Rotary Sieve 360 + Hopper

Customer Product Manual Part 7580607_04 Issued 11/24

For parts and technical support, call the Industrial Coating Systems Customer Support Center at (800) 433-9319 or contact your local Nordson representative.

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NORDSON Deutschland GmbH

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Change Record

Revision	Date	Change



EC DECLARATION OF CONFORMITY

ACCORDING TO CE DIRECTIVE 2006/42/ EC ANNEX II A

DESCRIPTION:	Rotary Sieve Station
FAMILY/MODELS:	AZO E360/650 with hopper All variants and models
APPLICABLE DIRECTIVES & STAN TO VERIFY COMPLIANCE:	Directive 2006/42/EG (Machinery) 2014/34/EU Explosive Atmosphere EN 60204-1: 2005 "Safety of Machinery - Electrical equipment of machines" EN ISO 12100 "Safety of machinery - Basic concepts, general principles for design"

MARKING OF PRODUCT:

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The equipment delivered is generally intended to be part of a powder coating system, and can be operated on its own or in conjunction with other equipment. In order to be in full compliance with the CE machinery directive and its amendments, the customer is obliged to

In order to be in full compliance with the CE machinery directive and its amendments, the customer is obliged to respect the applicable regulations for his powder coating system upon incorporation of the equipment in the powder coating plant and before starting operation.

We hereby declare that the product specified conforms to the directives and standards described above and that it has been provided with a CE label. Provided the product is installed and operated in line with the Nordson manuals, its operation is safe.

Name and address of the responsible person authorized to compile the technical file

K. Kai Flockenhaus

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Date: 03/08/17

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Safety

Read and follow these safety instructions. Task- and equipment-specific warnings, cautions, and instructions are included in equipment documentation where appropriate.

Make sure all equipment documentation, including these instructions, are accessible to all persons operating or servicing equipment.

For additional Safety information specific to the Rotary Sieve, please ensure you read the AZO technical manual. This is available upon request from Nordson.

Qualified Personnel

Equipment owners are responsible for making sure that Nordson equipment is installed, operated, and serviced by qualified personnel. Qualified personnel are those employees or contractors who are trained to safely perform their assigned tasks. They are familiar with all relevant safety rules and regulations and are physically capable of performing their assigned tasks.

Intended Use

Use of Nordson equipment in ways other than those described in the documentation supplied with the equipment may result in injury to persons or damage to property.

Some examples of unintended use of equipment include

- using incompatible materials
- making unauthorized modifications
- · removing or bypassing safety guards or interlocks
- using incompatible or damaged parts
- using unapproved auxiliary equipment
- operating equipment in excess of maximum ratings

Regulations and Approvals

Make sure all equipment is rated and approved for the environment in which it is used. Any approvals obtained for Nordson equipment will be voided if instructions for installation, operation, and service are not followed.

All phases of equipment installation must comply with all federal, state, and local codes.

Personal Safety

To prevent injury, follow these instructions.

- Do not operate or service equipment unless you are qualified.
- Do not operate equipment unless safety guards, doors, or covers are intact and automatic interlocks are operating properly. Do not bypass or disarm any safety devices.
- Ensure the system is securely fixed to the floor before operation.
- Keep clear of moving equipment. Before adjusting or servicing, shut off the power supply and wait until the equipment comes to a complete stop. Lock out power and secure the equipment to prevent unexpected movement.
- Relieve (bleed off) pneumatic pressure before adjusting or servicing pressurized systems or components. Disconnect, lock out, and tag switches before servicing electrical equipment.
- Ensure the powder pump has stopped feeding powder to the sieve prior to removing the waste bucket/collector. Do not allow the waste powder collector to overfill. Clean any excess/spilt powder immediately, using a vacuum or cloth.
- Obtain and read Safety Data Sheets (SDS) for all materials used. Follow the manufacturer's instructions for safe handling and use of materials, and use recommended personal protection devices.
- Wear appropriate personal protective clothing including gloves and breathing mask plus anything else recommended from the material supplier and the SDS.
- To prevent injury, be aware of less-obvious dangers in the workplace that often cannot be completely eliminated, such as hot surfaces, sharp edges, energized electrical circuits, and moving parts that cannot be enclosed or otherwise guarded for practical reasons.

