

10) Powder recovery system:16-tubes fast color change cyclone recovery System

11) Heat resourcer: Gas ,with 30,0000 Kcal Riello Brand burner

7) Power required:

Three-phase: 380 VAC 50 HZ 3Phase, fluctuation range: $\pm 10\%$

Single-phase: 220VAC 50Hz fluctuation range: $\pm 10\%$

Total equipment power:About 32 KW

Technological Process

- 1) Pretreated workpieces loaded on line manually.
- 2) Workpieces move on line automatically,then be coated by automatically electrostatic powder coating machine and manual spray gun
- 3) Workpieces curing temprature: min temprature 200°C ,max temprature 250°C
- 4) Workpieces cool down naturally after cured.
- 5) Workpieces unloaded manually.

Powder coating gun

COLO-800D Automatic electrostatic powder coating gun

Control cabinet for 8 pcs control unit



1. Centralized Control Box	1 set
2. Internal Static Electricity Generated Guns	8 Sets
3. Air pipe and Powder Pipes and 12 V Control Cable	8pcs
4. Powder Supplying/ storage unit	1Sets

COLO-800D characteristics:

- 1、 Digital control system, display preset Voltage and currency at the same time.
- 2、 Preset Voltage and currency be set by knobs, easy to operate.
- 3、 Alarm automatically if over the preset parameters
- 4、 Adjust the output static electricity automatically according the change of work piece's size and distance
- 5、 Could supply large amount powder under low pressure.
- 6、 The inside circuit region is independent closed, avoid the powder incoming.
- 7、 Good quality pressure gauge
- 8、 Good quality dust-proof powder switch
- 9、 Control the useless power strictly, low heating value, work continuously and steadily.

Technical Data

Electrical data	
Power range	220V/110V
Frequency	50HZ /60HZ
Temperature range in use	-10 °C+50 °C
Powder Gun	
Gun weight	500G
Rated output voltage	24VDC
Input voltage	- 200kv
Maximum output current	180Ua(max)
Maximum output voltage	0-100KV (adjustable)
Maximum powder injection	600g/min
Polarity	Polarity
Pneumatic data	
Maximum input-air pressure	10kg/cm
Optimum input-air pressure	6kg/cm
Minimum input-air pressure	4kg/cm
Maximum oil vapor content of compressed air	0.1ppm
Maximum compressed-air consumption	13.2 m3/h

COLO-800D electrostatic powder coating gun (manual)

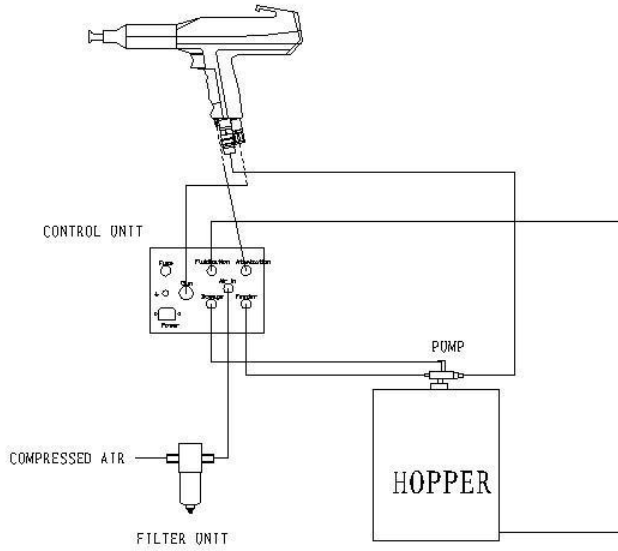
Dimensions

Width	690mm
Depth	800mm
Height	1135mm
Weight	45kgs

1. Control Box	2 sets
2. Internal Static Electricity Generated Guns	2 Sets
3. Air pipe and Powder Pipes and 12 V Control Cable	2 pcs
4. Hopper	2 Sets
5, Cart	2 Sets
6. Spray Gun Spraying Accessories Parts	2 Sets

