

Powder Feed Centre Lite

Version 1

Manual P/N 768660B
– English –

Issued 07/07

For parts and technical support, call your nearest Finishing Customer Support Centre.

Find your nearest centre at www.nordson.com/directory

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NORDSON Deutschland GmbH

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DECLARATION of CONFORMITY

PRODUCT: Powder Feed Centre Lite

PRODUCT RANGE: All variants and models

Conformity has been verified following the provisions of the following directives :

APPLICABLE DIRECTIVES:

Directive 94/9/EC (ATEX)

Directive 98/37/EC (Machinery)

Low Voltage directive 73/23/EEC

EMC directive 89/336/EEC

STANDARDS USED TO VERIFY COMPLIANCE:

EN 60204-1: 1993 "Safety of machinery – Electrical equipment of machines".

EN 292-1-2: 1992 "Safety of machinery – Basic concepts, general principles for design"

EN1127-1: 1997 "Explosion prevention and protection. Basic concepts and methods"

EN 13463-1: 2001 Part 1 "Non-electrical apparatus for potentially explosive atmospheres. Basic methods and requirements".

This product has been manufactured according to good engineering practice and conforms to the specified directives and standards described above.

Marked:

CE  II 3D T 200C



Jens Kollosche
Operations Manager Nordson Germany
Nordson Germany GmbH

Date: 2nd July 2009

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Congratulations on the Purchase of Your Nordson Product

Nordson equipment is engineered and manufactured in accordance with strict specifications, using high quality components and state-of-the-art technologies that assure reliable, long-term performance. Your product was thoroughly tested for proper operation prior to shipment.

Before unpacking and installing your new equipment, please read this manual. It is your guide to safe installation, productive operation and effective maintenance. We recommend that you keep the manual available for future reference.

Your Safety is Important to Nordson

Carefully read the *Safety* section. Your product is designed for safe operation when used according to the published instructions. Potential hazards exist when operating instructions are not followed.

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Section 1

Safety

Introduction

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, is accessible to all persons operating or servicing equipment.

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.
- Keep clear of moving equipment. Before adjusting or servicing any moving equipment, 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) hydraulic and pneumatic pressure before adjusting or servicing pressurized systems or components. Disconnect, lock out, and tag switches before servicing electrical equipment.
- Obtain and read Material Safety Data Sheets (MSDS) for all materials used. Follow the manufacturer's instructions for safe handling and use of materials, and use recommended personal protection devices.
- 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 MSDS 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.

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 NFPA requirements for Class 2, Division 1 or 2 Hazardous Locations. Refer to NFPA 33, NFPA 70 (NEC articles 500, 502, and 516), and NFPA 77, 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.

Disposal

Dispose of equipment and materials used in operation and servicing according to local codes.

Section 2

Description

Intended Use

The Powder Feed Centre Lite is intended to enhance quick colour change capabilities in a powder coating system. Powder is fed directly from the manufacturers box or fluidised hopper to the spray guns (maximum 18) via pick up tubes, powder pumps and powder delivery hose.

Over sprayed powder is transported from a cyclone at the spray booth back to the Powder Feed Centre, where it is recycled via a sieve unit. The conditioned powder is then returned from the sieve to the powder box / hopper.

During colour change the pick up tubes, powder pumps, powder delivery hose and recycle transport hose are purge cleaned by the purge clean system incorporated in to the Powder Feed Centre Lite.

A Powder Feed Centre Lite is always used in conjunction with an air extraction system that provides an airflow across the operator working area, and prevents powder escaping in to the environment.

Description of Components

See Fig 2-1. The Powder Feed Centre Lite consists of a canopy enclosure (6) that houses a vibratory table (3) to support the powder box. The powder box is loaded on to the vibratory table to allow the pick up tubes (7) to move downwards in to the powder. When the powder pumps (1) are operated powder is transported up the pickup tubes and in to the powder hose, to the spray guns.

As the powder is consumed from the box, a level probe (2) detects the level and continually moves the dip legs further down inside the box to a depth of 50mm below the powder surface. For long spray durations this level can be automatically replenished by using an optional powder virgin feeder.

