

## **SERVICE INSTRUCTION**

# RMA-550 FM SERIES APPLICATOR START-UP REQUIREMENTS

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

Bell speed limits set (min. 20,000 RPM - max. 55,000 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 Turbine air interlocked with paint trigger Is fluid flow rate (paint and solvent) known (fluid flow must be regulated 500ml/min or less) Robotic speed known (max. speed recommended 200-225 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  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 500 cc/min - minimum flow rate 25 cc/min Bell cup checked for tightness on spindle motor shaft (10-15 lb•in) (1.13 - 1.69 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 150 PSI (1035 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 robot path is free from collision to painted part and/or service grate	service n	Service Manual  LN-9284-15  www.ransburg.com formanual information
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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 a		
Do not spray down the applicator with solvent. Wipe down with wetted towel carefully		
When cleaning applicator, make sure shape air is on (70 SLPM) to prevent solvent and p	paint int	rusion.
NOTE: Additional information regarding applicator and/or its capability can be found in	the cor	responding
service manual. For "Spare Part Information" reference the applicator service ma		
Always use genuine Ransburg replacement parts to assure maximum uptime wit	th applic	cator.
Facility Representative:	Date: _	

## **Ransburg**

### Manufacturing

1910 North Wayne Street Angola, Indiana 46703-9100 Telephone: 260-665-8800

Fax: 260-665-8516

#### **Technical Service** — Assistance

320 Phillips Ave. Toledo, Ohio 43612-1493

Telephone (toll free): 800-233-3366

Fax: 419-470-2233

Technical Support Representative will direct you to the appropriate telephone number for ordering Spare Parts.

Form No. SI-15-06 Litho in U.S.A. 09/15

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