



Translation of the Original Operating and Assembly Manual

PXM

Powder Center

Version 08 / 2015



P_02519

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1 ABOUT THESE INSTRUCTIONS



1.1 PREFACE

The operating manual contains information about safely operating, maintaining, cleaning and repairing the device.
 The operating manual is part of the device and must be available to the operating and service personnel.
 The device may only be operated by trained personnel and in compliance with this operating manual.
 Operating and service personnel should be instructed according to the safety instructions. This equipment can be dangerous if it is not operated according to the instructions in this operating manual.



1.2 WARNINGS, NOTICES, AND SYMBOLS IN THIS OPERATING MANUAL

Warning instructions in this operating manual highlight particular dangers to users and to the device and state measures for avoiding the hazard. These warning instructions fall into the following categories:



Danger - immediate risk of danger.
 Non-observance will result in death or serious injury.

	 DANGER
	<p>This notice warns you of a hazard! Possible consequences of not observing the warning instructions. The signal word indicates the hazard level.</p> <p>→ The measures for preventing the danger and its consequences.</p>

Warning - possible imminent danger.
 Non-observance may result in death or serious injury.

	 WARNING
	<p>This notice warns you of a hazard! Possible consequences of not observing the warning instructions. The signal word indicates the hazard level.</p> <p>→ The measures for preventing the danger and its consequences.</p>

Caution - a possibly hazardous situation.
 Non-observance may result in minor injury.

	 CAUTION
	<p>This notice warns you of a hazard! Possible consequences of not observing the warning instructions. The signal word indicates the hazard level.</p> <p>→ The measures for preventing the danger and its consequences.</p>

Notice - a possibly hazardous situation.
 Non-observance may result in damage to property.

NOTICE
<p>This notice warns you of a hazard! Possible consequences of not observing the warning instructions. The signal word indicates the hazard level.</p> <p>→ The measures for preventing the danger and its consequences.</p>

Note - provides information about particular characteristics and how to proceed.

1.3 LANGUAGES

The operating manual is available in the following languages:

Language:	Order No.	Language:	Order No.
German	2350371	English	2350372
French	2361466	Italian	2361468
Spanish	2361471	Russian	2361472
Chinese	2361473		

1.4 ABBREVIATIONS

Stk	Number of pieces
Pos	Position
K	Marking in the spare parts lists
Order No.	Order number
ET	Spare part
FP	Fresh powder
RP	Reclaimed powder
IF	Version with integrated suction
FF	Version with final filter

1.5 TERMINOLOGY FOR THE PURPOSE OF THIS MANUAL

Cleaning	Manual cleaning of devices and device parts with cleaning agent
Flushing	Internal flushing with compressed air of parts carrying paint
Staff qualifications	
Trained person	Is instructed in the tasks assigned to him/her, the potential risks associated with improper behavior as well as the necessary protective devices and measures.
Electrically trained person	Is instructed by an electrician about the tasks assigned to him/her, the potential risks associated with improper behavior as well as the necessary protective devices and measures.
Electrician	Can assess the work assigned to him/her and detect possible hazards based on his/her technical training, knowledge and experience in relevant provisions.
Skilled person In accordance with TRBS 1203 (2010)	A person, who, based on his/her technical training, experience and recent vocational experience, has sufficient technical knowledge in the areas of explosion protection, protection from pressure hazards and electric hazards (if applicable) and is familiar with the relevant and generally accepted rules of technology so that he/she can inspect and assess the status of devices and coating systems based on workplace safety.

2 CORRECT USE

2.1 DEVICE TYPE

Powder center for feeding fluidized powder lacquers

2.2 TYPE OF USE

The PXM powder center is used to feed fluidized powder lacquers from a powder tank (including original tank) to several guns at the same time.

2.3 USE IN POTENTIALLY EXPLOSIVE AREAS

The PXM powder center is intended for construction outside of the dust Ex-zone (Zone 22).

2.4 SAFETY PARAMETERS

WAGNER accepts no liability for any damage arising from incorrect use.

- Use the device only to work with the products recommended by WAGNER.
- Operate only the device as a whole.
- Do not deactivate safety fixtures.
- Use only WAGNER original spare parts and accessories.

The device may only be operated under the following conditions:

- The operating personnel must be trained on the basis of this operating manual.
- The safety regulations listed in this operating manual must be observed.
- The operating, maintenance and repair information in this operating manual must be observed.
- The statutory requirements and accident prevention regulation standards in the country of use must be observed.

The powder center may only be used if all parameters are set and all measurements/safety checks are carried out correctly.

2.5 PROCESSIBLE WORKING MATERIALS

- Electrostatically charged powder types
- Metallic powder

2.6 REASONABLY FORESEEABLE MISUSE

- Use of damp powder lacquer
- Working with liquid coating products
- Use of defective components and accessories
- Use for foodstuffs

2.7 RESIDUAL RISKS

Residual risks are risks which cannot be ruled out even in the event of correct use. If necessary, warning and prohibition signs at the relevant points of risk indicate residual risks.

Residual risk	Source	Consequences	Specific measures	Lifecycle phase
Skin contact with powder lacquers and cleaning agents	Handling powder lacquers and cleaning agents	Skin irritations, allergies	Wear protective clothing Observe safety data sheets	Operation, maintenance, disassembly
Powder lacquer in air outside the defined working area	Lacquering outside the defined working area	Inhalation of substances hazardous to health	Observe work and operation instructions	Operation, maintenance
Noise	Exhaust system Blowing-out system	Hearing damage	Wear ear protection	Operation Cleaning

3 IDENTIFICATION

3.1 EXPLOSION PROTECTION IDENTIFICATION

The PXM powder center is intended for construction outside of the dust Ex-zone (Zone 22).

3.2 PERMISSIBLE DEVICE COMBINATIONS

The following components may be used in the PXM powder center:

- PI-F1 injector
- Hi-Coat ED injector
- Ultrasonic screening device (version for PXM with replaceable filter)
- IP 5000 powder pump
- EPG S2 control unit
- EPG-Sprint X control unit
- MCC controller
- MCS 1 controller
- CPD 1

3.3 TYPE PLATE

Powder center



P_02627

Control cabinet



P_02628

Note:

The type plate may only be attached with the CE mark if the complete installation (powder center, controller, add-on parts, etc.) complies with the provisions of the EC directives.

3.4 NOTE ON THE EX-ZONE CLASSIFICATION BY THE OPERATOR

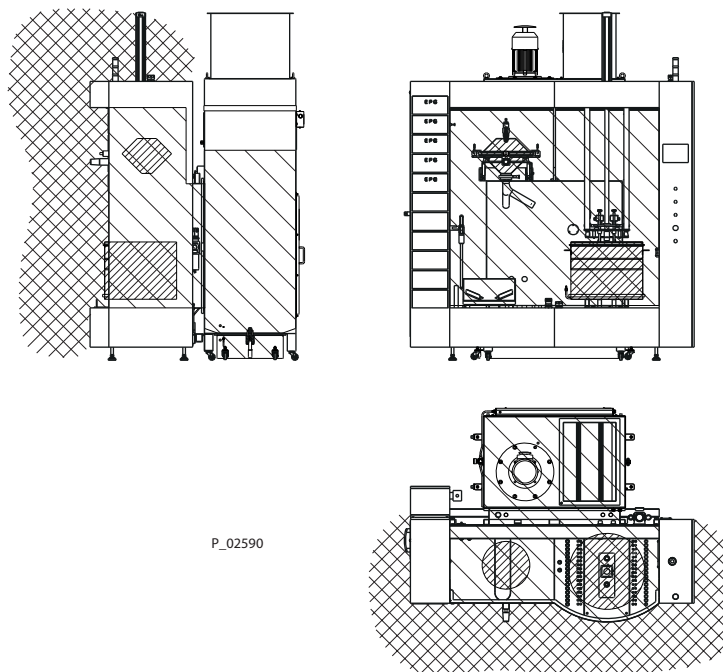
Decreased intrinsic emission is used by the PXM powder center to create a reduced zone extension as compared to classification and presentation as per EN 12981 (version 2010/06)* and BGI 764 (version 2009/10, as per 2014/02)*.


The permanent openings are facilitated. It is ensured by design and construction.


Therefore, operation is permitted only upon compliance with all the following requirements:


- The minimum air extraction rate corresponds to the operating manual and is ensured
- The powder center can only be operated when technical ventilation equipment is active (interlock with exhaust air)
- The open box is not fluidized, the fluidized box is only operated with "cover for box"
- The fluidized tank is closed with "cover for fluidized tank"
- The powder hoses and connections are airtight
- Necessary cleaning times are kept short
- The notes in the operating manual on safe operation are being observed.

Compliance with all the requirements and measures results in no relevant powder discharge. The zone extension caused by the powder center can be seen in the following images:



 Zone 20 in the tank and in the sieve chamber of the ultrasonic sieve

 Zone 22 within the powder center

 No zone caused by the powder center

* The EU standard and BG information are being revised. The exemptions shall be taken into account in future versions.

4 GENERAL SAFETY INSTRUCTIONS

4.1 SAFETY INSTRUCTIONS FOR THE OPERATOR

- Keep this operating manual on hand near the device at all times.
- Always follow local regulations concerning occupational safety and accident prevention.



4.1.1 ELECTRICAL DEVICES AND EQUIPMENT

- To be provided in accordance with the local safety requirements with regard to the operating mode and ambient influences.
- May only be maintained by skilled electricians.
- Must be operated in accordance with the safety regulations and electrotechnical regulations.
- Must be repaired immediately in the event of problems.
- Must be decommissioned if they pose a hazard.
- Must be de-energized before work is commenced on active parts.
- Secure the device against being switched back on without authorization. Inform staff about planned work.
- Observe electrical safety regulations.

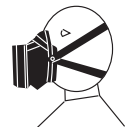


4.1.2 PERSONNEL QUALIFICATIONS

- Ensure that the device is only operated, maintained and repaired by trained persons.

4.1.3 SAFE WORK ENVIRONMENT

- The floor in the working area must be electrostatically conductive (measurements according to EN 1081).
- Make sure that all persons within the working area are wearing electrostatic-conductive shoes.
- Ensure that gloves worn are made of conductive material.
- The powder release must be electrically interlocked with the powder spray system's exhaust air equipment.
- Excess coating product (overspray) must be collected up safely.
- Ensure that there are no ignition sources such as naked flames, sparks, glowing wires, or hot surfaces in the vicinity. Do not smoke.
- Maintain sufficient quantities of suitable fire extinguishers and ensure that they are serviceable.
- The operating company must ensure that an average concentration of powder lacquer in the air does not exceed 50% of the lower explosion limit (LEL = max. permitted concentration of powder to air). If no reliable LEL value is available, the average concentration must not exceed 10 g/m³.



4.2 SAFETY INSTRUCTIONS FOR STAFF

- Always follow the information in this manual, particularly the general safety instructions and the warning instructions.
- Always follow local regulations concerning occupational safety and accident prevention.
- Under no circumstances may people with pacemakers enter the area where the high-voltage field between the spray gun and the work piece to be coated builds up!



4.2.1 SAFE HANDLING OF WAGNER POWDER SPRAY DEVICES

- Do not point spray guns at people.
- Before all work on the device, in the event of work interruptions and functional faults:
 - Switch off the energy/compressed air supply.
 - Secure the spray gun against actuation.
 - Relieve pressure on spray gun and device.
 - In case of functional faults: Identify and correct the problem, proceed as described in the "Fault Rectification" chapter.



4.2.2 GROUNDING THE DEVICE

The electrostatic charge may, in certain cases, give rise to electrostatic charges on the device. This may result in the formation of sparks or flames when discharging.

- Ensure that the device is grounded before each coating process.
- Ground the work pieces to be coated.
- Make sure that all persons inside the working area are grounded, e.g., that they are wearing electrostatically conductive shoes.
- The functionality of grounding cables must be checked regularly (see EN 60204).



4.2.3 PRODUCT HOSES

- Only use an original WAGNER powder hose.



4.2.4 CLEANING

- Before starting cleaning or any other manual work, the high-voltage in the spray area must be shut down and locked to prevent it from being switched back on.
- Lock the compressed air supply and decompress the device.
- Secure the device against being switched back on without authorization.
- Use only electrically conducting and grounded tanks for cleaning fluids.
- Preference should be given to non-flammable cleaning fluids.
- Flammable cleaning liquids may only be used if, after switching off the high-voltage, all high-voltage conducting parts are discharged to a discharge energy of less than 0.24 mJ before they can be accessed.
Most flammable solvents have an ignition energy of around 0.24 mJ or 60 nC.
- The cleaning agent's flash point must be at least 15 K above the ambient temperature.
- Only mobile industrial vacuum cleaners of design 1 (see EN 60335-2) may be used to remove dust deposits.

4.2.5 HANDLING POWDER LACQUERS

- When preparing or processing the powder and cleaning the device, take note of the processing regulations laid down by the manufacturer of the powder lacquers being used.
- Take note of the manufacturer's instructions and the relevant environmental protection regulations when disposing of powder lacquers.
- Implement the prescribed safety measures, in particular the wearing of safety glasses and safety clothing as well as the use of protective hand cream.
- Use a mask or breathing apparatus if necessary.
- To ensure sufficient protection of health and the environment, only operate the device in a powder booth or on a spray wall with activated ventilation (exhaust air).

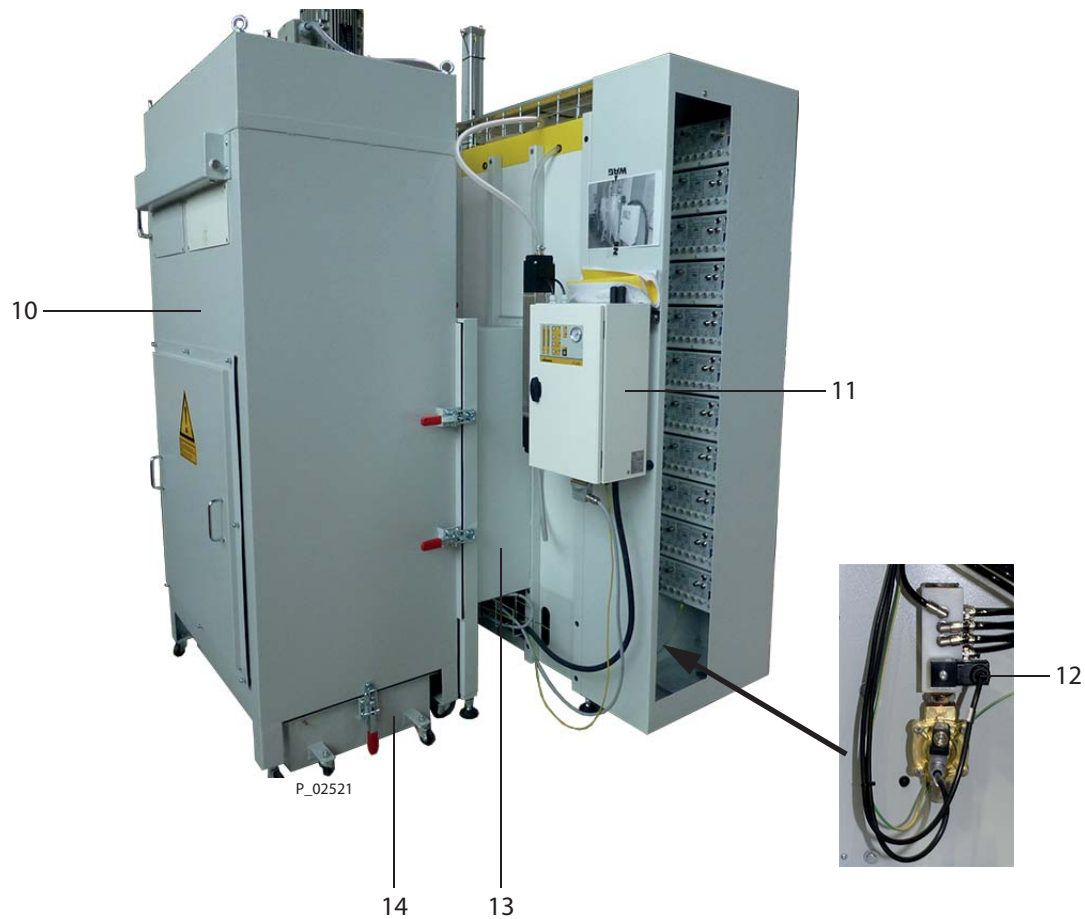


5 DESCRIPTION

5.1 COMPONENTS



- 1 Rack for EPG control units
- 2 Warning lamp with built-in alarm horn
- 3 Control cabinet with operating elements
- 4 Reciprocator with powder injectors and intake systems
- 5 Level sensor
- 6 Holder for box or container
- 7 Cleaning station for reclaimed powder; park station for loss mode of operation
- 8 Fresh powder supply
- 9 Cleaning position for fresh powder lance

5.1.1 VERSION WITH INTEGRATED FILTER

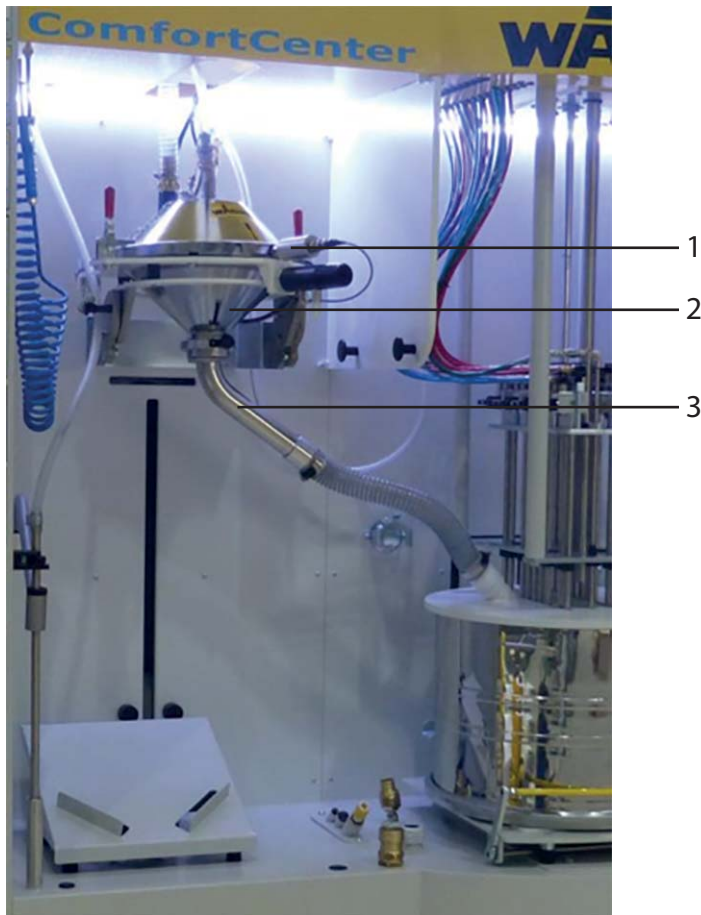
- 10 Filter suction
- 11 Fresh powder pump
- 12 Pressure switch for monitoring the mains pressure
- 13 Adapter for filter suction
Alternatively: Adapter to connect to the final filter
- 14 Powder catch basin

5.1.2 VERSION FOR FINAL FILTER



P_02674

5.1.2 VERSION WITH ULTRASONIC SIEVE



P_02675

- 1 Sieve frame with converter
- 2 Sieve housing
- 3 Powder spout

5.2 MODE OF OPERATION

The PXM powder center is a system from which fluidized powder is conveyed simultaneously from a powder tank (option) to several spray guns. Powder consumption is compensated by the fresh powder feed device (option) in the powder center or by manually refilling.

The linear motion unit suction system is immersed directly into the powder tank. A homogenous powder/air mixture is created through the fluidization and vibration (option) of the tank. The injectors convey the powdered paint to the guns in the coating system. A lowered powder level in the tank is detected by the level sensor in conjunction with sensors on the reciprocator. The level sensor also triggers the lowering of the suction system and the fresh powder supply (option) when necessary. A warning is triggered automatically in the event of a powder shortage and the warning lamp lights up yellow. If the minimum level is not reached after a certain time, the alarm lights up red and the system registers a malfunction. Powder level monitoring is active only in automatic mode.

5.3 PROTECTIVE AND MONITORING EQUIPMENT

- Protective and monitoring equipment must not be removed, modified or rendered unusable.
- Regularly check for perfect functioning.
- If defects are detected on protective and monitoring equipment, the system must not be operated until these defects are remedied.

Safety Device	Effect
EMERGENCY STOP button	- Powder feed blocked
	- Linear motion unit blocked
	- Fluidization and vibrator deactivated

5.4 SCOPE OF DELIVERY

Quantity	Order No.	Designation
1	see Chapter 5.4.1	PXM powder center
The standard equipment includes:		
1		Declaration of incorporation
1	2350371	Operating and assembly manual, German
1	see Chapter 1.3	Operating and assembly manual in the local language

5.4.1 DESIGN VARIANTS OF THE PXM POWDER CENTER

Basic Module:

Order No.	Designation
2350977	Powder center PXM 20/22 IF standalone, without ultrasonic sieve
2350980	Powder center PXM 20/22 FF standalone, without ultrasonic sieve
2359437	Powder center PXM 34 IF standalone, without ultrasonic sieve
	Powder center PXM 34 FF standalone, without ultrasonic sieve

Expansion Modules*:

Order No.	Designation
2350981	Injector set PI-F1
2350982	Injector set HiCoat-ED
2350983	Set EPG S2
2350984	EPG rack 1–11 for PXM 20/22
2359443	EPG rack 1–18 for PXM 34
2350987	Vibration table container/box
2350988	Box fluidizing device (only possible for PXM 20/22)
2350990	Box fresh powder addition
2341584	External valve cabinet for single-plug conveyor
2353462	Extension set ultrasonic sieve device 160 µm
2353306	Extension set ultrasonic sieve device 200 µm
2353302	Controller extension bigbag (without bigbag)
2350985	Set connection material for injectors and EPG including installation

- * Expansion modules can be used only in conjunction with an order of the basic module.
Product-specific limitations, e.g., flow rates must be observed and taken into account during the configuration.

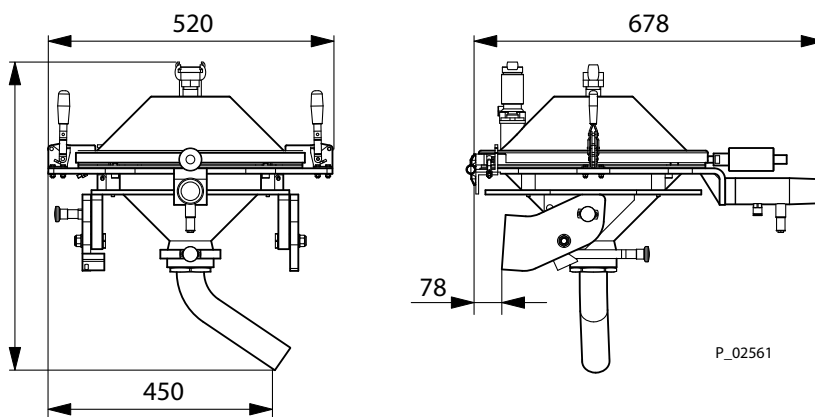
5.4.2 TYPE WITH ULTRASONIC SCREENING UNIT



P_02370

For more information on the ultrasonic screening unit, see operating manual for ultrasonic screening unit.

5.4.3 INSTALLATION DIMENSIONS FOR ULTRASONIC SCREENING UNIT



P_02561


5.5 TECHNICAL DATA

Dimensions:	
Maximum height	2,660 mm; 104.72 inches
Maximum width	2,170 mm; 85.43 inches
Maximum depth	1,400 mm; 55.12 inches
Weight	Approx. 500 kg + 150 kg filter suction

Electrical:	
Three-phase current connection	230/400 V 3P/N/PE 50 Hz
Frequency	50 Hz
Total power consumption	1.5 kW (without filter)/3.7 kW (with filter)
Protection class	IP 54

Pneumatic:	
Compressed air connection	0.6 – 0.8 MPa; 6 – 8 bar; 87 – 116 psi
Cross-section of compressed air line	At least 1.5"
Compressed air quality	6.5.2 according to ISO 8573.1: 2010
Air throughput coating mode	45 Nm ³ /h; 1,588.88 cf/h
Air throughput cleaning mode	100 – 150 Nm ³ /h in approx. 30 sec.
Suction capacity, exhaust	4,000 m ³ at 1,300 Pa; 5,230.86 cubic yards at 0.19 psi
Filter surface area (version with filter)	40 m ² ; 430.55 square foot
Number of filters	2
Filter capacity	> 99%
Permanent suction output for version with connection to a final filter: 1,000 Nm ³ /h; 35,308.34 cf	

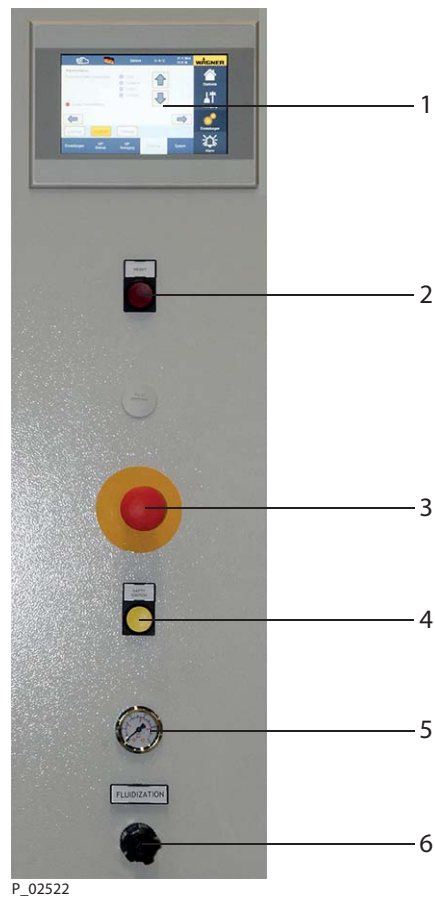
Equipment:	

	<p>WARNING</p> <p>Exhaust air containing oil! Risk of poisoning if inhaled.</p> <p>→ Provide compressed air free from oil and water (Quality Standard 7.5.4 as per ISO 8573.1, 2010) 7.5.4 = 5-10 mg/m³ / ≤7 °C; 44.6 °F / 5 mg/m³.</p>
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Number of injectors	PXM 20/22: 20 injectors when feeding from the box PXM 20/22: 22 injectors when feeding from the fluid tank PXM 34: 34 injectors when feeding from the fluid tank
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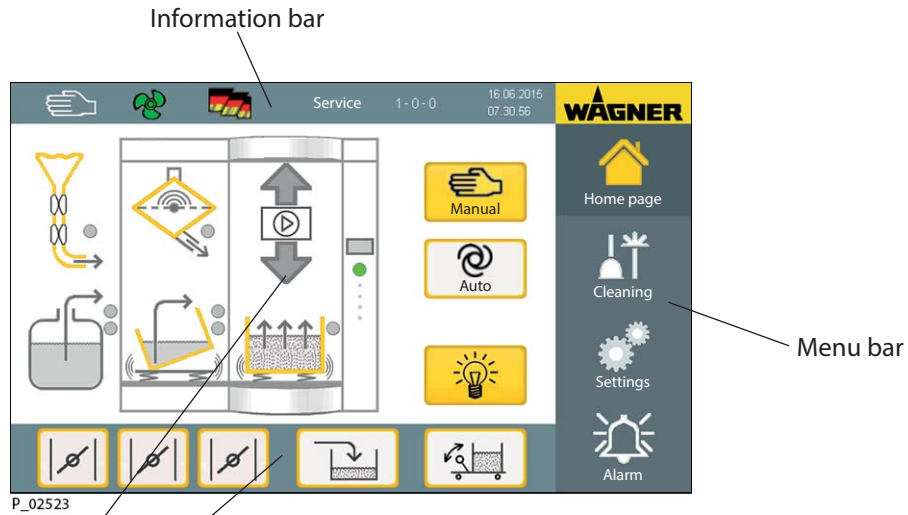
Ambient conditions:	
Operating temperature range	5 – 45 °C; 41 – 113 °F

5.6 CONTROLS



- 1 Touch screen for operating the PXM
- 2 Fault display: Lights up red when the emergency stop chain is interrupted
Button to reset the EMERGENCY STOP safety relay
- 3 EMERGENCY STOP switch
- 4 Safety button for two-hand control function
- 5 Pressure gauge for fluid air
- 6 Fluid air regulator

5.7 SCREEN LAYOUT OF THE TOUCH SCREEN



Function graphic

Function bar 1



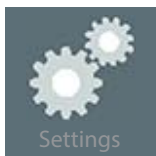
P_02591

Released functions and components are marked by a yellow frame.



P_02592

Activated functions and components are depicted by yellow highlighted icons or buttons.



P_02593

Non-activatable functions are depicted by a gray font for each function button and a gray frame.

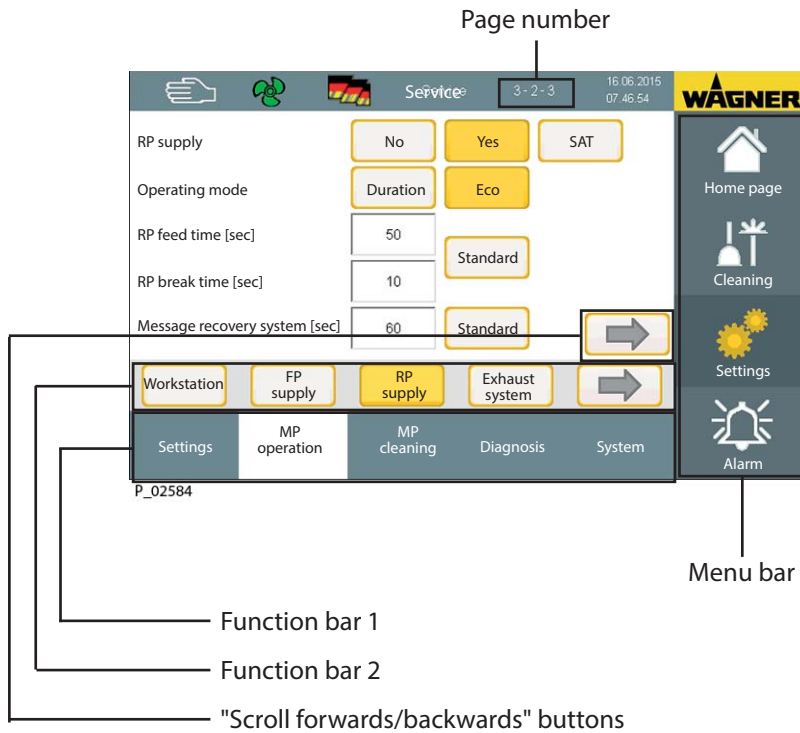
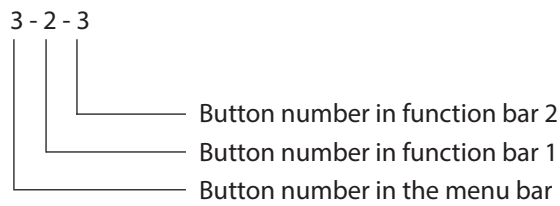
Tap on the respective component/function on the touch screen to switch things on and off.

