Operator
Short Instruction

Gema

Your global partner for high quality powder coating

Switching ON the System
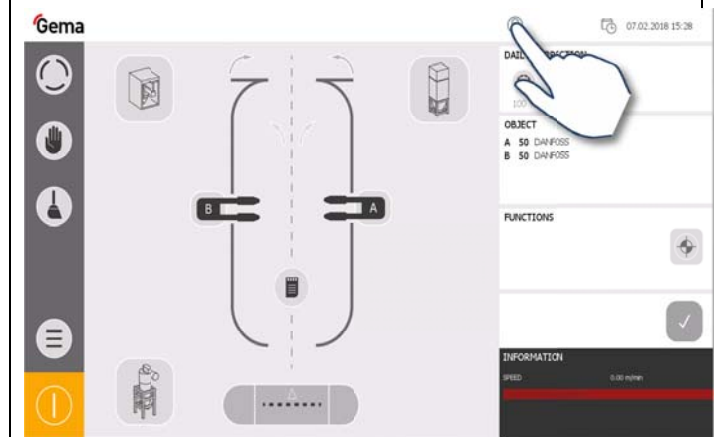
At the Touch Screen

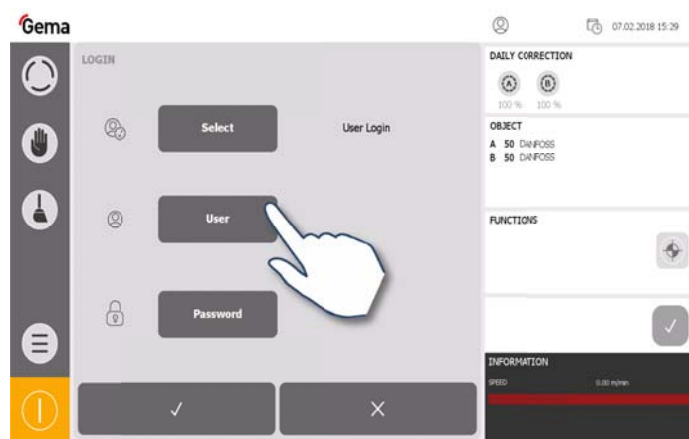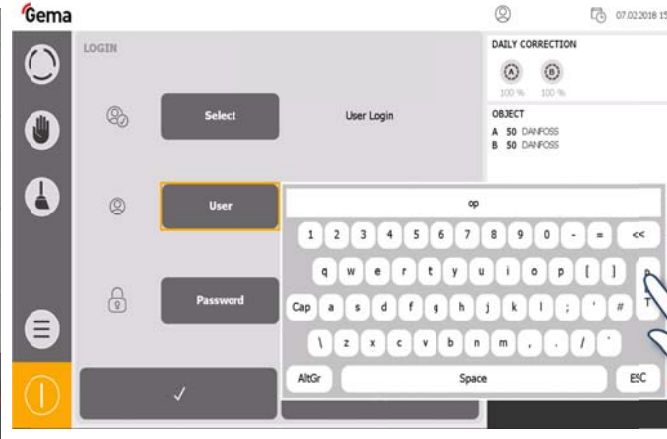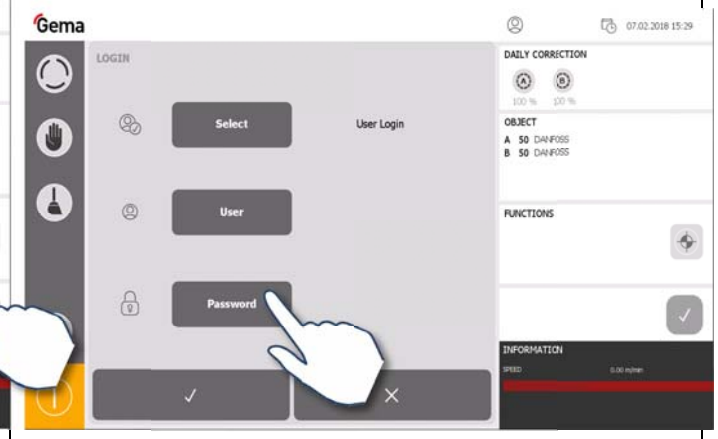