

Spectrum® VT and HD Feed Centers - Color Change Procedure

CAUTION: For all blow-off procedures, use the grounded blow-off spray gun and hose assembly provided by Nordson Corporation.

NOTE: Images shown with VT. The software screen shots show the color change procedure using a powder box. Any differences in procedure for a drum unloader will be noted in the text of that particular step.

1 Prepare for the Color Change Procedure



1. Close the booth doors.
 2. Operator can press the *Clean Cycle* button to initiate blow-off of the automatic spray guns. This does **not** start the color change procedure.
- Note:** The light tower on top of the feed center provides illuminated and audible status indication.

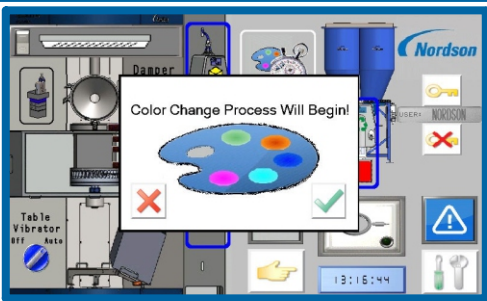
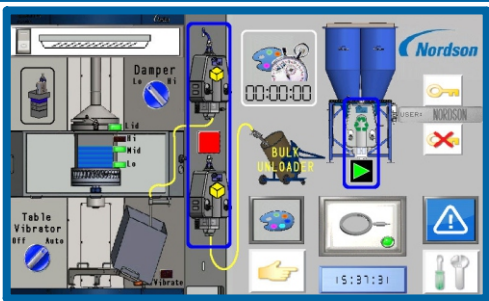


Light Tower Indicator Definitions
■ System Off - Exhaust Fan Off- Major Fault
■ System On - Exhaust Fan On

■ **Solid:** Active Step in Color Change
Slow Flash (1-second pause): Completed Step in Color Change
Fast Flash (1/2-second pause): Running Fault related to low powder, vibratory table, ultrasonic sieve, or main air low pressure.


2 Begin the Color Change Procedure

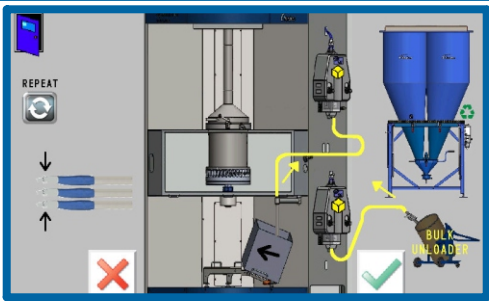
1. Select the *Color Change*  icon.
2. Select the  to confirm beginning the color change procedure.



3 Prepare for Hopper Purge


The system will begin to purge the automatic spray guns.

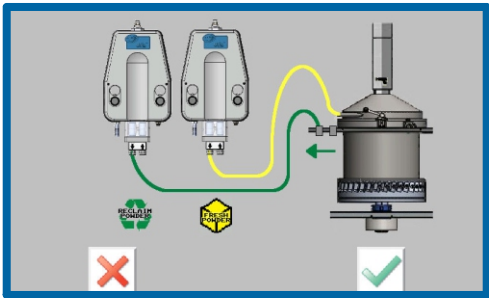
1. Remove the pick-up tube from the box and blow it off.
2. Place the pick-up tube in the holder.
3. Move the powder box onto the vibratory table beneath the hopper.
4. Select the  when the spray guns are purged and the previous steps are completed.



Note: Long pick-up tubes are used for drums and short pick-up tubes are used for customer-supplied bins. For a drum unloader, remove both pick-up tubes, blow them off, and secure them in their respective holders. Then, a customer-supplied bin should be placed on the vibratory table beneath the hopper.