Oversprayed powder is transported back from the booth to a sieve (8) (either vibratory or ultrasonic). After sieving, the powder is returned back to the box for feeding to the spray guns again. Operating instructions for the sieve can be found in a separate manual.

During colour change the powder box is removed and the pick up tubes move further downwards to dock with the purge clean manifold (4). This manifold supplies pulses of high pressure air through the pick up tubes, pumps, powder hoses and spray guns for cleaning.

The unit comes complete with its own control panel (9) and a powder extract duct (5) that is connected to a separate air extraction unit (not supplied with the Powder Feed Centre Lite) to ensure a clean environment.

Features

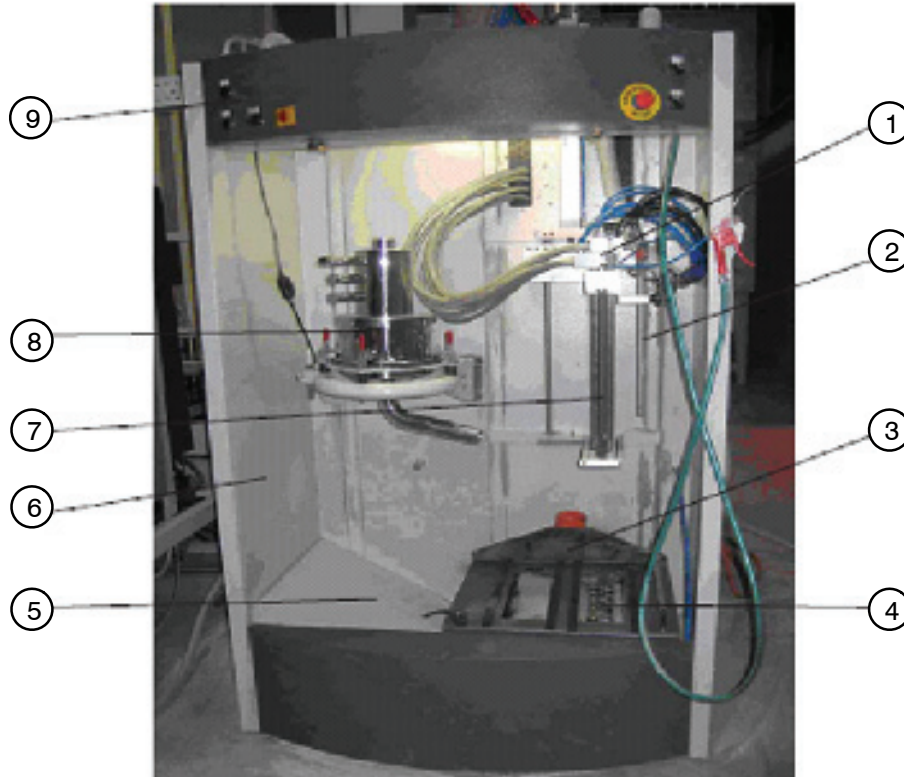


Figure 2-1 Powder Feed Centre Lite

- | | | |
|--------------------|-------------------------|------------------|
| 1. Powder pumps | 4. Purge clean manifold | 7. Pick up tubes |
| 2. Level probe | 5. Powder extract duct | 8. Sieve |
| 3. Vibratory table | 6. Canopy enclosure | 9. Control panel |

Section 3

Installation



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

Transport

Transport the unit so as to avoid damage. Use suitable packaging materials. Protect the unit from humidity, large temperature fluctuations (condensation), dust and vibrations.

Unpacking

Unpack the unit carefully to avoid damage. Inspect for any damage caused during transport. Save packing materials for possible later use, or otherwise dispose of properly according to local regulations.

Storage

Use suitable packaging materials. Protect the unit from humidity, large temperature fluctuations (condensation), dust and vibrations.

Preparing for Installation

Ensure that all cables are rated suitable for use, that they are suitable for the ambient temperature of the installation area and also provide adequate fuse / circuit protection from the power supply.

The Powder Feed Centre Lite must be positioned according to the general layout drawing supplied by Nordson on a level floor.

To ensure easy maintenance, a minimum operating and access zone of 1m should be left vacant around the machine wherever possible.

Electrical Connection



WARNING: Risk of electrical shock. Disconnect and lock out input power to equipment before servicing. Failure to observe this warning may result in personal injury or death.