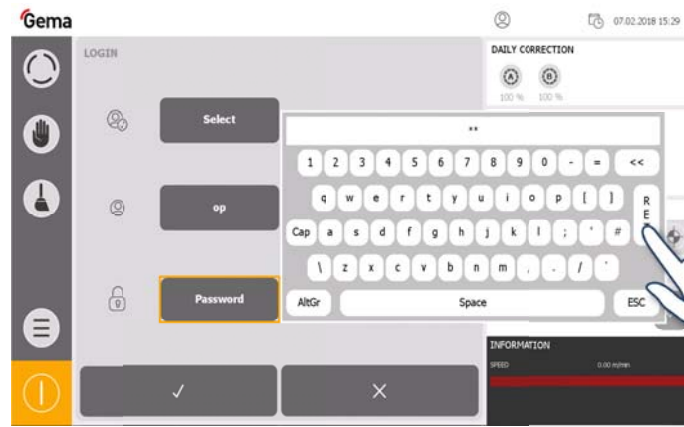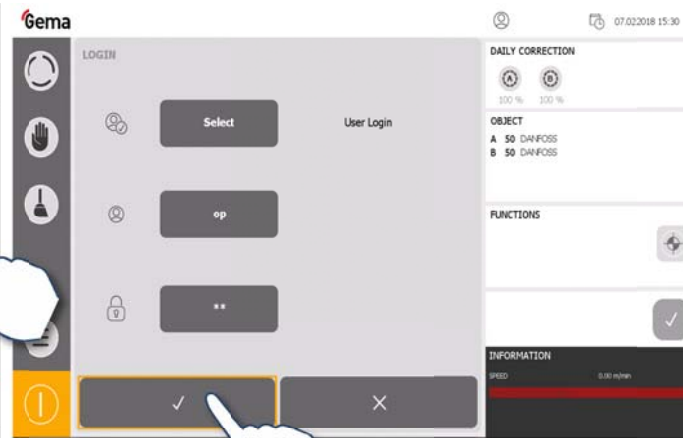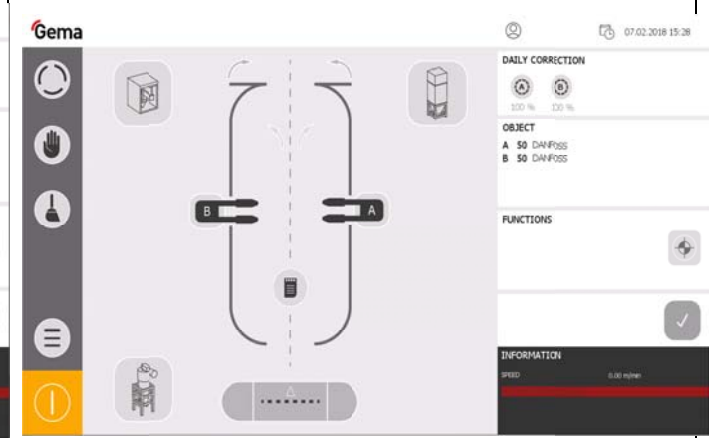| 1. System Key to 1	2. Touch the screen	3. Login with User Name and Password
	MagicControl 4.0	*3.1*
3.2	*3.3 Enter your User Name and push RET after*	*3.4 Push Password*

