

NORDSON CORPORATION

Powder Coating Systems



Color Change Procedures ColorMax® Engineered Powder Booth with Spectrum® Feed Center

1108062A





WARNING: Allow only qualified personnel to perform the following tasks. Follow the safety instructions in your powder coating equipment manuals.

Procedure 1

OPERATOR A

1



Close the booth doors.
Move the booth offline if it is a Roll On/Roll Off booth.

2



Blow off:

- door seams at the entrance end
- operator doors
- gun slots

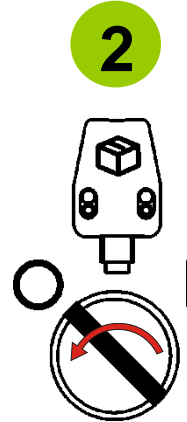
Go to page 10.

Procedure 2

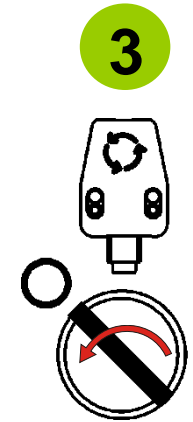
OPERATOR B



Turn OFF the Sieve.



Turn OFF the virgin
transfer pump.



Turn OFF the reclaim
transfer pump.

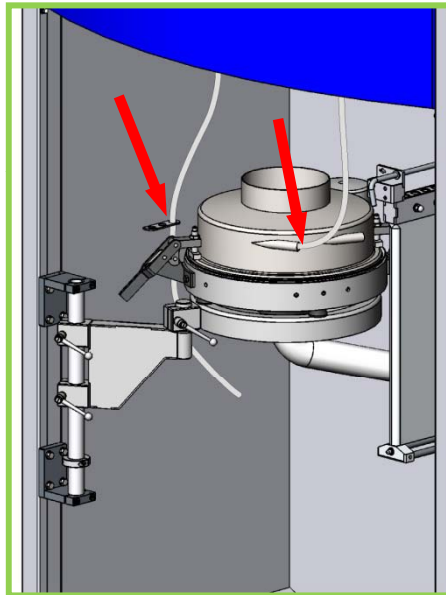
Procedure 2

OPERATOR B

4

Disconnect the reclaim and virgin transfer hoses from the sieve deck. (Virgin pump and hose are optional.)

Place the ends of the transfer hose(s) into the purge bracket.



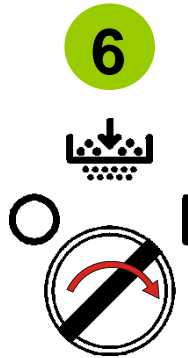
5



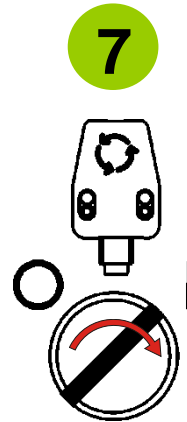
Unclamp the sieve and turn the pan chute so that it dumps toward the exhaust duct. Reclamp the sieve.

Procedure 2

OPERATOR B



Turn ON the sieve.



Turn ON the reclaim pump.



Turn ON the Color Change switch:

- Lance moves up.
- Gun external blow-off starts.
- Color Change Light blinks once per second.

Procedure 3

OPERATOR B

1



Turn OFF the Vibratory Table, if used (optional).

2



If using a fluidizing hopper, turn the fluidizing air off and disconnect the air tubing from the hopper first.

3



Remove the powder source from the feed center.

Procedure 3

OPERATOR B

4



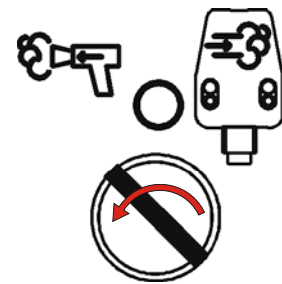
Blow off the lance assembly.

5



Gun Blow Off Done
Color Change Light blinks
two times per second.

6



Turn the Purge Select switch to the Internal Gun position.

- Lance moves down to the purge position.
- Purge clamp engages.
- Internal gun purge sequence begins.

Procedure 4

OPERATOR B

1



Internal Gun Purge Done
Color Change Light blinks
three times per second.

Turn the sieve OFF.

OPERATOR A:
Start cleaning the booth.
Go to page 10.

2



Unclamp the sieve deck and
remove the deck and screen.

Blow off the deck, screen, and
pan.

3



Assemble the sieve
with the pan chute
toward the lances.

Procedure 5

OPERATOR A

1



Blow off door sills at entry end of the booth, then enter booth and blow off ceiling and walls.

2



Blow off AeroDecks.™

DO NOT SCRATCH BOOTH INTERIOR OR TOUCH WITH BARE HANDS.