Only one power supply cable is necessary for the Powder Feed Centre Lite. Connect this in to the terminals of the control panel using a suitable gland.

Pneumatic Connection



WARNING: The air supply pressure should be set to 4 bar (maximum) and should only be modified by a Nordson technician.

Connect the air supply to the Powder Feed Centre Lite and ensure that the air supply is of the required quality. Also check that the air has been discharged from the system via the tank inlet filter to ensure that any material left in the line during installation does not enter the system.

Disassembly

To disassemble the unit, turn the unit off and remove the air and power supplies.

Disposal

Dispose of the unit according to local regulations.

Section 4

Operation



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

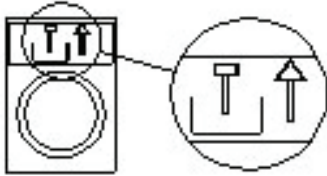
Control Functions

The Powder Feed Centre Lite is operated by using the controls situated on the front of the unit. Fig. 4-1 indicates the function of each switch.



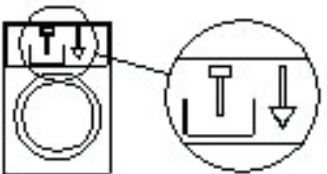
Main Switch

On / Off Switch



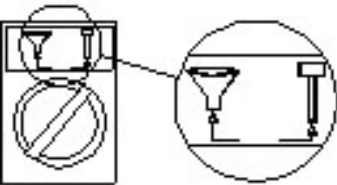
Up Button

When pressed, the pump lance arm is raised out of the powder box.



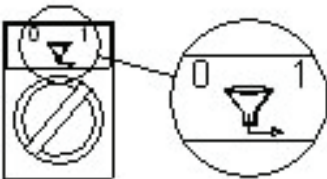
Down Button

When pressed, the pump lance arm descends in to the powder box.



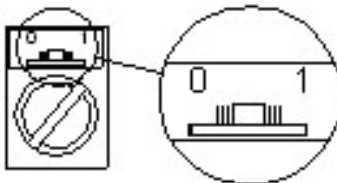
Cleaning Switch

Select purge cleaning of the cyclone or of the guns.



Sieve On / Off

Enables or disables the powder sieve operation.



Vibrating Table On / Off

Enables or disables the vibrating table that is used to agitate the powder box.



Emergency Stop

When pressed the whole machine will stop.

Reset this switch before restarting the unit.

Figure 4-1 Control functions

Colour Change Procedure

To colour change the Powder Feed Centre Lite, use the following procedure.

1. To remove the powder lance arm from the powder box, press the **UP Button**.
2. Remove the powder box from underneath the lance arm and place it underneath the recycling outlet of the sieve.
3. Turn off the application equipment
4. Clean down the powder lance arm with a compressed air gun, in the direction of the air extraction duct, to prevent powder escaping to the factory environment.
5. Select **GUN CLEANING** on the **CLEANING SWITCH**
6. To lower the powder lance arm to the purge nozzles, select the **DOWN BUTTON**. The purging sequence will now be activated.
7. Cyclone Cleaning.
8. Once all the recycled powder has returned back in to the sieve, remove the recycle hose.
9. Disassemble and clean the sieve (see separate manual).
10. Remove any remaining powder on the internal surfaces of the Powder Feed Centre Lite enclosure with a compressed air gun.
11. Reassemble sieve.
12. To remove the powder lance arm from the purge nozzles, press the **UP Button**.
13. Position a new powder container with the new colour.
14. To lower the powder lance arm in to the new powder box, press the **DOWN Button**.
15. The system is now ready to spray with the new colour.
16. After approximately two minutes of spraying, reconnect the recycling pipe to the sieve inlet.

Section 5

Maintenance



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

Daily Maintenance

1. Inspect the sieve mesh for damage or powder stuck in mesh. Clean with vacuum cleaner and blow lance.
2. At the end of each shift, disassemble the sieve and clean thoroughly with a dry lint free cloth.
3. Check sieve seals for damage and replace if necessary.
4. Disassemble and clean powder pumps with a dry lint free cloth.
5. Check powder pump venturis for wear. If the hole in the centre of the venturi is not circular then replace the venturi.
6. Clean enclosure with a blow gun to remove any powder from the unit in to the ductwork.