3.5 Enter the password and push RET	3.6 Push the select Button	3.7 This screen appears

4. Push the Reference Button
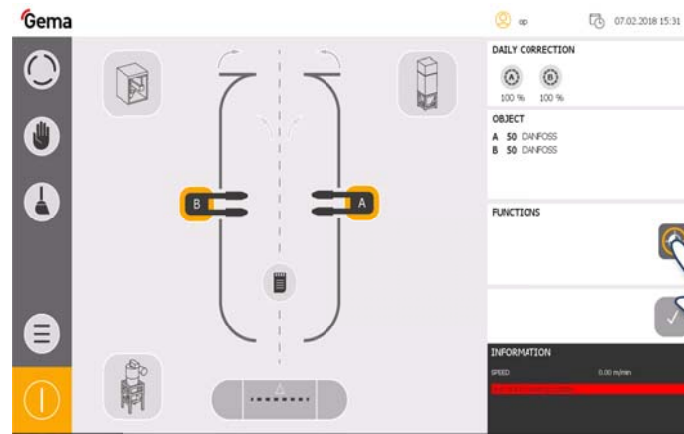
Info:

- All Axis start to move to reference position

5. **Put the Powder Bag in Cone, add the Lid and put the FP-Lance in, connect the RPP Hose to Waste**	6. **Choose Waste Powder Mode**	Info:
		- *Ventilation is starting* - *The Fresh Powder Pump starts to fill the OptiSpeeder*
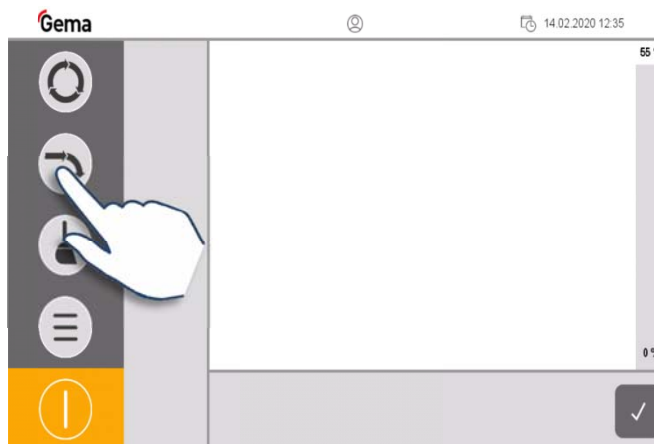
7. **Ready for Production**	
	 !!Caution!! **In Waste Powder Mode you work only with Fresh Powder.** **No Powder will be reclaimed!** **Change to Recovery Mode after a while!**

At the OptiCenter (recovery powder mode)

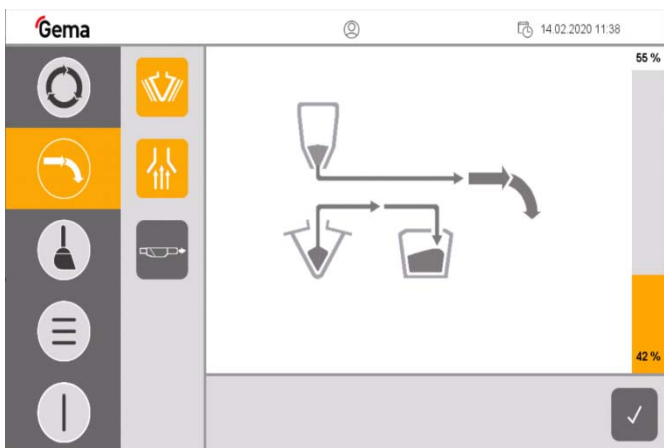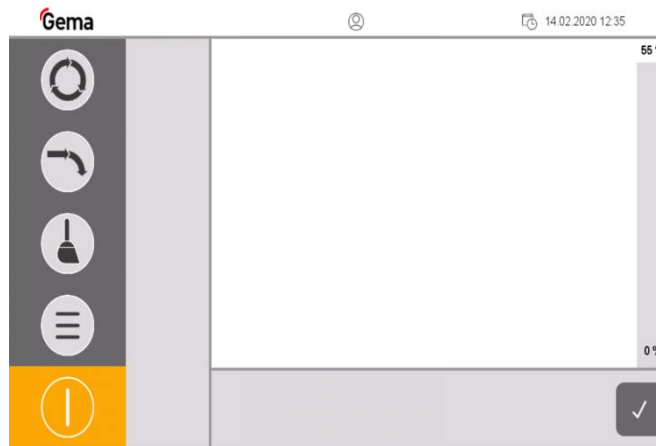| 8. Put the Powder Bag in Cone, add the Lid and put the FP-Lance in, connect the RPP Hose to Waste	9. Choose Recovery Powder Mode	Info:
		- There is NO Ventilation is starting - The Fresh Powder Pump starts to fill the OptiSpeeder
10. Ready for Production	**11. By pushing the timer**	You can set the time to recover the powder later