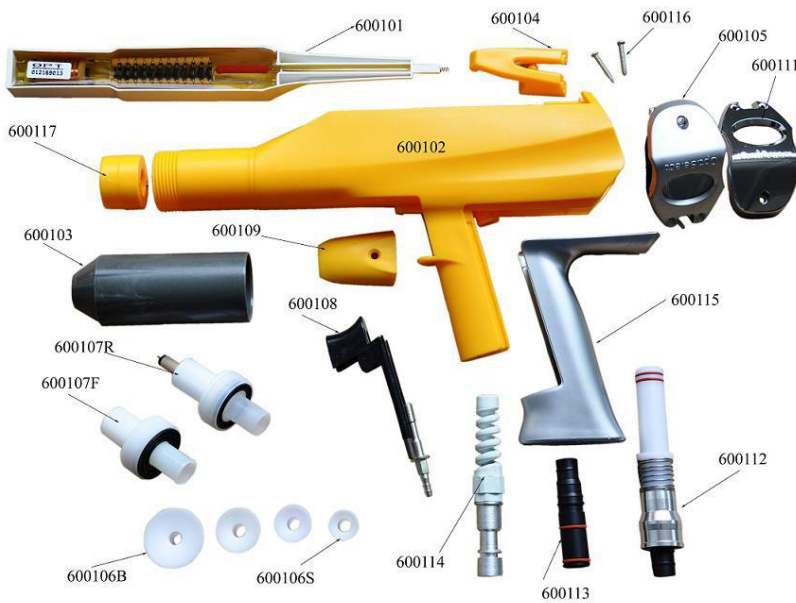
Manual Connecting guide



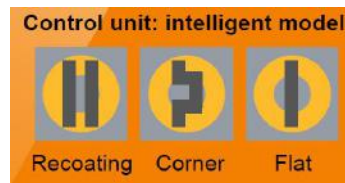


Manual Gun

PLS supply the item number will order the spa re parts for colo gun !



Structure



Manual coating equipment-structure

- | | |
|---------------------------|-------------------------------|
| 1 control unit | 2 Manual powder gun |
| 3 injector | 4 Mobile frame with hand rail |
| 5 Fluidized powder hopper | 6 Powder filler flap |
| 7 Swivel wheel | 8 Filter unit |
| 9 Gun holder | 10 Shelf |
| 11 Hose holder | 12 Hose holder |
| 13 Rubber wheel | |

Automatic powder coating booth with cyclone recovery system



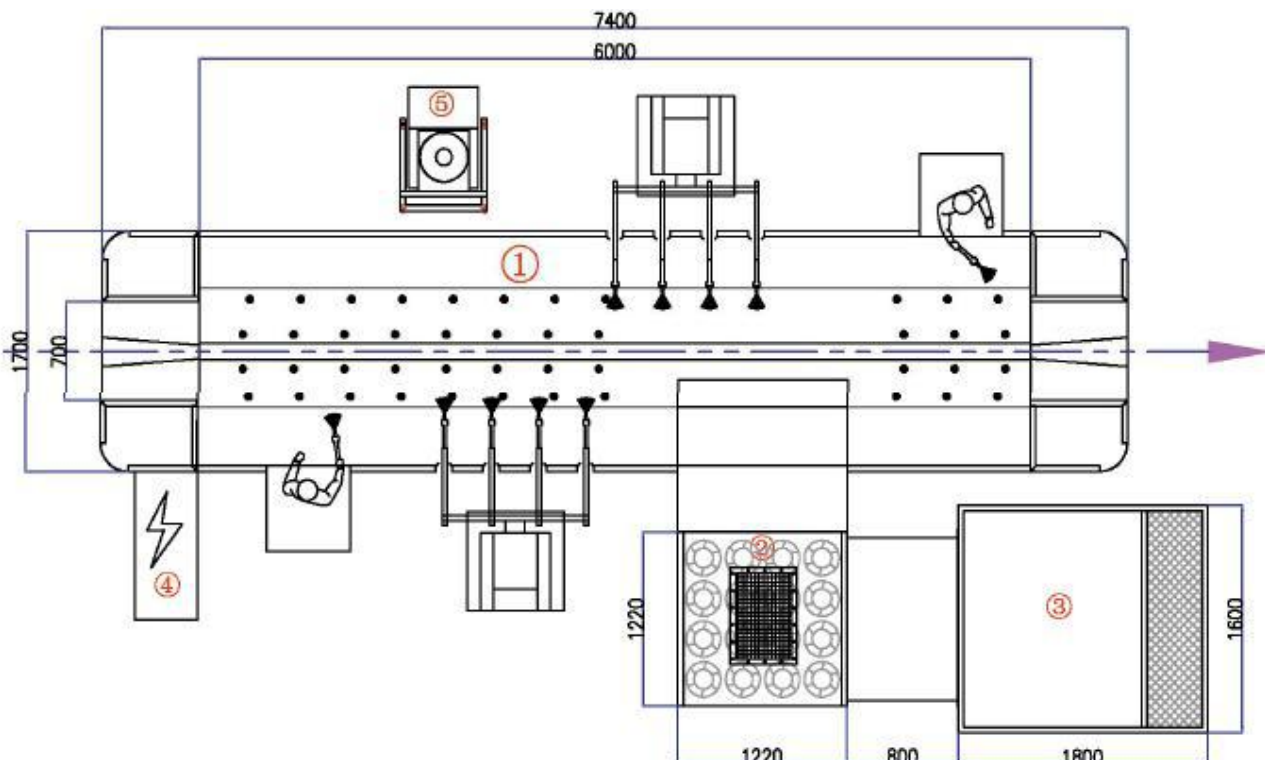
(2-work position powder coating booth)