Section 6

Troubleshooting



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

This section contains troubleshooting procedures. These procedures cover only the most common problems that you may encounter. If you cannot solve the problem with the information given here, contact your local Nordson representative for help.

Table 6-1 Trouble shooting procedures

Problem	Possible Cause	Corrective Action
1. Sieve vibrator not working	No power supply Vibrator failure	Check power supply and cable Replace vibrator
2. Powder accumulates on the sieve mesh	Sieve mesh size is too low for the powder being sieved Powder loading is too high Sieve mesh not cleaned correctly or often enough	Change sieve mesh to a large size Assess powder output of guns and reduce if possible Increase transfer efficiency to reduce powder levels being recycled back to the sieve Remove sieve mesh and clean at more regular intervals
3. Loss of air extraction from the extract duct	Damper valve closed Blockage in ductwork Air extraction unit not turned on	Open valve and lock in to position Inspect ductwork and remove any foreign articles Turn air extract unit on
4. Powder contaminated with other colours	Poor cleaning of sieve mesh Sieve mesh damaged	Check cleaning procedures Replace sieve mesh
5. Excessive noise from sieve	Sieve not re-assembled correctly after colour change Sieve seals damaged	Re-assemble sieve Inspect seals on sieve and replace if necessary

Section 7

Parts

Introduction

To order parts, call the Nordson Customer Service Center or your local Nordson representative. Use this five-column parts list, and the accompanying illustration, to describe and locate parts correctly.

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. Indentions show the relationships between assemblies, subassemblies, 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.

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

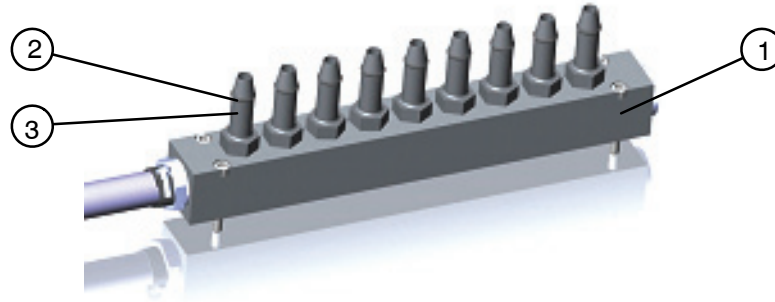


Figure 7-1 Purge manifold

Item	Part	Description	Quantity	Note
1	–	Manifold, purge clean, 9 pump	1	Non saleable
2	393471	O Ring, silicone, 11mm x 2.5mm	AR	A
3	7032259	Injector, m/steel, nickel coated, PFC	AR	A
NOTE A: Quantity maximum 9 per manifold, dependent upon the number of guns fitted to the system AR: As Required				

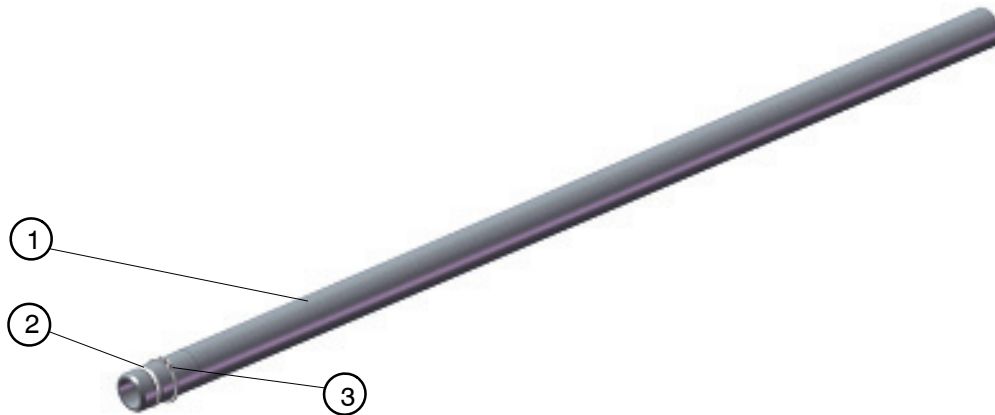


Figure 7-2 Pick up tube assembly

Item	Part	Description	Quantity	Note
1	7032260	Tube, pick up, m/steel nickel coated, PFC	AR	A
2	7032262	O Ring, pick up tube, 17.17 ID x 1.68mm Dia	AR	A
3	7032263	Circlip, pick up tube, 20mm ID, PFC	AR	A
NOTE A: Quantity maximum 9 per manifold, dependent upon the number of guns fitted to the system AR: As Required				