Switching OFF the System
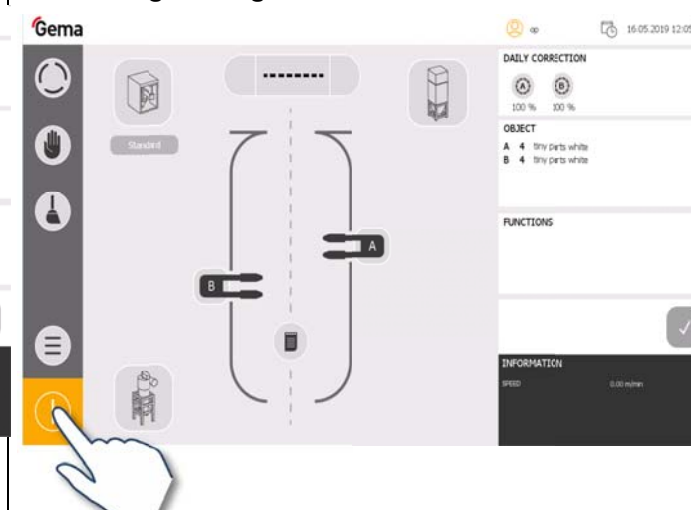
At the Touch Screen

1. Leave the Cleaning Mode by pushing longer the Button 	*This Screen appears* 	**2. Push again longer the button**
This Screen appears 	**3. System Key to 0** 	
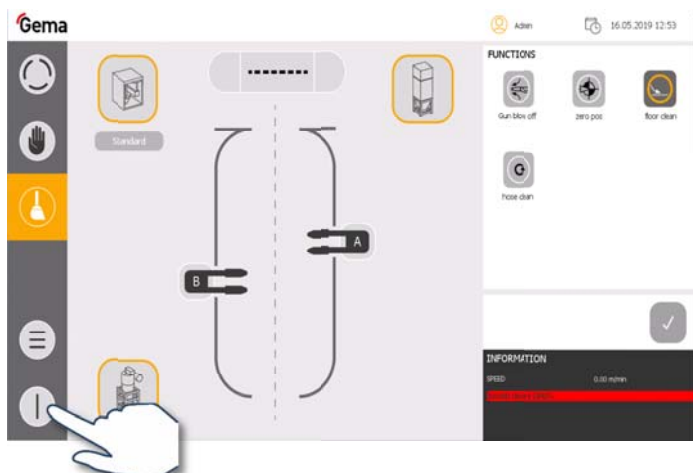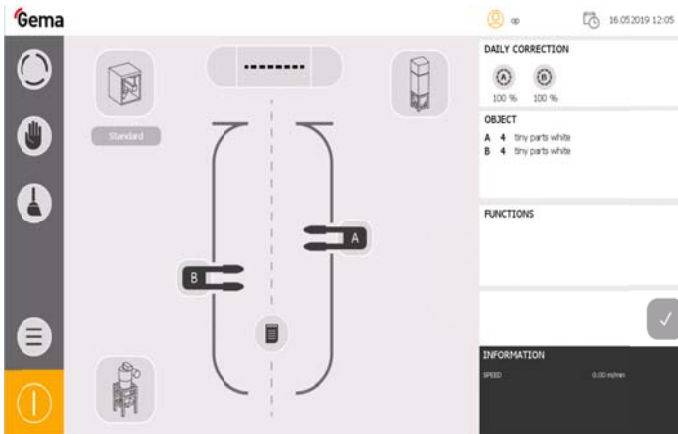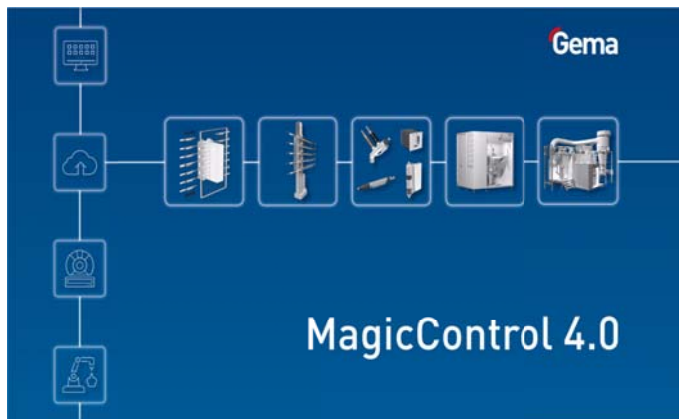
Color change

