

HOT WAX PRESSURE TANK SYSTEM

Item no. 140 104

Read instructions before start-up!

For ordering spares and queries please always quote the serial number. You will also find this next to the pressure control unit (6)

Serial number:

Version: hand version

Hand pistol: separate operating instructions

Tension: 400 V

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CE-manufacturer explanation

in the sense of the EG-machine guideline 89/392, appendix II B

Hereby we explain that the hot wax pressure tank system

Modell:HWDTs-140.104

Production No.: starting from 95104016

intended use:

Processing of solvent-free waxes.

Processing of solvent-free media.

corresponds to following guidelines.

EG-machine guideline: 89/392 EWG,
appendix II B with the changes 91/368/EWG,
93/44/EWG and 93/68/EWG
EC 745-2-7: 1989

Application for harmonized standards in each case the version valid at the time of the production: *EN 292 (security of machine)

Note: This machine is not subject to the demands in accordance with appendix IV for machines with special endangment in accordance with guideline 89/392/EWG. The keeping of the documents takes place therefore with us.

Name: Vinko Sebalj, Managing director
Aichach in February 2002



The VISECO Hot wax pressure tank system with electronic temperature regulation is for gentle wax heating. By means of the additional round broad jet control you can process hard wax easily.



1. General

These operating instructions should be read and strictly observed before starting the equipment. They include all the information required for trouble-free installation, commissioning and problem-free operation. Providing the operating instructions have been observed, we will be liable under our conditions of guarantee. During the guarantee period repairs and alterations may be undertaken only with our agreement and by our fitters or by qualified fitters authorised by us. The operator is responsible for the correct installation, operating and maintenance.



2. Safety

The hot wax pressure tank system represents up to date technology and is safe to operate. Improper use, e. ge. exceeding the operating data (see Technical Data), could be dangerous. It is the duty of the user to operate the equipment only in perfect condition. Regular checking by trained personnel is a prerequisite. Conversions and alterations may be not be carried out by unauthorised persons. Only original spares and accessories may be used. No solvent-based varnishes or paints may be used as the equipment is not Ex-protected. The hot wax pressure tank system may not be used in Zones 0, 1 and 2.

Important note:

With the employment of the hot wax pressure tank system we particularly refer to the adherence to the UVV VBG 1 and 23. Spray gun never toward persons direct. With cleaning the hot wax pressure tank system with solvent no ignition source may be in the work area, since easy-inflammable mixtures develop. The power supply plug of the plant must be marked out.



3. Technical data

| | |
|------------------------------|---|
| mains supply: | 400 VAC-50/60 Hz |
| fuse protection of the lead: | 16 A inert |
| Wachstherm capacity: | 760 VA |
| pressure tank capacity: | 1300 VA |
| output voltage: | max. 60 VDC at output |
| trafo: | isolation trafo in accordance with VDE 0551 |
| protection system | insulated |
| protection class: | IP 64 |
| temperature regulation: | microprocessor controlled |
| max. filling capacity: | 12 litres |
| max. material pressure: | 3 bar |
| max. material temperature: | 95°C |
| max. atomizer air pressure: | 6 bar |
| length of hose: | 7 m |
| nominal diameter: | 6 mm |
| heating: | heating wire inside |
| temperature: | max. 95°C |

Danger of burning!

Bare metal parts can become hot during operation!

Warning!

The hot wax pressure tank system is not suitable for solvent based varnishes. Do not use in EX-protection zones!

Subject to technical alterations.