The status of the individual components is depicted on the screen by different colors of the points on the respective components:

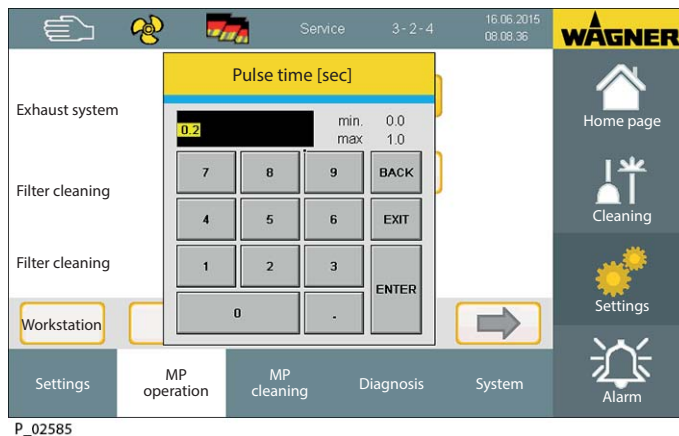
Status Display	Description
Gray	Not active
Green	Ready
Flashes yellow	Warning
Lights up yellow	During fresh powder feed in automatic mode: The fresh powder conveyor is ready to feed powder, but enough powder is available
Flashes red	Malfunction

5.8 EXPLANATION OF THE SCREEN PAGE NUMBERS

The screen pages are numbered from top to bottom (1-4) in the menu bar and from left to right (1-5) in the function bar.



5.9 INPUTS ON THE TOUCH PANEL



To modify number values, touch the value that is to be modified and the keypad shown above appears.

The minimum and maximum setting values are displayed on the right; lower or higher values are not applied.

Button assignment:

- BACK Cancel: the entered value is not applied.
- EXIT The input field is left without applying the set value.
- ENTER The entered value is applied.

5.10 DISPLAYS ON THE WARNING LAMP



illuminated Display	Description
Green	Powder center ok → No malfunction – Exhaust air OK – Ventilator is running
Flashes red briefly	Warning
Flashes red at regular intervals	Malfunction
Blue	Cleaning is active
Alarm horn sounds	Malfunction

5.11 USER RIGHTS

Main menu	Sub-menu	Function	Worker	Supervisor	Service	Facility	
Home page			X	X	X	X	
Cleaning			X	X	X	X	
Settings	Settings	Workstation	X	X	X	X	
		Powder supply	X	X	X	X	
		US Sieve	X	X	X	X	
		Test				X	
	MP operation	Workstation			X	X	X
		FP supply			X	X	X
		RP supply			X	X	X
		Exhaust system			X	X	X
		US Sieve			X	X	X
		Hardware			X	X	X
	MP cleaning	Interface			X	X	X
		Injectors			X	X	X
		FP supply			X	X	X
		RP supply			X	X	X
		US Sieve			X	X	X
	Diagnosis	LogView				X	X
		Diagnosis				X	X
		Maintenance				X	X
	System	Password			X	X	X
		Data backup			X	X	X
Backup				X	X	X	
IP setting					X	X	
Exit visualization software					X	X	
Alarm	Current	View	X	X	X	X	
		Confirm	X	X	X	X	
	History	View	X	X	X	X	
		Save as *.csv			X	X	X
		Save as *.xml			X	X	X
		Delete					X

6 ASSEMBLY AND COMMISSIONING

6.1 TRAINING THE ASSEMBLY STAFF

	 WARNING
	<p>Incorrect installation/operation! Risk of injury and damage to the device.</p> <ul style="list-style-type: none"> → The assembly and commissioning staff must have the technical skills to safely commission the device. → When assembling, commissioning and performing all work, please read and observe the operating manual and safety regulations of the additionally required system components.

A skilled person must check to ensure that the device is in a reliable state after it is installed and commissioned.

6.2 STORAGE CONDITIONS

Until the point of assembly, the powder center must be stored in a dry location, free from vibrations and with a minimum of dust. The powder center must be stored in closed rooms. The air temperature at the storage location must be between +10 °C and +20 °C (+50 °F and +68 °F).

The relative air humidity at the storage location must be between 20 and 70% (without condensation).

6.3 INSTALLATION CONDITIONS

The air temperature at the installation site must lie between +10 °C and +30 °C (+50 °F and +86 °F).

The relative air humidity at the installation site must be between 20 and 70% (without condensation).

6.4 TRANSPORTATION

	WARNING
	<p>Parts have high weights and centers of gravity! Risk of injury and damage to the device.</p> <ul style="list-style-type: none"> → Only use appropriate lifting tackle (crane, fork lift) for assembly. → Secure the parts against tipping during transport. → Cordon off assembly area to keep out unauthorized persons.

The powder center is delivered completely mounted to the site of installation. This may be supplied separately for a version with its own filter suction. Final assembly is performed on-site.

Transportation and warehouse operations may only be performed by qualified personnel, especially in the use of industrial trucks, ladders and cranes.

The selected means of transport must be suitable and permissible for the respective component weights.

For the insertion of parts at the installation site, an opening width of at least 2,000 mm (6.56 ft.) must exist, and an opening height of 2,000 mm (6.56 ft.). The PXM powder center is delivered upright.



P_02571

Support with wooden beams on the truck



P_02572

Loading/unloading with forklift



P_02573



Transport in the factory workshop



P_02574

Support with wooden beams on the filter module

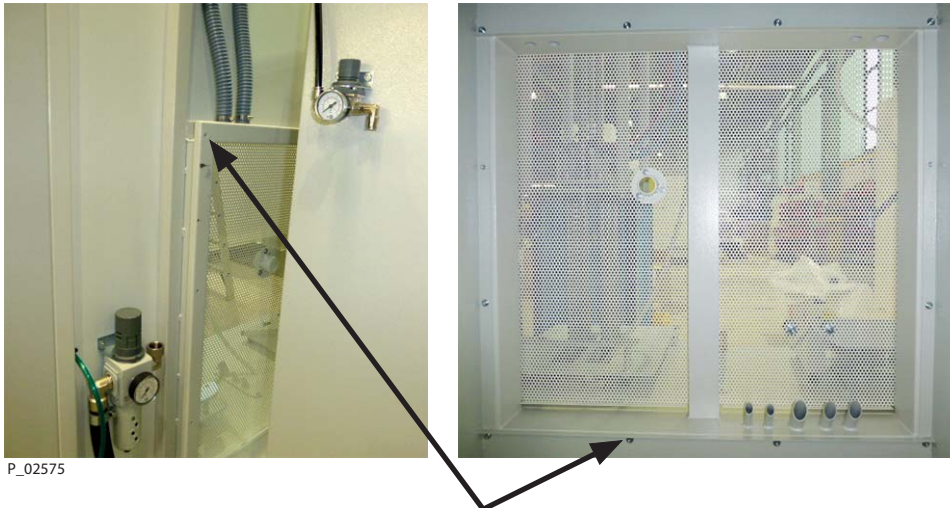
6.5 ASSEMBLY AND INSTALLATION

	 WARNING
	<p>Danger from electric current! Risk of injury and damage to the device.</p> <p>→ Before connecting the device, ensure that the external controller is switched off and the EMERGENCY STOP button is actuated.</p>

The device may only be put into operation if it complies with the essential requirements of Directive 2006/42/EC after installation.

The requirements of the relevant paragraphs must be met in particular:

- 1.1.4 Illumination
- 1.2.4.1 Normal shutdown
- 1.2.4.3 Emergency shutdown
- 1.2.4.4 Assemblies of machinery
- 1.2.5 Selecting the control or operating modes
- 1.2.6 Power supply malfunction
- 1.3.7 Risks from moving parts
- 1.3.8 Selection of protective equipment against risks from moving parts
- 1.5.6 Fire
- 1.5.16 Lightning
- 1.7.1.2 Warning devices



P_02575

1. Fasten filter module (if available) to the powder center housing. It is fastened with 12 screws from the back; two screws must have contact disks for proper grounding.



P_02576

2. Connect the compressed air supply to the air connection point (air connection point 1"; supply at least 1.5"; pressure regulator setting 6 bar).
3. Introduce the electrical cables from the top or from the back and connect these to the main terminal.

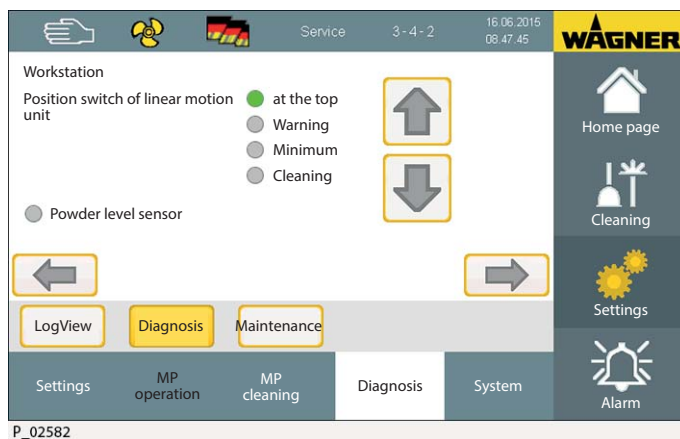


P_02577



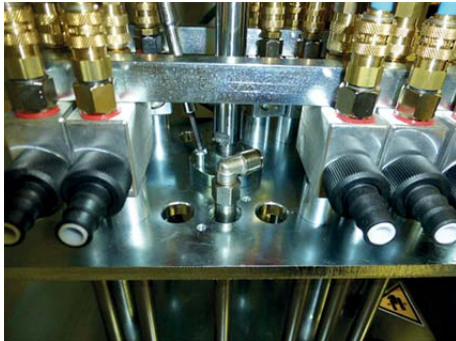
P_02578

4. Erect the piston cylinder and guide the piston through the roof.
The limit switches must be located on the left side (seen from the front).
5. Use 4 screws to fasten piston cylinder onto the roof.



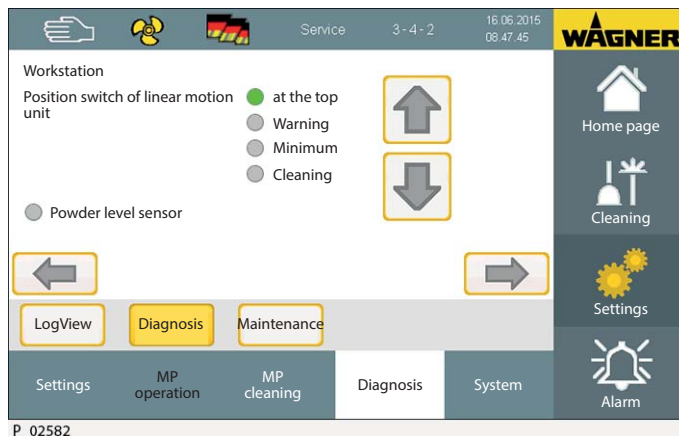
P_02582

6. Connect the compressed air and power supply.
7. Move the cylinder downwards via the touch screen (diagnostic page) and screw into place.



P_02581

8. Align the flange by hand and use 3 screws to fasten onto the injector retaining plate.



P_02582

9. Move the piston cylinder via the diagnostic side to adjust the limit switches.



P_02622

- Limit switch 1: Top = Cylinder moved all the way up.
Setting: Uppermost cylinder position
- Limit switch 2: Warning = Advance warning that the powder level will be reached soon.
Setting: 2 cm above limit switch 3
- Limit switch 3: Minimum = Powder level minimum; cylinder does not move further downwards.
Setting: Fluid tubes 1 cm from the fluid floor of the tank; use tank Order No. 3304505.
- Limit switch 4: Cleaning = Intake tubes dip into blowout nozzles.
Setting: Intake tube 1 cm in blowout nozzle



P_02583

10. Horizontally align the PXM using the leveling feet on the frame.
11. Align the intake tubes so that they meet centrally in the blowout nozzles.
To do this, first align the PXM with the leveling feet.
If necessary, loosen the four screws from the mounting plate of the blowout nozzles and bring the nozzles into position.

6.6 GROUNDING

For safety reasons the system must be properly grounded. WAGNER recommends the use of a copper cable of at least 16 mm² with sufficient mechanical resistance for connection to the signal ground.

Good grounding of the work piece is also necessary for optimum powder coating.

A poorly grounded work piece causes:

- dangerous electric charging of the work piece,
- very poor wrap-around,
- uneven coating,
- back spraying to the gun, i.e., contamination

Prerequisites for perfect grounding and coating are:

- Conducting suspension for the work piece that is to be coated.
- Grounding of the powder coating booth, transport and suspension equipment to be provided on site in accordance with the corresponding operating manuals or the definitions laid down by the manufacturer.
- Regular cleaning of hangers from powder residues.
- Grounding resistance for the work piece of a maximum of 1 MΩ (megaohm).
- Grounding cable connected to the controller module or control cabinet.

Sparks between work piece and conveyor hooks (hangers) can occur if hooks or other hanger parts are not completely cleaned! These sparks can cause heavy radio frequency interference.

6.7 SAFETY CHECKS

→ Perform safety checks in accordance with Chapter 8.2.3.

6.8 COMMISSIONING

- The tank mounting and injector mounting plate must be horizontally aligned in all directions.
- The hose for the fluid air must either be connected to the terminal for the box-fluidizing device (floor) or on the powder tank.



P_02589

NOTICE

Positioning of powder tank and tank cover!

Danger of damage to the device.

- Align the powder tank or powder box on the vibrator table so that the suction system can move in and out unimpeded.
- Only insert the cover into the guides and push it back to the limit stop after lowering the suction tubes.
- Remove cover before powering up the intake tubes.

6.9 STANDARD SETTINGS

The most important settings for speedy commissioning of the powder center have already been carried out by the manufacturer.

You can, however, change standard settings to suit your needs. The changes remain saved even if the powder center is switched off with the main switch.

The following standard settings are made in the factory.

6.9.1 MACHINE PARAMETERS OPERATION

Workstation	
Alarm delay powder shortage:	30 sec.
FP supply	
FP station:	1
FP bigbag:	1
Bigbag type:	IP 5000
FP redosing time manual:	30 sec.
FP redosing time automatic:	30 sec.
RP supply	
RP supply:	Yes
Operating mode:	Eco
RP feed time:	50 sec.
RP break time:	10 sec.
Message recovery system:	60 sec.
RP supply:	Cycle 1: 2.5 sec.
	Cycle 2: 0.3 sec.
	Cycle 3: 2.5 sec.
	Cycle 4: 0.3 sec.
US sieve	
US sieve:	No
After-run time if US sieve available:	30 sec.
Dirt discharge:	3 pulses
After-run time before:	12 sec.
Wait time:	10 min.
Pulse time:	1.0 sec.
Break time:	5.0 sec.
Exhaust system	
Exhaust system:	Integrated
Filter cleaning pulse time:	0.2 sec.
Filter cleaning break time:	60 sec.
Final filter, automatic closing:	10 sec.

6.9.2 MACHINE PARAMETER CLEANING

Interface	
Communication with the application controller:	No
Injectors	
Preliminary cleaning Block 1	
Number of pulses:	2
Pulse time:	0.2 secs
Break time:	1 secs
Preliminary cleaning Block 2	
Number of pulses:	2
Pulse time:	0.2 secs
Break time:	1 secs
Cleaning Block 1	
Number of pulses:	8
Pulse time:	0.5 secs
Break time:	2 secs
Cleaning Block 2	
Number of pulses:	8
Pulse time:	0.5 secs
Break time:	2 secs
Dynamics:	Off
FP supply	
Pre-cleaning	
Number of pulses:	2
Pulse time:	0.5 secs
Break time:	2.0 secs
Cleaning	
Pulse time:	1.0 secs
Break time:	2.0 secs
RP supply	
Cleaning	
Number of pulses:	10
Pulse time:	1.0 secs
Break time:	2.0 secs
US sieve	
Pre-cleaning	
Number of pulses:	5
Pulse time:	0.2 secs
Break time:	2.0 secs
Cleaning	
Number of pulses:	5
Pulse time:	0.5 secs
Break time:	2.0 secs

6.9.3 CAN ADDRESSES FOR MCM SYSTEM

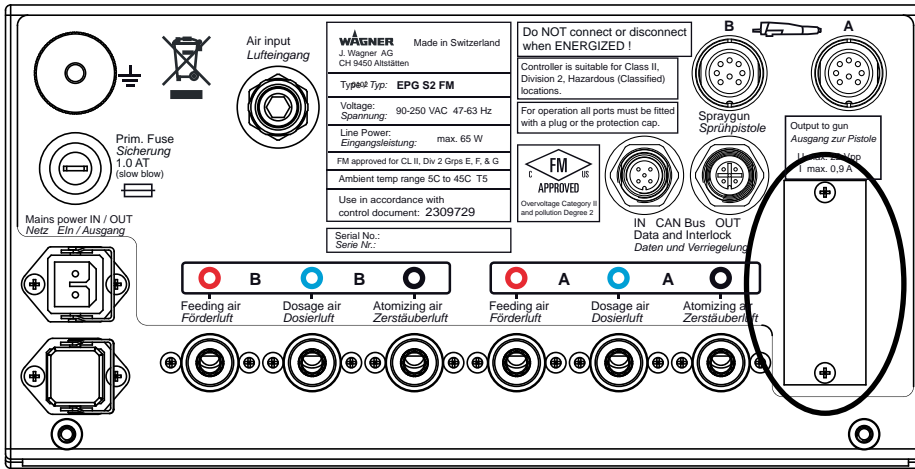
CAN Node	Module Type	Application
0	CAN Diagnosis	Do not use
1	CAN Open Master 1	MCM CAN 1
2	CAN Open Master 2	MCM CAN 2
3	I/O Module	MCM CPS
11	HU1 No. 1	Sliding table 1
12	HU1 No. 2	Sliding table 2
13	HU1 No. 3	Sliding table 3
14	HU1 No. 4	Sliding table 4
21	VU1 No. 1	Reciprocator 1
22	VU1 No. 2	Reciprocator 2
23	VU1 No. 3	Reciprocator 3
24	VU1 No. 4	Reciprocator 4
31	EPG S2 No. 1	Guns 1 and 2
32	EPG S2 No. 2	Guns 3 and 4
33	EPG S2 No. 3	Guns 5 and 6
34	EPG S2 No. 4	Guns 7 and 8
35	EPG S2 No. 5	Guns 9 and 10
36	EPG S2 No. 6	Guns 11 and 12
37	EPG S2 No. 7	Guns 13 and 14
38	EPG S2 No. 8	Guns 15 and 16
39	EPG S2 No. 9	Guns 17 and 18
40	EPG S2 No. 10	Guns 19 and 20
41	EPG S2 No. 11	Guns 21 and 22
42	EPG S2 No. 12	Guns 23 and 24
43	EPG S2 No. 13	Guns 25 and 26
44	EPG S2 No. 14	Guns 27 and 28
45	EPG S2 No. 15	Guns 29 and 30
46	EPG S2 No. 16	Guns 31 and 32
61	Light curtain portal	Kontur 2, with Quattro CAN Open
62	CML 720 light curtain	CML 720i height light curtain
63	CML 720 light curtain	CML 720i depth light curtain, right
64	CML 720 light curtain	CML 720i depth light curtain, left
65	CML 720 light curtain	CML 720i code catching
81	Extension module	for recipe selection (11 bit)
82 ... 127	not defined	free application

OPERATING AND ASSEMBLY MANUAL

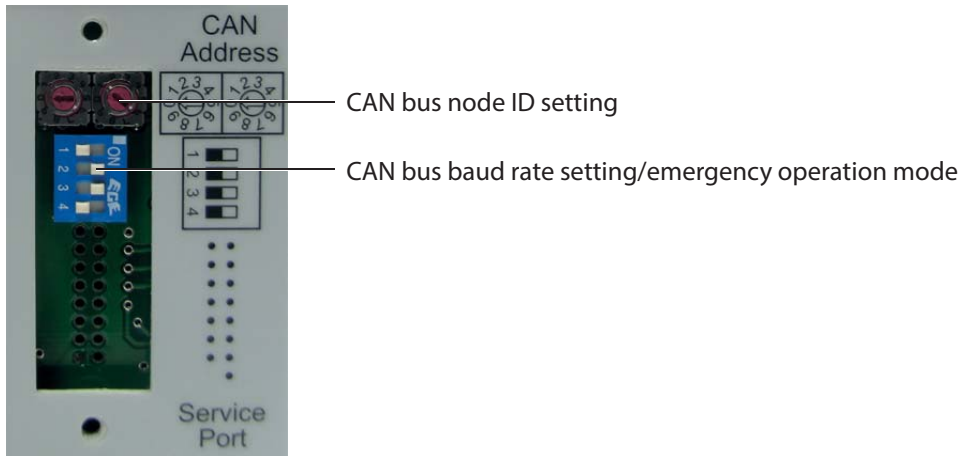


6.9.4 EPG S2 SETTINGS

Normally, these settings have been made prior to shipment. The description is for reference purposes only and when an error message is displayed.



P_02714



OPERATING AND ASSEMBLY MANUAL

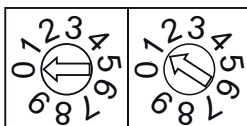


	Switch				CAN baud rate	Maximum cable length
	1	2	3	4		
<p>P_01509</p>	0	0	0	X	1,000 kBit/s	25 m
	0	0	1	X	800 kBit/s	50 m
	0	1	0	X	500 kBit/s	100 m
	0	1	1	X	250 kBit/s	250 m
	1	0	0	X	125 kBit/s	500 m
	1	0	1	X	100 kBit/s	1,000 m
	1	1	0	X	50 kBit/s	1,000 m
	1	1	1	X	20 kBit/s	1,000 m

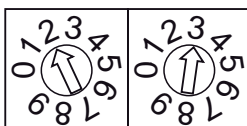
Shown example: Factory setting 250 kBit/s

Setting address of each EPG S2, starting from 31 for the first EPG S2 (from top to bottom)

CAN Node	Module Type	Application
31	EPG S2 No. 1	Guns 1 and 2
32	EPG S2 No. 2	Guns 3 and 4
33	EPG S2 No. 3	Guns 5 and 6
34	EPG S2 No. 4	Guns 7 and 8
35	EPG S2 No. 5	Guns 9 and 10
36	EPG S2 No. 6	Guns 11 and 12
37	EPG S2 No. 7	Guns 13 and 14
38	EPG S2 No. 8	Guns 15 and 16
39	EPG S2 No. 9	Guns 17 and 18
40	EPG S2 No. 10	Guns 19 and 20
41	EPG S2 No. 11	Guns 21 and 22
42	EPG S2 No. 12	Guns 23 and 24
43	EPG S2 No. 13	Guns 25 and 26
44	EPG S2 No. 14	Guns 27 and 28
45	EPG S2 No. 15	Guns 29 and 30
46	EPG S2 No. 16	Guns 31 and 32



Node ID 01 (0/1)



Node ID 23 (2/3)

P_02715



6.10 FUNCTION TEST

The function test is performed after the system has been configured.

- Test all the functions on the touch screen in manual mode
- Test the cleaning process
- Test fluidization
- Test fresh powder pump
- Test automatic operation



7 OPERATION

7.1 TRAINING THE OPERATING STAFF

	 WARNING
	<p>Incorrect operation! Risk of injury and damage to the device.</p> <ul style="list-style-type: none"> → The operating staff must be qualified to operate the entire system. → The operating staff must be familiar with the potential risks associated with improper behavior as well as the necessary protective devices and measures. → Before work commences, the operating staff must receive appropriate system training.

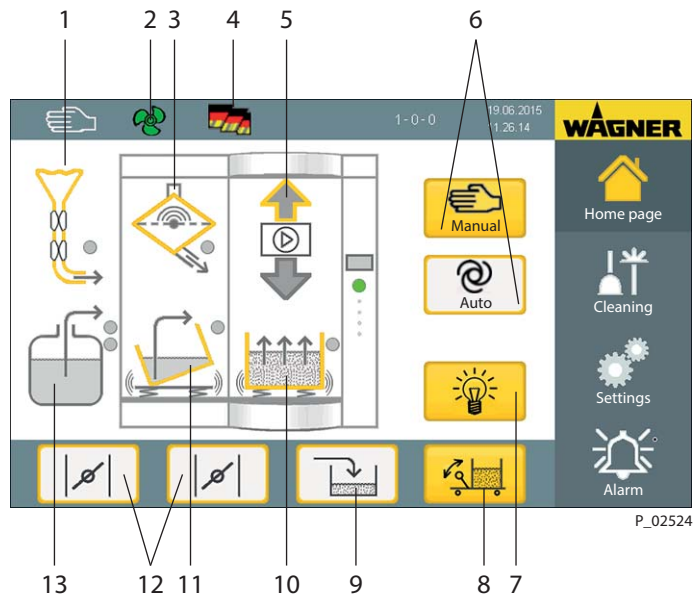
7.2 SAFETY INSTRUCTIONS

→ Observe safety instructions in Chapter 4.

	 WARNING
	<p>Incorrect operation! Risk of injury and damage to the device.</p> <ul style="list-style-type: none"> → Take appropriate precautionary measures, e.g. wear protective clothing, if contact with powder products or cleaning agents causes skin irritation. → The footwear worn by operating staff must comply with EN ISO 20344. The measured insulation resistance must not exceed 100 megohms. → The protective clothing, including gloves, must comply with EN ISO 1149-5. The measured insulation resistance must not exceed 100 megohms.

7.3 TOUCH SCREEN OPERATION STANDARD EQUIPMENT

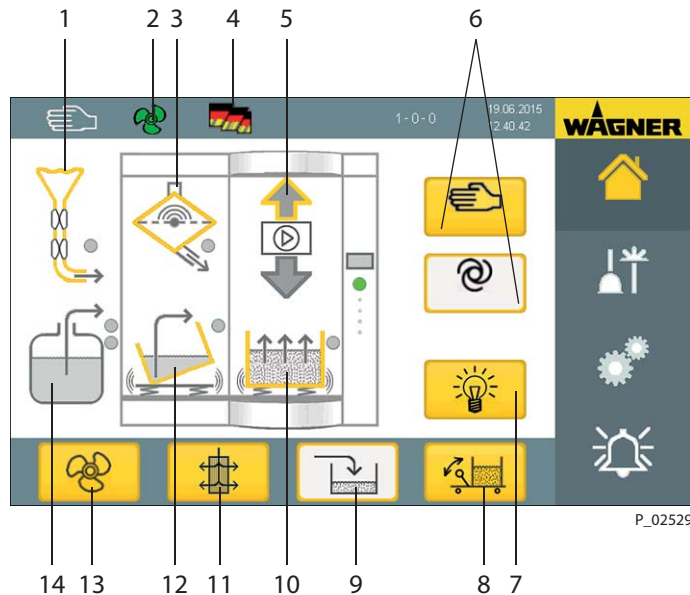
7.3.1 EQUIPMENT WITH FINAL FILTER



- 1 Peristaltic pump On/Off
- 2 Exhaust system status
- 3 Ultrasonic sieve device On/Off
- 4 Language selection
- 5 Reciprocator Up/Down
- 6 Manual/automatic mode
- 7 Illumination On/Off
- 8 Button for clamping the tank (box, powder container)*
- 9 Replenishing fresh powder (manual, time-controlled) On/Off
- 10 Workstation/vibrator fluidization On/Off
- 11 Automatic fresh powder supply On/Off (only in automatic mode)
- 12 Throttle valve Open/Closed
- 13 BigBag fresh powder On/Off, as an alternative to the fresh powder supply from the box

* Additional actuation of the safety switch for two-handed operation below the touch screen required

7.3.2 EQUIPMENT WITH INTEGRATED EXHAUST SYSTEM



- 1 Peristaltic pump On/Off
- 2 Exhaust system status
- 3 Ultrasonic sieve device On/Off
- 4 Language selection
- 5 Reciprocator Up/Down
- 6 Manual/automatic mode
- 7 Illumination On/Off
- 8 Button for clamping the tank (box, powder container)*
- 9 Replenishing fresh powder (manual, time-controlled) On/Off
- 10 Workstation/vibrator fluidization On/Off
- 11 Automatic filter cleaning On/Off
- 12 Automatic fresh powder supply On/Off (only in automatic mode)
- 13 Exhaust system On/Off // Switchover frequency
Press the button briefly: Switch on suction
Press the button briefly when suction is switched on: Switchover frequency ventilator
Press and hold the button: Switch off suction
- 14 Bigbag fresh powder On/Off, as an alternative to the fresh powder supply from the box

* Additional actuation of the safety switch for two-handed operation below the touch screen required

7.4 SET LANGUAGE



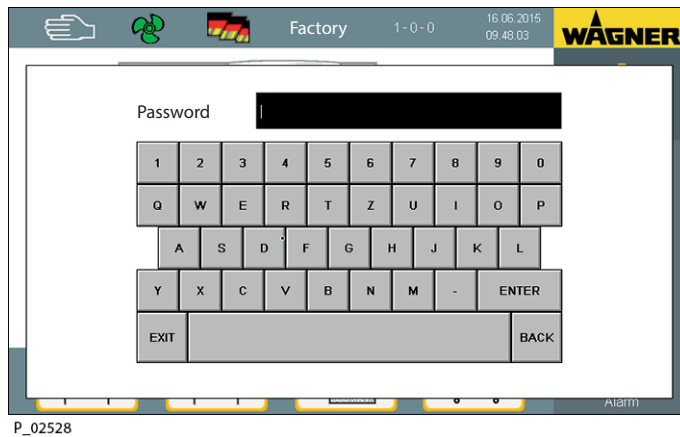
1. Tap "Flag" button in the information bar.
The depicted screen appears.
2. Select the desired language by tapping on the corresponding flag button.
The screen is now displayed in the selected language.

7.5 LOGGING A USER ON/OFF

The currently logged in user is displayed in the information bar, in the example "Factory". Press the button to change the user; the following display appears.



Press the "Log in user" button; the following display appears.



Enter the password for the desired user level and press the "Enter" button. It is switched to the desired user level. Press the "Log off user" button to go back to the lowest level (operator level).

7.6 STARTING/STOPPING COATING

1. Switch the system on.
2. Move the reciprocator all the way to the top (reference).
3. Set the powder tank. For boxes, loosen powder beforehand.
4. When feeding from the powder box: Pull the foil over the box rim until it lies flat on the box walls.
5. Insert fluidization and check pressure (start with 0.5 bar setting).
6. Plug the peristaltic pump tube and fresh powder hose onto the loss position.
7. Select the "Automatic" button; the retractor then moves downwards and determines the powder level.

When using boxes, ensure that the fluid device moves past the foil and does not press it down.

If necessary, retighten the foil.
8. Check fluidization and set if necessary.

When using a fluid tank, the powder should flow like water without generating larger bubbles.

When using powder boxes, the powder should be flowable in the fluid rod area without generating larger bubbles or dust.

Note: An excessive fluid air setting leads to a greater loss of powder.
9. Insert tank cover.
10. Plug the fresh powder hose^{*,**} onto the tank cover.
11. Start coating.
12. First switch off the peristaltic pump on the touch screen according to an arbitrary time, plug the hose ^{*,**} on the tank cover and switch the peristaltic pump on again.
13. For longer breaks and at the end of production, switch to manual mode and move the suction system from the tank to the top in reverse order.

Attention: Remove the cover first.
14. At the end of production, WAGNER recommends you rough clean the system and flush the injectors, powder hoses and guns (via application controller) and perform a normal cleaning for the IP 5000 fresh powder pump.

Move the suction device completely up before turning off the system.

Remove tank or box or close with a dummy cover so that no debris can fall into it.