Fire Safety

To avoid a fire or explosion, follow these instructions.

- Do not smoke, weld, grind, or use open flames where flammable materials are being used or stored.
- Provide adequate ventilation to prevent dangerous concentrations of volatile materials or vapors. Refer to local codes or your material SDS for guidance.
- Do not disconnect live electrical circuits while working with flammable materials. Shut off power at a disconnect switch first to prevent sparking.
- Know where emergency stop buttons, shutoff valves, and fire extinguishers are located. If a fire starts in a spray booth, immediately shut off the spray system and exhaust fans.
- Clean, maintain, test, and repair equipment according to the instructions in your equipment documentation.
- Use only replacement parts that are designed for use with original equipment. Contact your Nordson representative for parts information and advice.

Transport	
	Transport the unit so as to avoid damage. Use suitable packaging materials and sturdy cartons. Protect the unit from exposure to humidity, dust and vibrations.
Unpacking	
	Upon receipt, unpack the Rotary Sieve & Hopper carefully to avoid damage. Report any damage immediately to the shipper and to your Nordson representative. Save packing materials for possible later use, or dispose of properly according to local regulations.
Removing	
	Switch off the mains supply, then disconnect all electrical and pneumatic connections from the unit.
Storage	
eterage	Switch off the mains supply, then disconnect all electrical and pneumatic connections from the unit.
Disposal	
·	Dispose of equipment and materials used in operation and servicing according to local codes.

Installation



WARNING: Allow only qualified personnel to perform the following tasks. Follow the safety instructions in this document and all other related documentation.

Do not position the Rotary Sieve & Hopper assembly in an EX-Zone.

NOTE: The ATEX zone for inside the Rotary Sieve & Hopper are according to the Ex–Drawing supplied with the system. If the unit was supplied alone (not part of a full system) the details of the ATEX zone can be found on the serial number identification plate.

Preparing for Installation

Position the Rotary Sieve & Hopper assembly on a level floor. Secure the frame to the floor using suitable anchors/bolts. The location must be according to the general layout drawing supplied by Nordson engineering, when part of a system.

Electrical Connections



WARNING: Equipment damage may occur if the electrical panel is connected to any line voltage other than that stated on the identification plate. Power to the Rotary Sieve Assembly must be supplied from a locking disconnect switch or breaker. Failure to observe this warning may result in a severe shock during installation or repair.

Make sure that all electrical cables are correctly rated and suitable for the ambient temperature of the installation area. Provide adequate fuse/circuit protection from the power supply. Refer to the foldout wiring diagrams and schematics at the end of this manual for more information.

Initial start-up should be performed only by a Nordson field engineer or technician.

Pneumatic Connections

For the connection size, location and volume required please refer to your Service Requirements drawing or contact your Nordson representative. Clean, dry, compressed air should be supplied from a refrigerated or desiccant air dryer and filter/separators. Refer to the Operation section for compressed air specifications.

Note: For information on the Rotary Sieve please refer to technical manual of AZO.

Grounding



WARNING: Operating faulty electrostatic equipment is hazardous and can cause electrocution, fire, or explosion. Make resistance checks part of your periodic maintenance program. If you receive even a slight electrical shock or notice static sparking or arcing, shut down all electrical or electrostatic equipment immediately. Do not restart the equipment until the problem has been identified and corrected.

Grounding inside and around the booth openings must comply with EN50050-2, EN50177, EN16985, latest conditions.

- All electrically conductive objects in the spray areas shall be electrically connected to ground with a resistance of not more than 1 megohm as measured with an instrument that applies at least 500 volts to the circuit being evaluated.
- Equipment to be grounded includes, but is not limited to, the floor of the spray area, operator platforms, hoppers, photoeye supports, and blow-off nozzles. Personnel working in the spray area must be grounded.
- There is a possible ignition potential from the charged human body. Personnel standing on a painted surface, such as an operator platform, or wearing non-conductive shoes, are not grounded. Personnel must wear shoes with conductive soles or use a ground strap to maintain a connection to ground when working with or around electrostatic equipment.
- Operators must maintain skin-to-handle contact between their hand and the gun handle to prevent shocks while operating manual electrostatic spray guns. If gloves must be worn, cut away the palm or fingers, wear electrically conductive gloves, or wear a grounding strap connected to the gun handle or other true earth ground.
- Shut off electrostatic power supplies and ground gun electrodes before making adjustments or cleaning powder spray guns.
- Connect all disconnected equipment, ground cables, and wires after servicing equipment.