4. Hot wax pressure tank system frontal view

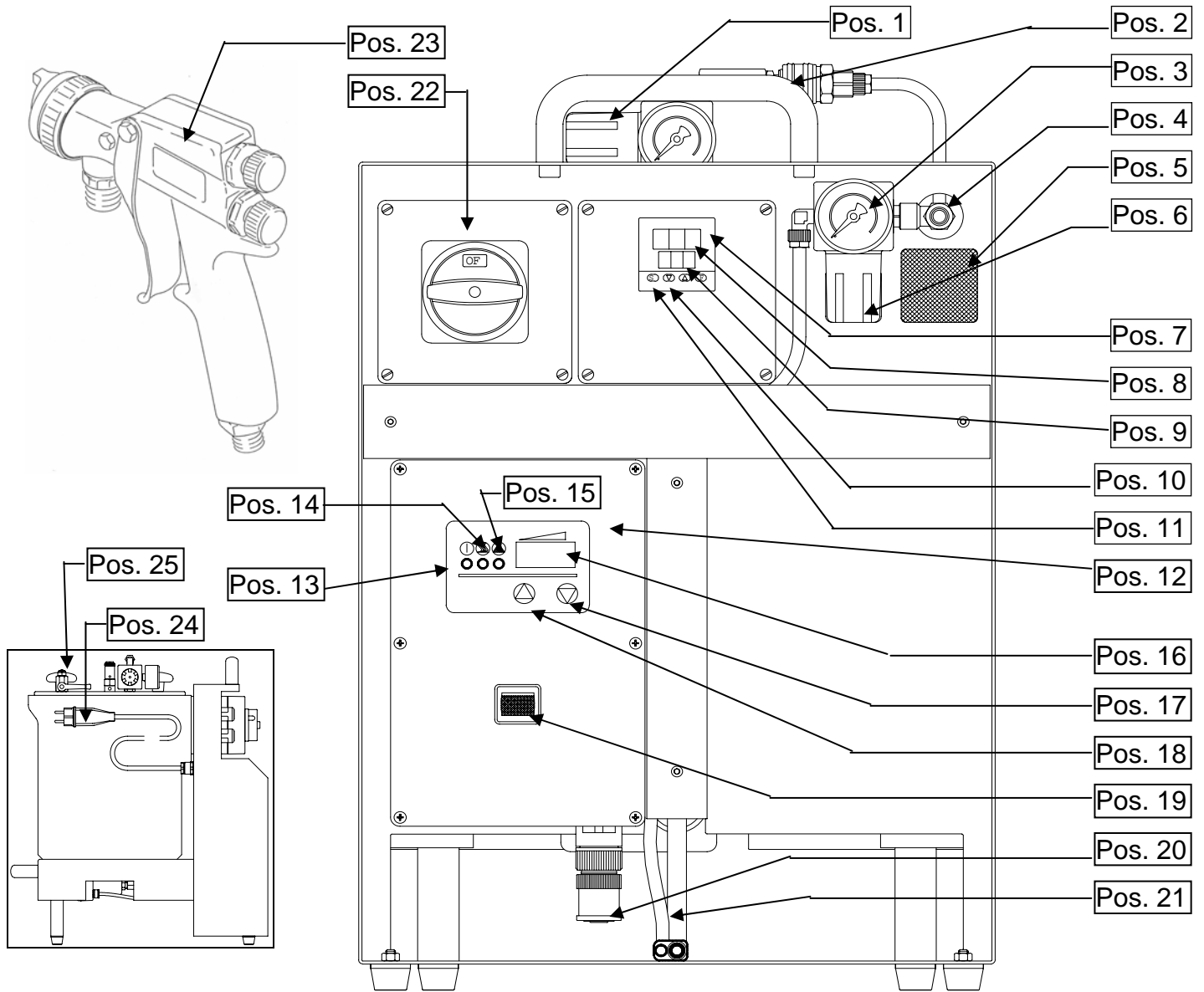


Illustration 1

| Pos. | Designation | Part number | Pos. | Designation | Part number |
|------|--|-------------|------|----------------------------------|-------------|
| 1 | Manometer 0 - 4 bar | 104.50.100 | 14 | Light emitting diode heating | |
| 2 | Compressed air clutch compl. | 104.50.078 | 15 | Light emitting diode disturbance | |
| 3 | Manometer 0 - 10 bar | 104.50.101 | 16 | Digital power indication | |
| 4 | Compressed air plugs NG 8 | 104.50.080 | 17 | Amount of heat decrease | |
| 5 | Identification plate | | 18 | Amount of heat increase | |
| 6 | Compressed air regulator | 104.50.102 | 19 | Power switches Wachstherm | |
| 7 | Volcano temperature regulator | 104.50.112 | 20 | Plug hose package | |
| 8 | Is – value indication | | 21 | Hose package | 104.50.089 |
| 9 | Target – value indication | | 22 | Main switch | |
| 10 | Temperature increase | | 23 | Graco – spray gun | |
| 11 | Temperature decrease | | 24 | Mains cable | |
| 12 | Wachstherm - electronics for material hose | 104.50.083 | 25 | Star grasp | 104.50.111 |
| 13 | Light emitting diode enterprise | | | | |

