe incl. nozzles</p> <p>Check of the condition on damage. (Remark: not available at fire detecting systems without extinguishing)</p>  <p>Alarm units (horn/flashing light)</p> <p>Check of the condition on faulting and damage.</p> 	 
<p>The annual check of the system must be executed by the manufacturer (STS) or by an authorized expert (At the extinguishing systems the responsible person for safety of the customer must be present during the check)</p>	<p>Annual</p>

Service Contract



If the servicing of equipment for Your maintenance team is too demanding, we recommend an annual service by a certified partner company of
Gema Switzerland GmbH

Helpdesk

Contact our Help desk at:

helpdesk@gema.eu.com

+41-71-313 83 33



Please provide detailed information such as:

- Project number
- Pictures
- where exactly is the item located
- ...





 **Gema**

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