Note: If the PXM is connected to the final filter, the throttle valves can only be opened if no coating is applied.

* When an automatic fresh powder supply is available

** When using an ultrasonic sieve, plug the fresh powder hose directly onto the connection on the sieve and the peristaltic pump tube on the feedthrough socket on the base plate of the powder center

7.6.1 PAINT CHANGE COMPONENTS



P_02676

5

4

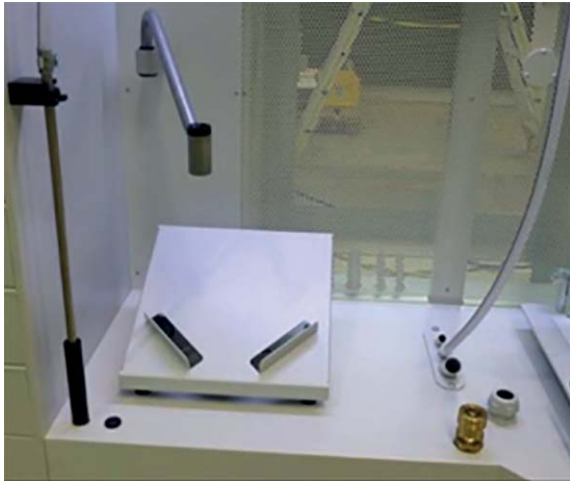
3

2

1

- 1 Blowout nozzles for intake tubes
- 2 Blowout nozzle for the fresh powder hose and peristaltic pump tube
- 3 Parking station peristaltic pump tube during loss operation
- 4 Parking station, fresh powder hose
- 5 Cleaning position, fresh powder lance

7.6.2 CLEANING POSITIONS POWDER HOSES



P_02677

Cleaning fresh powder, standard



P_02679

Loss position, reclaimed powder



P_02678

Cleaning fresh powder, intensive



P_02680

Cleaning, reclaimed powder

7.7 CONFIGURING THE POWDER CENTER

The configuration of the powder center must be adjusted when first commissioning or in special cases.

Configuration is performed in the "Settings" menu item.

Different configuration settings are displayed depending on the user level selected.

Icon explanation:



Button for scrolling to the next screen page



Button for scrolling back to the previous screen page



Number of pulses



Pulse time (duration)



Break time (duration)

P_02621

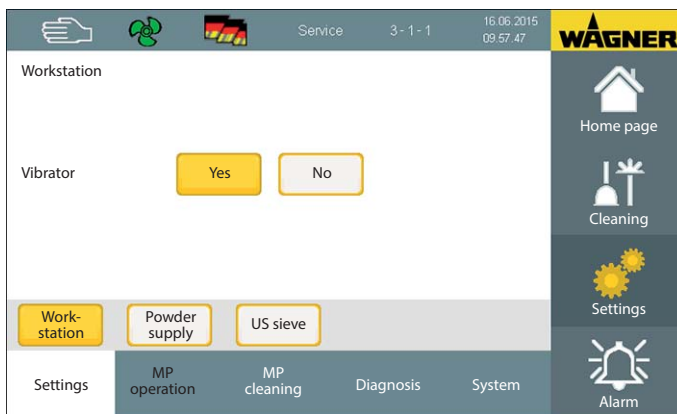
7.7.1 SETTINGS

The settings can be temporarily changed and adapted to the specific work situation.

The maximum configuration is displayed below, i.e. the switches become visible depending on the configuration.

Meaning of a deselection:

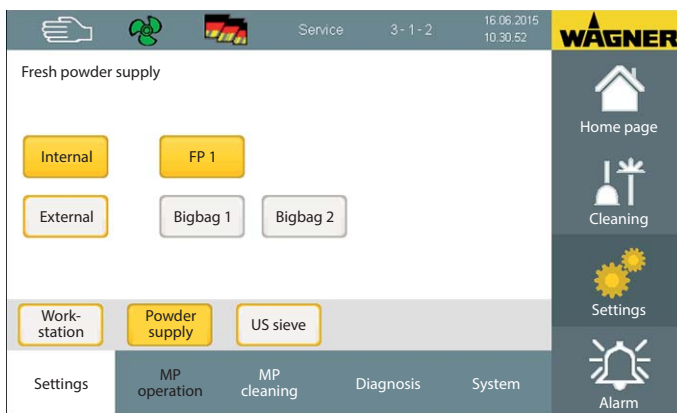
- Icon is nevertheless displayed on the home page (gray)
- Fresh powder feed cannot be switched on (manual mode)
- Deselected components do not work in automatic mode



P_02595

Parameter:
Vibrator

Explanation:
Yes: Vibrator available at the workstation
No: No vibrator available at the workstation



P_02596

Parameter:
FP 1

Explanation:
Fresh powder pump 1 is active (selected)

7.7.2 MACHINE PARAMETERS OPERATION

The settings in the "Operation" machine parameters are normally not changed since they are defined by the installed hardware.



Parameter:

Fault trigger delay powder shortage
 WS cylinder lowering Feeding rate [sec]
 WS cylinder lowering Break time [sec]
 Time setting for level controller [sec]

Explanation:

Delay time after which an error message is triggered in the case of powder shortage
 Period of time in which the workstation cylinder is supplied with compressed air during raising and lowering
 Period of time in which the workstation cylinder is not supplied with compressed air during raising and lowering
 Delay time after which the linear motion unit lowered during a powder shortage and the fresh powder pump is switched on



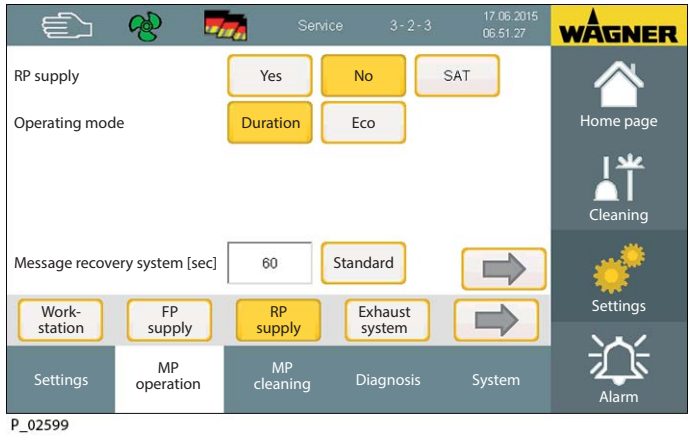
P_02598

Parameter:

Explanation:

FP station	No: No fresh powder pump available 1: A fresh powder pump is available (installed) 2: Two fresh powder pumps are available (installed)
FP Bigbag	No: No fresh powder pump available on the bigbag 1: An external fresh powder pump is available (installed) 2: Two external fresh powder pumps are available (installed)
Bigbag type	
FP redosing time man. [sec]	Redosing time of the fresh powder pump in manual mode
FP redosing time auto [sec]	Redosing time of the fresh powder pump in automatic mode

If the "FP bigbag" parameter is set to 1 or 2, then the "Bigbag type" parameter is displayed.



Parameter:

RP supply

Explanation:

Yes: Reclaimed powder pump available
 No: No reclaimed powder pump available
 SAT: Specific configuration for the SAT system

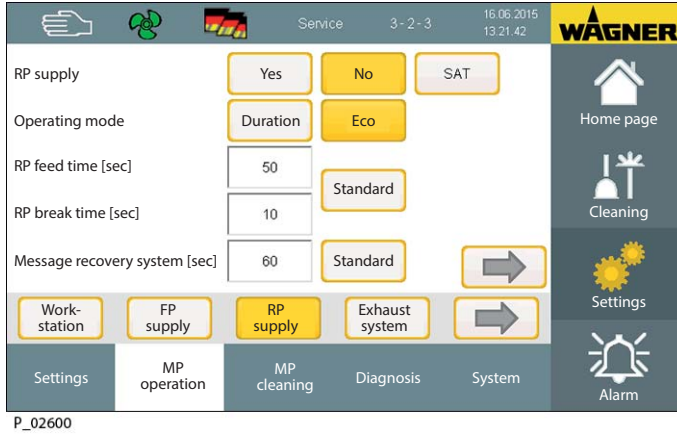
Operating mode

Duration: Peristaltic pump operates continuously
 Eco: Peristaltic pump works per cycle, that is, it works during the "Feed time" adjustable time and subsequently switches off for the "Break time" adjustable time (power saving mode)

Message recovery system [sec]

A timer runs at the specified time after the initial feed after cleaning. After this time expires, a note is displayed on the screen to plug the recovery hose from the loss position to the recovery position.

OPERATING AND ASSEMBLY MANUAL



Parameter:
RP supply

Explanation:
Yes: Reclaimed powder pump available
No: No reclaimed powder pump available
SAT: Specific configuration for the SAT system

Operating mode

Duration: Peristaltic pump operates continuously
Eco: Peristaltic pump works per cycle, that is, it works during the "Feed time" adjustable time and subsequently switches off for the "Break time" adjustable time (power saving mode)

RP feed time [sec]

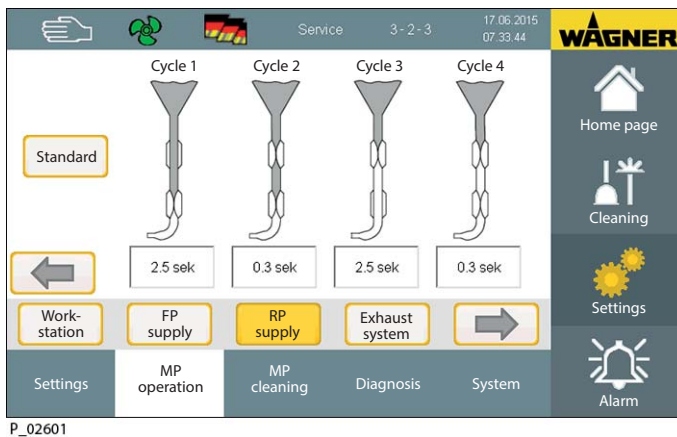
Period in which the reclaimed powder pump is running

RP break time [sec]

Time in which the reclaimed powder pump is at a standstill

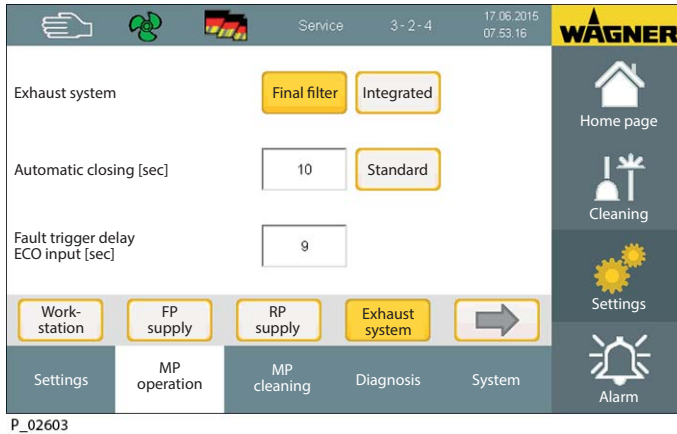
Message recovery system [sec]

A timer runs at the specified time after the initial feed after cleaning. After this time expires, a note is displayed on the screen to plug the recovery hose from the loss position to the recovery position.



Parameter:
Cycle 1 – 4

Explanation:
Duration of the cycle 1 - 4



P_02603

Parameter:

Exhaust system

Explanation:

Final filter: Final filter available

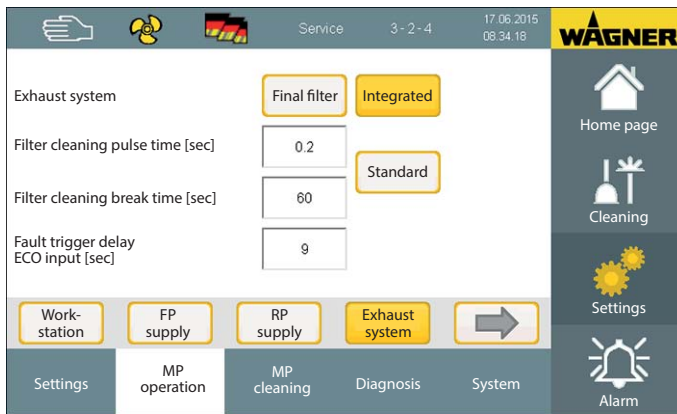
Integrated: Filter module available

Automatic closing [sec]

Time in which the throttle valves are automatically closed after the time expires

Fault trigger delay

ECO input [sec]



P_02604

Parameter:

Exhaust system

Explanation:

Final filter: Final filter available

Integrated: Filter module available

Filter cleaning pulse time [sec]

Duration of the cleaning pulses

Filter cleaning break time [sec]

Time in which no filter cleaning takes place

Fault trigger delay

ECO input [sec]

OPERATING AND ASSEMBLY MANUAL



P_02602

Parameter:
US Sieve

Explanation:

Yes: Ultrasonic screening device available
No: No ultrasonic screening device available

After-run time [sec]

Sieve continues to run during each switch-off power signal so that no residual powder remains on the fabric (damage while blowing out!)

Dirt discharge

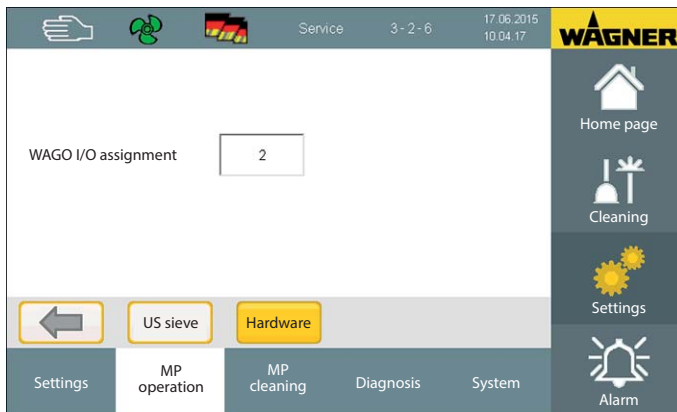
Number of suction cycles with pulse and break time

After-run time before [sec]

Before activating the dirt discharge, the screen continues running in order to sieve remnants of powder on the fabric (reduction of powder loss)

Wait time [sec]

Interval for debris discharge cycle



P_02695

Parameter:
WAGO I/O assignment

Explanation:

This parameter is used to parameterize the various configurations of the powder center. Each configuration has a different CAN node ID.

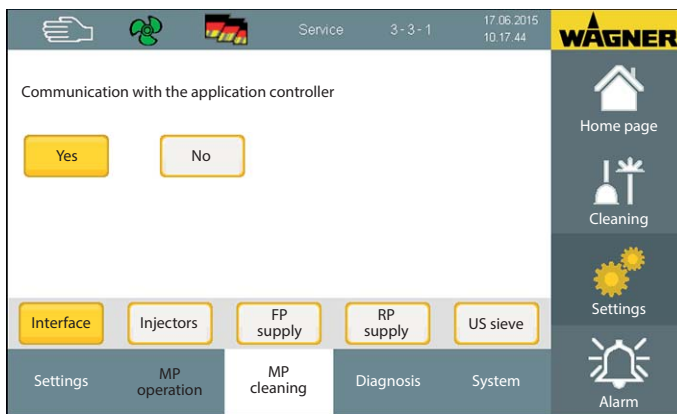
- 1: PXM without bigbag/node ID = 5
- 2: PXM with bigbag/node ID = 6
- 3: PXM with 34 injectors/node ID = 7



P_02716

7.7.3 MACHINE PARAMETER CLEANING

The settings in the "Cleaning" machine parameters can be optimized for customer-specific requirements.



P_02605

Parameter:

Communication with the application controller

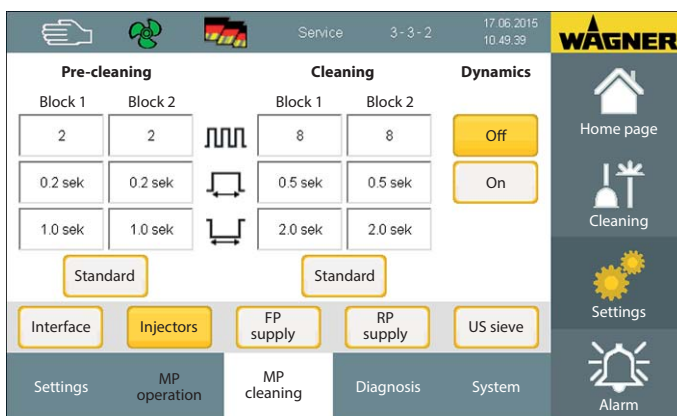
Explanation:

Yes: The powder center controller communicates with the application controller

In doing so, the following information is exchanged in conjunction with MCC, ProfiTech M or S ProfiTech:

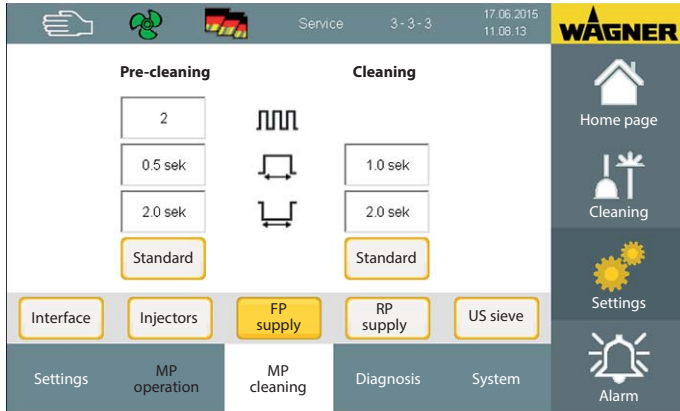
- Move the guns to the cleaning position for internal cleaning
- Switch on the gun air during internal cleaning
- Switch off the gun air after internal cleaning finishes

No: The powder center controller does not communicate with the application controller

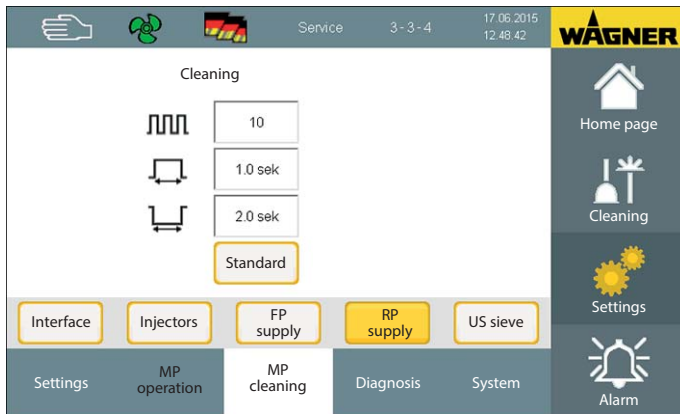


P_02606

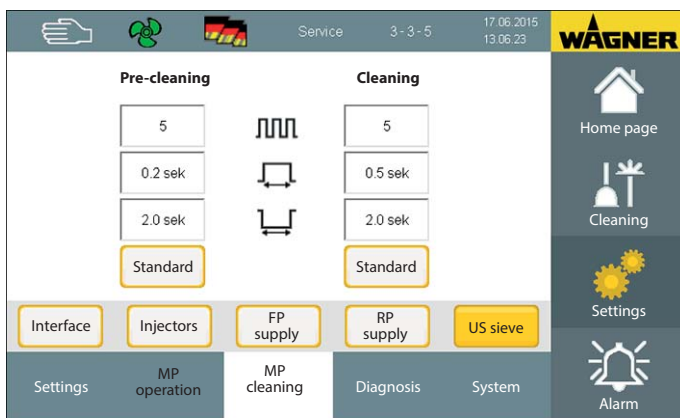
OPERATING AND ASSEMBLY MANUAL



P_02607

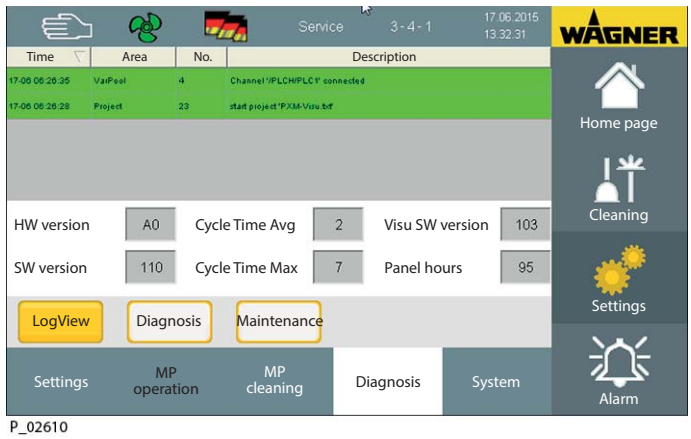


P_02608

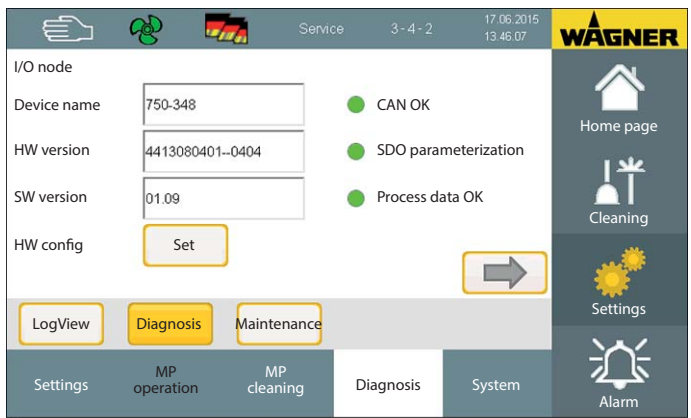


P_02609

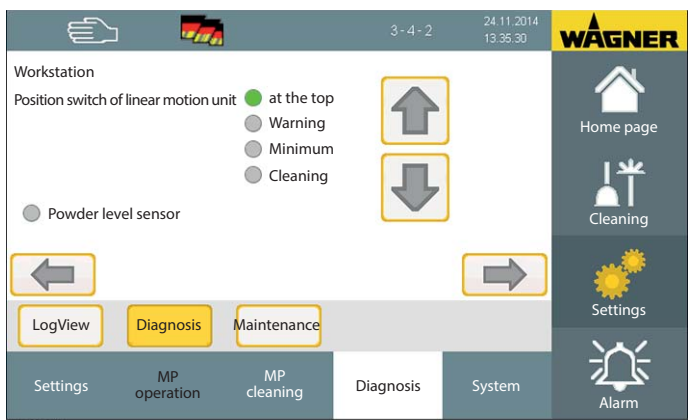
7.7.4 MACHINE PARAMETERS DIAGNOSIS



P_02610



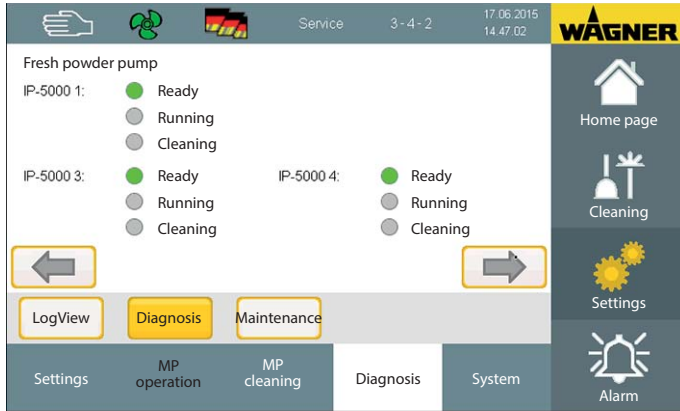
P_02611



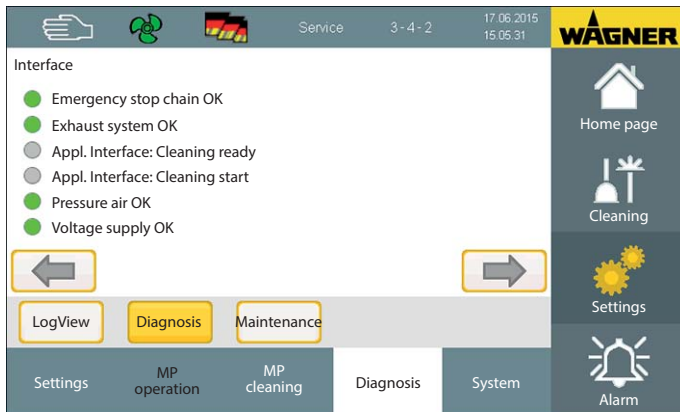
P_02612

This side is very helpful for adjusting the position switch on the reciprocators and for testing the function of the level probe.

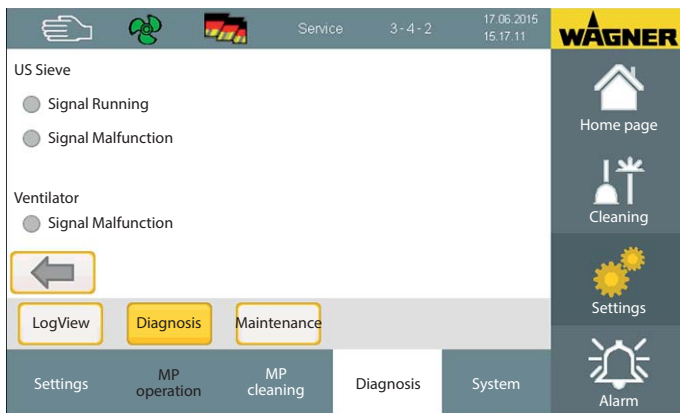
OPERATING AND ASSEMBLY MANUAL



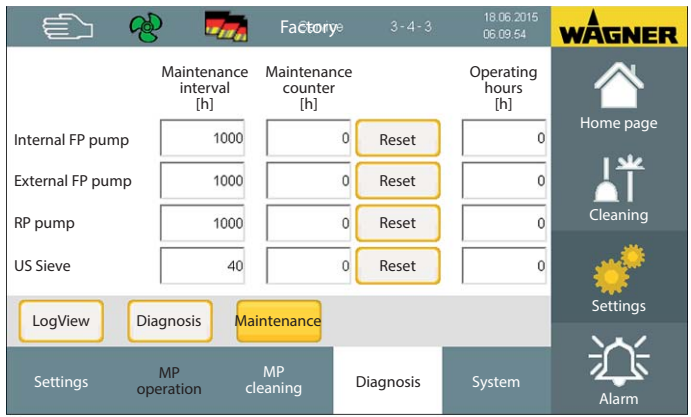
P_02613



P_02614

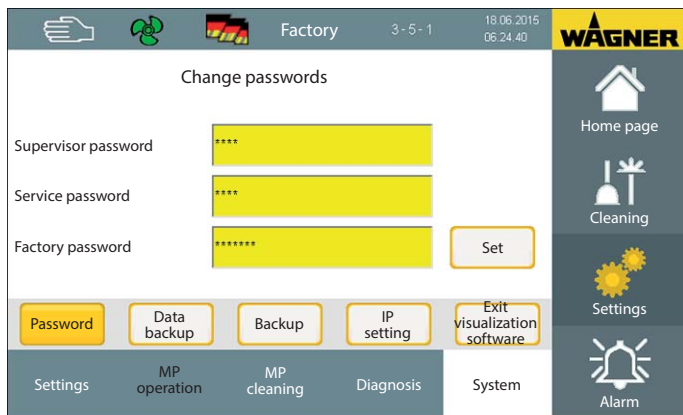


P_02615



P_02616

7.7.5 SYSTEM



P_02617

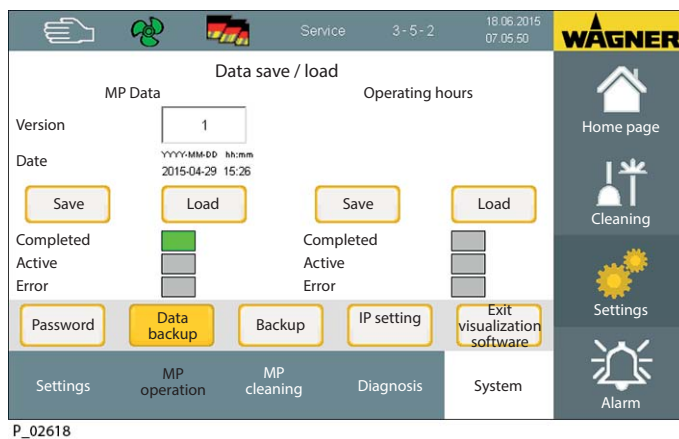
1. Press the "Settings" button in the right-hand menu bar to call up the page.
2. Press the "System" button to call up the page
3. The "Change passwords" page is displayed.
4. Only the password for the current level can be changed.
To change a password for another level, the level in question must first be activated.

OPERATING AND ASSEMBLY MANUAL

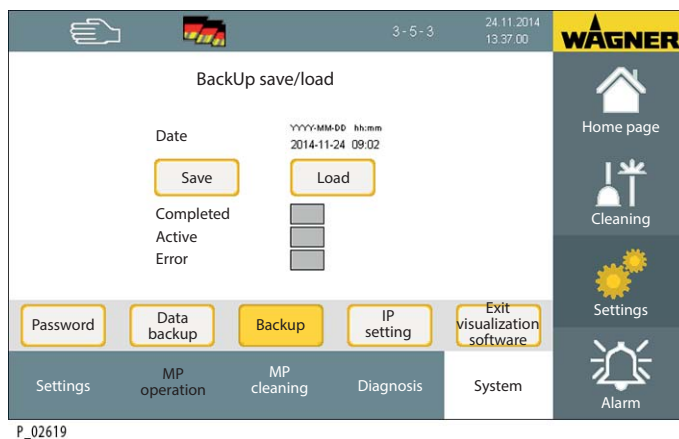


Various functions can be called up on the following pages:

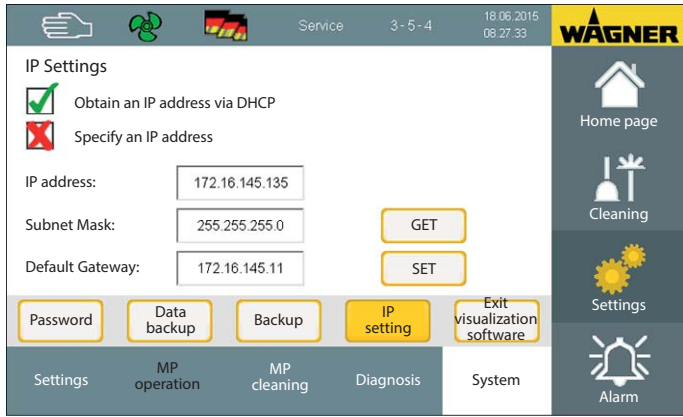
- Backing up and rebooting data
- Creating and booting a backup
- Adapting the IP settings



Data backup is a mechanism for the service technician to, for example, secure the set machine parameters after commissioning. This mechanism is also required during a software update.



The backup is created automatically by the system after 24 hours of operation. Only one file is available, which is always overwritten. Manually save by pressing the "Save" button. The time of storage is displayed by pressing the "Load" button.



P_02620

8 CLEANING AND MAINTENANCE

8.1 CLEANING



8.1.1 CLEANING STAFF



Cleaning work should be undertaken regularly and carefully by qualified and trained staff. They should be informed of specific hazards during their training.