◆

5. Sectional drawing pressure tank

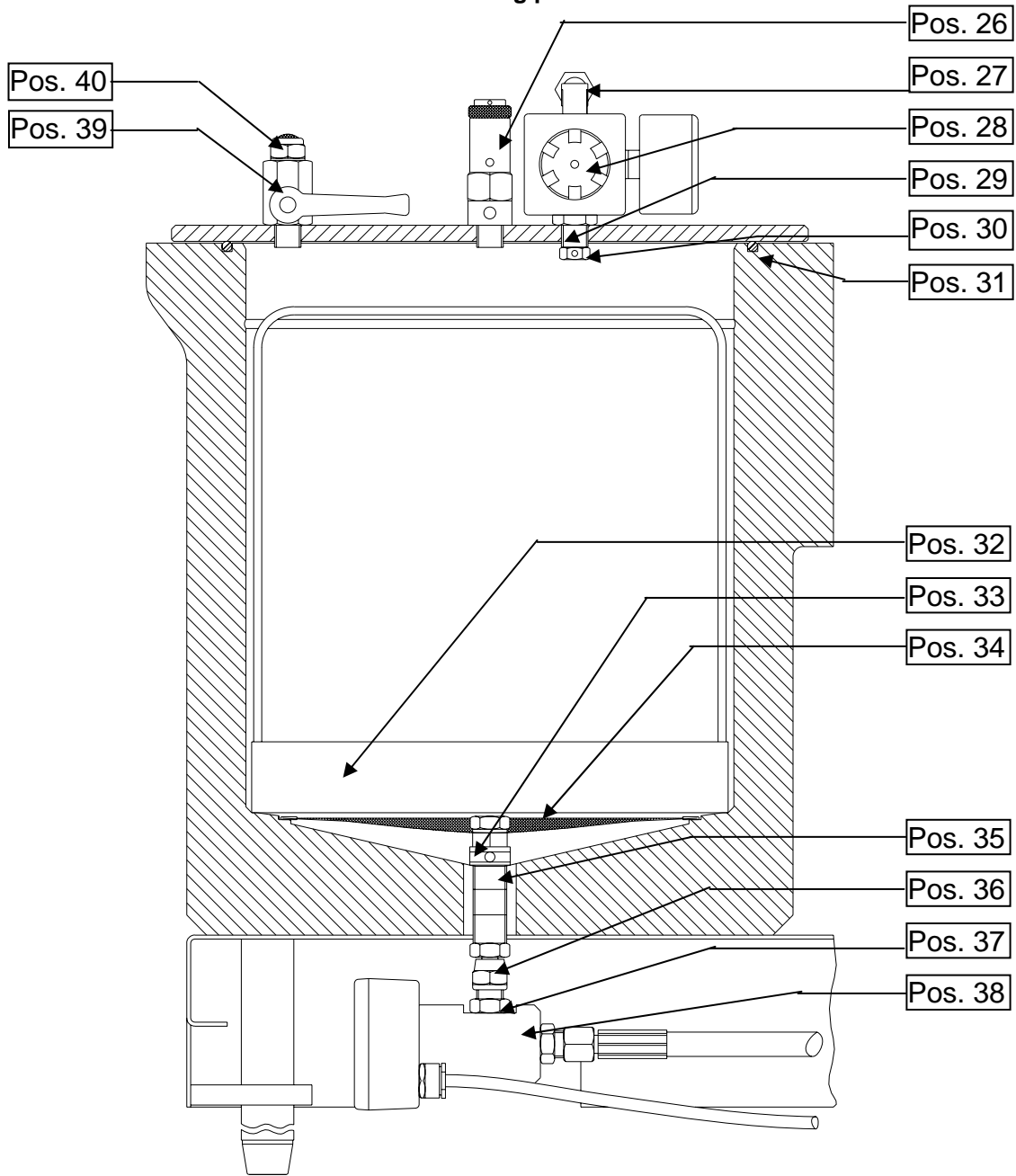


Illustration 2

| Pos. | Designation | Part number | Pos. | Designation | Part number |
|------|---------------------------------|-------------|------|---|-------------|
| 26 | Relief valve | 104.50.103 | 34 | Soil filter | 104.50.108 |
| 27 | Check valve with angle | 104.50.104 | 35 | Filter owner | 104.50.086 |
| 28 | Material pressure control valve | 104.50.102 | 36 | Swivel joint nipple | 104.50.087 |
| 29 | Double nipple ¼" M 8x1 | 104.50.105 | 37 | Double nipple | 104.50.088 |
| 30 | Distributor screw | 104.50.106 | 38 | Distributor (only with hose package completely) | 104.50.089 |
| 31 | Sealing ring | 104.50.090 | 39 | Breather ball valve | 104.50.109 |
| 32 | Strainer basket (option) | 104.50.107 | 40 | Muffler | 104.50.110 |
| 33 | Filter screw | 104.50.085 | | | |



6. Start-up

- ⇒ Take the hot wax pressure tank system at the place planned for it set up
- ⇒ Compressed air clutch pos. 2 mark out
- ⇒ Star grasp pos. 40 (4 pieces) screw on
- ⇒ Remove cover of container
- ⇒ With first filling: hard wax liquefy and cast in
- ⇒ During filling it can come to cavities underneath the soil filter. By agitating and easy knocking with an agitating staff on the soil filter you can let the cavities ascend.
- ⇒ Minimum amount of filling: 2,5 l
- ⇒ Max. amount of filling: to tank marking (12 l)

Reference:

Wax quantity must cover the filter. Otherwise danger of skin formation under the surface filter. With oxidative hardening waxes we recommend the pressure in the tank with regulated nitrogen (input pressure max. 5 bar) to operate.

- ⇒ Place cover on and screw star grasps pos. 40 (4 pieces)
- ⇒ Stick on compressed air clutch pos. 2 at pressure rule unit pos. 1
- ⇒ Check whether breather ball valve pos. 39 is closed
- ⇒ Put in mains cable pos. 24
- ⇒ Switch on main switch pos. 22 (ON)
- ⇒ Switch on temperature controller „Wachstherm®“ Pos. 12 (factory-installed attitude 80° C)