2-work position manual powder coating

- 1) Size: Outer size L6.0×W1.5×H1.8(m)
- 2) Material: SPGt 1.2mm
- 3) Work position: 2 manual work positions
- 4) Automatic reciprocator: 2 set travel 2.5m.with automatic gun 8 pcs
- 4) Equipped with 2 pcs ceiling lighting , ensure enough illumination
- 5) Explosion proof lighting system, mounted outside of the booth, easy to clean and repair and avoid to be sucked by the recovery system during long-time use.

fast color change cyclone powder recovery system

- 1) Enough air capacity,less shake,low noise
- 2) Independent from the booth to prevent the resonance and reduce the noise.
- 3) High quality filter to ensure the filter efficiency.
- 4) Pulse blowback to ensure the filters have good breathability during long time working.
- 5) The filter cabinet is easy to change,saving time(the replaced filter cabinet could be cleaned in other time)



System Constitution:

- 1) Fan motor: 1set, 15kw, air capacity 5700~9000m³ /h

- 2) Cyclone:16pcs tubes with 16 pcs filters
- 3) Frame:4#square pipe
- 4) Light power:72kw/PC,2pc,total is 150kw
- 5) Air container: 1 set
- 6) Electronic pulse recovery system:1 set
- 7) PLC Electric control 1set

Operation and display elements

- 1) PLC Electro switching cabinet three phase 4 wires
- 2) Cylcone:16 tubes
- 3) Filter /325mm*900mm *16 pcs
- 4) Air storage 1 set
- 5) Solenoid valve/380V 16pcs
- 6) fan motor power:380v,15kw, 50hz

Cabinet



Bottom:

- 1,power on/off
- 2,hopper go up/go down
- 3, emergency stop

Automatic reciprocator

Parameter:

- 1)Rated voltage: AC220V~240V/50~60Hz
- 2)Rated power: 0.75Kw
- 3)Speed: 0.08m/S-0.8m/S (adjustable)
- 4) Stroke: 2.5m
- 5)Setting system: digital button
- 6)Speed reducer: worm gear
- 7)Speed control method: frequency conversion
- 8)Required temperature: -10~50℃

Characteristics:

- 1) Mitsubishi frequency converter, integrated transducer and worm gear. Make sure the process reliable and steadily.
- 2) Digital operation panel, could preset 80 sets mode data for backup
- 3) You could preset the Max and Min limits according to the working conditions so that to avoiding the knocking.
- 4) You could preset automatic running when opening the electric power.
- 5) There are 88 sets of polyurethane roller inside to hold the direction guide pillar, work stable, abrasion rate low.

Operation panel:



Sieving machine
Characteristics:

- (1) Stainless steel will not pollute the powder
- (2) It can supply multiple spray guns with powder simultaneously
- (3) Equipped with automatic powder return system, could return powder fall into the powder box through powder screen
- (4) Equipped with powder position detector, when the powder is less than the set value, it can emit signals of lack of powder
- (5) Equipped with magnetic sealing, can added powder during working.