At the CM40-Panel

1. Push the Hose rinsing Icon 	*Info:* *- Hose rinsing is starting*	**2. Leave Coating Mode by pushing Broom Icon**
3. AFTER Step 2 push the Gun blow off Icon 	*Info:* *- You can already start with the rough booth cleaning when the main powder from step 2 and 3 disappeared*	**4. Rough Booth cleaning**
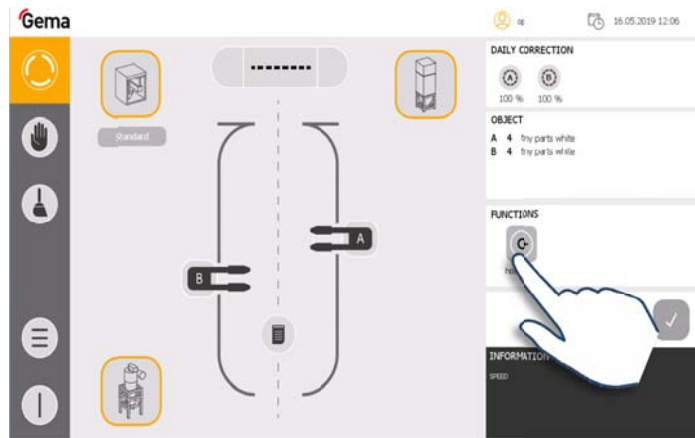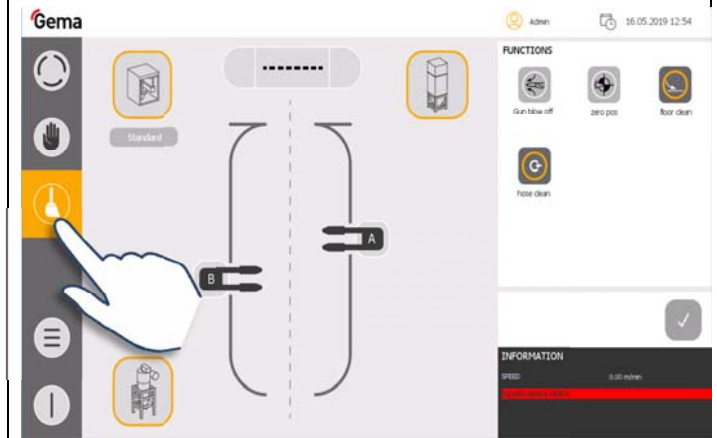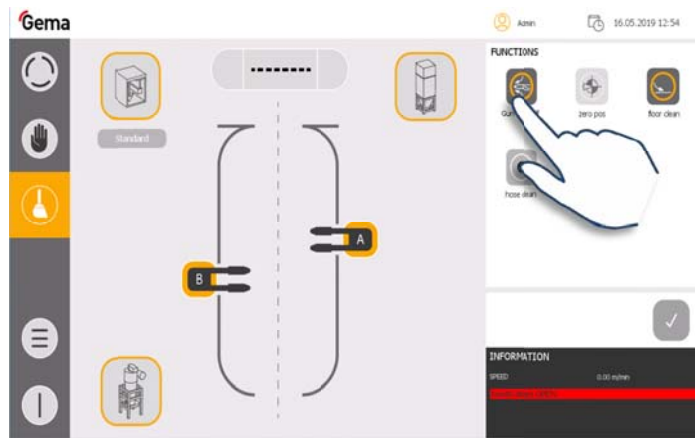
5. Leave Coating Mode by pushing the Broom Icon		**6. Choose the necessary cleaning cycle**
7. Clean the Fresh Powder Lance and put it to Parking Position	**8. Push the FP Cone under the Speeder**	**9. Push the Start Icon**