Action in the Event of a Malfunction

If a system or any equipment in a system malfunctions, shut off the system immediately and perform the following steps:

- Disconnect and lock out electrical power. Close pneumatic shutoff valves and relieve pressures.
- Identify the reason for the malfunction and correct it before restarting the equipment.

Description – full assembly

The E360 rotary sieve, screens the reclaimed powder. The sieve and hopper assembly supplies reclaimed powder for up to 28 powder coating guns on the Venturi system and 32 on the HDLV, depending on the type of powder and screen mesh. A 510 micron mesh screen is standard with alternative options 160, 205, 245 micron in conductive carbon and 200, 250, 400 and 850 in nylon mesh. A three-phase AC electric motor drives the sieve rotor. A variety of voltage and frequency ratings are available on request.



Figure 1360 Rotary Sieve + Hopper assembly (Organic HDLV and PE Venturi version shown above)The Rotary Sieve + Hopper assembly is available in 3 variations.

Option	Part Number	Description	Notes
1	7035235	Rotary Sieve 360 – HDLV	
2	7035236	Rotary Sieve 360 – Venturi, Organic	
3	7035311	Rotary Sieve 360 – Venturi P.E.	A – B

NOTE A: Magnet Grate to be ordered separately

B: Only available as part of an engineered system

Using the Illustrated Parts List

Numbers in the Item column correspond to numbers that identify parts in illustrations following each parts list. The code NS (not shown) indicates that a listed part is not illustrated. A dash (—) is used when the part number applies to all parts in the illustration.

The number in the Part column is the Nordson Corporation part number. A series of dashes in this column (-----) means the part cannot be ordered separately.

The Description column gives the part name, as well as its dimensions and other characteristics when appropriate. Indentations show the relationships between assemblies, sub–assemblies, and parts.

- If you order the assembly, items 1 and 2 will be included.
- If you order item 1, item 2 will be included.
- If you order item 2, you will receive item 2 only.

The number in the Quantity column is the quantity required per unit, assembly, or subassembly. The code AR (As Required) is used if the part number is a bulk item ordered in quantities or if the quantity per assembly depends on the product version or model.

Letters in the Note column refer to notes at the end of each parts list. Notes contain important information about usage and ordering. Special attention should be given to notes.

ltem	Part	Description	Quantity	Note
—	0000000	Assembly	1	
1	000000	Subassembly	2	A
2	000000	• • Part	1	

Configuration 1 – Rotary Sieve 360 – HDLV





Figure 2 360 Rotary Sieve Assembly – HDLV – Configuration 1

ltem	Part	Description	Quantity	Note	
-	7035235	ROTARY SIEVE 360 – HDLV	1	A	
1	-	 SIEVE, ROTARY, E360 + KIT, PNEUMATIC 	1	В	
2	-	HOPPER, HDLV	1	B – C	
3	-	 STAND ASSEMBLY, ROTARY SIEVE 360, HDLV 	1	B – D	
	-	KIT, ROTARY SIEVE, HDLV	1	B – E	
4	7035476	 VENT HOSE 50MMX3M,SPIRAL,WASTE BUCKET 	1		
5	7035489	 VENT HOSE, CONDUCTIVE, 100MM,1M 	1		
6	144837	BUCKET,SCRAP,SIEVE,5 GAL	1	F	
NOTE A: Main Assembly – control panel and valve island included					
В	: Subassemb	ly			
C	: Includes 3 le	evel sensors complete with 2 m cables and IO Link Module.	See page 23.		
D	D: Includes mini cyclone and damper				
E: Includes venting hoses					

F: Waste Bucket must be ordered separately

Note: Care must be taken to ensure there is no sag in the venting hoses as this could allow powder to collect inside and block the venting flow. Pay attention to the location of the vents.





