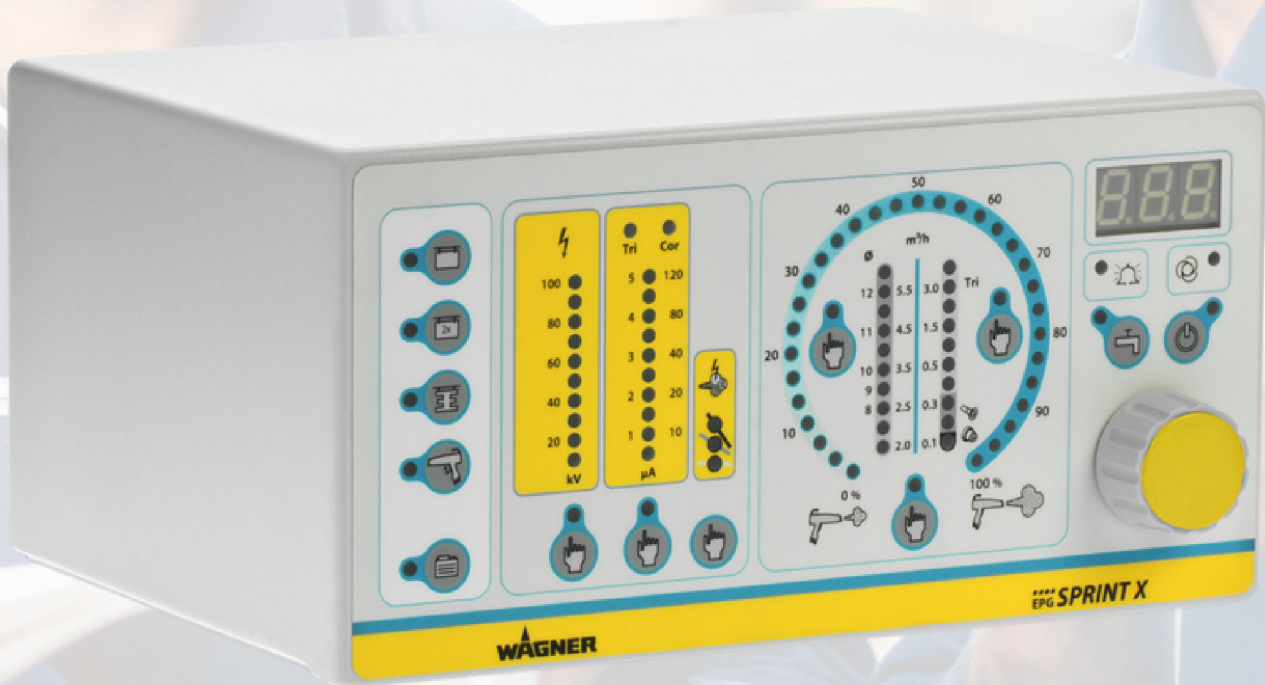


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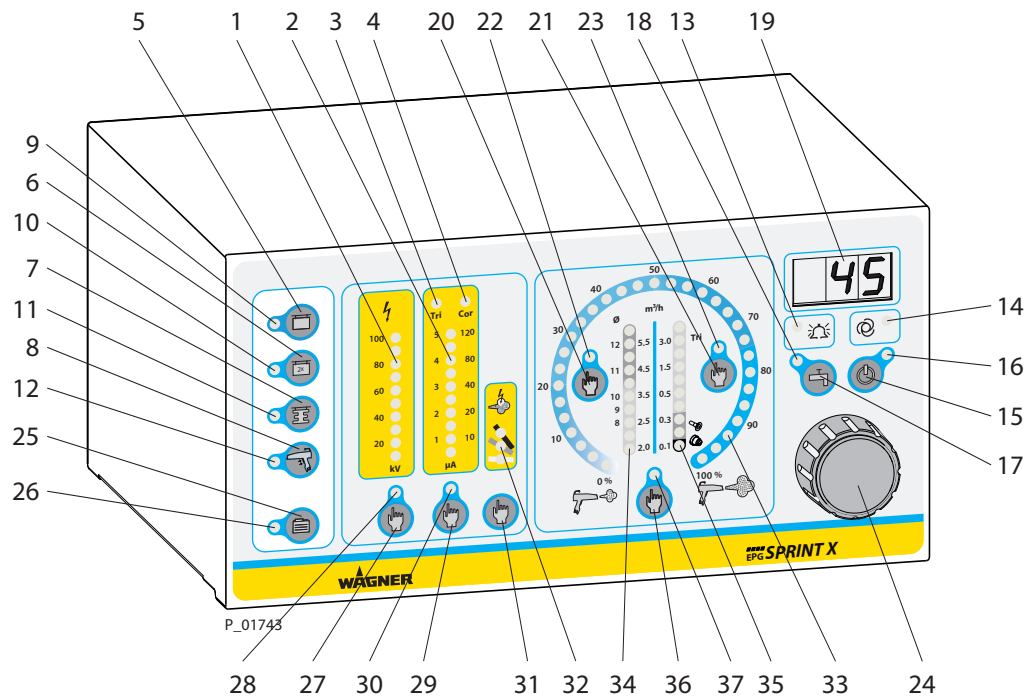
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5.3 OPERATION OF THE CONTROL UNIT**1 Illuminated display: "High voltage"**

- Lights up green
- Display range: 0-100 kV
- Resolution 10 kV
- Single LED display: Nominal voltage
- Bar display: Working voltage

2 Illuminated display: "Corona or Tribo Current"

- Lights up green
- Tribo scale:
- When a Tribo gun is connected and selected
 - Bar display: When powder feed is activated
 - Display range: 0-5 µA
 - Resolution 0.5 µA

Corona scale:

- When a Corona gun is connected and selected
- Display and adjusting range: 0 [5]–120 µA,
0 [5]–20 µA resolution 5 µA
20-40 µA resolution 10 µA
40-120 µA resolution 20 µA
- Single LED display: "Trigger Point of Current Limitation"
- Bar display: Corona current

- 3 Display: "Tribo Gun"**
 - Lights up when a Tribo gun is connected and selected
- 4 Display: "Corona Gun"**
 - Lights up when a Corona gun is connected and selected
- 5 Push button: recipe for "Surface Parts"**
- 6 Push button: recipe for "Second Coating"**
- 7 Push button: recipe for "Profiles"**
- 8 Push button: recipe for "Double Click"**
 - To access the recipe, press the trigger lever on the spray gun twice in quick succession and hold it down
- 9 LED display: recipe for "Surface Parts"**
 - Lights up green when the recipe for surface part is selected