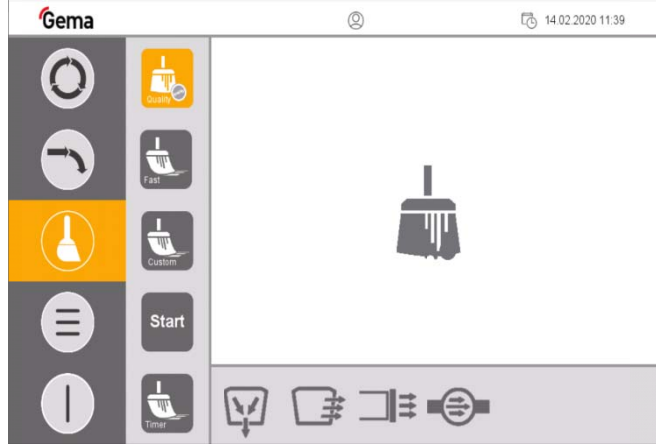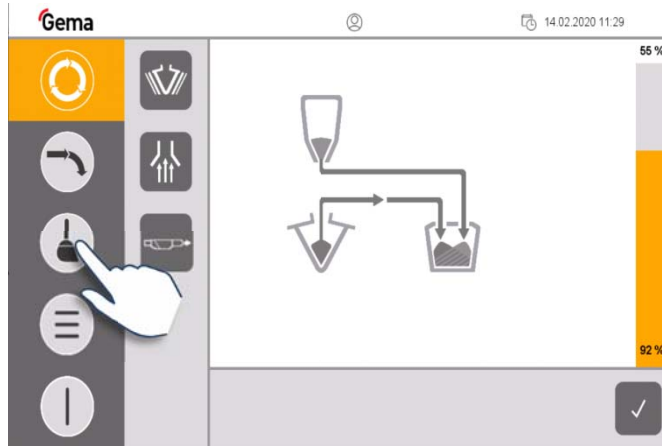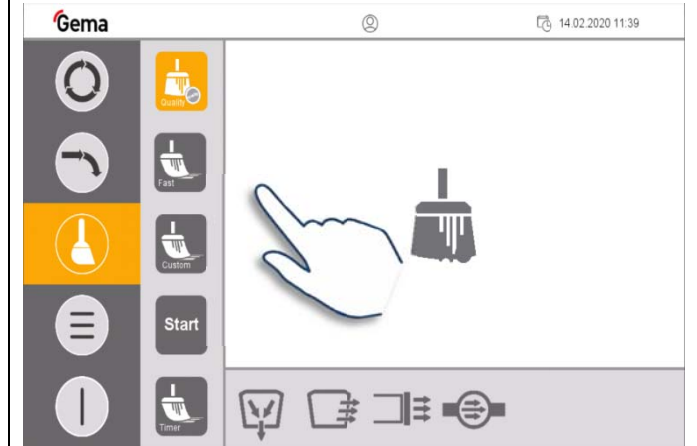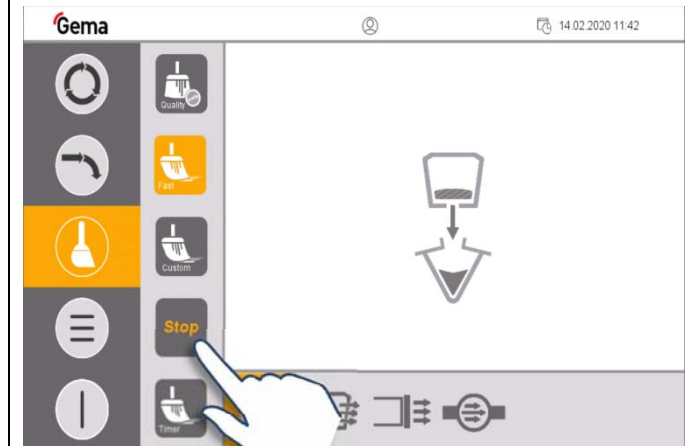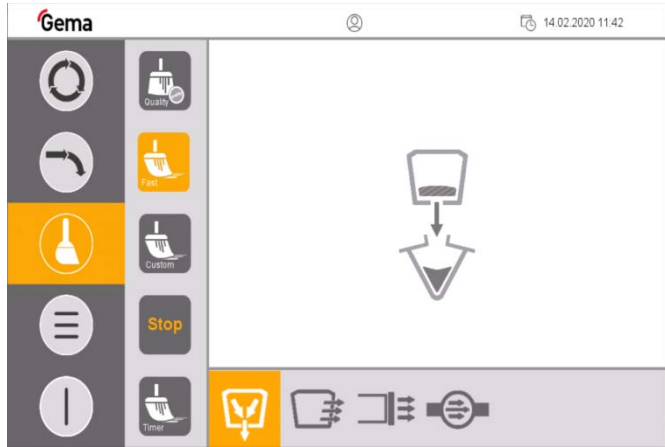|	Info:	
	- The empty Speeder sequence is starting	
	- At the same time the RP Pump is transferring powder from the cyclone	
	- When this step is done the operator can start to take the paint bag out and clean the bag carrier	
	- The OptiCenter automatically continues with the remaining steps	

10. Now you can start to fine clean the speeder	Info:	**11. Now you can clean the whole OptiCenter**
	- Some powders are very sticky. It is recommended to use a rag instead only the air gun	