Configuration 2 – Rotary Sieve 360 – Venturi



Figure 4 360 Rotary Sieve Assembly – Venturi – Configuration 2

ltem	Part	Description	Quantity	Note	
_	7035236	ROTARY SIEVE 360 – VENTURI, ORGANIC	1	А	
1	-	 SIEVE, ROTARY, E360B + KIT, PNEUMATIC 	1	В	
2	-	HOPPER, VENTURI	1	B – C	
3	-	 STAND ASSEMBLY, ROTARY SIEVE 360, VENTURI 	1	B – D	
	-	 KIT, ROTARY SIEVE, VENTURI 	1	B – E	
4	7035476	 VENT HOSE 50MMX3M,SPIRAL,WASTE BUCKET 	1		
5	7035489	 VENT HOSE, CONDUCTIVE, 100MM,1M 	1		
6	144837	BUCKET,SCRAP,SIEVE,5 GAL	1	F	
NOTE A: Main Assembly – control panel and valve island included					
В	B: Subassembly				
С	C: Includes 3 level sensors complete with 2 m cables and IO Link Module. See page 23.				
D	D: Includes mini cyclone and damper				
E	E: Includes venting hoses				
F: Waste Bucket must be ordered separately					

Note: Care must be taken to ensure there is no sag in the venting hoses as this could allow powder to collect inside and block the venting flow.







Configuration 3 – Rotary Sieve 360 – Venturi, PE





Figure 6 360 Rotary Sieve Assembly – PE – Venturi – Configuration 3

Item	Part	Description	Quantity	Note	
-	7035311	ROTARY SIEVE 360 – VENTURI, PE	1	А	
1	-	 SIEVE, ROTARY, E360B + KIT, PNEUMATIC 	1	В	
2	-	HOPPER, VENTURI	1	B – C	
3	-	 STAND ASSEMBLY, ROTARY SIEVE 360, PE 	1	B – D	
	-	 KIT, ROTARY SIEVE, VENTURI 	1	B – E	
4	7035476	VENT HOSE 50MMX3M,SPIRAL,WASTE BUCKET	1		
5	5 7035489 • VENT HOSE, CONDUCTIVE, 100MM,1M		1		
6	144837	BUCKET,SCRAP,SIEVE,5 GAL	1	F	
7	1018903	GRATE, TRAMP IRON, 4 TUBE, 8.5 X6	1	G	
NOTE A	NOTE A: Main Assembly – control panel and valve island included				
В	B: Subassembly				
C: Includes 3 level sensors complete with 2 m cables and IO Link Module. See page 23.					
D	D: Includes mini cyclone and damper				

- E: Includes venting hoses
- F: Waste Bucket must be ordered separately
- G: Magnets must be ordered separately. See page 17

Note: Care must be taken to ensure there is no sag in the venting hoses as this could allow powder to collect inside and block the venting flow. Pay attention to the location of the vents.





Description and Parts – HDLV – 150L Powder Feed Hopper

The HDLV–150L Powder Feed Hopper is used to hold the virgin and reclaimed powder when using Nordson HDLV powder feed pumps. It comes fitted with casters and removable lid for easy operator access. Fitted with level sensors, it automatically monitors the powder level and maintains the required level of powder.

HDLV Powder Pick-up Lance must be ordered separately. Use link below for appropriate manual. https://emanuals.nordson.com/finishing/files/Powder/1084294.pdf



Figure 8 HDLV–150L Hopper assembly

- 1. INSPECTION COVER
- 5. VENT AIRFLOW DAMPER
 6. HOPPER VENT
- 2. PICK-UP LANCE PORT
 3. FLUID BED, HOPPER, 150L
 7.
- 4. POWDER RETURN
- 7. LATCH
- 8. LEVEL SENSOR
- 9. FLUIDISING AIR
- CONNECTION
- 10. CASTOR WHEEL
- 11. PICK-UP LANCE

HDLV-150L Hopper assembly Specifications - See spare parts list on page 23

Powder Capacity	150 litre
HDLV apertures	2 * 16 Pick–Up Lance (32 guns max)
Dimensions in mm (L x D x H)	1025x600x730 (includes castors and latches)
Capacity	70kg
Fluidising Air Pressure	1.0–2.7 bar (15–40 psi)
Fluidising Air Tubing diameter	10 mm (ring main)

Description and Parts – Venturi – 150L Powder Feed Hopper

The Venturi – 150L Powder Feed Hopper is used to hold the virgin and reclaimed powder when using Nordson Encore powder feed pumps. It comes fitted with casters and removable lid for easy operator access. Fitted with level sensors, it automatically monitors the powder level and maintains the required level of powder.