The following hazards may arise during cleaning work:

- Health hazard from inhaling powder lacquer
- Use of unsuitable cleaning tools and aids

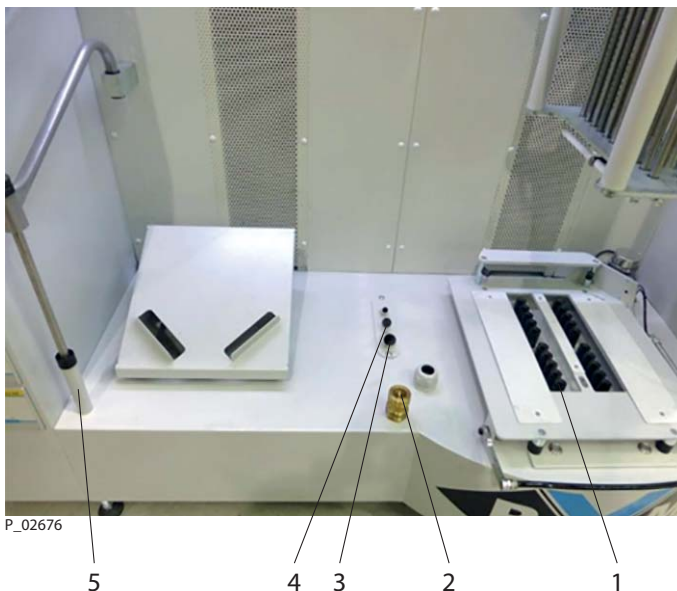
8.1.2 SAFETY INSTRUCTIONS

	 <b style="font-size: 1.2em; margin-left: 10px;">DANGER
	<p>Explosive powder/air mixes! Danger to life and equipment damage.</p> <ul style="list-style-type: none"> → Before starting cleaning or other manual work, the high-voltage must be shut down and locked to prevent it from being switched back on! → The spray gun must be separated from the high-voltage supply before any cleaning work is started! → Use only electrically conductive tanks for cleaning liquids! Ground the tank! → Preference should be given to non-flammable cleaning fluids. → Flammable cleaning liquids may only be used if, after switching off the high-voltage, all high-voltage conducting parts are discharged to a discharge energy of less than 0.24 mJ before they can be accessed. Most flammable solvents have an ignition energy of around 0.24 mJ or 60 nC. → The cleaning agent's flash point must be at least 15 K above the ambient temperature. → Only mobile industrial vacuum cleaners of design 1 (see EN 60335-2) may be used to remove dust deposits.

	 DANGER
	<p>Incorrect maintenance/repair! Danger to life and equipment damage.</p> <p>→ Only specialist staff or WAGNER Service may carry out maintenance and repair work.</p> <p>→ Before starting work switch off the system and lock to ensure that other people cannot switch it back on by mistake (lock main switch on the controller).</p> <p>→ Ensure that all system components are grounded properly.</p>

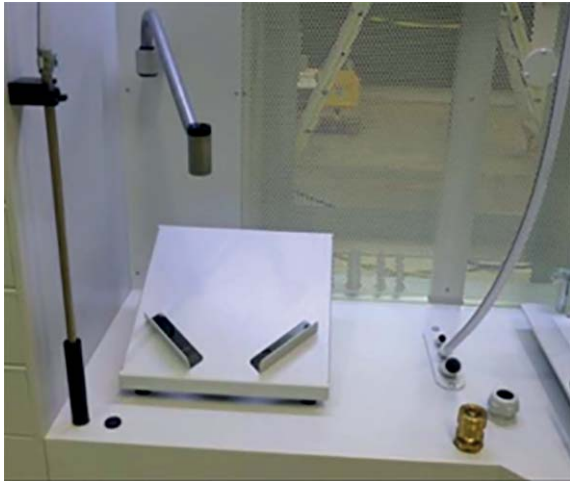
8.2 PAINT CHANGE

8.2.1 PAINT CHANGE COMPONENTS



- 1 Blowout nozzles for intake tubes
- 2 Blowout nozzle for the fresh powder hose and peristaltic pump tube
- 3 Parking station peristaltic pump tube during loss operation
- 4 Parking station, fresh powder hose
- 5 Cleaning position, fresh powder lance

8.2.2 CLEANING POSITIONS POWDER HOSES



P_02677

Cleaning fresh powder, standard



P_02679

Loss position, reclaimed powder



P_02678

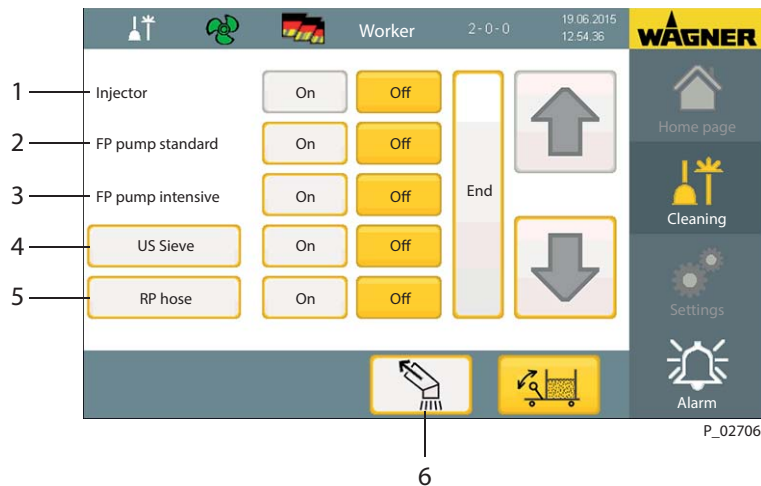
Cleaning fresh powder, intensive



P_02680

Cleaning, reclaimed powder

8.2.3 CLEANING FUNCTIONS



- 1 Perform impulse flushing of the injectors
 - Interlock with guns in blowout positions (height and depth) for ProfiTech controllers
- 2 Clean the IP 5000 with internal cleaning program and/or preliminary clean US sieve
- 3 Perform pulse flushing of the IP 5000 via the blowout device
- 4 Perform main cleaning of the US sieve via the blowout device
- 5 Perform pulse cleaning of the peristaltic pump via blowout device
- 6 Activate suction gun (pinch valve is opened); only in conjunction with US sieve

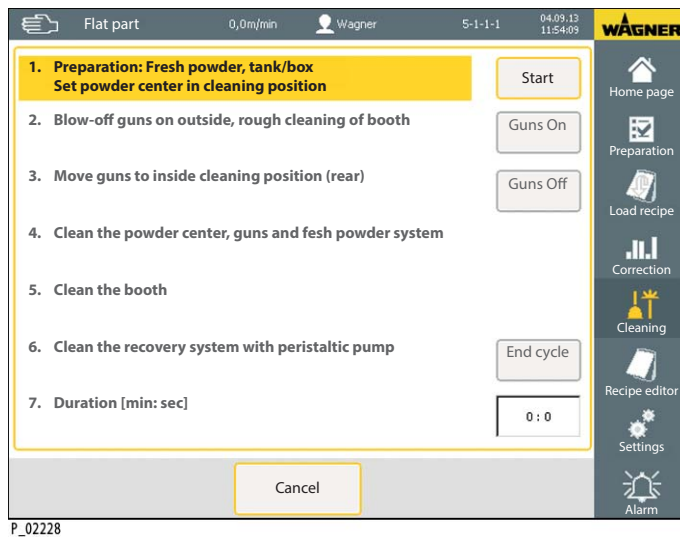
8.2.4 CLEANING PARAMETERS

- Operate the IP 5000 fresh powder pump in accordance with the IP 5000 operating manual and "Clean fresh powder (FP)" machine parameter; see Chapter 7.7.3
- Perform impulse flushing of the injectors; see "Clean injectors" machine parameter; see Chapter 7.7.3
- Perform impulse flushing of the ultrasonic sieve; see "Clean sieve" machine parameter; see Chapter 7.7.3
- Perform impulse flushing of the peristaltic pump; see "Clean reclaimed powder (RP)" machine parameter; see Chapter 7.7.3

8.2.5 START CLEANING (EXAMPLE: PROFITECH M)

Notes for the paint change sequence:

- The depicted paint change sequence represents the general principle and the procedure for a complete paint change.
- Detailed steps must be individually adapted and optimized.
- A possible signal exchange between the application controller and the powder center for greater automation of the paint change sequence depends on the type of application controller used.
- The required intensity of the individual paint change steps and the possible repetition of individual steps depends on the desired paint change intensity and how the powder behaves.
- If the PXM is connected to a final filter, then the PXM throttle valves cannot be opened when powder is introduced into the booth.
Otherwise, paint carryover may result from powder deposits in the booth/tubing.
- It is generally recommended to run on loss for some time (e.g. 1 minute) after a paint change and then switch to recovery.
- When using powders with high amounts of pigment and wax, further measures may be required, which must be specified individually.
WAGNER cannot make a forecast in this regard.



1. Before the start of cleaning on the powder center, the application controller must be switched over to manual or cleaning mode and paint change started there. Paint change duration is measured from this time.



2. Call up the "Cleaning" menu by pressing the "Cleaning" button in the right menu bar.
3. Call up the cleaning page by pressing the "Cleaning" button.



P_02531

4. Remove the cover from the box or tank.

Injector blowing out can only be started when the enabling signal from the application controller is cleared (if the signal exchange was activated in the configuration (ProfiTech M, ProfiTech S)).



P_02532

5. Boot the workstation by pressing the "Up arrow" button.
6. Remove the box from the box receptacle.
7. Move the injector device downwards by pressing the "Down arrow" button on the blowout nozzles.
To do this, simultaneously press the safety switch for two-handed operation.
The "Blow out injector On" button is outlined in yellow.
8. Start injector cleaning by pressing the "Blow out injector On" button.
The subsequent cleaning procedure depends on whether or not the powder center communicates with the application controller.
Both versions are described below.

Without Communication with the Application Controller:

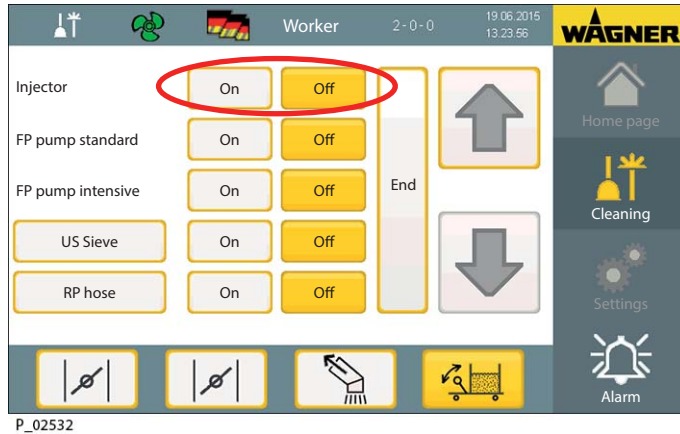
PXM:	Pressing the "OK" button is used directly as the start command for the sequence of cleaning steps. No query is made on whether or not the pulses should begin.
Application:	<p>The application controller must be prepared before the start of the cleaning step:</p> <ul style="list-style-type: none"> ● Bring the guns to the internal cleaning position (reciprocators and sliding tables) ● Switch on reverse air for injectors via dosing and feed air <p>Example, ProfiTech M:</p> <div style="display: flex; align-items: center;"> <div style="background-color: yellow; padding: 2px; margin-right: 10px;">3. Move guns to inside cleaning position (rear)</div> <div style="border: 1px solid gray; padding: 2px 10px;">Guns On</div> </div>
PXM:	<p>Injector cleaning (pulses)</p> <ol style="list-style-type: none"> 1. An injector series is flushed first and subsequently the other injector series. <p>Pre-flushing can be set (gentler with short pulses).</p>
Application:	<p>Subsequently, if necessary, when controlling the application:</p> <ul style="list-style-type: none"> ● Switch off reverse air for injectors via dosing and feed air <p>Example, ProfiTech M:</p> <div style="display: flex; align-items: center;"> <div style="background-color: yellow; padding: 2px; margin-right: 10px;">3. Clean the powder center, guns and fresh powder system</div> <div style="border: 1px solid gray; padding: 2px 10px;">Guns Off</div> </div>

With Communication with the Application Controller:

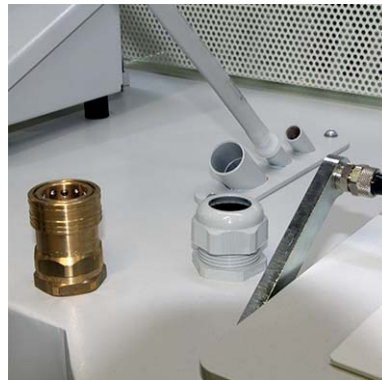
Note:

All steps are carried out without operator intervention.

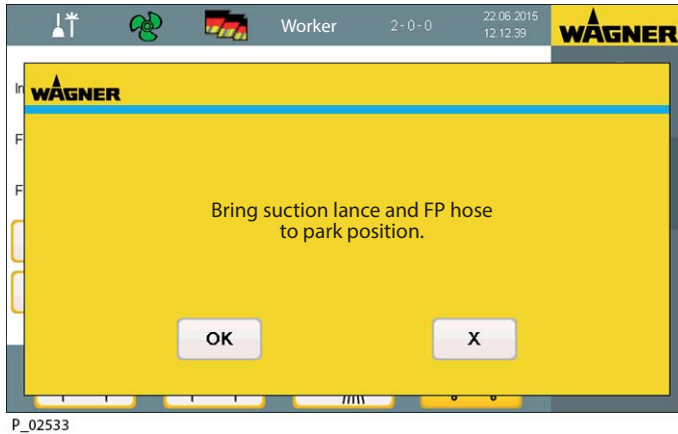
PXM	Exam., MCM
PXM output: "Blow out injectors active" (terminal X2:15) is set to "HIGH".	<p>The powder center sets the "Request PC cleaning" MCM input (terminal X20:13) to "HIGH".</p> <p>It is advanced by one cleaning step.</p> <p>The MCM performs pre-flushing (feed and dosing air of the injector are controlled by pulses).</p> <p>The duration can be configured in the machine parameters.</p> <p>The motion technology is also moved to the cleaning position.</p> <p>The MCM subsequently switches on the reverse air for internal cleaning (feed and dosing air).</p> <p>The MCM sets the "PC cleaning ready" output (terminal X20:15) to "HIGH".</p>
<p>After the "PC cleaning ready" signal comes from the application controller, the PXM performs injector cleaning.</p> <p>PXM input: "Release blow out injectors" (terminal X2:19).</p>	
<p>Performing injector cleaning:</p> <p>An injector series is flushed first and subsequently the other injector series.</p> <p>Pre-flushing can be set (gentler with short pulses).</p>	
<p>PXM output: "Blow out injectors active" (terminal X2:15) is set to "LOW".</p> <p>The PXM signals the end of internal cleaning.</p>	<p>The powder center brings the "Request PC cleaning" MCM input (terminal X20:13) to "LOW".</p>
	<p>The reverse air for internal cleaning (feed and dosing air) are switched off.</p>
	<p>The MCM carries out part 2 of exterior cleaning.</p>



9. The end of injector cleaning is displayed by a white "Blow out injector On" button and a yellow "Blow out injector Off" button.
10. Clean the ultrasonic sieve if necessary.



11. Clean the IP 5000 fresh powder pump.
There is the possibility of normal cleaning here (during tone-in-tone paint changes) or intensive cleaning.
Note: When connecting the PXM to a final filter, no powder may be whirled/blown off in the booth during this time.
12. "Standard" cleaning sequence: Put suction lance in the park position (depicted left) and snap into the clamp.
13. Plug the feed hose in the park position (pictured right).
14. Press "FP pump Standard On" button; the pump's own cleaning program is running.



P_02533

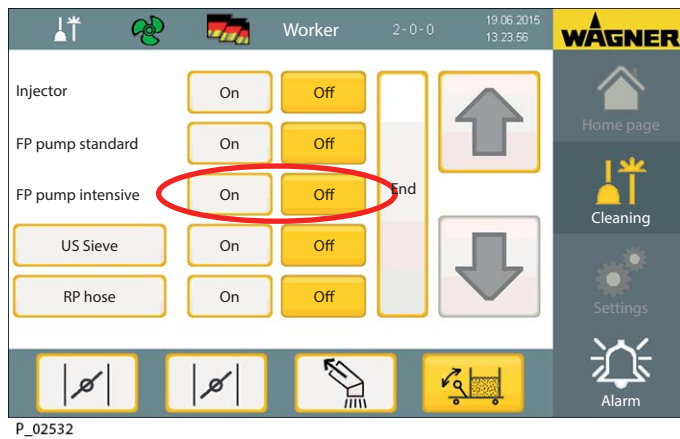
15. A confirmation message appears.
16. "FP-intensive" cleaning sequence: put suction lance, as in workstep 13, in the cleaning position.
17. Use an adapter to plug the feed hose onto the blowout coupling.



P_02594

18. Press "FP pump Intensive On" button.

A combined cleaning program with pump and blowout pulses is running according to the time set in the pump.



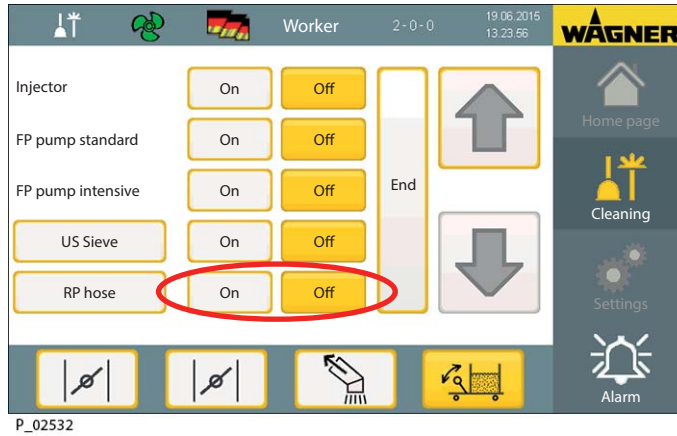
19. The end of fresh powder pump cleaning is displayed by a white "Clean FP pump On" button and a yellow "Clean FP pump Off" button.



20. Clean the peristaltic pump.

Open cyclone and swivel out sieve (pictured left).

Plug the reclaimed powder hose onto the blowout coupling (pictured right).



Press "RP hose cleaning On" button to start cleaning the reclaimed powder hose.

The end of reclaimed powder hose cleaning is displayed by a white "Clean RP hose On" button and a yellow "Clean RP hose Off" button.

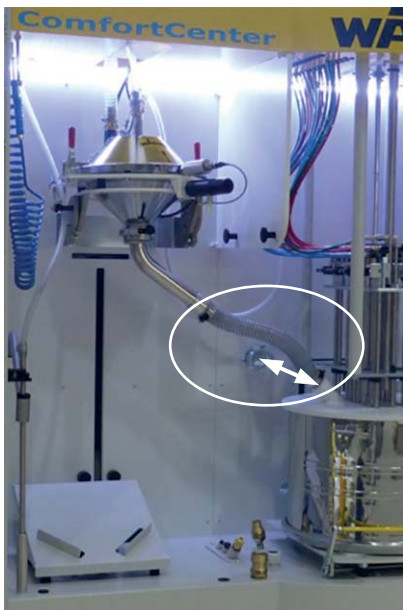
21. Press the "End" button to finish cleaning.
22. Blow out the cyclone and the cyclone sieve.
23. Close the cyclone funnel several times, wait 15 seconds, open and blow out to remove residual dust from the cyclone.

8.2.6 CLEANING/PAINT CHANGE ON THE PXM WITH ULTRASONIC SIEVE

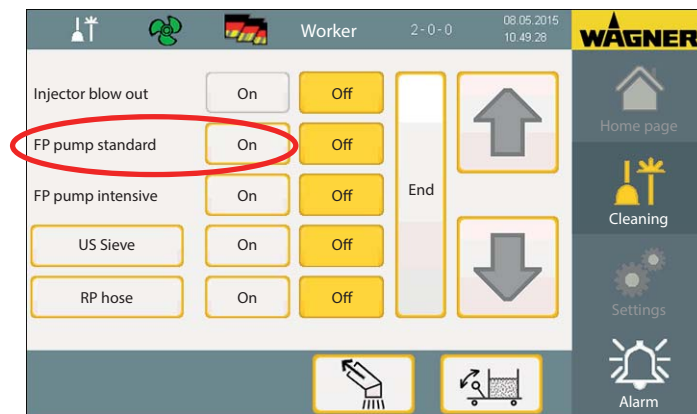
Notes for the paint change sequence:

The ultrasound sieve can be cleaned either manually or using existing cleaning components. Three steps are planned:

- Coarse cleaning using the internal cleaning program of the IP 5000 fresh powder pump. The screen frame can remain installed.
- Main cleaning with blowout device and compressed air pulses (see Cleaning Parameters, Chapter 6.9.2). The sieve frame must be replaced with a dummy frame to avoid damage to the sieve fabric.
- Perform a manual final cleaning of the individual components.



P_02682



P_02683

1. Plug the outlet hose to the park position.
2. Clean IP 5000 internally.



P_02684

3. Remove the connections from the cover.
4. Put the cover aside.
5. Remove the sieve frame and hang it on the side wall.
6. Insert the dummy frame.
7. Put the cover on again.

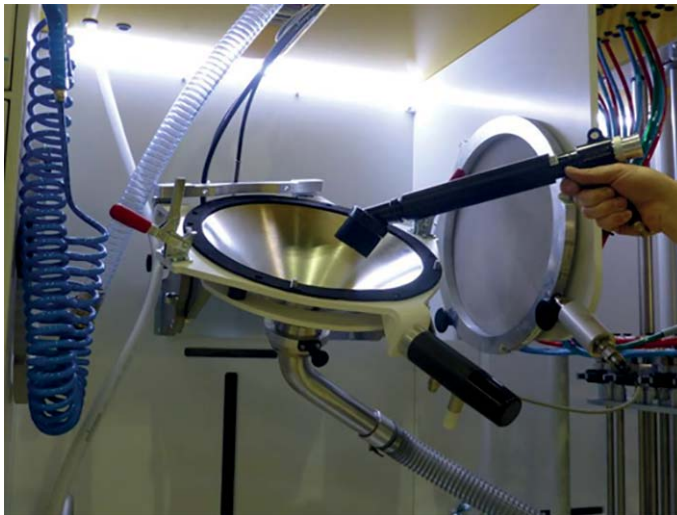


P_02685



P_02683

8. Plug the blowout hose onto the peristaltic pump connection.
9. Remove the fresh powder hose and to plug onto the blowout position (below).
10. Plug the dummy plugs onto the fresh powder connection.
11. Select main cleaning of the US sieve.



P_02686

12. Remove all connections from the sieve cover.
13. Blow out the sieve cover.
14. Suction clean the sieve funnel with the suction gun and blow it out with the blow gun.
15. Remove outlet hose and blow through.
16. Blow off sieve.
17. Mount all components again.

8.3 MAINTENANCE

8.3.1 MAINTENANCE STAFF



Maintenance work should be undertaken regularly and carefully by qualified and trained staff. They should be informed of specific hazards during their training.

The following hazards may arise during maintenance work:

- Health hazard from inhaling powder lacquer
- Use of unsuitable tools and aids
- Danger due to residual pressure in compressed-air lines

Once the maintenance work is complete, the device must be checked by a qualified person to ensure a reliable condition.

8.3.2 SAFETY INSTRUCTIONS

	 DANGER
	<p>Incorrect maintenance/repair! Danger to life and equipment damage.</p> <ul style="list-style-type: none">→ Only a WAGNER service center or a suitably trained person may carry out repairs and replace parts.→ Only repair and replace parts that are listed in the Chapter "Spare parts" and that are assigned to the unit.→ Before all work on the device and in the event of work interruptions:<ul style="list-style-type: none">- Switch off the energy supply and the compressed air supply.- Relieve spray gun and device pressure.- Secure the spray gun against actuation.→ Observe the operating and service manual for all work.

8.3.3 MAINTENANCE PROCEDURES

The maintenance intervals should be adapted by the operator depending on the level of use and if necessary the level of soiling.

If in doubt, we recommend contacting J. Wagner AG's specialist personnel.

The valid health and safety specifications and safety instructions provided in Chapter 4 must be adhered to for all maintenance work.

Maintenance work	Time stamp
Check ultrasonic sieve cloth *	per shift
Check fluid unit	per shift
Check the air hose of level probe for blockages	per shift
Check that the fluid rods of the workstation are not bent	weekly
Check that the fluid rods fluidize evenly	weekly
Check injectors	weekly
Check integrated IP 5000 fresh powder pump	weekly
Check filter cartridges for secure fit and retighten if necessary	monthly

* For more information, see ultrasonic sieve operating manual



8.3.4 SAFETY CHECKS

8.3.4.1 GROUNDING CHECK

Every day

Before starting work, carry out a visual check to ensure that the system is grounded.

9 TROUBLESHOOTING AND RECTIFICATION

	 DANGER
	<p>Incorrect maintenance/repair! Danger to life and equipment damage.</p> <ul style="list-style-type: none">→ Only a WAGNER service center or a suitably trained person may carry out repairs and replace parts.→ Only repair and replace parts that are listed in the Chapter "Spare parts" and that are assigned to the unit.→ Before all work on the device and in the event of work interruptions:<ul style="list-style-type: none">- Switch off the energy supply and the compressed air supply.- Relieve spray gun and device pressure.- Secure the spray gun against actuation.→ Observe the operating and service manual for all work.

9.1 FAULT MESSAGES

The "Alarm" function can be used to display the fault messages. Either the fault active at that time or all fault messages can be displayed.

The date, reset time, module, fault code, and a brief text are displayed.

9.2 TYPES OF FAULT MESSAGES

Warnings:

Warning messages are displayed in yellow in the visualization but do not cause the system to be stopped. The warning is reset automatically (without acknowledgement) when the warning state has been resolved.

Faults:

Error messages are displayed in red in the visualization. Faults cause the system to be stopped.

System stop in the case of faults:

Reaction to a fault in the system:

- Faulty devices are switched off and the "Powder center OK" outlet is set to "LOW".

9.3 CURRENT

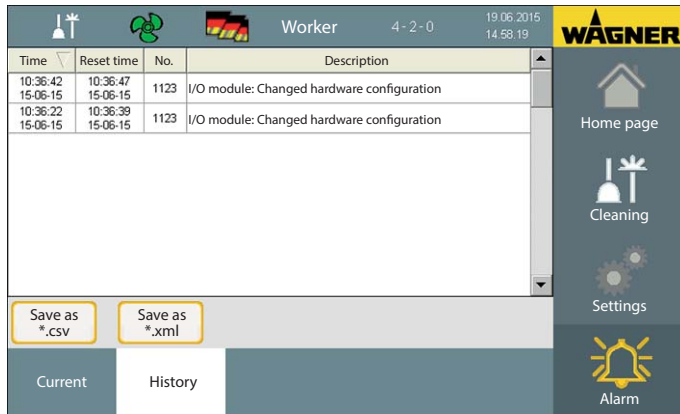
Time	No.	Description
11:47:45 05-08-14	2026	Wagner bigbag: malfunction
11:46:55 05-08-14	2205	Warning linear motion unit not referenced ==> Move to the top manually

Current
History

P_02538

1. Press the "Alarm" button in the right-hand menu bar to activate the function.
2. The "Current alarms" page is displayed.
3. To reset the error, press the "Confirm" button.

9.4 HISTORY



Time	Reset time	No.	Description
10:36:42 15:06-15	10:36:47 15:06-15	1123	I/O module: Changed hardware configuration
10:36:22 15:06-15	10:36:39 15:06-15	1123	I/O module: Changed hardware configuration

P_02539

1. Press the "History" button in the bottom function bar to activate the function.
2. The "History" page is displayed.
All fault messages are displayed.

Malfunction	Cause	Remedy
Warning Powder shortage	<ul style="list-style-type: none"> ● Powder shortage detected by the sensor at the workstation in automatic mode 	<ul style="list-style-type: none"> ● Check whether the feed is enabled and running ● Replace fresh powder box
Warning predetection powder shortage	<ul style="list-style-type: none"> ● Predetection powder shortage detected at the workstation in automatic mode 	<ul style="list-style-type: none"> ● Advance warning → Only for display to the operator ● Provide fresh powder box
Warning linear motion unit not referenced → Move the linear motion unit upward manually	<ul style="list-style-type: none"> ● Controller rebooted → The controller does not know in which segment the linear motion unit is located; that is why the upper position switch must be actuated first. That is why the operator must move the linear motion unit upwards with the "Up arrow" button. 	<ul style="list-style-type: none"> ● Move linear motion unit upwards with the "Up arrow" button ● Acknowledge warning
Powder shortage	<ul style="list-style-type: none"> ● Powder shortage detected by the sensor at the workstation in automatic mode 	<ul style="list-style-type: none"> ● Check whether the feed is enabled and running ● Provide enough fresh powder
Problems in the linear motion unit	<ul style="list-style-type: none"> ● Timeout when moving the linear motion unit 	<ul style="list-style-type: none"> ● Check position switch of the linear motion unit ● Move linear motion unit in jog mode and check whether the linear motion unit is running correctly
Problems during position detection of the linear motion unit	<ul style="list-style-type: none"> ● Multiple position switches deliver a "1" simultaneously 	<ul style="list-style-type: none"> ● Check position of the position switch
Pulsing powder cloud, spitter	<ul style="list-style-type: none"> ● Too low or too high fluidization ● Fluid rods bent/defective ● Poorly fluidizable powder ● Total air of the injector too low 	<ul style="list-style-type: none"> ● Set fluidization ● Align fluid rods horizontally; replace if necessary ● Use another powder ● Set the total air on the application controller
Level detection does not work properly	<ul style="list-style-type: none"> ● Air sensor tube clogged ● No air flow from the sensor tube ● Limit switch incorrectly set or defective 	<ul style="list-style-type: none"> ● Disconnect air coupling and blow out tube downwards ● Contact the WAGNER Service Team ● Check limit switch and adjust

Malfunction	Cause	Remedy
Control button on the touch screen does not respond	<ul style="list-style-type: none"> ● No release; button must be outlined in yellow 	<ul style="list-style-type: none"> ● Check conditions for release ● Function is not performed since the switching element is defective in the control cabinet ● Too little pressure in the compressed air supply
Screen performance too low	<ul style="list-style-type: none"> ● Mesh width too small ● Sieve mesh is clogged ● Sieve mesh damaged ● Sieve mesh has no tension 	<ul style="list-style-type: none"> ● Use sieve frame with larger mesh width ● Clean sieve mesh ● Have sieve frame restrung ● Have sieve frame restrung ● Have sieve frame restrung

10 REPAIR

10.1 REPAIR PERSONNEL

Repair work should be undertaken carefully by qualified and trained personnel. They should be informed of specific hazards during their training.

The following hazards may arise during repair work:

- Health hazard from inhaling solvent vapors
- Use of unsuitable tools and aids

A skilled person must check to ensure that the device is in a reliable state after it is repaired.

10.2 SAFETY INSTRUCTIONS



→ Observe the safety instructions in Chapter 4 and Chapter 8.1.2.

Before a Repair

- Flush and clean the system. → Chapter 8.1.3.

After a Repair

- Carry out a safety checks in accordance with Chapter 8.2.4.

	 DANGER
	<p>Incorrect maintenance/repair! Danger to life and equipment damage.</p> <ul style="list-style-type: none"> → Only a WAGNER service center or a suitably trained person may carry out repairs and replace parts. → Only repair and replace parts that are listed in the Chapter "Spare parts" and that are assigned to the unit. → Before all work on the device and in the event of work interruptions: <ul style="list-style-type: none"> - Switch off the energy supply and the compressed air supply. - Relieve spray gun and device pressure. - Secure the spray gun against actuation. → Observe the operating and service manual for all work.