12. *Start once more the gun outside cleaning*	*Info:*	13. *After gun cleaning is OK, park the gun´s outside the booth*
	- Meanwhile you can start already the booth fine cleaning	
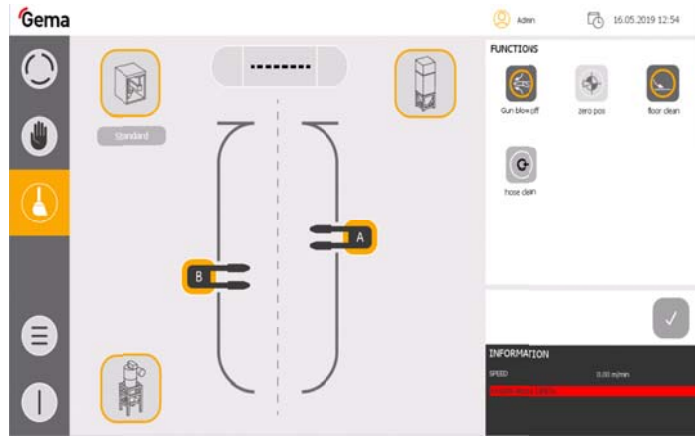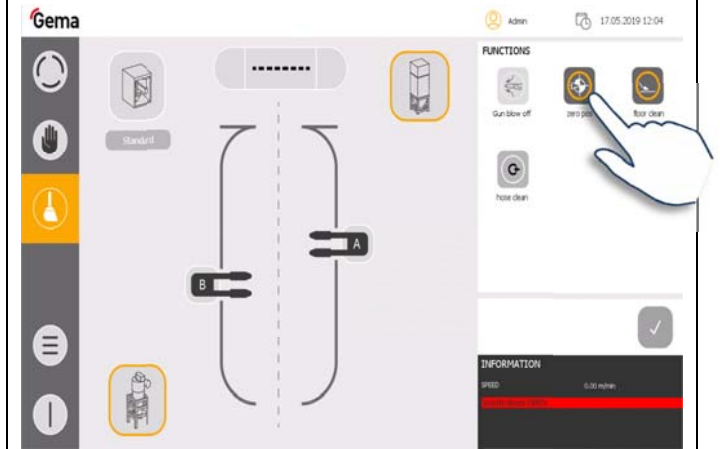
14. *Clean the Booth seriously*	15. *Clean the Ducting*	16. *Clean and remove the Screen*

17. Release RP-Hose Cleaning	18. Clean the Cone	19. Clean the Cyclone
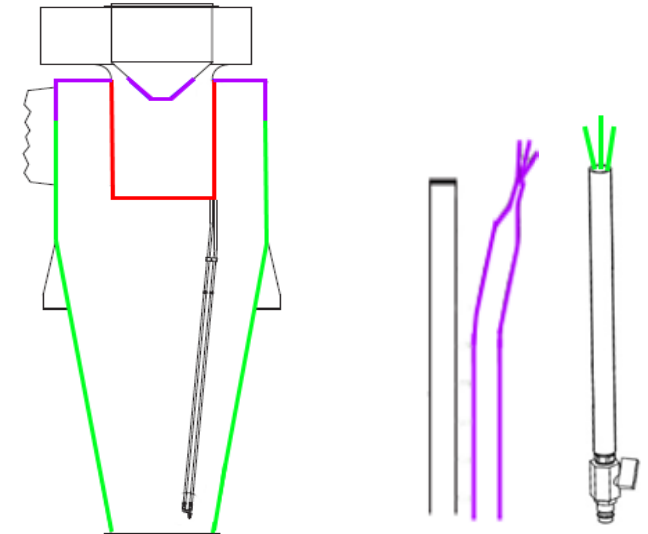
20. Put the screen back and close the cyclone	Info:
	- It is strongly recommended to clean the cyclone from time to time by Granulate

At the OptiCenter

21. Prepare for the new Color	*22. Leave the Cleaning Mode by selecting waste or recovery mode*	
		!!Caution!! **In Waste Powder Mode you work only with Fresh Powder.** **No Powder will be recovered!** **After a while you will see a reminder** **At the CM40 screen**