4 Move the Reclaim Hose

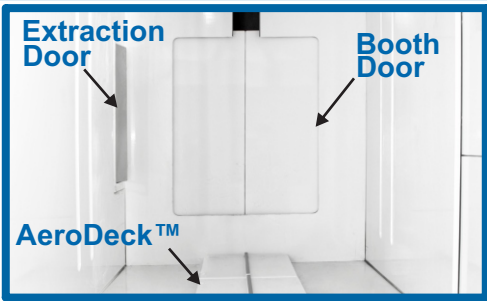
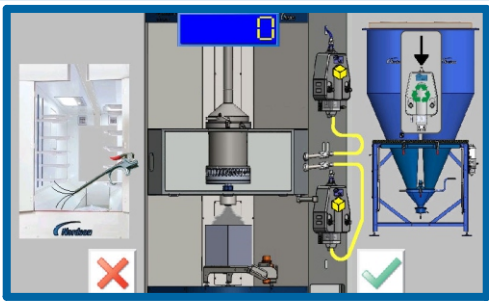
1. Move the reclaim (green) hose from the hopper to either waste port.
2. Select the  when the hose is moved.




5 Clean the Booth

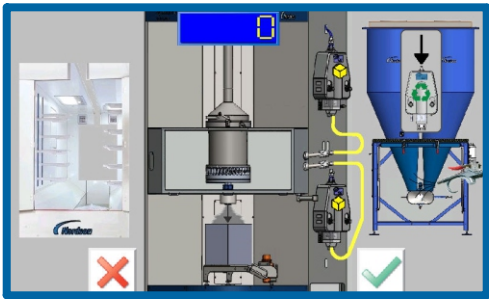
A countdown timer will begin to indicate when the hopper is empty of all powder.

1. Blow off the door sills at the entry of the booth, then enter the booth and blow off interior beginning with the ceiling and ending with the floor.
2. Blow off the AeroDecks™.
3. Blow off the extraction door.





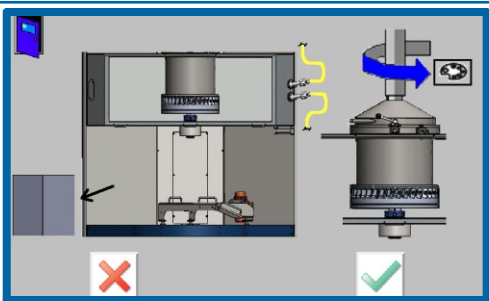
6 Clean the Cyclone Pan

1. Open the transfer pan and blow it clean while the bulk feed and reclaim pumps are purging.
2. Blow clean the bottom flange of the cyclone.
3. Lock the transfer pan in the *Open* position.
4. Blow off the manual spray gun sleeve and nozzle.
5. Select the  when these steps are completed.



7 Return to the Feed Center

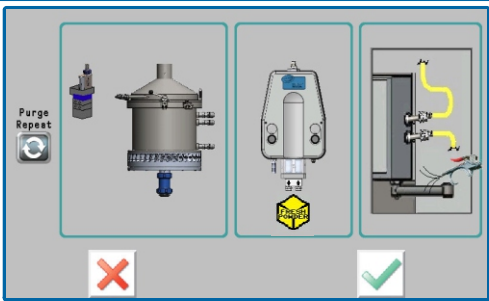
1. Remove the box/bin.
2. Turn the stack sleeve to *Color Change*  mode.
3. Select the  when these steps are completed.



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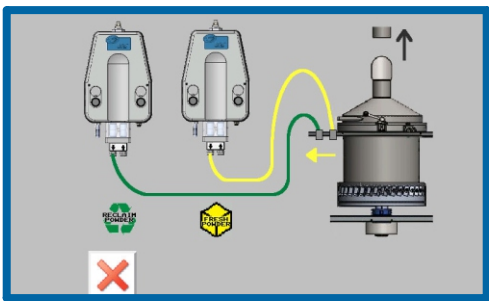
8 Blow Off Pick-Up Tube Arm

- The hopper and fresh powder pump will begin to purge.
1. Blow off the pick-up tube arm.
 2. Select the when the purge is complete and the box or bin is removed.



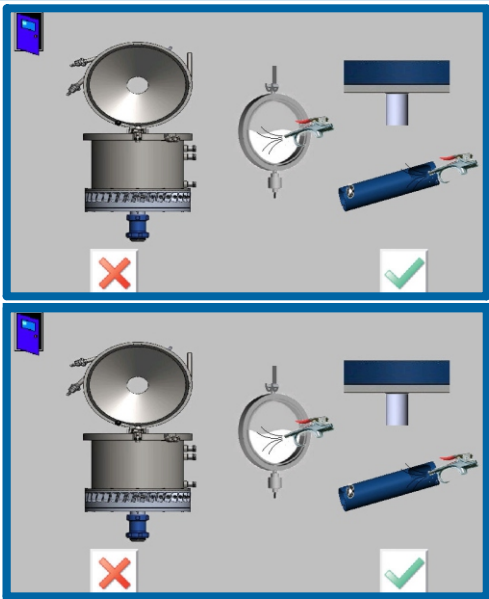
9 Move the Fresh Powder Hose

1. Move the fresh powder (yellow) hose from the hopper to the waste port. Both the reclaim (green) and fresh powder (yellow) hoses should be on the waste ports.
2. Lift the stack sleeve and lock it in place so it is in the *Up* position.
3. Select the when these steps are completed.



