

SERVICE INSTRUCTION

RMA/MMA SERIES APPLICATOR START-UP REQUIREMENTS

Inspector's
Initials

For Ransburg Technical Service Call: (800) 233-3366

Before Start-Up (Site Inspection)

	Ransburg air heater installed A11065-XX or A13230-xx (reference service manual for proper settings)	
	Bell speed limits set (min. 20,000 RPM - max. 80,000 RPM)	
	Bearing air filters installed (RPM-418 .3 to .6 Micron Coalescing Filter, 19 SCFM)	
	Turbine air filters installed (RPM-417,.3 to .6 Micron Coalescing Filter, 136 SCFM)	
	Pneumatic and fluid lines connected (look for possible kinks especially bearing air)	
	Bearing air interlocked with turbine air	Reference www.ransburg.com for service manual information
	Turbine air interlocked with paint trigger	
	Is fluid flow rate (paint and solvent) known (fluid flow must be regulated 800ml/min or less)	
	Robotic speed known (max. speed recommended 250 degrees angular velocity)	
	High voltage connections inspected (verify connections and wiring)	
	Grounding checked to a known earth ground (max. 1 Mega ohm)	
	High voltage interlocked installed on booth door	
	High voltage interlocked with solvent trigger (HV locked off when solvent is sprayed)	

Start-Up Requirements

	Bearing air pressure set 90 PSI (5.51-6.90 bar)
	Brake air supply regulated (60-100 PSIG (414-689 kPa))
	Applicator inspected for air and fluid leaks, prior to operation
	Customer's PLC programmed correctly (review steps in code)
	Fluid flow rates checked. Do not exceed 800 cc/min - minimum flow rate 25 cc/min
	Bell cup checked for tightness on spindle motor shaft (50-70 lb•in (5.65-7.91 Nm))
	Bell cup must be spinning 20,000 RPM minimum before fluid flow, check interlocks
	Test bell cup wash function with bell cup spinning 20,000 RPM minimum
	Verify paint supply is regulated to applicator (max. pressure 200 PSI (1379 kPa))
	Verify solvent supply is regulated to applicator (max. pressure 150 PSI (1035 kPa))
	Test output voltage and output current (reference service manual for "Specifications")

Verify PLC Programming: (Robot Mounted Applicators Only)

	Verify cup wash cycle cleans bell cup properly (bell cup must be cleaned periodically)
	Verify robot path is free from collision to painted part and/or service grate

Applicator Clean up Guidelines When Fixed or Robotic Mounted:

Use only non-polar solvent for clean up of the applicator.
When cleaning applicator, make sure bearing air is on to prevent solvent intrusion into air motor.
Do not spray down the applicator with solvent. Wipe down with wetted towel carefully as required.
Make sure the rear well of the bell cup is clean from trapped paint to avoid air motor failures.

NOTE: Additional information regarding applicator and/or its capability can be found in the corresponding service manual
For "Spare Part Information" reference the applicator service manual

Always use genuine Ransburg replacement parts to assure maximum uptime with applicator.

Facility Representative: _____

Date: _____

Ransburg Representative: _____

Date: _____