At the CM40-Panel

23. Leave the cleaning mode by pushing Auto Mode	*24. Now you are back ready for production*	

Main Screen

Gun Settings

Access to Axes Settings

Current Recipe

Powder Output

Total Air
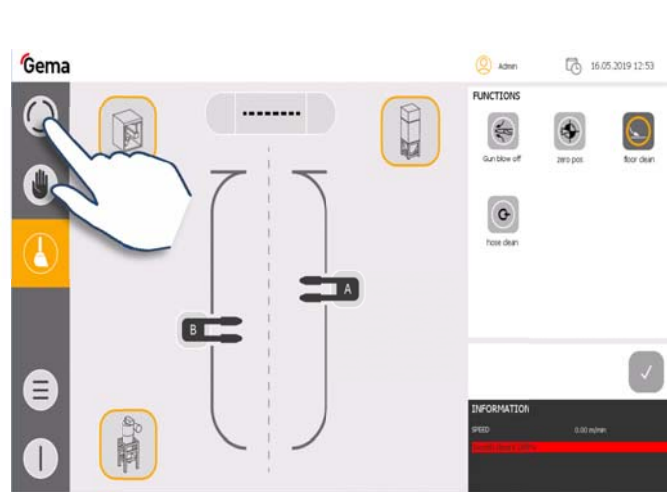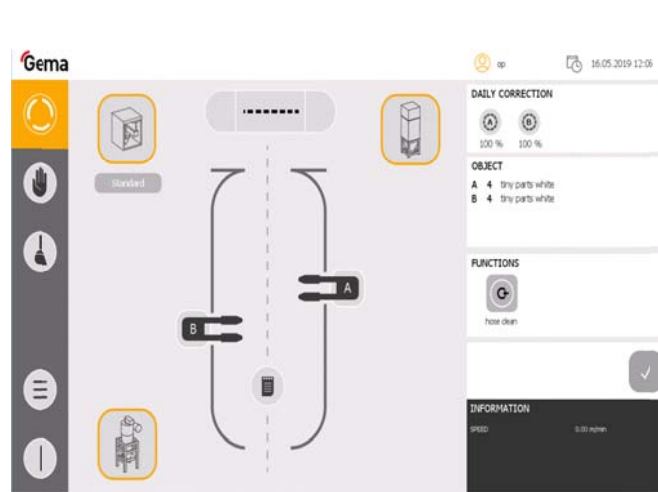
High voltage

Current

Electrode Cleaning

Admin   16.05.2019 12:24

GUN PARAMETER

OBJECT: 4   tiny parts white

Gun ON / OFF before and after the Object

kV   µA

Gun activated

Gun deactivated

1	A	1	40	4.0	60	5	0.1	25	25
2		2	40	4.0	60	5	0.1	25	25
3		3	40	4.0	60	5	0.1	25	25
4		4	40	4.0	60	5	0.1	25	25
5		5	40	4.0	60	5	0.1	25	25
6	B	1	40	4.0	60	5	0.1	25	25
7		2	40	4.0	60	5	0.1	25	25
8		3	40	4.0	60	5	0.1	25	25
9		4	40	4.0	60	5	0.1	25	25
10		5	40	4.0	60	5	0.1	25	25

Gun spraying

Gun not spraying

Access to all Recipes

Save Changes

Leave Page

All

INFORMATION

Reciprocator Settings

Labels in the figure:

- **Access to Gun Settings**
- **Current Recipe**
- **Upper Reversing Point**
- **Lower Reversing Point**
- **Current Axis Position**
- **START / STOP (manual Mode only)**
- **Start/Stop before and after Object**
- **Automatic X-Axis adjustment**
- **Fix Travel way !! Caution!! Collosion Hazard**
- **Axis deactivated**
- **Axis activated**
- **Speed**
- **approx Spray Distance**
- **Access to all Recipes**
- **Save Changes**
- **Leave Page**

Screen content:

AXIS PARAMETER

OBJECT: 4   tiny parts white

		↑⊤	↓⊥	↑			↔	⊢⊣	⊢⊦	
1	A Z	27	0	32	14	⟳	20	20	20	
2	X	60	0	10	60	⟳	10	10	10	Auto
3	B Z	27	0	32	14	⟳	2	20	20	
4	X	60	10	60		⟳	10	10	10	Manu

INFORMATION All

Z
X

Admin   16.05.2019 12:47

Schematic Powder Circuit