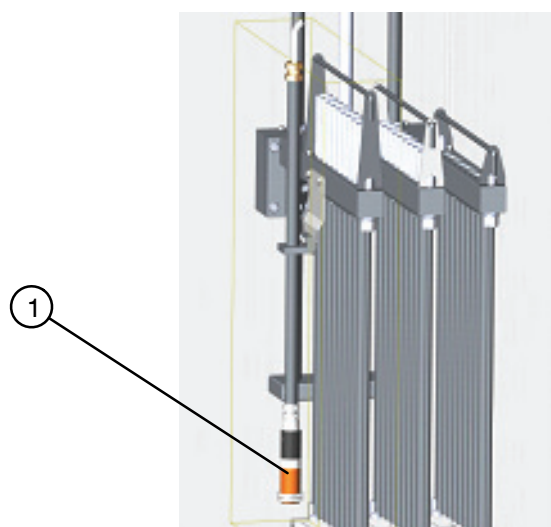


Figure 7-3 Powder Level Control

Item	Part	Description	Quantity	Note
1	7032244	Probe. level sensor, 24VDC,PNP, ATEX	1	AR
assembly	7032452	Level Sensor 24VDC, PNP, ATEX, complete kit (comes with cable & stainless steel tube)	1	AR

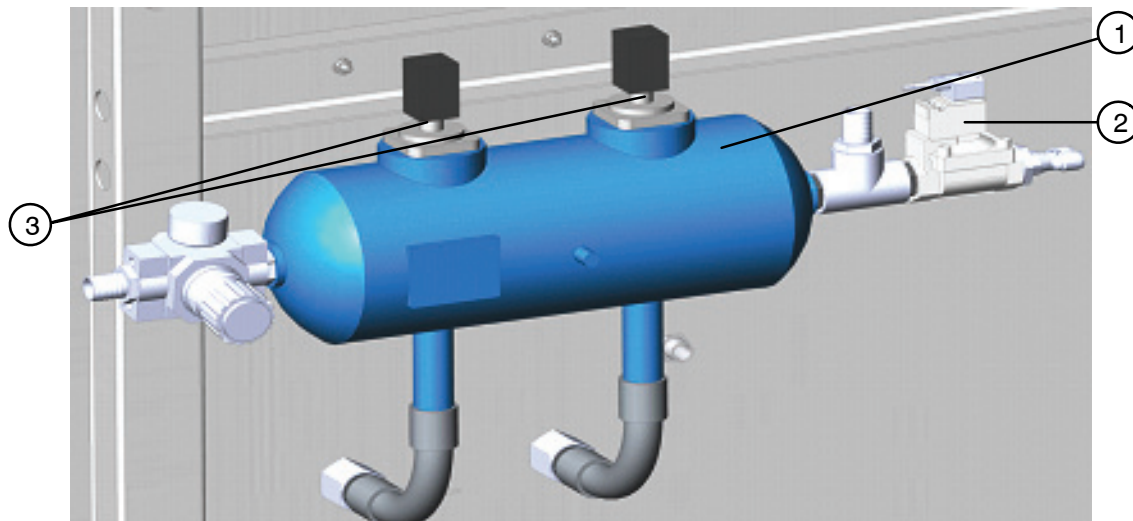


Figure 7-4 Feed centre cleaning components

Item	Part	Description	Quantity	Note
1	–	Manifold reservoir	1	Non saleable
2	736167	Valve, solenoid, 1", 24vDC, PFC	1	
	376618	Flange, alum, 1"solenoid, p/valve, PFC	1	A
3	736154	Valve, solenoid, 1", 24vDC, full immersion, PFC	2	

NOTE A: Flange is part of solenoid valve (736167).