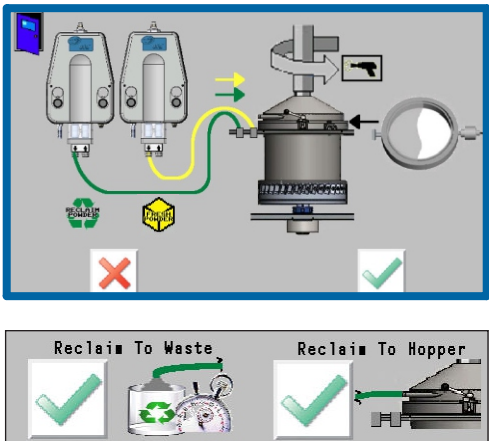
10 Clean Critical Points on the Feed Center

- Note:** If *Reclaim to Waste* timer mode is selected, then the reclaim (green) hose will not be moved to the hopper until the timer times out and the operator is notified.
1. Lift the hopper lid.
 2. Remove, blow off, and hang the sieve.
 3. Remove and blow off the stack sleeve.
 4. Blow off all critical points (noted in the image).
 5. Select the when these steps are completed.
- Note:** Be sure to blow off all visible powder, including the vibratory table, the inlets on the hopper, and behind the hopper lid.



11 Reassemble the Feed Center Components

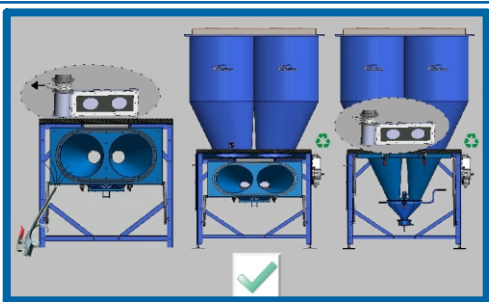
1. Move the reclaim (green) and fresh powder (yellow) hoses back to the hopper.
2. Replace the stack sleeve and lock it in the *Paint Mode* .
3. Replace the sieve.
4. Close the hopper lid.
5. Select the when these steps are completed.



Note: System has optional configuration to initiate a timed reclaim-to-waste function.

12 Clean the Cyclone

1. Open the cleaning duct slide gate.
2. Blow off the lower section of the cyclone.
3. Blow off the upper section of the cyclone.
4. Swing the lower section of the cyclone down and latch it closed.
5. Swing the transfer pan down and latch it closed.
6. Close the cleaning duct slide gate.
7. Open the booth doors at the entry of the booth.
8. Select the when these steps are completed.

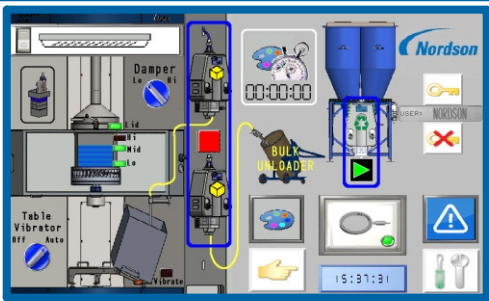


Note: The slide gate is located behind the cyclone.

13 Complete the Color Change

1. Load a new box of powder into the *Feed Position* on the vibratory table.
2. Select the red *Transfer Pump* icon to fill the hopper with the new powder color.
3. Once the screen shows the hopper is full , begin spraying the new powder color.

Note: Within 60 seconds, the reclaim pump will automatically turn on. It can be turned off, but to begin again, it will have to be turned on manually.



Reclaim to Waste Time complete
Stop Pump, Move Reclaim Hose to Hopper



Note: If the timed reclaim-to-waste option was configured, a popup will appear to signify completion.