For Hard-to-Clean Powders: Use damp cotton towels to wipe down the booth interior, inlet duct, and vertical duct.

3



Blow out inlet duct and vertical duct.

4

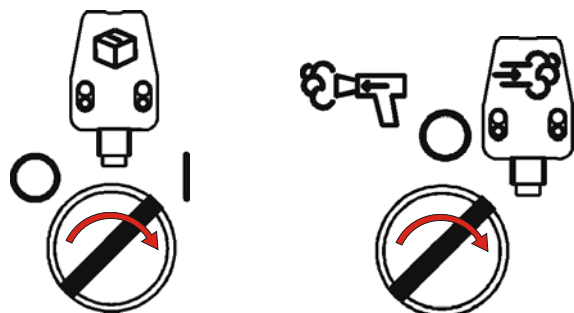


Set AeroDecks in operating position and exit booth.

Procedure 6

OPERATOR A

1

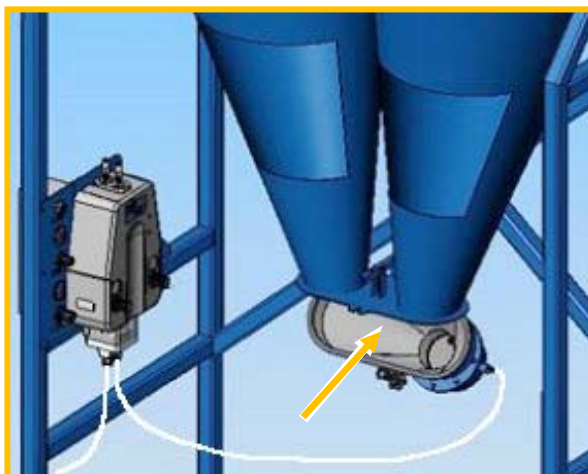


Turn ON the virgin transfer pump.

Make sure the transfer hoses are parked in the transfer hose bracket.

Turn the Purge Select switch to the Pump Purge position.

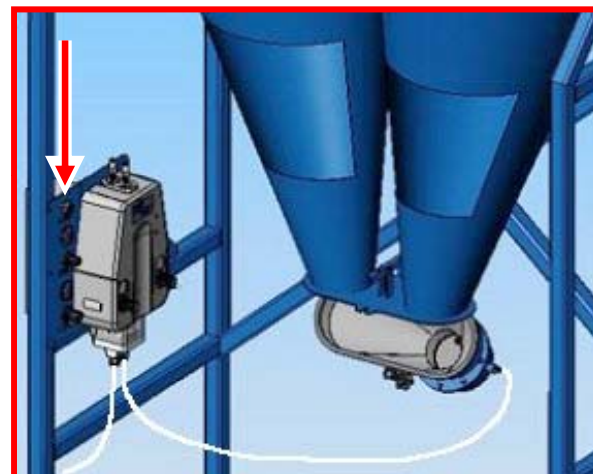
2



While the virgin and reclaim pumps are purging, open the transfer pan and blow out all powder remaining in pan.

When the pump purge sequence is complete the Color Change Light stops blinking and stays lit.

3



If the pump purge sequence completes before the pan is clean, **press and hold** the MANUAL PURGE button on the reclaim pump panel to finish cleaning the pan.

Procedure 6

OPERATOR A

4



Open the cyclone access doors and blow off the interiors using the short wand, then the long wand.

For Hard-to-Clean Powders Only:

With a damp cotton towel, wipe all surfaces inside the cyclone and transfer pan.

5



Close and latch the cyclone access doors.

6

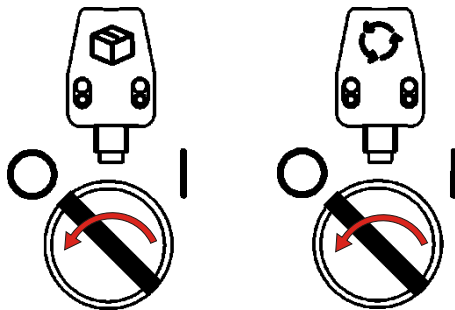


Close and latch the transfer pan.

Procedure 7

OPERATOR B

1



When the pump purge sequence is complete the Color Change Light stops blinking and stays lit.

Turn OFF the virgin and reclaim transfer pumps.

2

Blow off:

- Lances and pumps
- Lift assembly
- Sieve and mounting bracket
- Transfer hoses and bracket
- Vibrator table
- Purge manifold and cylinder under table
- Feed center interior

Wipe down the feed center interior with a damp cotton towel, if necessary.