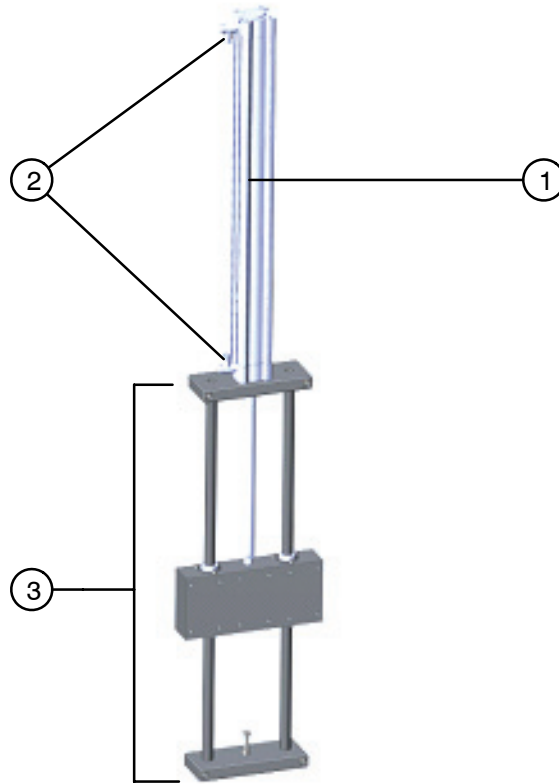


Figure 7-5 Lance arm mechanism

Item	Part	Description	Quantity	Note
1	376671	Cylinder, pneumatic, PFC	1	
N/S	376592	Switch, reed, LED, PFC	1	
2	7034004	Valve, flow control, cylinder	1	
3	7034516	Full slider assembly	1	A
N/S	7032459	Siemens PLC with Program	1	
N/S	7032460	Siemens PLC Expansion Module	1	
N/S	7032461	Power Supply 24VDC	1	

NOTE A: This part includes the full assembly of the slider mechanism with the 2 slider rods and with the top and bottom brackets



Item	Part	Description	Quantity	Note
1	7032457	Mains Isolator 16A complete with handle	1	

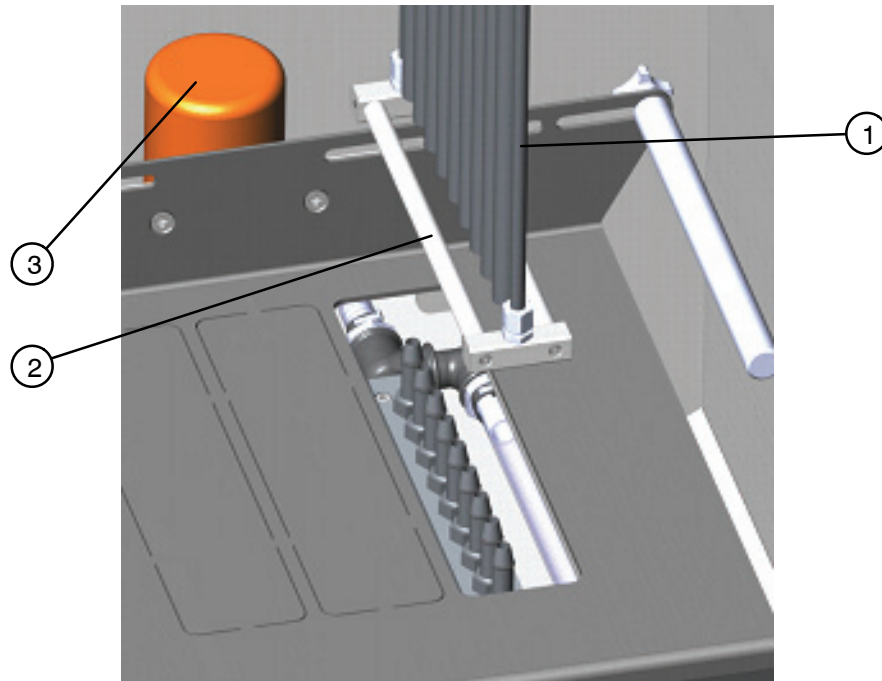


Figure 7-6 Powder fluidising components

Item	Part	Description	Quantity	Note
1	7032246	Support, Fluidising tube, PFC	2	A
2	736151	Fluidising ring assembly, 9 pump	1	A
	736150	– Fluid tube, poly,15.5MM DIA,312.5 MM LGTH.	2	A
	7032239	– Holder, fluid tube assembly	2	A
3	7032255	Vibrator	1	
NOTE A: Quantity per set of 9 guns.				