Powder pumps must be ordered separately. Use links below for appropriate manuals. **Organic** – https://emanuals.nordson.com/finishing/files/Powder/1095927_02.pdf **PE** – https://emanuals.nordson.com/finishing/files/Powder/1602273_01.pdf



Note: Vibrator turbine only fitted to PE systems

Venturi – 150L Hopper assembly Specifications – See spare parts list on page 23

Powder Capacity	150 litre
Venturi Pumps	Up to 28 pumps
Dimensions in mm (L x D x H)	1025x600x730 (includes castors and latches)
Capacity	70kg
Fluidising Air Pressure	1.0–2.7 bar (15–40 psi)
Fluidising Air Tubing diameter	10 mm (ring main)

Description – Mini Cyclone

The Mini Cyclone is used as an accumulator for virgin and reclaimed powder. Both are fed to the Mini Cyclone in order to mix and blend prior to sieving. By default, it has 10 inlets. As standard, 2 inlets come with a hose tail connector for powder hose. Blank caps are provided for the rest.



Figure 10	Mini Cyclone Assembly	

ltem	Description	Notes
1	Push in fitting 10 mm – air assist for systems vented to a booth	A
2	Spare powder inlets	В
3	Mini Cyclone body	
4	Powder inlet hose tail connection for powder hose. 1/2"	С
5	Vent to booth or Afterfilter	
6	Over centre clamp- GH-40323-SS	
7	Vent to atmosphere – only use when connected to Afterfilter	D
8	Damper – adjust airflow based on extraction	E
9	Damper – adjust airflow based on extraction	F

NOTE A: Not required if venting to an Afterfiler/extract system.

- B: The system is supplied with 2 hose connectors as standard (item 4). If more inlets are required, additional hose tail connectors (item 4) will need to be sourced locally.
- C: 2 supplied as standard
- D: If venting to an Afterfilter, remove blank plug and adjust damper (item 8) as required.
- E: This damper should be adjusted to allow air movement, but not enough to create a vacuum at the vertical vent pipe of the mini cyclone. Only used when vented to an Afterfilter.
- F: This damper should be set so that air movement is allowed to vent the excess air, but not create a vacuum at the mini cyclone.

Description – Magnetic Separator

The Magnetic Separator is used to remove the finest magnetic particles that could contaminate powder, particularly with porcelain enamel powders. Release the 2 draw latches to open the door to gain access.





Figure 11	Magnetic Separator Assembly
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Item	Part Number	Description	Notes
-	-	SEPERATOR, MAGNETIC, SIEVE, E360B	
1	1018903	GRATE,TRAMP IRON,4 TUBE,8.5 X6	A

NOTE A: Magnets are ordered separately. One set is required.

Description – Accumulator

The Accumulator is used to receive and mix both fresh and reclaimed powder, prior to entering the sieve. Supplied with 4 transfer hose connectors + 12 more blanks to allow for more inlets. The Accumulator is particularly used with Porcelain Enamel powders and is capable of handling higher volumes of powder than the Mini Cyclone.



Figure 12 Accumulator Assembly

ltem	Description	Notes
-	ACCUMULATOR,MINI,SIEVE,E360B,W/4 HOSE BR	
1	Vent to atmosphere – only use when connected to Afterfilter	A
2	Damper – adjust airflow based on extraction	В
3	Damper – adjust airflow based on extraction	С
4	Powder inlet hose tail connection for powder hose. 1/2"	D
5	BRACKET,SUPPORT,TRANSFER HOSE	
6	Push in fitting 10 mm – air assist, only for systems vented to a booth	E
7	Vent to booth or afterfilter	
8	Cap, PVC, Inlet	
9	Spare powder inlets (*12)	
10	Accumulator body	

NOTE A: If venting to an Afterfilter, remove blank plug and adjust damper (item 2) as required.

- B: This damper should be adjusted to allow air movement, but not enough to create a vacuum at the vertical vent pipe of the mini cyclone. Only used when vented to an Afterfilter.
- C: This damper should be set so that air movement is allowed to vent the excess air, but not create a vacuum at the mini cyclone.
- D: The system is supplied with 4 hose connectors as standard. If more inlets are required, additional hose tail connectors (item 4) will need to be sourced locally.
- E: Not required if venting to an Afterfiler/extract system.