- 10 LED display: recipe for "Second Coating"**
 - Lights up green when the recipe for "Second Coating" is selected
- 11 LED display: recipe for "Profiles"**
 - Lights up green when the recipe for profile part is selected
- 12 LED display: recipe for "Double Click"**
 - Lights up green, when the recipe for "Double Click" is selected
- 13 LED display: "Fault"**
 - Lights up, when there is a fault on the device
- 14 LED display: "Automatic Gun"**
 - Lights up, when an automatic gun is connected
- 15 Push button: "Standby"**
 - To switch into standby mode
 - High voltage and powder feed cannot be activated in this mode
 - To reactivate normal mode, press the button again
- 16 LED display: "Standby"**
 - Lights up when the unit is in standby mode
- 17 Push button: "Flush"**
 - To activate the injector and the hose flushing

18 LED display: "Flush"

- Lights up blue, when the flush function is activated

19 LED display: 7 segments, three-digit number

- Indicates the exact value depending on the activated function:
"Total air volume; atomizing, ionizing and Tribo air; additional recipes; high voltage;
current limitation; powder quantity"
- Display showing error number in the event of warnings and malfunctions

20 Push button: "Total Air Volume"

- To activate the function, the value is precisely adjusted with rotary controller 24 and is indicated in LED display 19
- Adjusting range: 2-6 m³/h
- Resolution: 0.05 m³/h