Section 8

Technical Data

Electrical Requirements

Supply voltage

- 220v 1 phase + Earth (+ / – 5%)
- Required at a height of 2000mm from floor level

Pneumatic Requirements

Compressed air pressure for operation

- Maximum 4 Bar (87 – 16 psi)
- Required at a height of 400mm from floor level

Compressed air quality

- Dry and clean, oil content less than 0.01 ppm

Compressed air consumption

- 44m³/hr to 78 m³/hr

Installation Area

To be installed in Group II 3D area Zone 22 (directive 94/9/CE)

Weights and Dimensions

For weights and dimensions refer to table 8–1

Table 8-1 *Powder Feed Centre Lite weights and dimensions*

	<i>Part Number</i>	<i>Weight</i>	<i>Height (mm)</i>	<i>Width (mm)</i>	<i>Depth (mm)</i>
<i>Powder Feed-Centre Lite</i>	737664	400 Kg	2000	1300	900

Section 9

Options

Optional Items

The following optional items are also available for the Powder Feed Centre Lite. Contact your Nordson representative for further information.

Fluidised powder box

- Fluidised powder box. See Fig. 9-1. For long spray runs a fluidised powder box with a 50kg capacity can be used to feed the powder guns. This has the benefit that the powder box does not have to be refilled or changed as regularly. The assembly (part number 737701) is delivered complete.

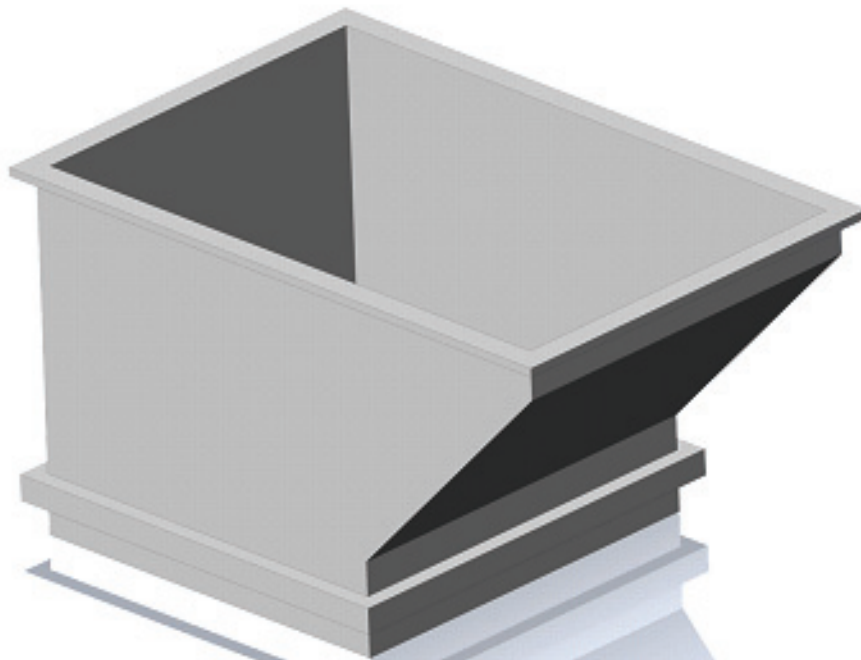


Figure 9-1 Fluidised powder box, 50 Kg

Additional guns

- Additional guns can be added up to a maximum of 27 by adding an additional purge clean manifold, pick up tubes and pumps. Contact your Nordson representative for further details.

Virgin Feed

- Virgin Feed. Powder level in the container (manufacturers box or fluidised bed hopper) can be automatically refilled when the level drops to a certain level. The benefits of this system include reduced labour required to monitor the powder level, and consistent mixing of virgin and recycled powder. Contact your Nordson representative for further details on our HDLV Virgin Feed Dolly system.