(Stainless powder supply box)



(Automatic powder sieving machine and absorb pump)

Automatic powder sieving and powder absorb pump*1set

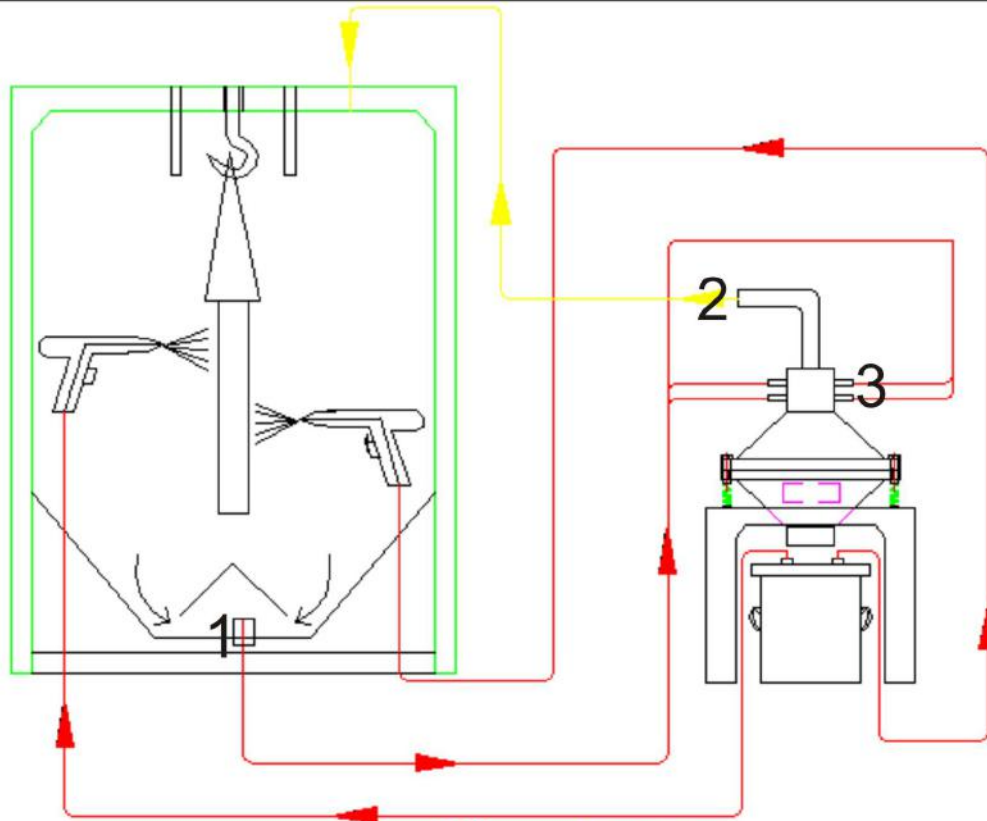

- 1) Power: $\leq 100W$



Tel: (0571) 86015003 Fax: (0571) 86015003 E-mail:colo@colourspray.com Contact:Sonne Xie

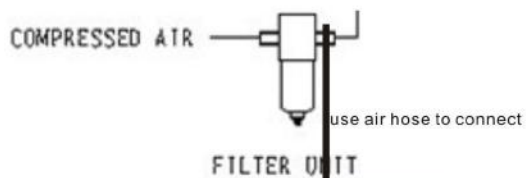
2) The powder absorb pump and automatic powder sieving

3) Instalation:



说明: □ 代表回收粉泵

- 1, powder pump for recycling the powder
- 2,exhaust vent
- 3,recycle powder hose joints



- a** screw out, then screw from the inside of hopper to connect the powder pump to the hopper
- b** use air hose(outside size 10mm) connect to the air filter which connect to the air compressor
- c** use powder hose (inside size 20mm) connect to the recycle powder hose joints in sieving machine

use exhaust air hose connect to the spray booth as photo show



Curing tunnel system



Gas curing oven*1set

1)Size Outer size:L39.5×W1.4×H2.0(m)

2)Material:100mm thick rock wool board.internal material SPGt1.0mm.

Outer material 0.7mm color plate

3) Disassembled structure, easy to transport and install.