21 Push button: "Atomizing, Ionizing and Tribo Air"

- To activate the function, the value is precisely adjusted with rotary controller 24 and is indicated in LED display 19
- Adjusting range: 0.1-4 m³/h
- Resolution: 0.05 m³/h

22 LED display: "Total Air"

- Lights up yellow, when the setting "Total Air" is selected

23 LED display: "Atomizing, Ionizing and Tribo Air"

- Lights up yellow, when the setting "Atomizing, Ionizing and Tribo Air" is selected

24 Universal control dial

- Dynamic digital control dial with 32 positions per revolution
- Adjustment speed is proportional to rotational speed
- Used to set: "Total air volume; atomizer, ionizer and Tribo air; additional recipes; high voltage; current limitation; powder quantity"
- For setting parameter values in configuration mode

25 Push button: "Additional Recipes"

- To activate the function, the additional recipes adjustment is set with the rotary controller (24) and is indicated in the LED display (19).
- Selection of the recipes 5 to 50

26 LED display: "Additional Recipes"

- Lights up yellow, when an additional recipe is selected

27 Push button "High voltage"

- To activate the function, the high voltage is set with rotary controller 24 and is indicated in LED Display 19
- Adjusting range: 10–100 kV
- Resolution: 1 kV

28 LED display: "High Voltage"

- Lights up yellow. The high voltage is selected and can be adjusted using rotary controller 24

29 Push button: "Current Limitation"

- To activate the function, the current limitation is set with the control dial 24 and is indicated in the LED display 19
- Adjusting range: 5–120 μA
- Resolution: 1 μA

30 LED display: "Current Limitation"

- Lights up yellow. The current limitation is selected and can be adjusted using the rotary controller (24).

31 Push button: "Characteristic Slope"

- To switch the characteristic slope
- Display with LED 32

32 LED display: "Characteristic Slope"

- Lights up green
- Lower LED characteristic curve, flat
- Middle LED characteristic curve, medium
- Upper LED characteristic curve, steep

33 Illuminated display: "Powder Quantity"

- Lights up green
- Display range: 0–100 %
- Resolution: 3.33 %
- Single LED display: Set point (high voltage and powder are deactivated)
- Bar display: Actual value (high voltage and powder are activated)

34 Illuminated display: "Total Air Volume"

- Lights up green
- Display range: 2–6 m^3/h
- Resolution: 0.2–0.5 m^3/h
- Single LED display: Set point (high voltage and powder are deactivated)
- Bar display: Actual value (high voltage and powder are activated)

35 Illuminated display: "Atomizing, Ionizing and Tribo Air Volume"

- Lights up green
- Display range: 0.1–4 m^3/h
- Resolution: 0.1–1.0 m^3/h
- Single LED display: Set point (high voltage and powder are deactivated)
- Bar display: Actual value (high voltage and powder are activated)

36 Push button: "Powder Quantity"

- To activate the function, the powder quantity is set with rotary controller 24 and is indicated in LED display 19.
- Adjusting range: 1–100%
- Resolution: 1%

37 LED display: "Powder Quantity"

- Lights up yellow, when the powder quantity is selected

7.3 FACTORY SETTING RECIPE NOS. 1-4

The following set values are stored in recipe Nos. 1-4 in the factory.

Recipe no.	Designation	Characteristic	High voltage [kV]	Current limitation [μ A]	Characteristic curve	Total air [m^3/h]	Feed air [%]	Atomizing air [m^3/h]
P01	Flat part	High surface coverage	90	80	Standard	4.0	70	0.1
P02	Second coating	Avoidance of spraying back	50	20	Soft	3.6	57	0.1
P03	Profile part	Penetration and reduced build-up of edges	70	40	Soft	3.6	50	0.1
P04	Double click	Small components	80	20	Soft	3.6	45	0.1
P05-50	variable	individual	80	100	Standard	4.5	80	0.1

Notes:

Under normal conditions, metallic powder can be processed well using recipes Nos.1-4.

When operating the system with a Tribo gun, the values for total air, powder flow and Tribo air must be adjusted accordingly and saved.

With the 3 L tank variant, the values must also be adjusted individually and saved.