OPERATING AND ASSEMBLY MANUAL



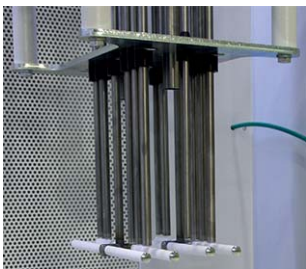
The following repairs can be carried out as needed:

- Replacing the O-ring on the blowout station for the injectors in case of leaks



P_02586

- Replace scraper rings on the guide bushings of the intake tubes
- Replace fluid tubes



P_02587

- Replace the solenoid valves on the pressure tank of the blowout device



P_02588

- Replace the solenoid valves of the filter suction
- Replace transvector to the guide tubes of the injector holding plate (mounted on the roof)
- Check the wearing parts on the injectors and replace if necessary in accordance with the Injectors operating manual
- Check the wearing parts of the IP 5000 and replace if necessary in accordance with the IP 5000 operating manual

11 FUNCTION TEST AFTER THE REPAIR

All functions must be checked in manual and automatic mode.

12 INSPECTIONS IN ACCORDANCE WITH DIN EN 50177: 2010

If the system is used for electrostatic coating with flammable coating powders, testing should be undertaken in accordance with DIN EN 50177: 2010-04 as per Table 3 and Table 4.

OPERATING AND ASSEMBLY MANUAL



Section	Type of inspection	Requirements	Inspection by	Type of inspection	Inspection interval
1	Checking the effectiveness of technical ventilation	Checking the effectiveness of technical ventilation	TP/SP	ME Measurements of air flow speed / air quantities Check the differential pressure indicator.	continuously
2	Link between technical ventilation equipment and high-voltage, compressed air and coating material supply	The technical ventilation should be interlocked such that the powder feed and high-voltage cannot be switched on, while the technical ventilation is not working effectively.	SP	FT Test whether the system is safely stopped and the product supply, supply air and high-voltage are switched off when the ventilation is shut down.	annually
3	Parts carrying high-voltage outside the spray area	Parts carrying high-voltage outside the spray area must be routed such that discharges which put people at risk do not occur.	SP	FT Inspect and test (e.g. by measuring) whether all high-voltage carrying parts do not result in a discharge that puts people at risk.	weekly

Legend:
 MF = Manufacturer
 ER = Employer
 SP = Skilled person
 FPO = Fire prevention officer
 ELT = Electrician
 TP = Trained person

FT = Function test
 ME = Measurement
 OC = Organization check
 VI = Visual inspection
 CM = Constant monitoring
 TT = Technical testing

OPERATING AND ASSEMBLY MANUAL



Section	Type of inspection	Requirements	Inspection by	Type of inspection	Inspection interval
4	Effectiveness of grounding	All the system's conductive elements, such as floors, walls, ceilings, protective grating, transport equipment, work pieces, powder tanks, machines or construction parts etc. in the spray area, with the exception of parts which carry high-voltage during operation, must be connected to the grounding system. Parts of the booth must be grounded in accordance with EN 12215.	SP	VI/ME/CM Visual check of ground connections, perform function test on grounding switch, measurement of grounding resistors.	weekly
5	Measures to take if conductive components are insufficiently grounded	If sufficient grounding of conductive parts cannot be ensured, their discharge energy must not exceed the permissible value.	SP	ME/CM Measurement of discharge energy.	weekly
6	Ground leaking resistance from the workpiece attachment point	The resistance to ground of every work piece's locating point must not exceed 1 megohm (measurement voltage must be 1000V). The form of construction of the workpiece mount must guarantee that the workpieces remain grounded during coating.	SP	ME/CM Measure resistance to ground (work piece receiver - ground potential) max. 1 megohm @ 1000 V.	weekly

Legend:
 MF = Manufacturer
 ER = Employer
 SP = Skilled person
 FPO = Fire prevention officer
 ELT = Electrician
 TP = Trained person

FT = Function test
 ME = Measurement
 OC = Organization check
 VI = Visual inspection
 CM = Constant monitoring
 TT = Technical testing

13 DISASSEMBLY AND DISPOSAL

We recommend having the WAGNER system disassembled by WAGNER or another specialist.

Before starting disassembly, all supply media (electric current, compressed air) must be disconnected at the connection points. All powder lacquer lines must be completely emptied and then rinsed. Lacquer residues must be disposed of in line with statutory requirements.

Before starting disassembly, check whether the supply lines have actually been interrupted and have been depressurized and/or de-energized if necessary.

The empty system should be thoroughly cleaned. In particular, fire loads, such as unused lacquers in exhaust air pipes, etc. for example, should be removed to keep the risk of fire during disassembly as low as possible.





We recommend reporting to the public authorities the fact that systems with mandatory approval requirements are decommissioned.


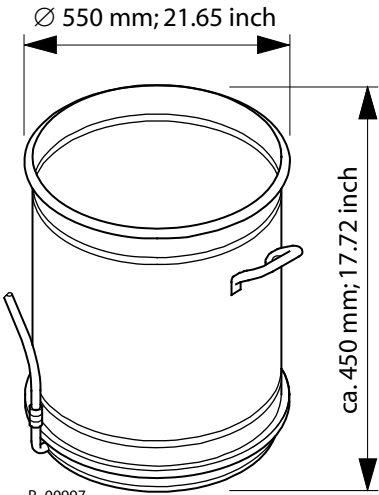
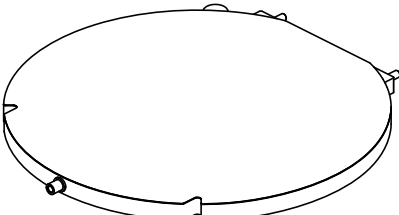

Separate all materials encountered during disassembly as clearly as possible in line with statutory requirements. Take appropriate actions to ensure that no dangerous substances enter the system during disassembly. All waste produced must be separated and disposed of in line with local requirements.

Used materials are:

- Steel
- PVC synthetic material
- Cable ...

14 ACCESSORIES

 <p>P_02548</p>	<p>Cover for fluid tank (without sieve) PXM 20/22 Order No. 2350986</p>
 <p>P_02707</p>	<p>Cover for fluid tank (with sieve) PXM 20/22 Order No. 2357417</p>
 <p>P_02549</p>	<p>Cover for box (without sieve) PXM 20/22 Order No. 2350989</p>
 <p>P_02708</p>	<p>Cover for box (with sieve) PXM 20/22 Order No. 2353300</p>

 <p>P_02713</p>	<p>Cover for fluid tank (without sieve) PXM 34 Order No. 2359829</p>
	<p>Cover for fluid tank (with sieve) PXM 34 Order No.</p>
 <p>P_00997</p>	<p>Fluidized powder tank Order No. 3304505</p>
 <p>P_02709</p>	<p>Sieve frame 160 µm, Order No. 2358243 Sieve frame 200 µm, Order No. 2353877</p>
 <p>P_02687</p>	<p>Blow nozzle for vent pipes (Fits to gun, Order No. 3920048) Order No. 2358577</p>

 <p>P_02688</p>	<p>Blow gun, Order No. 3920048 Threaded nipple, Order No. 3920043 (order separately)</p>
 <p>P_02710</p>	<p>Hose reel Order No. 3923136 Quick-release coupling, Order No. 3305061 Reduction sleeve, Order No. 3306468</p>

15 SPARE PARTS

15.1 HOW CAN SPARE PARTS BE ORDERED?

Always supply the following information to ensure delivery of the right spare part:

Order number, designation and quantity

The quantity need not be the same as the number given in the quantity column "Stk" on the list. This number merely indicates how many of the respective parts are used in each component.

The following information is also required to ensure smooth processing of your order:

- Address for the invoice
- Address for delivery
- Name of the person to be contacted in the event of any queries
- Type of delivery (normal mail, express delivery, air freight, courier, etc.)

Identification in spare parts lists

Explanation of column "K" (labeling) in the following spare parts lists.

- ◆ = Wearing parts
Note: These parts are not covered by warranty terms
- = Not part of standard equipment, available, however, as additional extra.



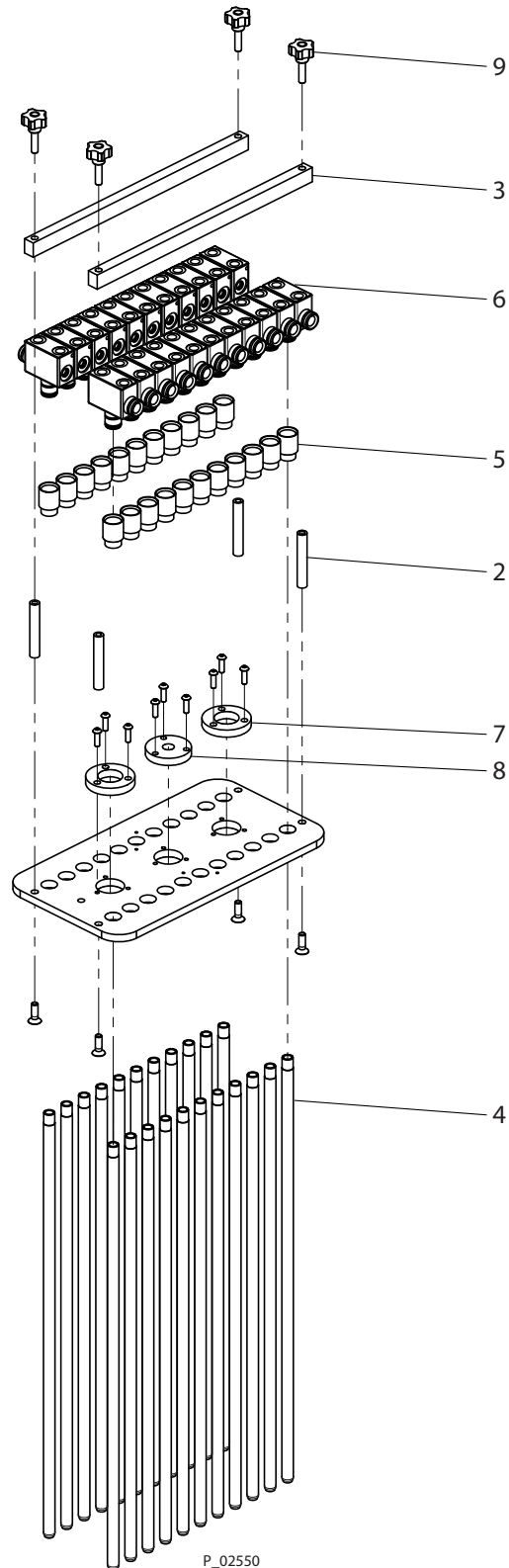
DANGER

Incorrect maintenance/repair!

Danger to life and equipment damage.

- Only a WAGNER service center or a suitably trained person may carry out repairs and replace parts.
- Only repair and replace parts that are listed in the Chapter "Spare parts" and that are assigned to the unit.
- Before all work on the device and in the event of work interruptions:
 - Switch off the energy supply and the compressed air supply.
 - Relieve spray gun and device pressure.
 - Secure the spray gun against actuation.
- Observe the operating and service manual for all work.

15.2 WORKSTATION 22 INJECTORS

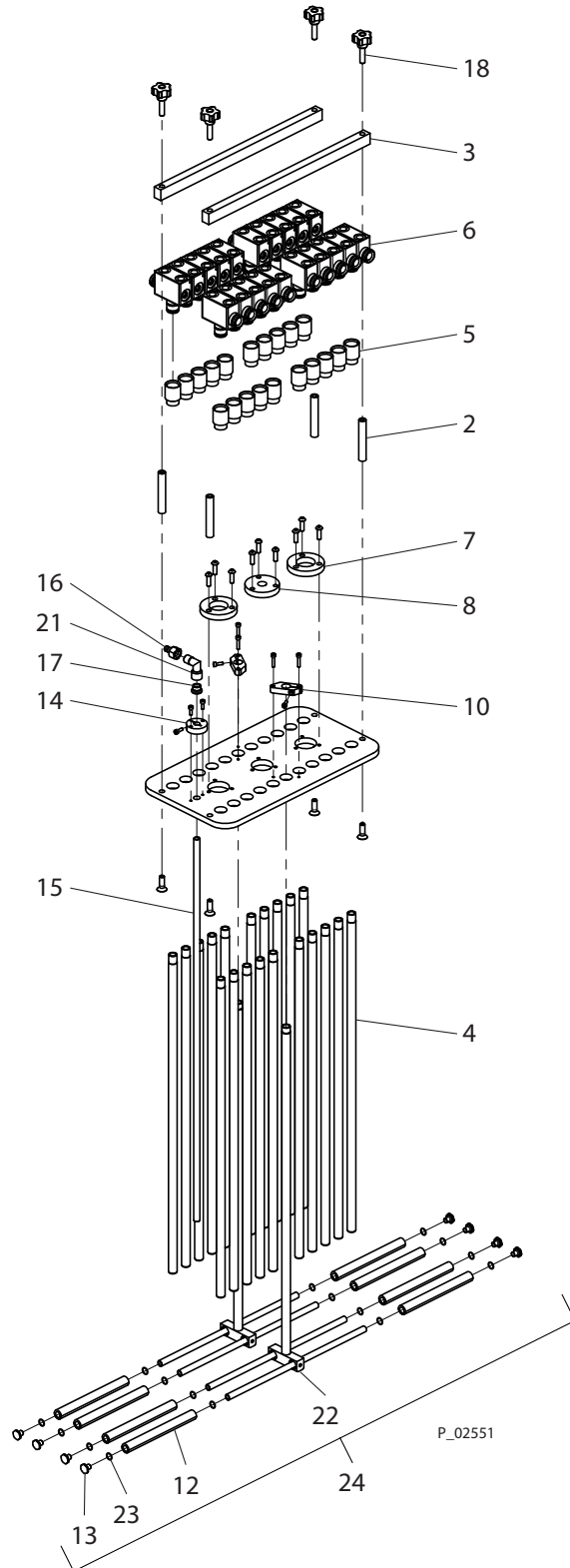


P_02550

Pos	K	Quantity	Order No.	Designation
2		4	2359887	Spacer bushing injector plate
3		2	2359888	Square holder for injectors
4		22	2359892	Suction tube
5		22	2359893	Injector connection
6		22		Injector
7	◆	2	2354873	Guide piece suction
8		1	2359897	Adjustment plate
9		4	2359899	Hand knob M8x30

◆ Wearing part

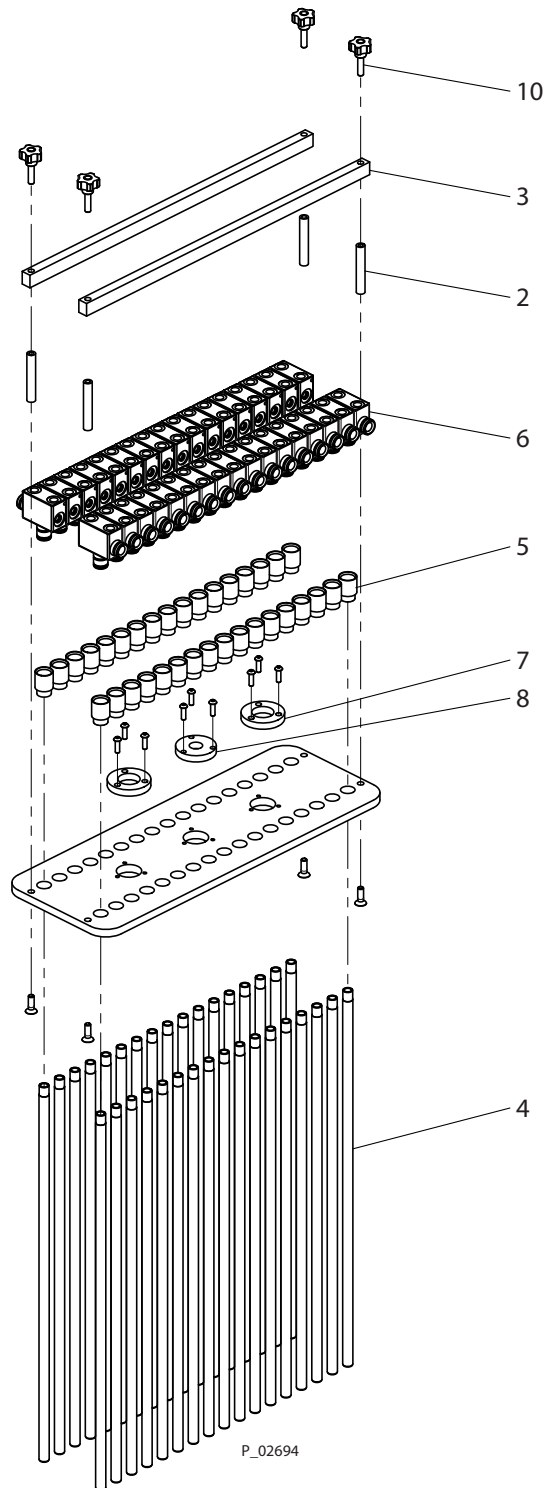
15.3 WORKSTATION 20 INJECTORS WITH FLUIDIZATION



Pos	K	Quantity	Order No.	Designation
2		4	2359887	Spacer bushing injector plate
3		2	2359888	Square holder for injectors
4		20	2359892	Suction tube
5		20	2359893	Injector connection
6		20	--	Injector
7	◆	2	2354873	Guide piece suction
8		1	2359897	Adjustment plate
10	◆	2	2359900	Clamp fluid tube
12		8	2354876	Poroplast tube for fluidization
13		8	2359943	Screw plug
14		1	2359944	Clamp for level sensor
15		1	2359949	Tube for level sensor
16		1	2359954	Plug connection 1/4"
17		1	2359957	Adapter connection probe tube
18		4	2359899	Hand knob M8x30
21		1	2359959	Angled pipe connection 1/4" level sensor
22		2	2354875	Fluidization connection
23	◆	16	2360988	O-ring
24		2	2361284	Box fluidization

◆ Wearing part

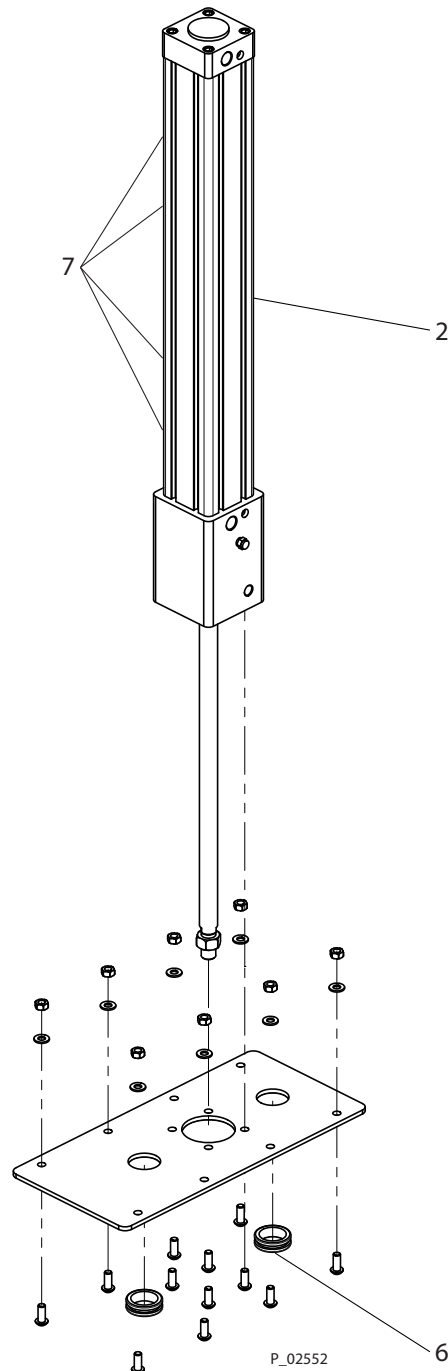
15.3 WORKSTATION 34 INJECTORS



Pos	K	Quantity	Order No.	Designation
2		4	2359887	Spacer bushing injector plate
3		2	2359962	Square holder for 34 injectors
4		34	2359892	Suction tube
5		34	2359893	Injector connection
6		34	--	Injector
7	◆	2	2354873	Guide piece suction
8		1	2359897	Adjustment plate
10		4	2389899	Hand knob M8x30

◆ Wearing part

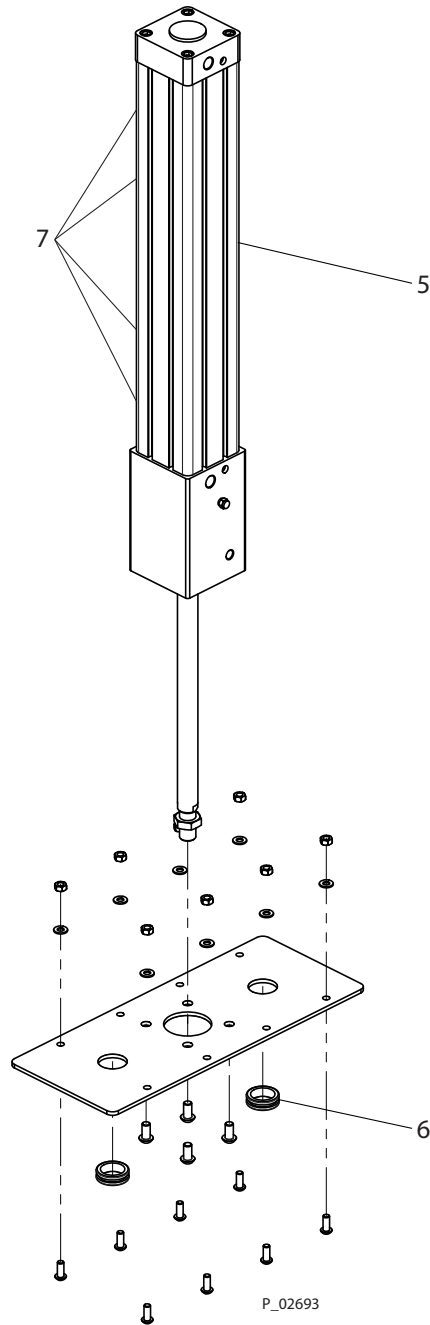
15.4 CYLINDER WORKSTATION (22 INJECTORS)



Pos	K	Quantity	Order No.	Designation
2		1	2359651	Pneumatic cylinder 63 x 525
6	◆	2	2354879	Guide bush
7		4	2309763	Proximity switch with holder

◆ Wearing part

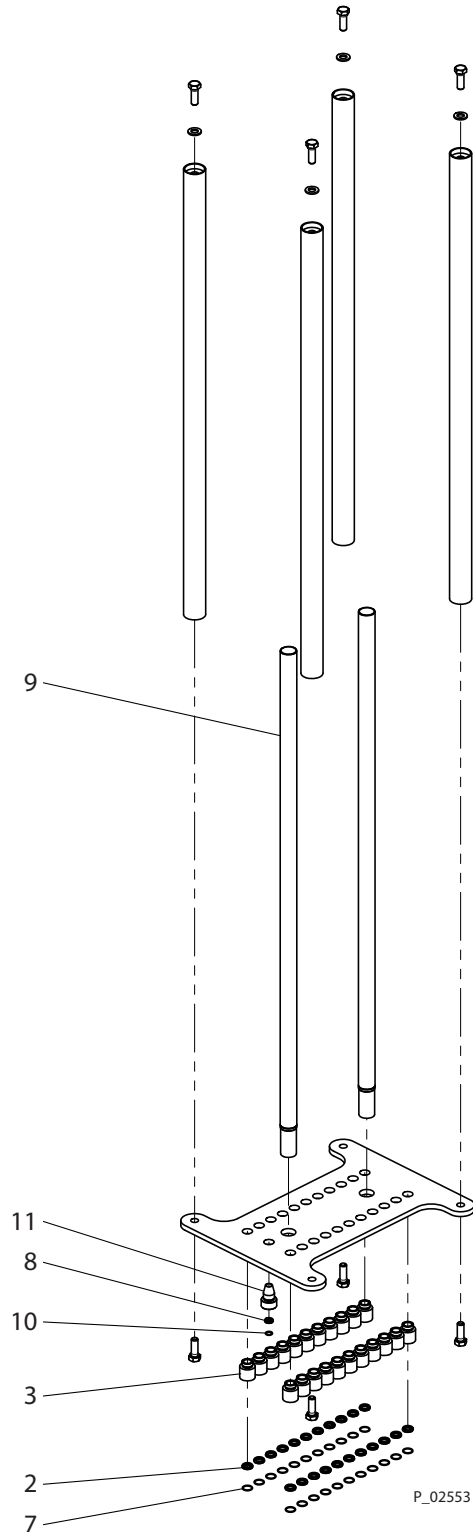
15.5 CYLINDER WORKSTATION (34 INJECTORS)



Pos	K	Quantity	Order No.	Designation
5		1	2359655	Pneumatic cylinder 80 x 525
6	◆	2	2354879	Guide bush
7		4	2309763	Proximity switch with holder

◆ Wearing part

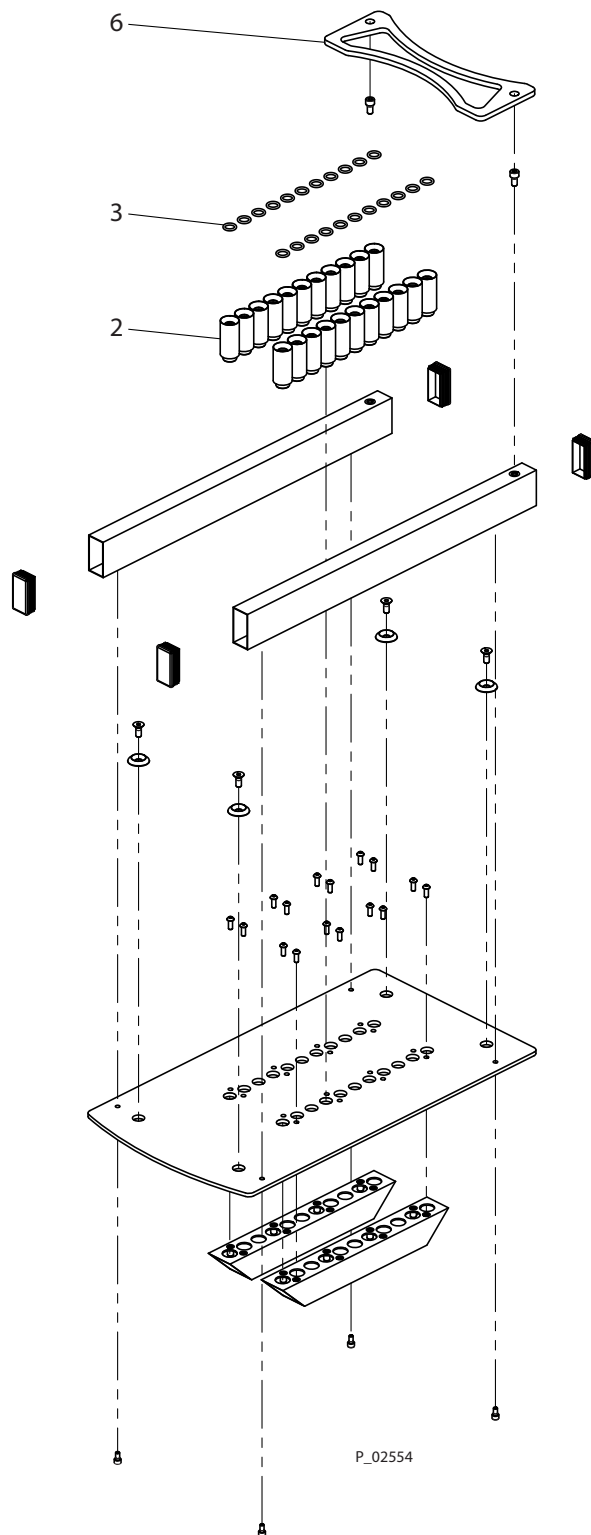
15.6 SCRAPER ASSEMBLY INTAKE TUBES



Pos	K	Quantity	Order No.	Designation
2	◆	22	2313045	Flexiseal D14 with O-ring (set)
3		22	2359852	Intake tube
7		22		O-ring
8		1	2359854	Flexiseal sealing ring D10
9		2	2359851	Suction tube for dust
10		1	2359856	O-ring for level sensor
11		1	2359865	Bushing for level sensor

◆ Wearing part

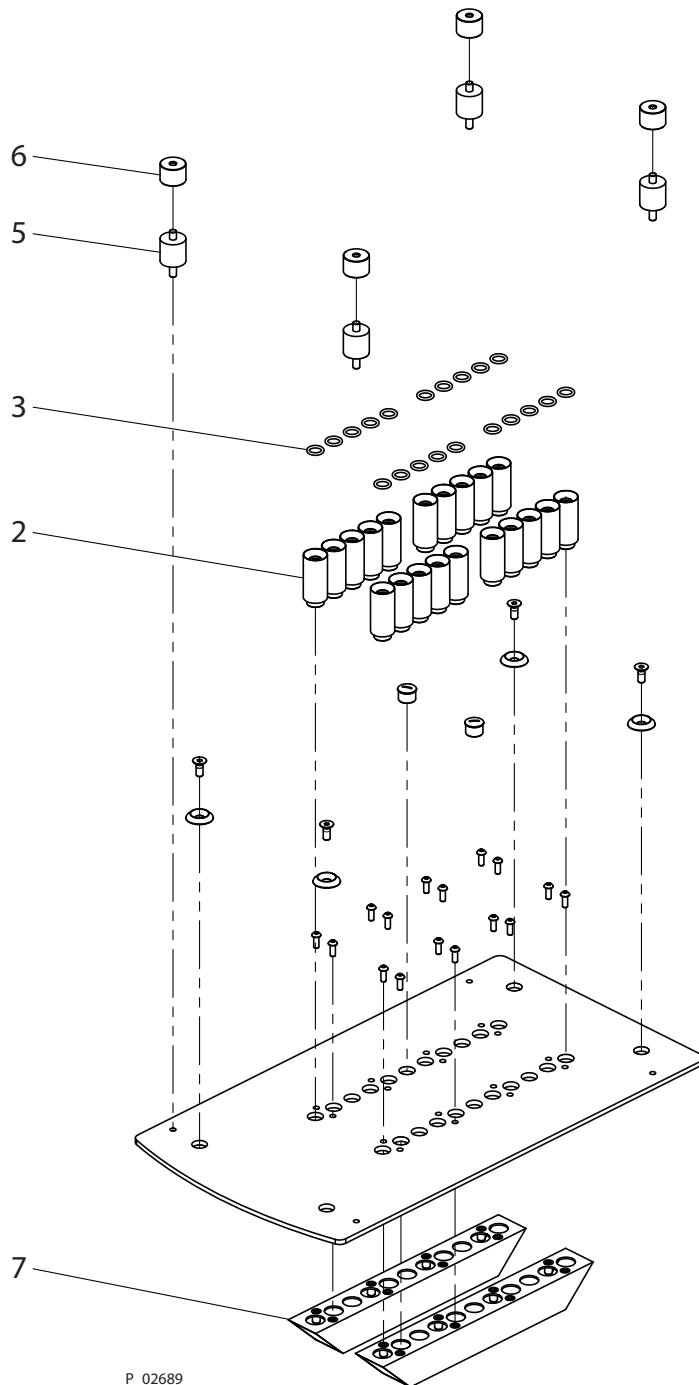
15.7 CLEANING SYSTEM TANK VERSION (22 INJECTORS)