4) Underframe:squre pipe 10#

5)Heating with Gas burner 30,000 kcal (Italy Riello brand) 1 set

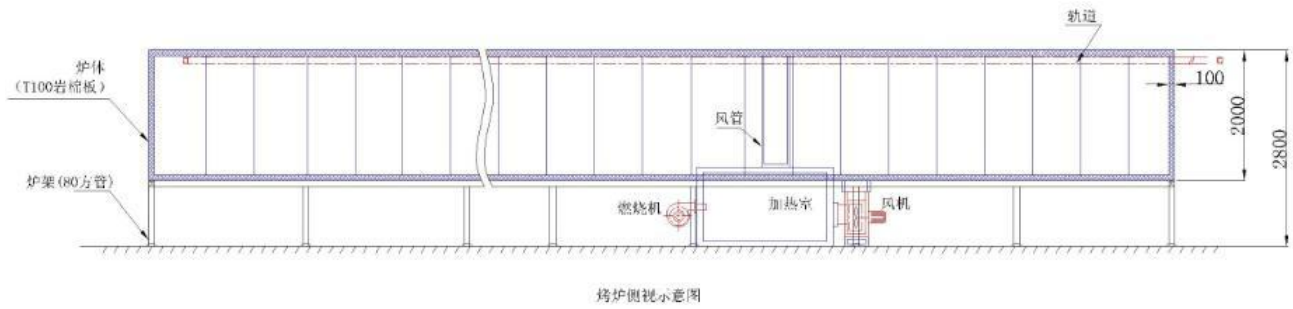
6) Fan motor power:7.5kw,380V,3phase 50Hz 1 set

Gas heating system*1set

1) Heating power:Gas burner 30,000 kcal (Italy Riello brand)

2) Curing temprature: min temprature 200℃ ,max temprature 250℃

3) Temprature up to 200℃ need 40 min



PLC electric control system*1set



Conveyor system

【4-1】 Chain model:QXG-250#

- 1) total length is 100m,one point loading 50Kg
- 2) Stepless speed change control driving system.
- 3) Emergency stop port*4,1each for loading zone and unloading zone,2 for manual powder coating work positions.

【4-2】 2.2 KW driving system*1set



【4-3】 R1500 gravitational automatic tensioning system*1set

【4-4】 MA-10 automatic oil injection lubrication system*1set

Heavy duty driving system



Gravitational automatic tensioning system



(Intelligent setting up, Fixed-point oil injection,Chain speed display,Current failure memory,Less-oil alarm)

【4-5】 Conveyor Line Parameters:

One Point Hanging Weight	50kg
Maximum Temp Allow	300℃
Drive Mode	Inverter Control, Chain Conveyance, 2 Set
Driving Unit Motor	2.2 kw, 1 Set, Inverter Speed Control
Tension Control Unit	Weight Control Type, 1Set
Greaser Unit	Auto Greaser Unit, 1Set

【4-6】 Speed Controller Parameter:

Electric Speed Controller	Motor from China
Input Voltage	<i>Three Phases , 5 cables, 380V,50 Hz</i>
Control Mode	Inverter,
Maximum capacity	2.2kw
Running Status	Step-less Adjustment

Electric control system



- a) Above setup includes electricity control system;
- b) All control cable/wiring is fitted with metallic or fire-retardant plastic tube protection
- c) Electrical components/parts within the control panel are CHINT
- d) Centralized Control Cabinet x 1 ;
- e) Power Configuration: **AC ,390V, 50Hz, 3 Phases, 5 Wires;**
- f) Temperature Control Meter Accuracy:±1 °C;
- g) Protection and Alert Function will be activated when the following occurs
 - i. Curing oven exceeding maximum or preset temperature
 - ii. Burner catches fire or malfunction;
 - iii. Emergency Stop for the production line
 - iv. Speed Adjustment Malfunction
 - v. Heat Exchanger Exceeding Temperature limit
 - vi. Machine Start Warning

h) Control System Function:

A	Burner Temperature Display and Control	2 Sets
B	Temperature Control:	2 Sets
C	Circulating Fan Control	2 Sets
D	Oven Tunnel Temperature Display and Control	2 Sets
E	Powder Coating Booth Recycle Unit Control	1 Set

Equipment Spare parts brand

NO	Name	brand
----	------	-------



1.	load switch	chnt
2.	circuit breaker	chnt
3.	ac contactor	chnt
4.	button and indicator light	chnt
5.	overheat switch	chnt
6.	fluidization plate	China
7.	limit switch	chnt
8.	proximity switch	chnt
9.	solenoid valve	Shanghai
10.	fan	Hangzhou
11.	filter	Shanghai
12.	spray gun	Hangzhou hicolor
13.	chain	Shanghai
14.	PLC control unit	Shanghai