Procedure 7

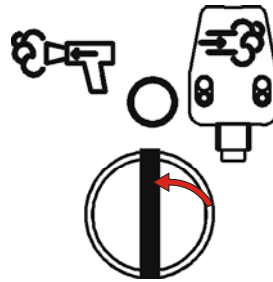
OPERATOR B

3



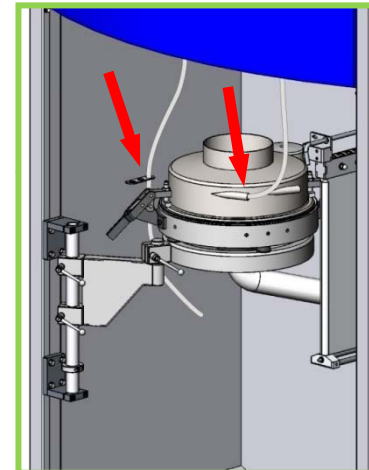
Turn OFF the Color Change switch. The Color Change Light turns off.

4



Turn OFF the Purge Select switch.

5



Remove the transfer hoses from the bracket and connect them to the sieve deck.

Procedure 7

OPERATOR B

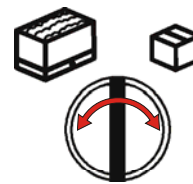
6



Install a new powder feed source on the vibratory table.

If the source is a feed hopper, connect fluidizing air tubing to the hopper.

7

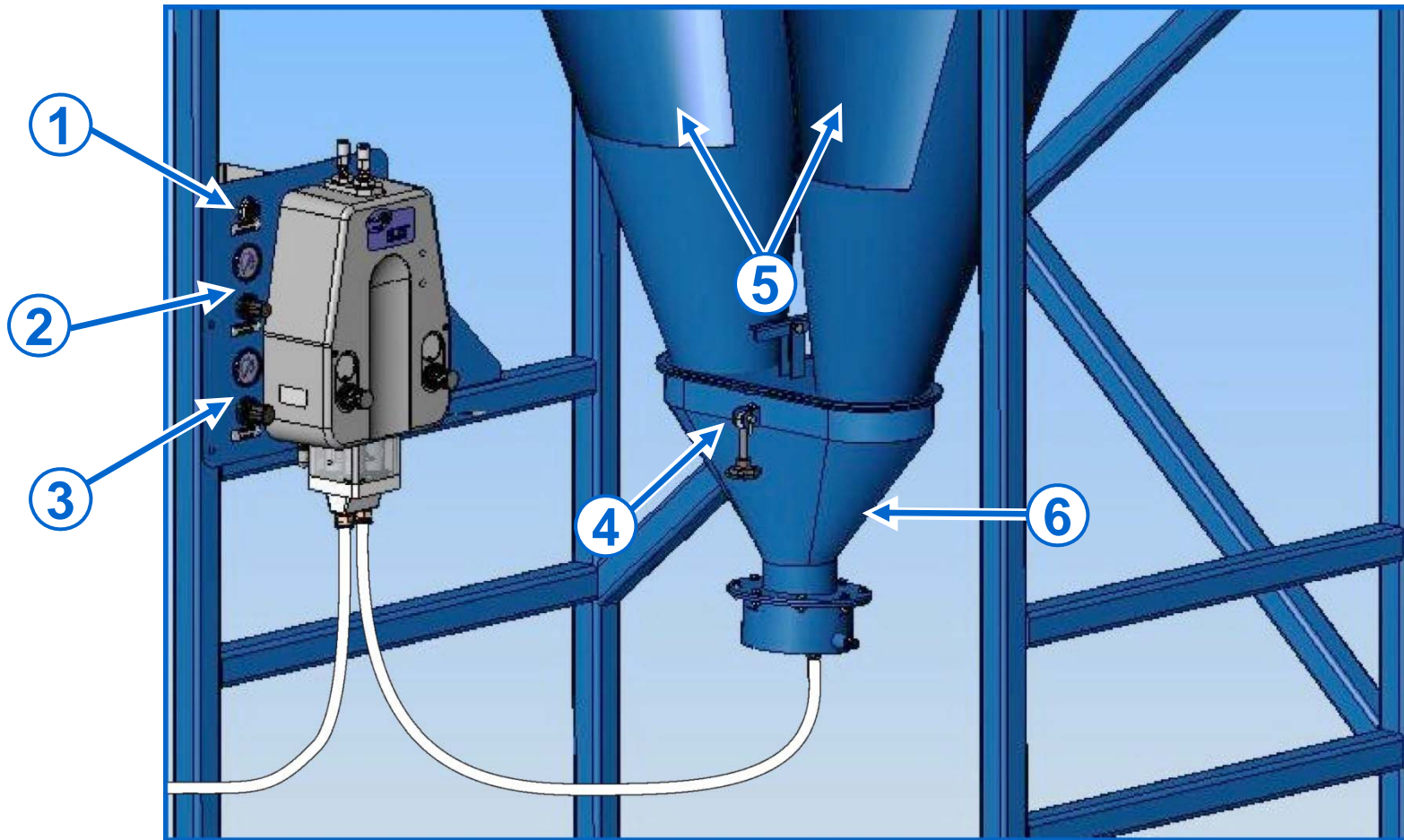


Select hopper or box.