Pos	K	Quantity	Order No.	Designation
2		22	2350573	Blow out fitting
3	◆	22	2313200	O-ring 14 x 3
6		1	2360012	Stop plate tank

◆ Wearing part

15.8 CLEANING SYSTEM BOX VERSION (22 INJECTORS)

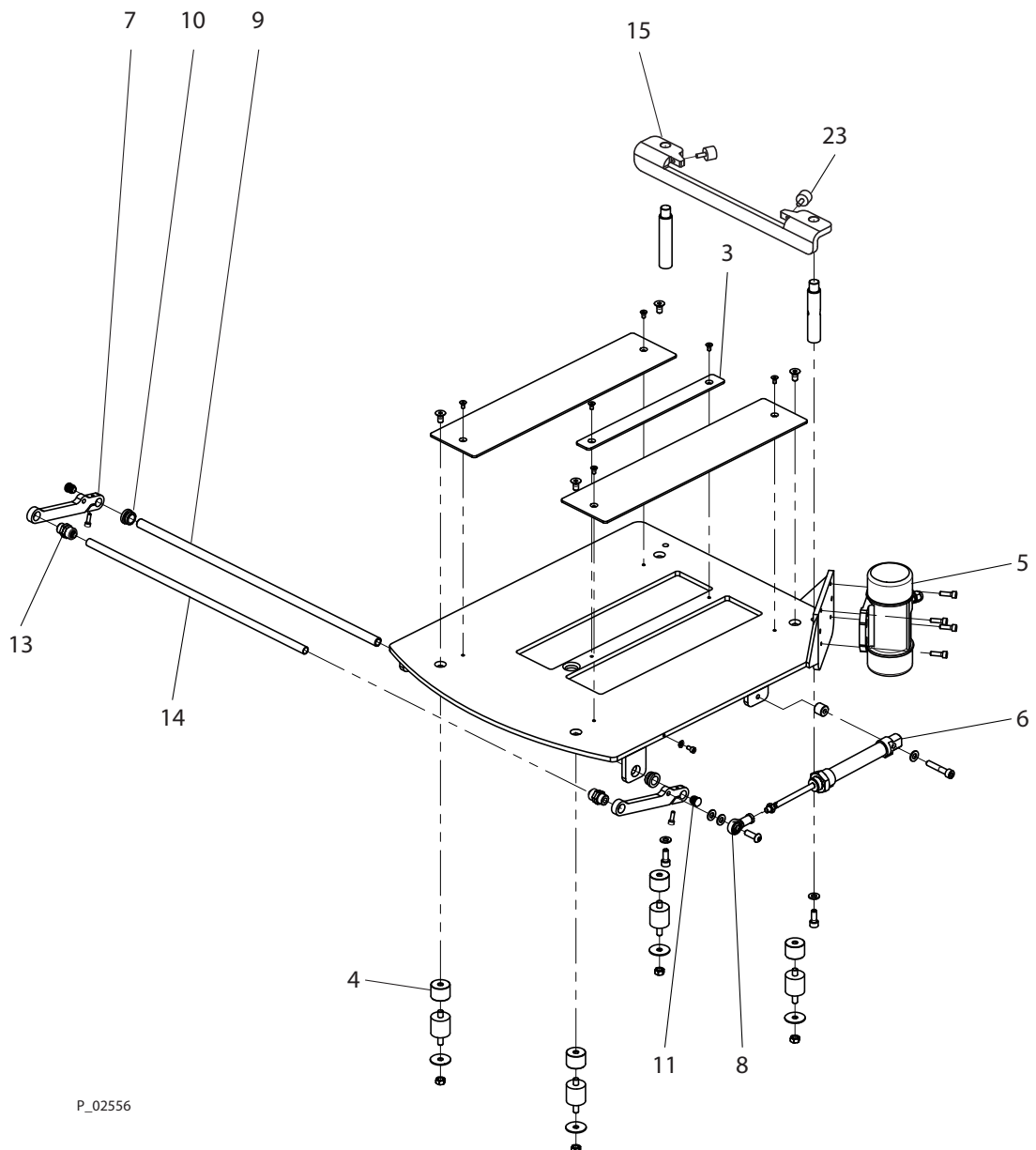


P_02689

Pos	K	Quantity	Order No.	Designation
2		20	2350573	Blow out fitting
3	◆	20	2313200	O-ring 14 x 3
5		4	2360001	Vibration buffer vibration table
6		4	2359981	Spacer vibration table
7		2	2360019	Cleaning bar workstation

◆ Wearing part

15.9 VIBRATION TABLE

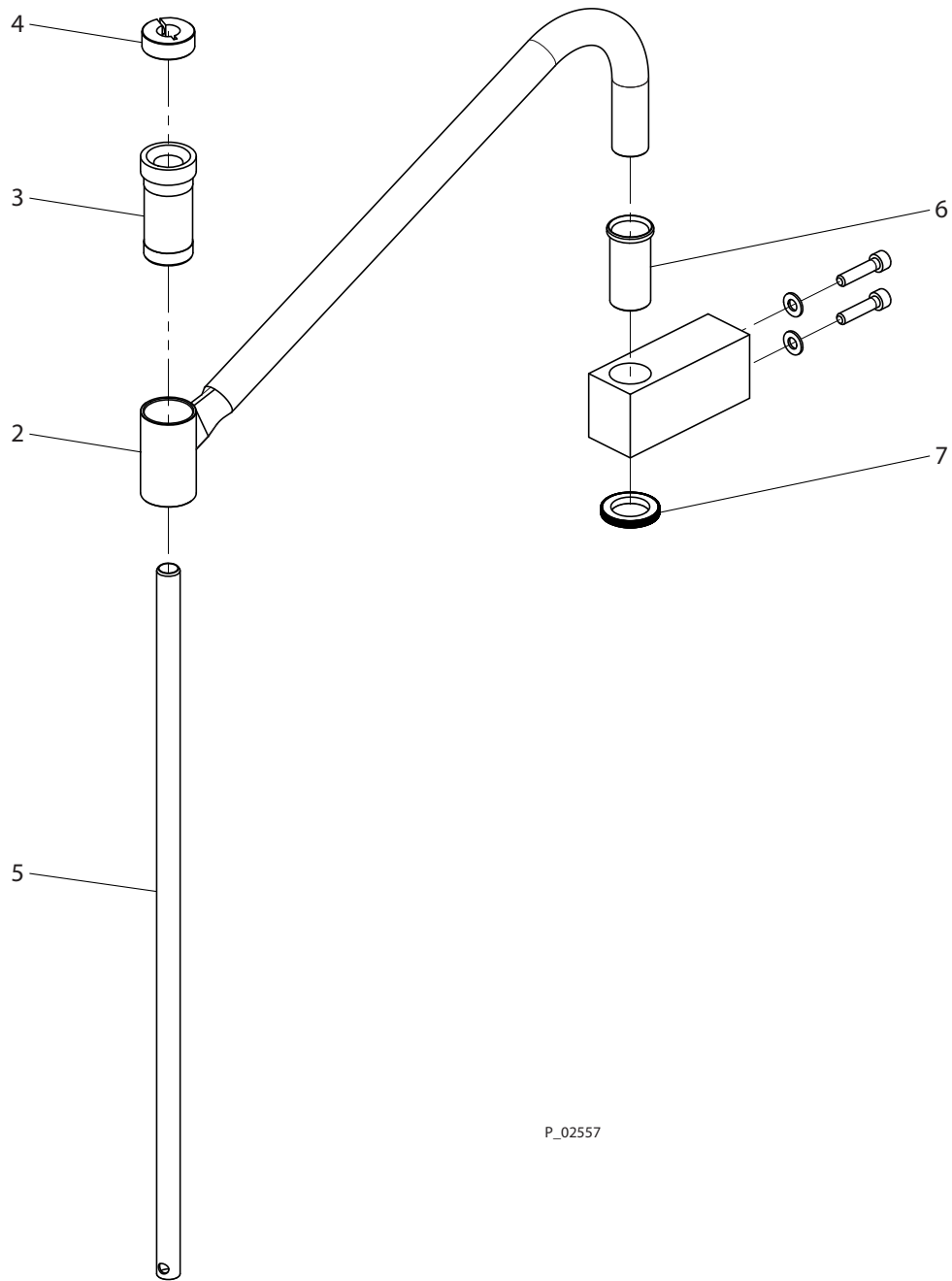


P_02556

Pos	K	Quantity	Order No.	Designation
3		1	2359982	Guard plate
4		4	2359981	Spacer vibration table
5		1	2359989	Vibrator motor
6		1	2354891	Pneumatic cylinder
7		1	2359990	Interlocking
8	◆	1	2354894	Ball joint
9		2	2359990	Pivot lever
10	◆	2	2313566	Guide bushing intake tube
11		2	2354897	Vane plastic cap
13		2	2359999	Fitting
14	◆	1	2354898	Tube Elastollan®
15		1	2360007	Stop
23	◆	4	2354883	Buffer element

◆ Wearing part

15.10 FEED LANCE

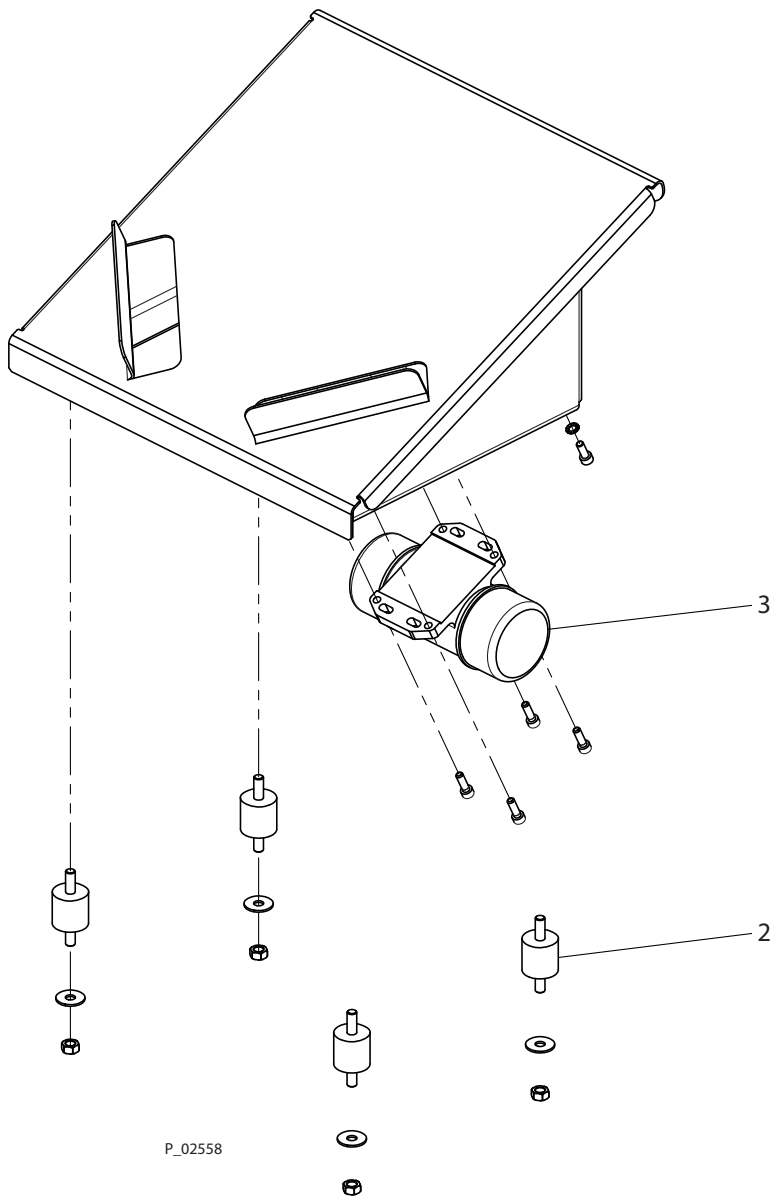


P_02557

Pos	K	Quantity	Order No.	Designation
2		1	2307117	Conveying arm
3	◆	1	2354899	Guide bush
4	◆	1	2354901	Sealing ring
5		1	2359657	Suction lance fresh powder
6	◆	1	2303279	Guide bush
7	◆	1	2305421	Guide ring

◆ Wearing part

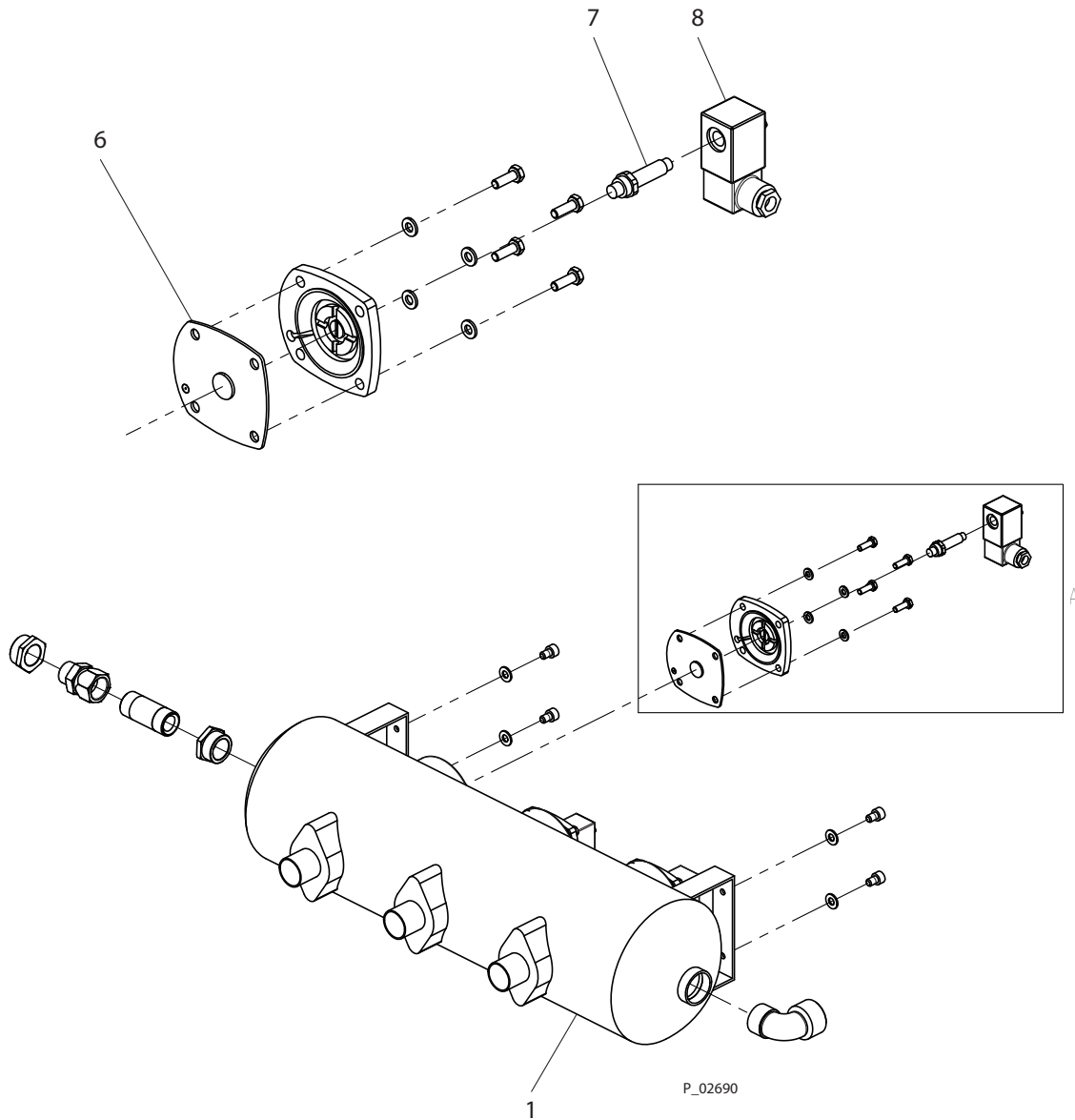
15.11 VIBRATING TABLE FRESH POWDER



Pos	K	Quantity	Order No.	Designation
2	◆	4	2316255	Vibration damper
3		1	2359648	Vibrator motor

◆ Wearing part

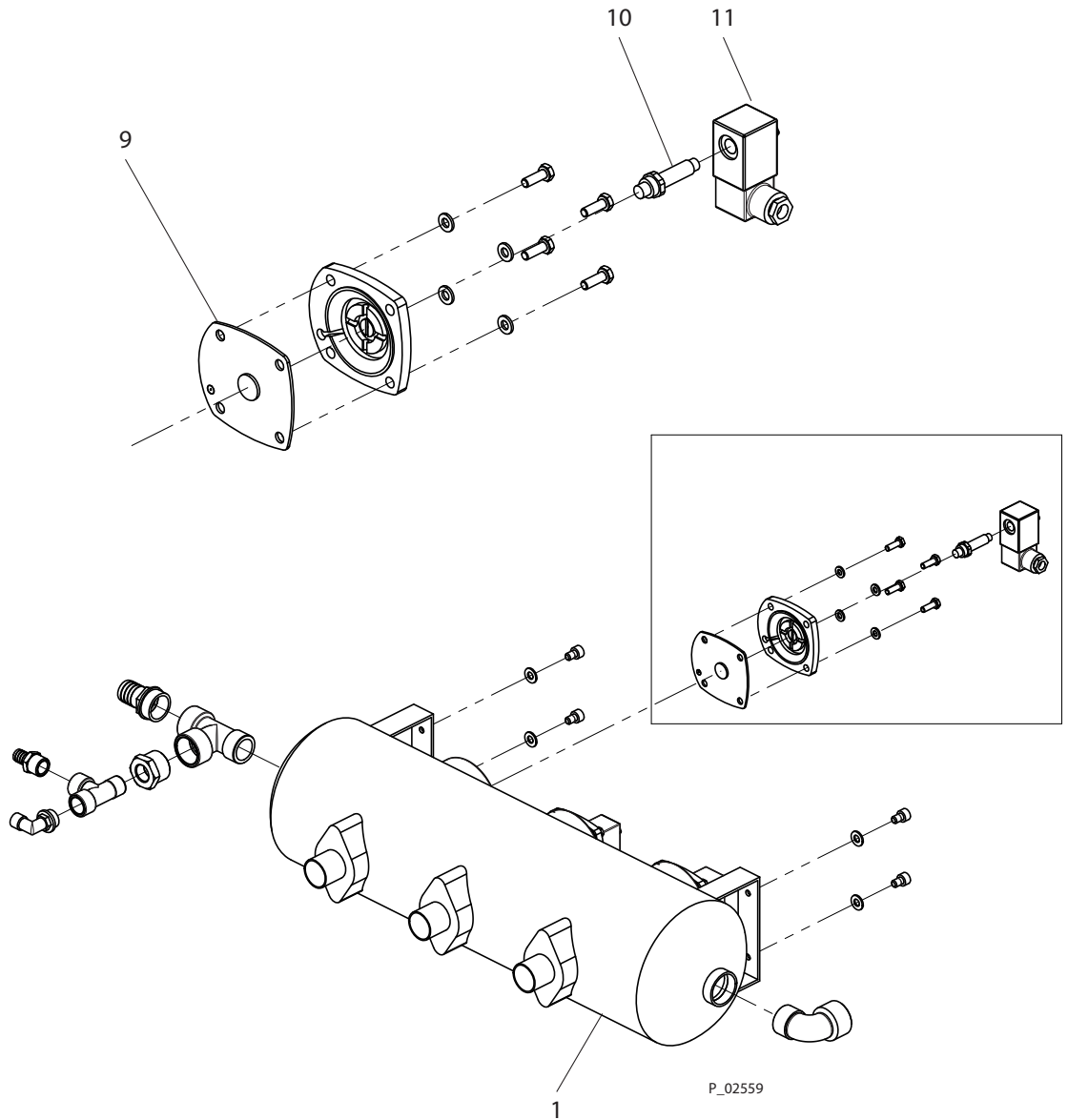
15.12 COMPRESSED AIR TANK FOR 22 INJECTORS (1 OUTLET)



Pos	K	Quantity	Order No.	Designation
1		1	2360020	Pressure tank with 3 valves
6		3	2360021	Valve diaphragm
7		3	2360022	Pilot valve
8		3	2360023	Solenoid with plug

◆ Wearing part

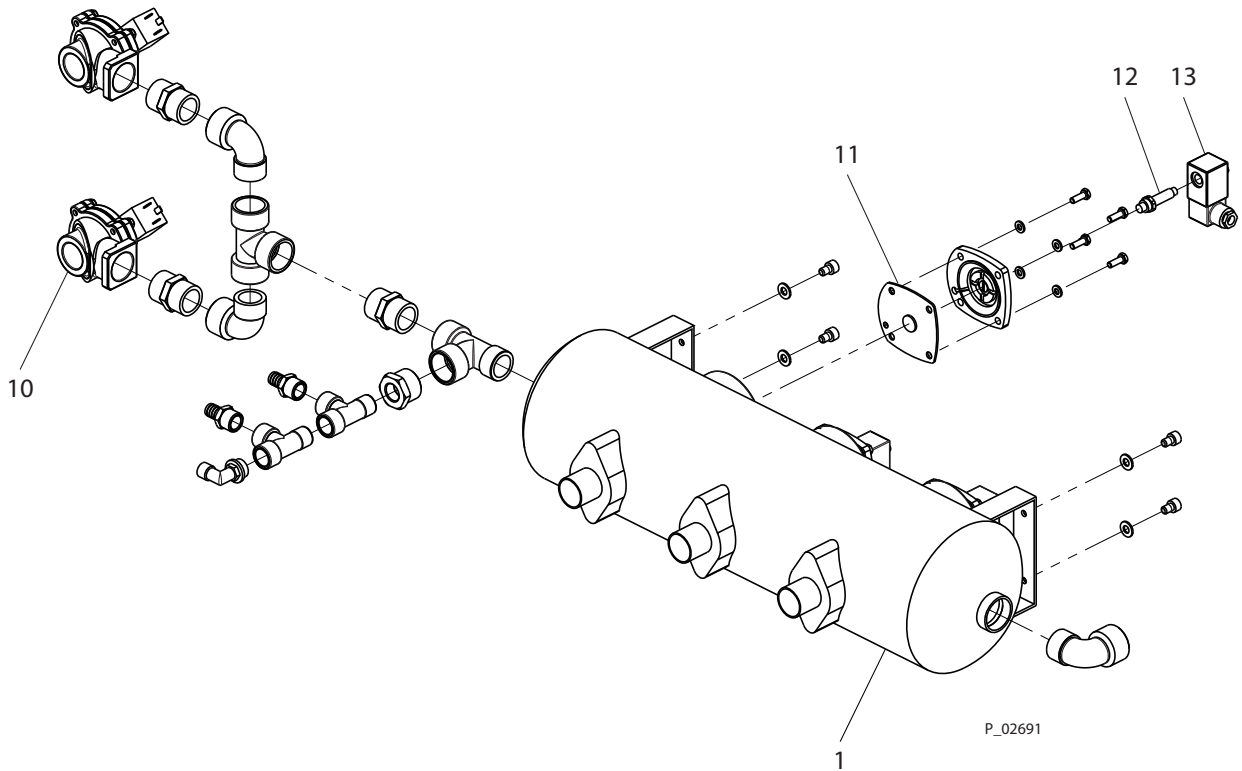
15.13 COMPRESSED AIR TANK FOR 22 INJECTORS



Pos	K	Quantity	Order No.	Designation
1		1	2360020	Pressure tank with 3 valves
9		3	2360021	Valve diaphragm
10		3	2360022	Pilot valve
11		3	2360023	Solenoid with plug

◆ Wearing part

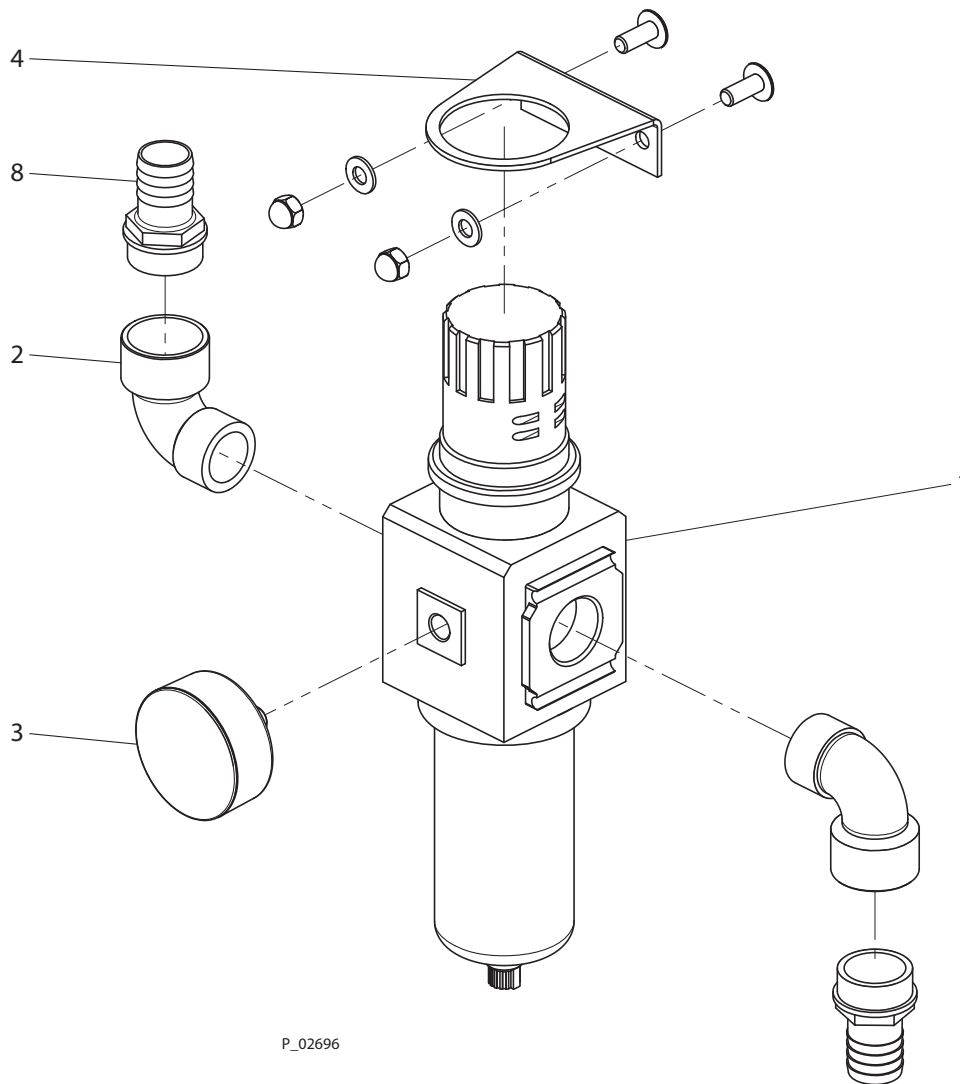
15.14 COMPRESSED AIR TANK FOR 34 INJECTORS



Pos	K	Quantity	Order No.	Designation
1		1	2360020	Pressure tank with 3 valves
10		2	2316275	Solenoid valve, complete
9		3	2360021	Valve diaphragm
10		3	2360022	Pilot valve
11		3	2360023	Solenoid with plug

◆ Wearing part

15.15 PRESSURE REGULATOR, COMPLETE

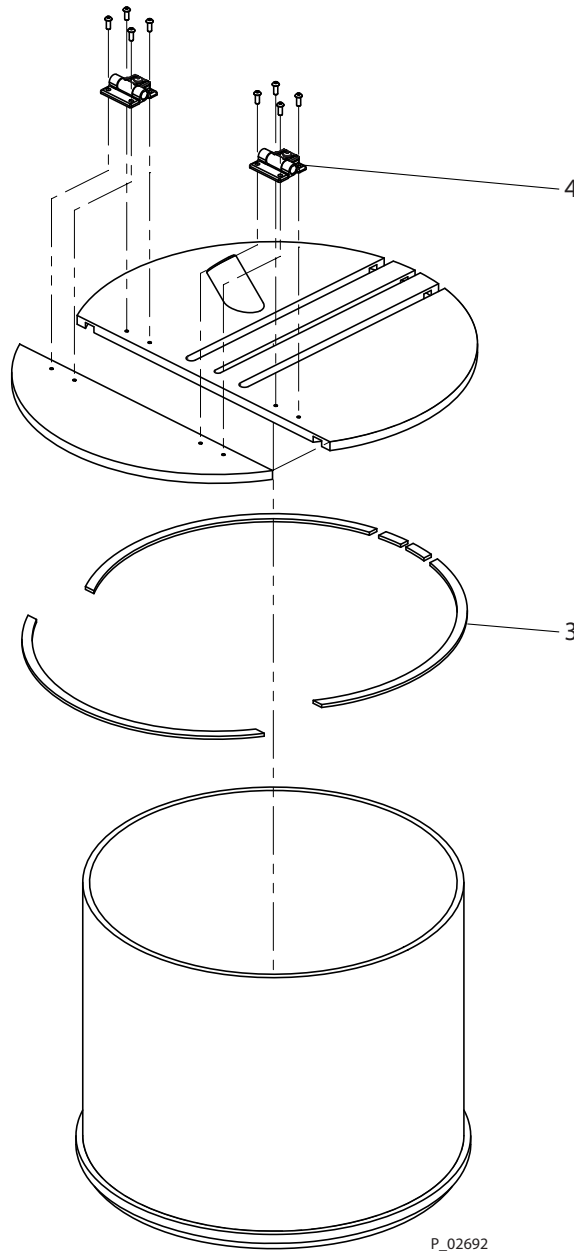


P_02696

Pos	K	Quantity	Order No.	Designation
1		1	2327951	Filter pressure regulator, complete
2		2	2360073	Angled pipe
3		1	3304494	Pressure gauge 0-12 bar 1/4"
4		1	2320467	Mounting bracket for pressure regulator MX3
8		2	9985671	Hose fitting G1"