Operation



WARNING: Allow only qualified personnel to perform the following tasks. Follow the safety instructions in this document and all other related documentation.

1. Before starting your powder coating system, make sure of the following:

All air tubing, transfer hoses, vent & waste hoses and electrical cables are securely connected.

All doors are correctly installed and closed/clamped to the housing.

2. Turn on the system compressed air supply and electrical power.

3. Start the booth exhaust fan. In most systems, this will start the sieve motor.

4. Set the sieve air pressures and flow rates.

Sieve Configurations	Fine Pressure Valve	Restriction Valve Festo VA 1/4"	Air in NI/min
All 360 Assemblies	2 bar	5 (4.75) cycles open	180 – 200

5. Adjust the vent-assist air pressure.

6. Apply the following settings:

Mini Cyclone – 1.5 – 2 bar (application depending)

Hopper fluidisation – 1.5 – 2.5 bar (application depending)

Sieve seals - 2 bar

NOTE: Check the air regulator and restriction valve settings when you start the system. Check the restriction valve periodically during the day to make sure air is being supplied to the bearings. Check the bearings for powder when you are cleaning the sieve. If the lip seals are undamaged, but powder has contaminated the bearings, increase the purge air pressure.

Air quality must be according to ISO 8573.1 Class 1:4:2

Incoming air pressure must not exceed 7 bar ,maximum.

Maintenance



WARNING: Allow only qualified personnel to perform the following tasks. Follow the safety instructions in this document and all other related documentation.

NOTE: Maintenance procedures given here are for the general assembly only. Refer to your system component manuals for maintenance procedures for all other system equipment. For all maintenance requirements of the rotary sieve, please refer to the AZO E360B technical manual; this can be supplied by Nordson upon request.

Daily Maintenance

Note: You may need to perform these procedures more or less often, depending on your application requirements.

Component	Maintenance Procedure
Cables, Tubing, and Feed Hoses	Check all external cables, powder hoses, and air tubing for damage. Repair or replace as necessary
HDLV Transfer Pumps	Purge the pumps. Inspect the pinch valve body for signs of powder leakage. If powder is present in the pinch valve section, replace the pinch valves. Refer to the Prodigy HDLV High–Capacity pump manual for repair procedures
Powder Supply	Check the powder supply level regularly and add powder as necessary
Compressed Air Supply	Check the compressed air dryers and filters. Drain filters if needed. Perform maintenance as necessary
Enclosure	Clean the interior and exterior of the Rotary Sieve Assembly. Check all equipment ground connections
Venting	Check and clean sieve and hopper venting hoses
Hopper	Check hopper fluidisation is correct. Gently simmering evenly.

Periodic Maintenance

Note: You may need to perform these procedures more or less often, depending on your application requirements.

Component	Maintenance Procedure
Compressed Air System	Open the drop leg and use a clean, white cloth to check for contaminants. Correct any problems immediately. Drain the air filters and change the elements as necessary.
Electrical System	Tighten all electrical connections and inspect tor loose or broken wires. Check the electrical system tor electrical safety every 12 months. The system must comply with all local, state, and federal codes.
System Grounds	Check all equipment grounds. Electrical equipment must be grounded according to the relevant code. For maximum transfer efficiency and safety, electrostatic equipment must be grounded to provide a complete circuit from the product, through the hangers, conveyors booth and back to the gun controllers.
	Refer to Grounding in the Safety section of this manual and to publication number TCTT-06-3881 on the Nordson emanuals website (http://emanuals.nordson.com/finishing) for more information on powder coating system grounding.
Air Tubing	Pressurise the system and identify if there any air leaks. Replace or repair any damaged fittings or tubing.

Sieve Maintenance

Refer to the AZO Rotary Sieve manual for more information on sieve maintenance. Available upon request from Nordson.

Festo Valve Island Maintenance

Manual: Valve terminals MPA-S (Typ32)

https://www.festo.com/cat/de_de/data/doc_engb/PDF/EN/TYP32_EN.PDF

Troubleshooting



WARNING: Allow only qualified personnel to perform the following tasks. Follow the safety instructions in this document and all other related documentation.