Turn ON the sieve and reclaim transfer pump.

Turn ON the vibratory table and virgin transfer pump, if used.

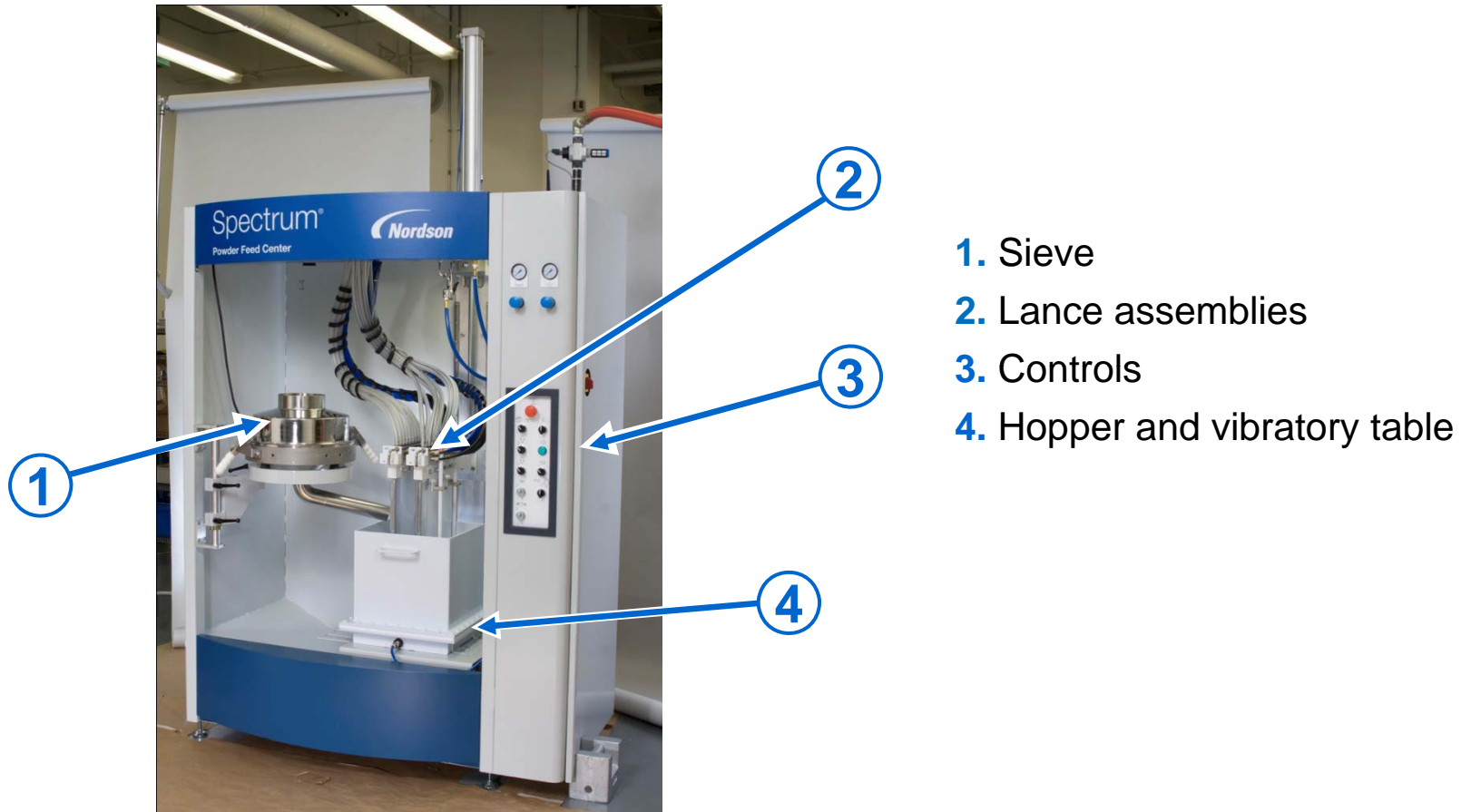
Cyclone Components



- 1. MANUAL PURGE button
- 2. Reclaim pump supply air regulator/gauge
- 3. Transfer pan fluidizing air regulator/gauge

- 4. Transfer pan latch
- 5. Cyclone access doors
- 6. Transfer pan

Feed Center Components



Nordson Corporation • 300 Nordson Drive • Amherst, Ohio 44001



Nordson Corporation • Amherst, Ohio • USA