◆ Wearing part

15.12 POWDER TANK, FLUIDIZED (22 INJECTORS)

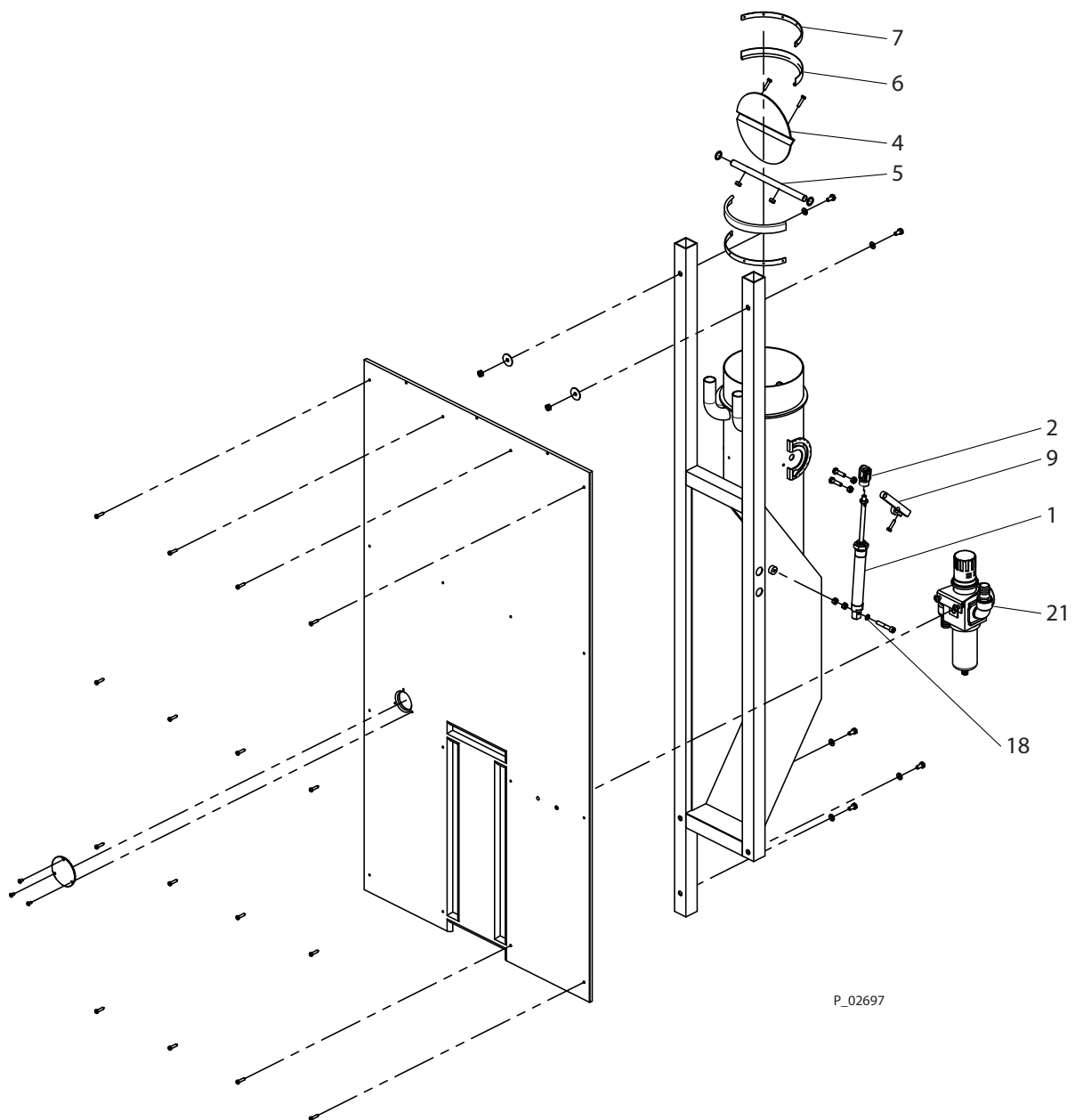


Pos	K	Quantity	Order No.	Designation
3	◆	2	2306025	Seal for tank lid
4	◆	2	2314293	Hinge

◆ Wearing part

15.13 FINAL FILTER ADAPTER

15.14 EXHAUST SYSTEM THROTTLE VALVE

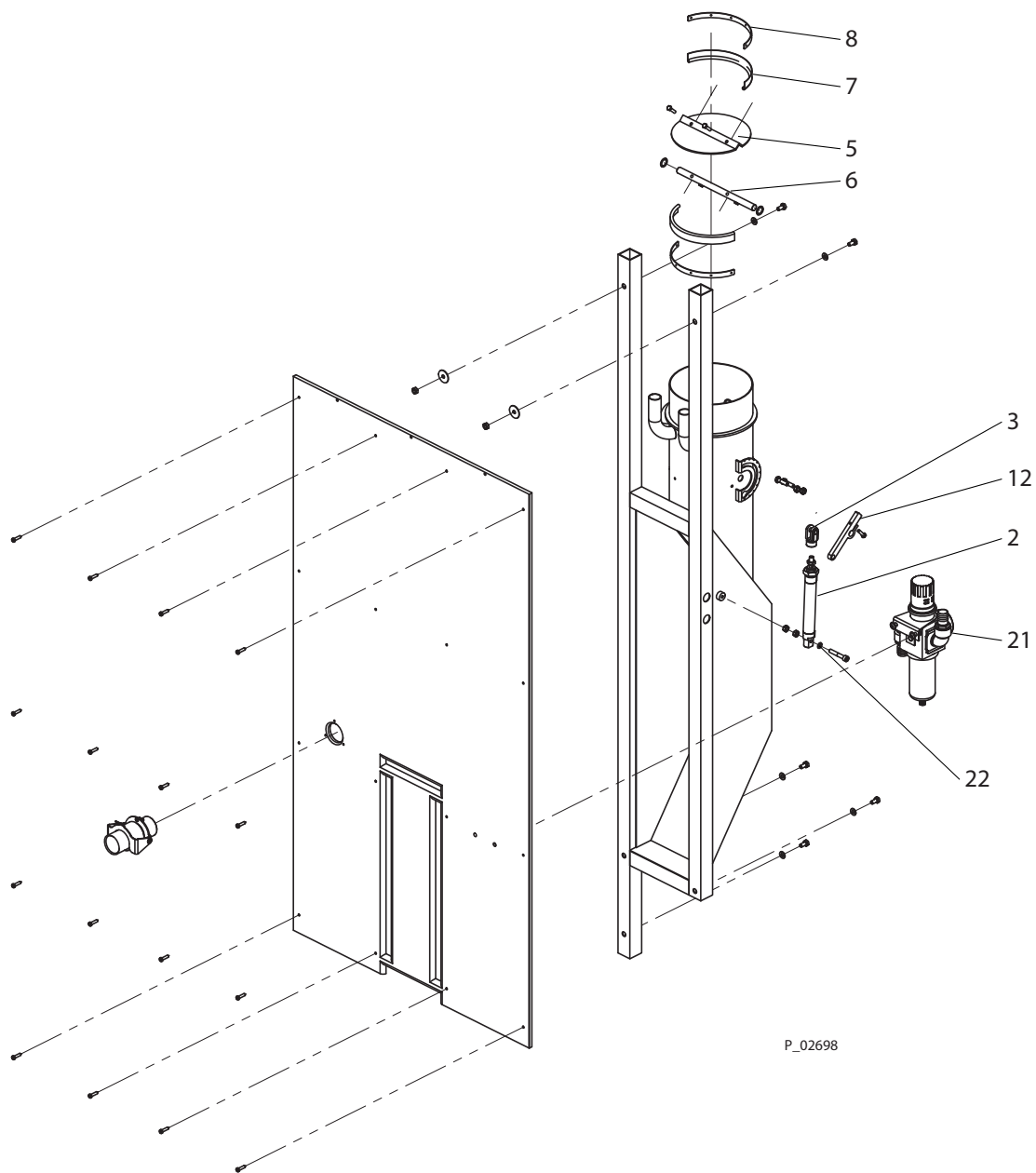


P_02697

Pos	K	Quantity	Order No.	Designation
1		1	2360238	Pneumatic cylinder D25
2		1	2360373	Fork end G23-32
4		1	2360374	Throttle valve exhaust duct
5		1	2360383	Axis for throttle valve
6		2	2360386	Flat gasket for throttle valve
7		2	2360387	Holder flat seal
9		1	2360388	Connecting rod
19		2	2360390	Washer PA
21		1	2327951	Pressure regulator complete 1"

◆ Wearing part

15.15 EXHAUST SYSTEM THROTTLE VALVE (VERSION WITH US SIEVE)

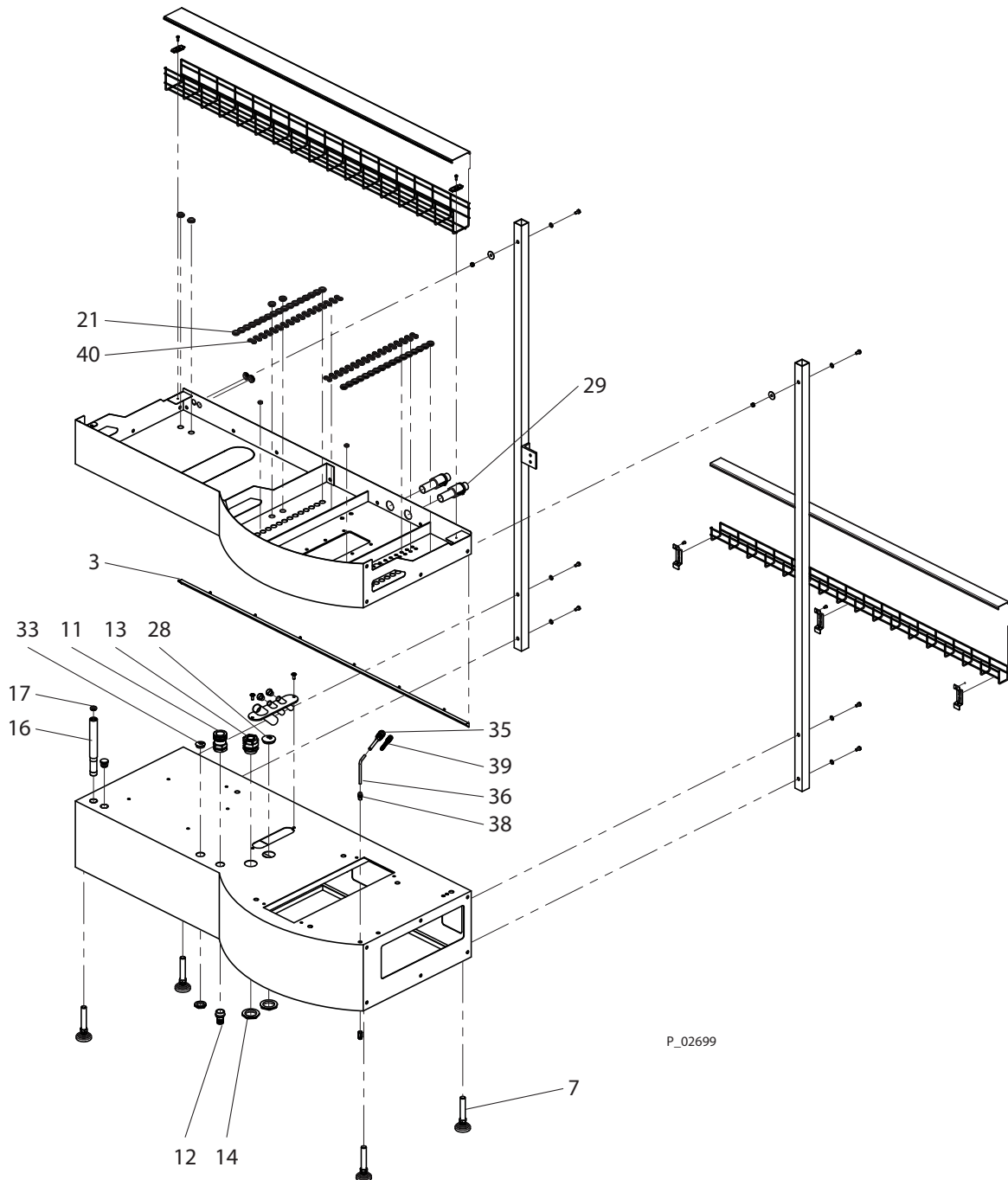


P_02698

Pos	K	Quantity	Order No.	Designation
2		1	2360238	Pneumatic cylinder D25
3		1	2360373	Fork end G23-32
5		1	2360374	Throttle valve exhaust duct
6		1	2360383	Axis for throttle valve
7		2	2360386	Flat gasket for throttle valve
8		2	2360387	Holder flat seal
12		1	2360388	Connecting rod
21		1	2327951	Pressure regulator complete 1"
22		2	2360390	Washer PA

◆ Wearing part

15.16 HOUSING

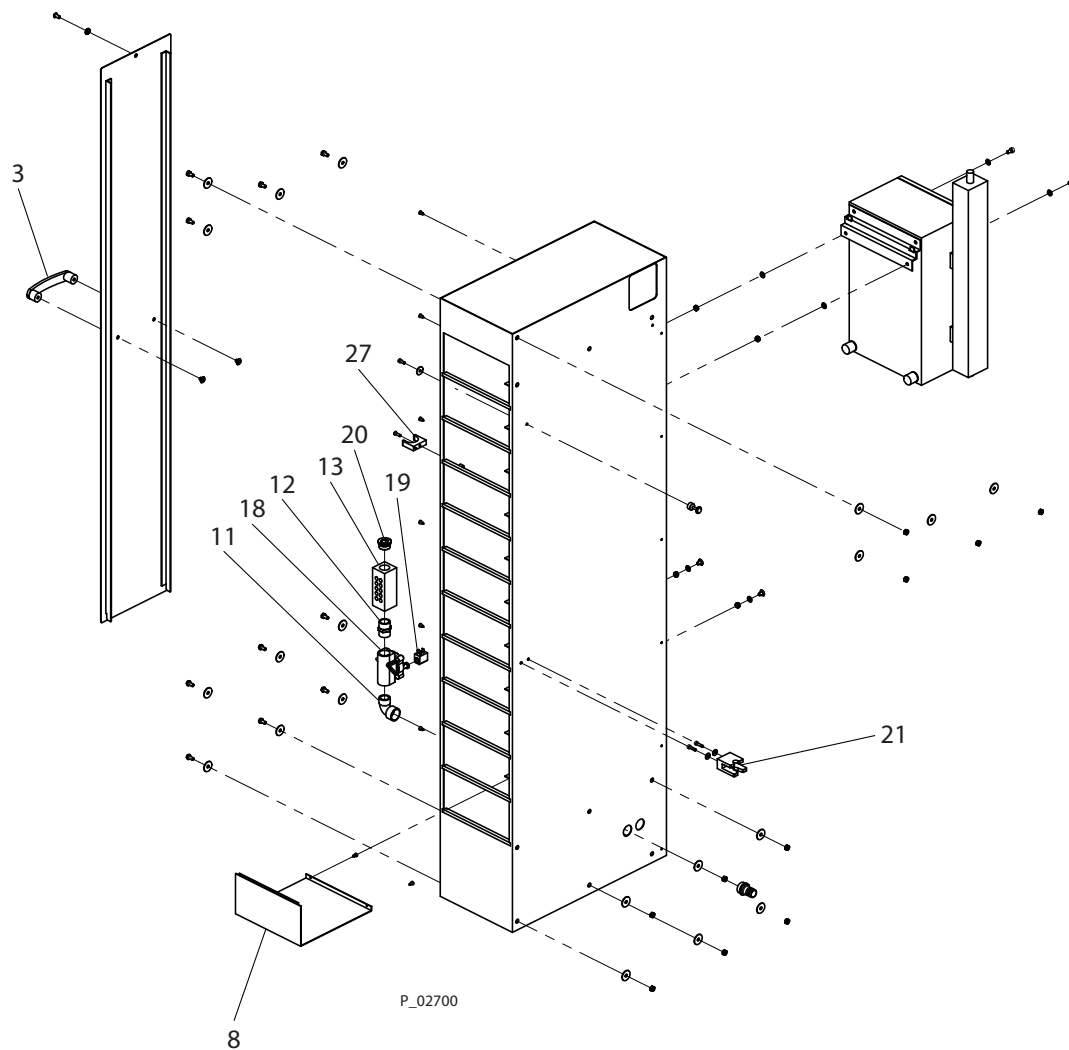


P_02699

Pos	K	Quantity	Order No.	Designation
3		1	2360161	LED lamp, complete
7		4	2360163	Adjustment foot
11		1	2345525	Quick-action coupling G1"
12		1	9985671	Hose fitting G1"- NW25
13		1	2360169	Threaded hose coupling straight PG36
14		2	2360170	Lock nut PG36
16		1	2360171	Cleaning connection pipe
17	◆	1	2360173	Scraper fresh powder tube
21		40	2349423	Protective ring for powder hose
28		1	2360178	Dummy cover PG36
29	◆	2	2316629	Transvector venting
33		1	3156865	Dummy plug
35		1	2316183	Quick-action coupling DN7
36		1	2360232	Hose PU
38		1	2360235	Air hose connection screwed tight 1/4" F-8
39		1	2360237	Non-return valve
40		68	2360181	Cable entry grommet d8

◆ Wearing part

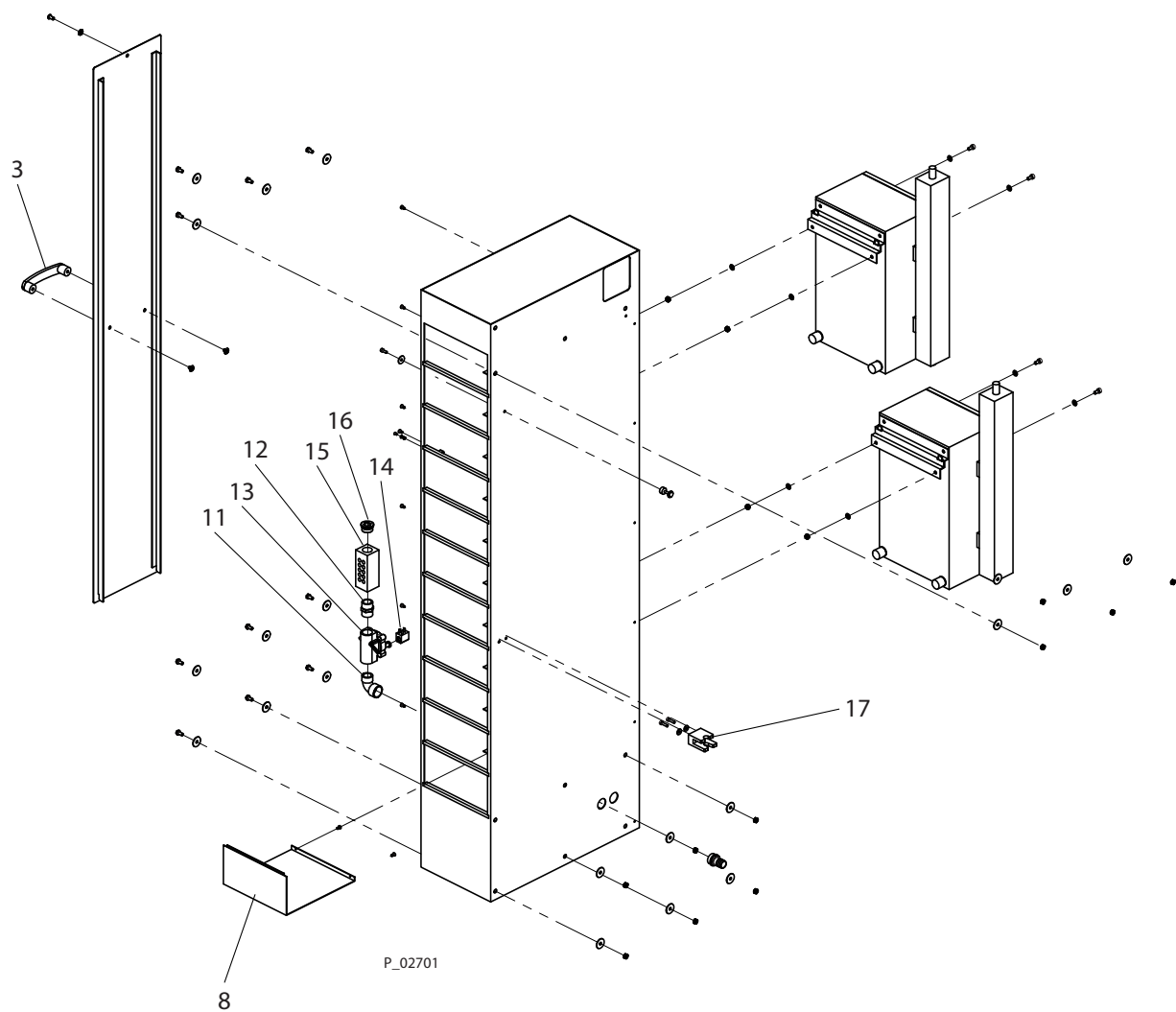
15.17 CONTROL UNIT CABINET (1 IP 5000)



Pos	K	Quantity	Order No.	Designation
3		1	2360490	Handle
8		1	2360491	Module cover EPG housing
11		1	9985613	Angle bracket
12		1	3303062	Double nipple
13		1	2360495	Air manifold block
18		1	2360496	Stop valve 2/2 1"
19		1	2360498	Solenoid stop valve
20		1	9907088	Plug with rim
21		1	2360510	Support bracket fresh powder tube
27		1	2360503	Cable clamp

◆ Wearing part

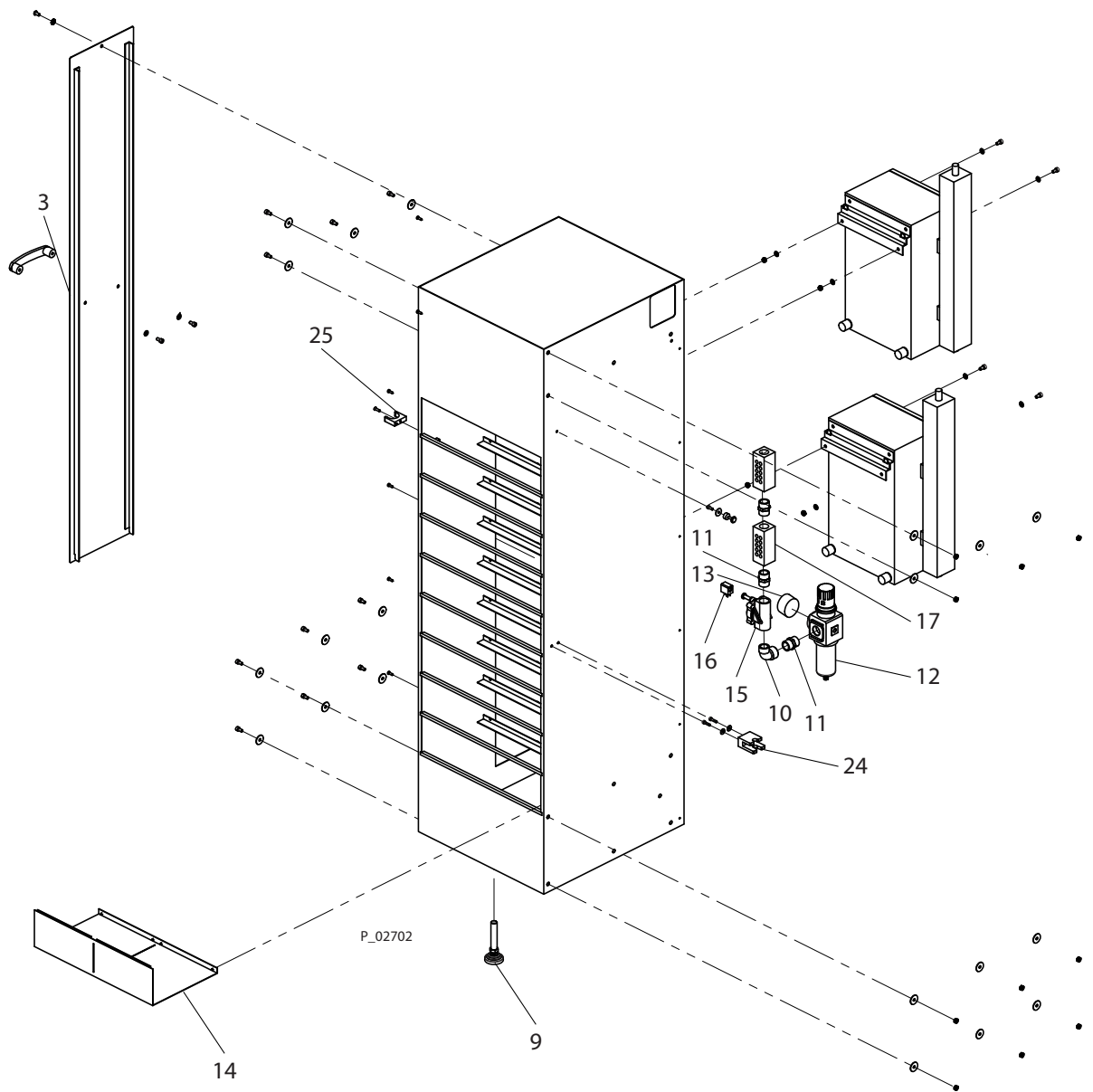
15.18 CONTROL UNIT CABINET (2 IP 5000)



Pos	K	Quantity	Order No.	Designation
3		1	2360490	Handle
8		1	2360491	Module cover EPG housing
11		1	9985613	Angle bracket
12		1	3303062	Double nipple
13		1	2360496	Stop valve 2/2 1"
14		1	2360498	Solenoid stop valve
15		1	2360495	Air manifold block
16		1	9907088	Plug with rim
17		1	2360510	Support bracket fresh powder tube

◆ Wearing part

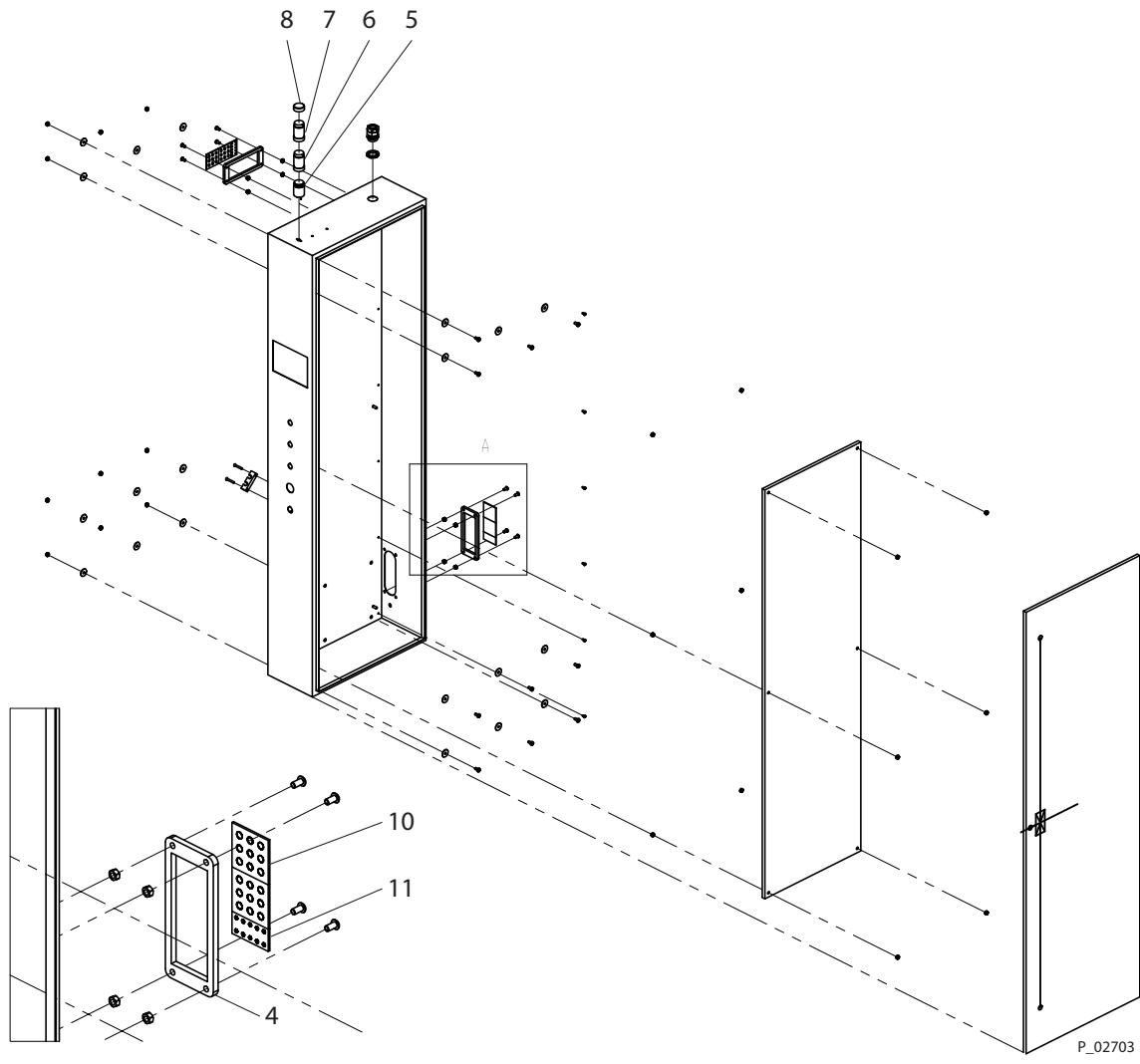
15.19 CONTROL UNIT CABINET (18 EPG)



Pos	K	Quantity	Order No.	Designation
9		1	2360163	Adjustment foot
10		1	9985613	Angle bracket
11		3	3303062	Double nipple
12		1	2333201	Pressure regulator
13		1	3304494	Pressure gauge 0-12 bar 1/4"
14		1	2360514	Module cover double EPG housing
15		1	2360496	Stop valve 2/2 1"
16		1	2360498	Solenoid stop valve
17		2	2360495	Air manifold block
24		1	2360510	Support bracket fresh powder tube
25		1	2360503	Cable clamp

◆ Wearing part

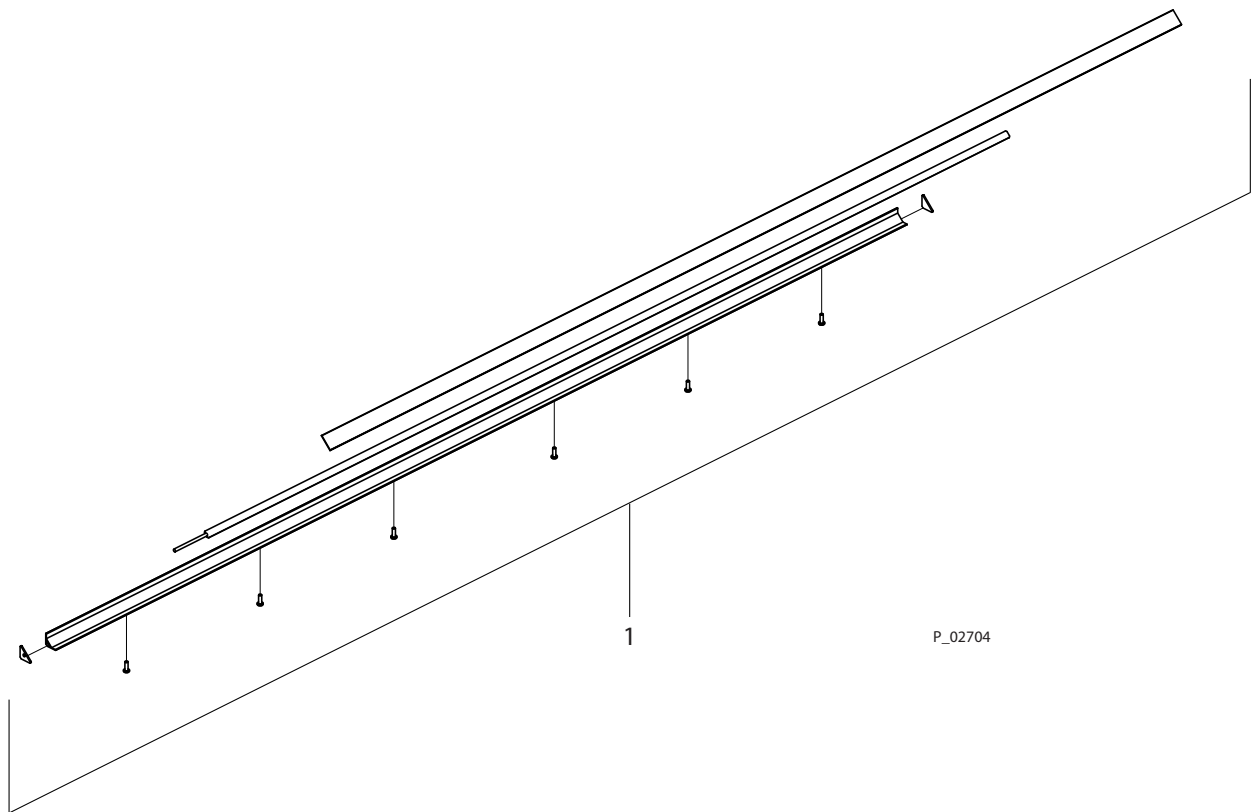
15.20 CONTROL UNIT CABINET CONTROL PANEL