These troubleshooting procedures cover only the most common problems. If you cannot solve a problem with the information given here, contact your local Nordson representative for help.

	Problem	Possible Cause	Corrective Action
1.	Good powder in the waste container	Powder feed rate exceeds sieve capacity	Reduce the venturi transfer-pump air pressure. If a HDLV system, contact your Nordson representative.
		Erratic or pulsating feed rate. Heavy surges may exceed sieve capacity	Check the transfer-pump air supply and pressure. Check the transfer pumps, pickup tubes, and hoses for blockages. Check the fluidising plates and the powder in the colour module hoppers for contamination.
		Too many oversized particles in reclaimed powder	Check the powder in the colour module for contamination
		Screen mesh is too fine	Change to a more coarse screen mesh. Refer to AZO E360B technical manual for procedure.
		Loose screens	Remove the screen frame from the sieve. Adjust the screen tension according to the AZO E360B technical manual.
		Clogged screens	Clean or replace the screen. Check the powder for contamination. Add new powder to the hopper. Too large a ratio of reclaimed-to-new powder can cause clogging.
		Vent-assist air pressure too low, or hose to scrap container and/or container not air tight	Adjust the vent-assist air pressure. Check the hose and scrap container connections and seals.
		Sieve not level, discharge end pitched down	Level the sieve and/or the feed hopper.
2.	Powder backing up in the accumulator	Restriction in sieve and/or powder path causing blockage	Clean the powder path
		Vent-assist air pressure too high	Adjust the vent-assist air pressure

Repair

Contact your Nordson representative for repair information.

Parts

To order parts, call the Nordson Industrial Coating Systems Customer Support Center at (800) 433-9319 or contact your local Nordson representative.



ltem	Part	Description	Note
1	_	LANCE ASSEMBLY, PRODIGY, # PUMP	A
2	-	PUMP ASSY,CORONA,ENCORE GEN II,PKG	В
3	-	PUMP ASSEMBLY, 90°, ENCORE PE	С
4	7035500	PROBE,LEVEL,IOL	
5	7035502	CABLE,2M,M12,IOL	
6	7035501	MODULE,AUX DEVICES,PN-IOL	
NS	7035503	VIBRATOR, TURBINE, ATEX II 2D	D
NS	1105689	TUBE,PICK-UP,50LB,ENCORE.PKGD	E
NS	1602284	MOUNT ASSY,PUMP,18"	F
NS	7033452	SCREEN 0,850MM,NYLON,ROTARY SIEVE E360B	G
NS	7033453	SCREEN 0,400MM,NYLON,ROTARY SIEVE E360B	G
NS	7033454	SCREEN 0,250MM,NYLON,ROTARY SIEVE E360B	G
NS	7033455	SCREEN 0,200MM,NYLON,ROTARY SIEVE E360B	G
NS	7033456	SCREEN 0,510MM,CARBON,ROTARY SIEVE E360B	G
NS	7033457	SCREEN 0,245MM,CARBON,ROTARY SIEVE E360B	G
NS	7033458	SCREEN 0,205MM,CARBON,ROTARY SIEVE E360B	G
NS	7033459	SCREEN 0,160MM,CARBON,ROTARY SIEVE E360B	G

NOTE A: Organic Systems – See technical manual https://emanuals.nordson.com/finishing/files/Powder/1084294.pdf

- B: Organic Systems See technical manual https://emanuals.nordson.com/finishing/files/Powder/1095927.pdf
- C: PE Systems See technical manual https://emanuals.nordson.com/finishing/files/Powder/1602273_01.pdf
- D: PE Systems See item 15 on page 15
- E: See technical manual https://emanuals.nordson.com/finishing/files/Powder/1062942.pdf
- F: See technical manual https://emanuals.nordson.com/finishing/files/Powder/1604293.pdf
- G: 2 required per Rotary Sieve

Specifications – Rotary Sieve 360 Assembly

Electrical

Unit	Value
Voltage (V)	400
Power (kW)	0.75
Frequency (Hz)	50
Protection	IP54

Noise

Less than 80dB (A) measured at a distance of 1 m from the surface of the unit and at a height of 1.6 m.

Diagrams

Description	Part Number
Control Box – Sieve E360	47.20-00.00 E
Pneumatic – Sieve E360	47.20-00.00 D





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