Pos	K	Quantity	Order No.	Designation
4		2	2360470	Frame cable entry plate
5		1	2360481	Status light base element
6		1	2360482	Status light element red
7		1	2360483	Status light element green
8		1	2360481	Status light base element
10		4	2360473	Cable entry plate
11		2	2360486	Cable entry plate

◆ Wearing part

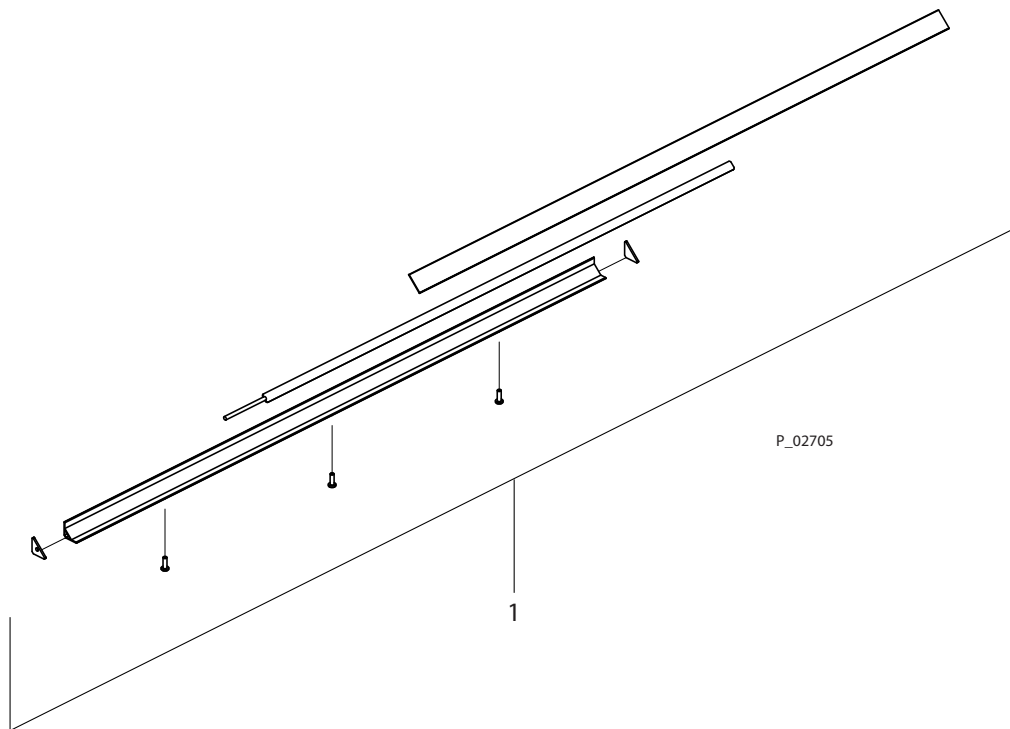
15.21 LED LAMP 1500



Pos	K	Quantity	Order No.	Designation
1		1	2360161	LED lamp, complete

◆ Wearing part

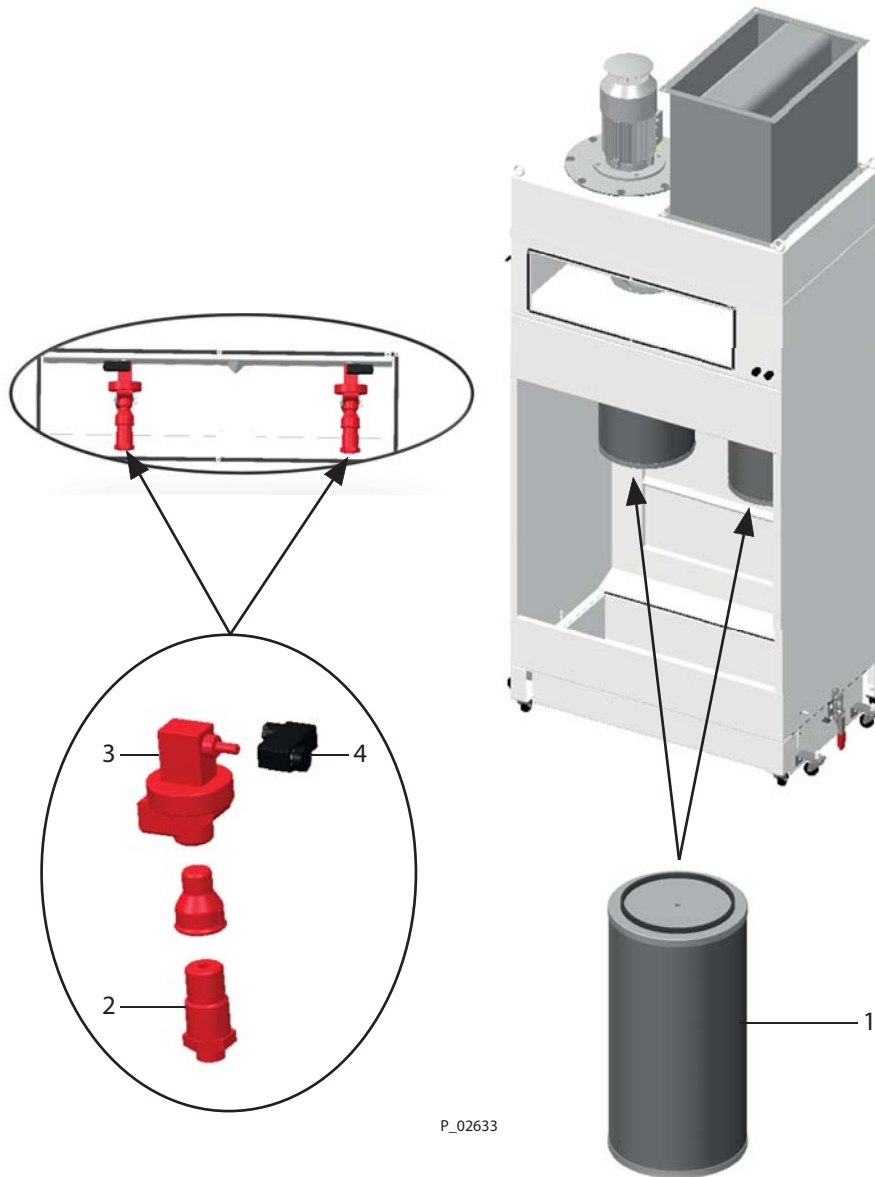
15.22 LED LAMP 700



Pos	K	Quantity	Order No.	Designation
1		1	2360421	LED lamp, complete

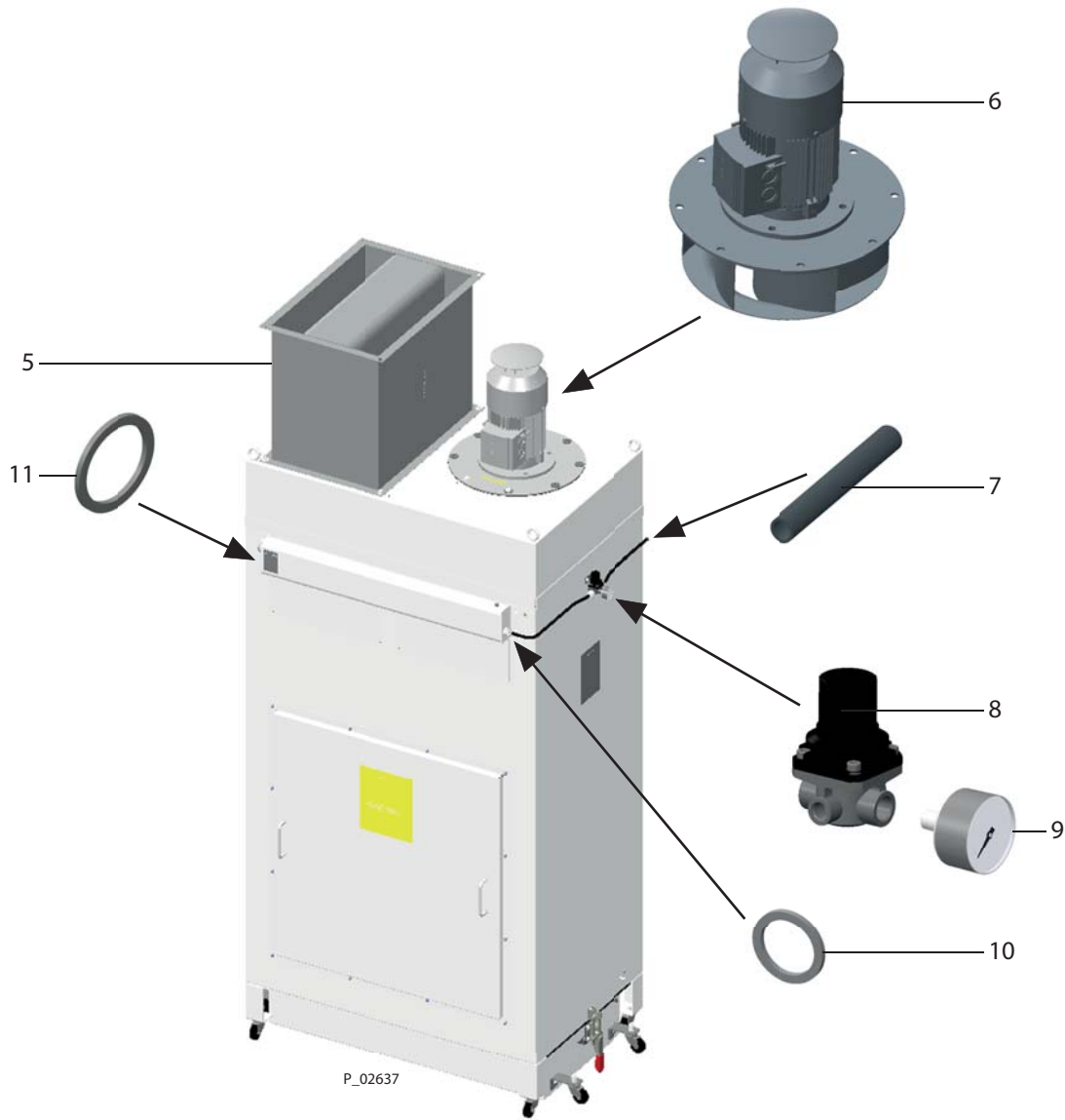
◆ Wearing part

15.23 FINAL FILTER



Pos	K	Quantity	Order No.	Designation
1		2	2341742	Filter cartridge
2		2	3140826	Nozzle
3		2	3303998	Solenoid valve, 2/2 way
4		2	3114850	Valve connector

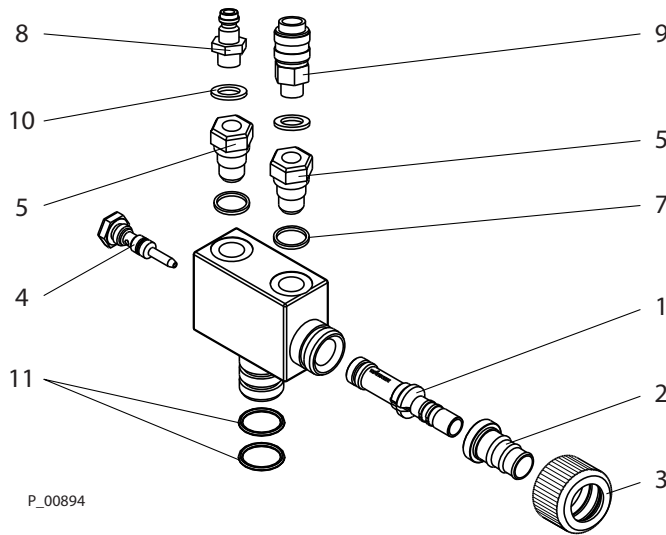
◆ Wearing part



Pos	K	Quantity	Order No.	Designation
5		1	2347702	Splitter attenuator
6		1	2347408	Radial fan
7		1	9987076	Hose
8		1	3060190	Pressure regulator
9		1	114324	Pressure gauge
10		1	3050173	Sealing ring
11		1	3051041	Sealing ring

◆ Wearing part

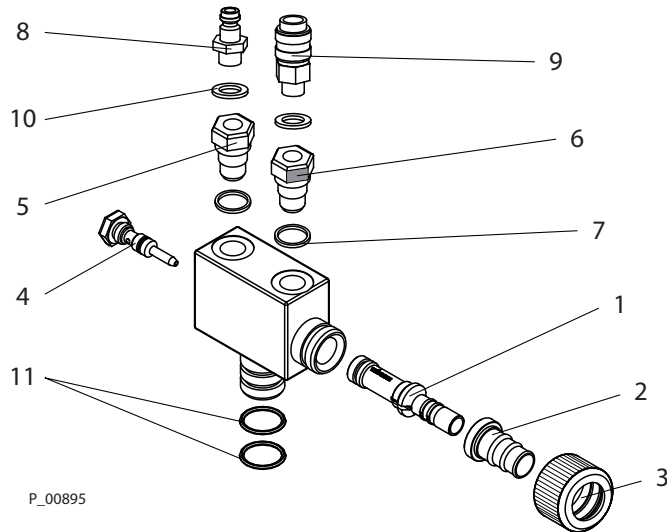
15.24 PI-F1 POWDER INJECTOR



Pos	K	Quantity	Order No.	Designation
			241622	PI-F1 powder injector
1	◆	1	241225	Annular gap collector nozzle
2		1	241476	Conductive nozzle
3		1	241466	Union nut
4	◆	1	241923	Air nozzle
5		2	241460	Spring check valve
7		1	9970149	Sealing ring
8		1	9999047	Quick-release plug
9		1	9999048	Quick-release socket
10		1	9970150	Sealing ring
11	◆	2	9974023	O-ring, electrically conductive

◆ Wearing part

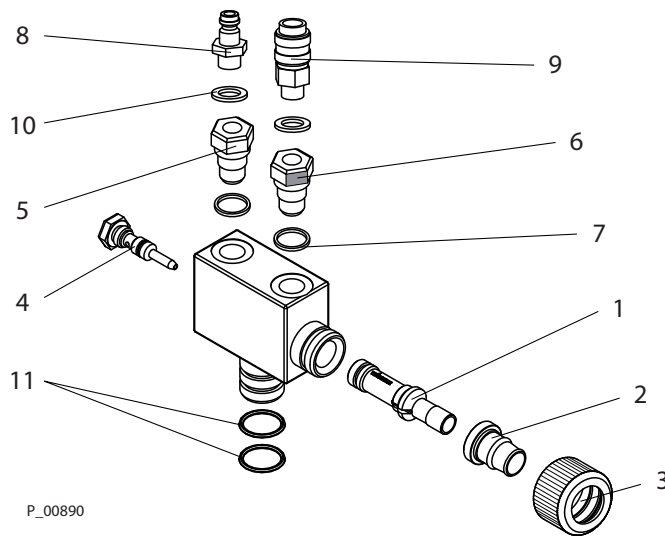
15.25 PI-P1 POWDER INJECTOR



Pos	K	Quantity	Order No.	Designation
			241621	PI-P1 powder injector
1	◆	1	241225	Annular gap collector nozzle
2		1	241476	Conductive nozzle
3		1	241466	Union nut
4	◆	1	241923	Air nozzle
5		1	241460	Spring check valve
6		1	241461	Spring check valve with choke (marked in black)
7		1	9970149	Sealing ring
8		1	9999047	Quick-release plug
9		1	9999048	Quick-release socket
10		1	9970150	Sealing ring
11	◆	2	9974023	O-ring, electrically conductive

◆ Wearing part

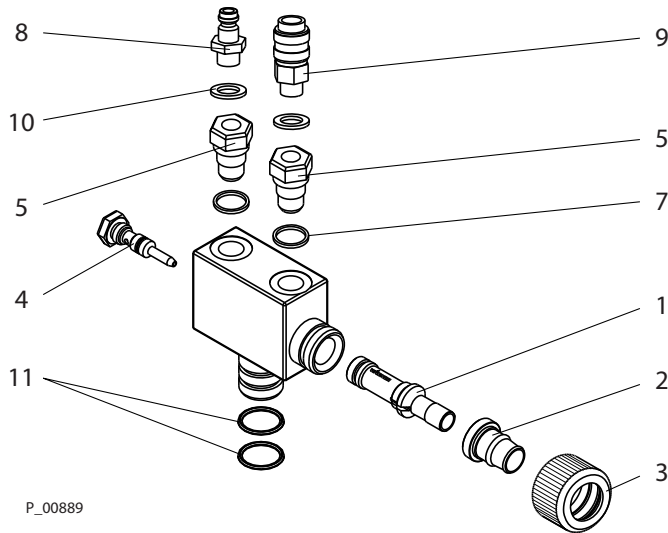
15.26 HICOAT-ED PUMP P



Pos	K	Quantity	Order No.	Designation
			241623	HiCoat-ED pump P
1	◆	1	241229	Collector nozzle low air
2		1	241479	Hose sleeve
3		1	241466	Union nut
4		1	241930	Air nozzle
5		1	241460	Spring check valve
6		1	241461	Spring check valve with choke (marked in black)
7		2	9970149	Sealing ring
8		1	9999047	Quick-release plug
9		1	9999048	Quick-release socket
10		1	9970150	Sealing ring
11	◆	2	9974023	O-ring, electrically conductive

- ◆ Wearing part
- Not part of the standard equipment, but available as a special accessory
- ★ Only available as a set

15.27 HICOAT-ED PUMP F



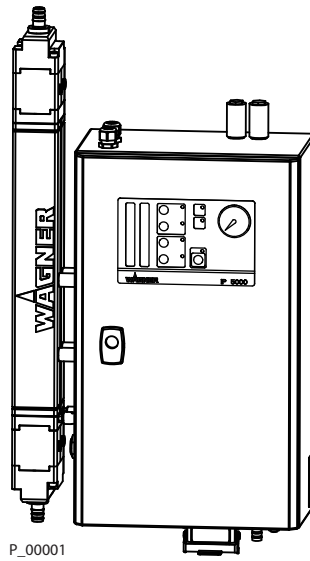
P_00889

Pos	K	Quantity	Order No.	Designation
			241624	HiCoat-ED pump F
1	◆	1	241229	Collector nozzle low air
2		1	241479	Hose sleeve
3		1	241466	Union nut
4		1	241930	Air nozzle
5		2	241460	Spring check valve
7		1	9970149	Sealing ring
8		1	9999047	Quick-release plug
9		1	9999048	Quick-release socket
10		1	9970150	Sealing ring
11	◆	2	9974023	O-ring, electrically conductive

- ◆ Wearing part
- Not part of the standard equipment, but available as a special accessory
- ★ Only available as a set

15.28 FRESH POWDER FEED UNIT

Spare and wearing parts are listed in the operating manual "IP 5000 powder pump" (order No. 241935).



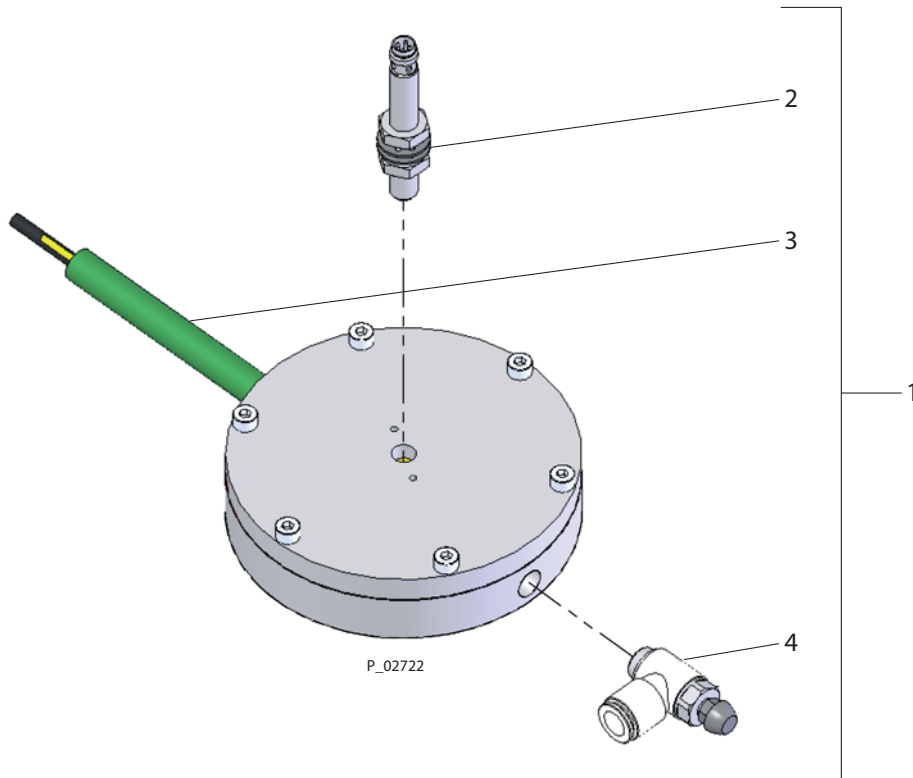
15.29 ULTRASONIC SCREENING UNIT

See ultrasonic screening device operating manual for spare parts and wearing parts (Order No. 2333034).



P_02370

15.30 LEVEL SENSOR



Pos	K	Quantity	Order No.	Designation
1		1	2362329	Pressure sensor, complete (without cable)
2		1	2362330	Proximity switch
3		1	2362332	Connection cable for proximity switch
4		1	2362331	Throttle

- ◆ Wearing part
- Not part of the standard equipment, but available as a special accessory
- ★ Only available as a set

16 WARRANTY DECLARATION AND DECLARATION OF INCORPORATION

16.1 IMPORTANT NOTES REGARDING PRODUCT LIABILITY

As a result of an EC regulation effective from January 1, 1990, the manufacturer shall only be liable for his product if all parts originate from him or are approved by him, and if the devices are properly mounted, operated and maintained.

The manufacturer will not be held liable or will only be held partially liable if third-party accessories or spare parts have been used.

With genuine WAGNER accessories and spare parts, you have the guarantee that all safety regulations are complied with.

16.2 WARRANTY CLAIM

Full warranty is provided for this device:

We will at our discretion repair or replace free of charge all parts which within 24 months in single-shift, 12 months in 2-shift or 6 months in 3-shift operation from date of receipt by the purchaser are found to be wholly or substantially unusable due to causes prior to the sale, in particular faulty design, defective materials or poor workmanship.

The type of warranty provided is such that the device or individual components of the device are either replaced or repaired as we see fit. The resulting costs, in particular shipping charges, road tolls, labour and material costs will be borne by us except where these costs are increased due to the subsequent shipment of the device to a location other than the address of the purchaser.

We do not provide warranty for damage that has been caused or contributed to for the following reasons:

Unsuitable or improper use, faulty assembly or commissioning by the purchaser or a third party, normal wear, negligent handling, defective maintenance, unsuitable coating products, substitute products and the influence of chemical, electrochemical or electrical agents, except when the damage is attributable to us.

Components that have not been manufactured by WAGNER are subject to the original warranty of the manufacturer.

Replacement of a component does not extend the period of warranty of the device.

The device should be inspected immediately upon receipt. To avoid losing the warranty, we or the supplier company are to be informed in writing about obvious faults within 14 days upon receipt of the device.

We reserve the right to have the warranty compliance met by a contracting company.

The services provided by this warranty are dependent on evidence being provided in the form of an invoice or delivery note. If the examination discovers that no warranty claim exists, the costs of repairs are charged to the purchaser.

It is clearly stipulated that this warranty claim does not represent any constraint on statutory regulations or regulations agreed to contractually in our general terms and conditions.

J. Wagner AG

16.3 DECLARATION OF INCORPORATION (STATEMENT OF CONFORMITY)

The PXM powder center is an incomplete machine. Commissioning is only permitted if it has been determined that the machine/system in which it is to be installed conforms to the guidelines.

Only then may the CE mark be used.

See Appendix A (H.B. S.a.s. di Luigi Volontè e C.)

DECLARATION OF INCORPORATION (Fac-Simile)

According to annex II.B of the European Directive 2006/42/EC relating to Machineries ad according to all other applicable European Directives,

We:

H.B. S.a.s. di Luigi Volontè e C.
Via Carlo Porta,13 – 23861 – Cesana Brianza (LC) - ITALY

declare, as Manufacturers of the machinery in the scope of this declaration, that the following :

Model: Powder center
Type: PXM - ITA
Serial Number : FAC-SIMILE
Year of manufacturing : FAC_SIMILE

Are designed and manufactured according to the following European Directives:


-	European Directive	2006/42/EC	Safety of Machineries
-	European Directive	2004/108/EC	Electromagnetic compatibility
-	European Directive	94/9/EC	ATEX
-	European Directive	2006/95/CE	Low voltage

And aligned to the following harmonized standards:

European Directive	94/9/EC	
EN 13463-1:2009	Non-electrical equipment for potentially explosive atmospheres — Part 1: Basic method and requirements	
European Directive	2006/42/EC	
EN 12100:2010	Safety of machinery - General principles for design - Risk assessment and risk reduction (ISO 12100:2010)	
EN 60204-1:2006	Safety of machinery - Electrical equipment of machines - Part 1: General requirements	
EN 12981 : 2005 + A1 : 2009	Coating plants - Spray booths for applications of organic powder coating material. Safety requirements	
European Directive	2006/95/CE	
EN61439-1 : 2011	Low-voltage switchgear and control gear assemblies. General rules	
EN 60204-1:2006	Safety of machinery - Electrical equipment of machines - Part 1: General requirements	
European Directive	2004/108/EC	
EN 61000-6-4:2006	Electromagnetic compatibility (EMC) - Part 6-4: Generic standards - Emission standard for industrial environments	
EN 61000-6-2:2005	Electromagnetic compatibility (EMC) - Part 6-2: Generic standards - Immunity for industrial environments	

The electrical installation is also compliant with the following European Standard:

EN 60079-14: 2014	Explosive atmospheres -- Part 14: Electrical installations design, selection and erection
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Do not change the document or the safety relevant information without approval of the MACHINERY expert			
	Declaration of Incorporation Powder center – PXM-ITA	Issued	
		Approved	PXM-ITA R0 04/05/2015
		Mach Expert	sheet 1 of 2
H.B. S.a.s. di Luigi Volontè e C. – Via Carlo Porta, 13 - 23861 Cesana Brianza (LC)			

ATEX conformity assessment procedure has been executed according to Annex VIII of European Directive 94/9/EC producing the following technical file,

serial.as4

The ATEX marking is the following: II 3/-D T85°C IP54 -0°C≤Tamb≤+40°C

MACHINERY conformity assessment procedure has been executed according to Annex VIII of European Directive 2006/42/EC producing the following technical file,

serial.as4

EMC conformity assessment procedure has been executed according to Annex II of European Directive 2004/108/EC producing the following technical file,

serial.as4

Low voltage conformity assessment procedure has been executed according to Annex IV of European Directive 2006/95/EC producing the following technical file,

serial.as4

We hereby declare that the person authorized to assemble the Machinery technical file is:

Luigi Volontè

Address: Via Carlo Porta, 13
Cesana Brianza (LC) - Italy



Essential health and safety requirements that are not met and are on charge to the user

With reference to Annex I of Directive 2006/42/EC shows the Essential Health and Safety are in part or entirely on charge to the installer and user. Installer and user are invited to take charge of the resolution of open points before operation of the machine.


- 1.1.4 Lighting
- 1.1.7. Operating positions
- 1.2.4.1. Normal Stop
- 1.2.4.4. Assembly of machinery
- 1.2.5. Selection of control or operating modes
- 1.2.6. Failure of the power supply
- 1.5.6. Fire
- 1.5.16 Lightning

This partly completed machinery must not be put into service until the final machinery into which it is to be incorporated has been declared in conformity with the provisions of this Directive.

Cesana Brianza, XX/XX/XXXX

Luigi Volontè
CEO

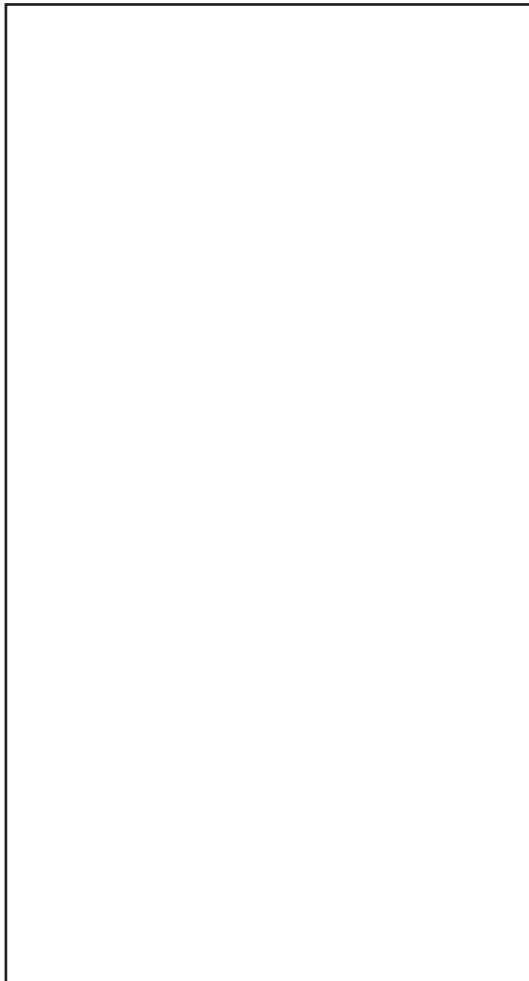


Do not change the document or the safety relevant information without approval of the MACHINERY expert			
	Declaration of Incorporation Powder center – PXM-ITA	Issued	
		Approved	
		Mach Expert	
H.B. S.a.s. di Luigi Volontè e C. – Via Carlo Porta, 13 - 23861 Cesana Brianza (LC)		PXM-ITA R0 04/05/2015 sheet 2 of 2	

17 ELECTRICAL CONNECTION PLANS

See supplied circuit diagrams in the control cabinet.

WAGNER



Order No. 2350372

Edition 08/2015

Germany

J. WAGNER GmbH

Otto-Lilienthal-Str. 18

Postfach 1120

D- 88677 Markdorf

Phone +49/ (0)7544 / 5050

Telefax +49/ (0)7544 / 505200

E-mail service.standard@wagner-group.com

Switzerland

J. WAGNER AG

Industriestrasse 22

Postfach 663

CH- 9450 Altstätten

Phone +41/ (0)71 / 757 2211

Telefax +41/ (0)71 / 757 2222

More contact addresses on the internet at:

www.wagner-group.com

Company/Locations/WAGNER worldwide

Subject to changes without notice