- To change the temperature at the temperature controller pos. 7, press only *mode*; with *arrow keys* the desired value stop and with the *mode key* the new value confirm
- ⇒ With first filling approx. 30 min. heating-up time
- ⇒ Couple air supply line (cleaned compressed air pressure min. 5 bar – max. 10 bar) at compressed air plug pos. 4
- ⇒ Adjust pressure rule unit pos. 1 on approx. 1,5 bar material pressure
- ⇒ Adjust pressure rule unit pos. 6 on approx. 2 bar of atomizer air and by taking off the spray gun pos. 23, air out material hose line
- Equipment is ready for use.




7. Operating notes

During spraying it is important to ensure that the hot wax does not fall below the fill mark of the soil filter pos. 34. After completing work the hot wax can remain in the pressure tank, in the material hose and in the spray pistol. During cooling, due to the formation of a wax skin, the soil filter pos. 34 must always be covered with wax to avoid any danger of clogging.

Regular preventive cleaning of the pressure tank unit increases the operating safety. In order to prevent burning by hot wax when filling the equipment protective goggles and protective gloves must be worn. This is also advisable when cleaning to protect from solvents.

Before putting into operation check the sealing ring pos. 31 for cleanliness to ensure perfect pressure tightness of the equipment.



8. Maintenance of the spray gun

NOTE !

Spray gun may never be separated of the hose package pos. 21, because otherwise the core heating is damaged. Before beginning of the work chapters 1 and 2 are to be considered. Before the development of the material needle only the air cap and the material nozzle must be dismantled carefully. When assembling the material needle must be led past that heating spiral. It is on it to respected that the material needle is not blocked by the heating spiral. With cleaning the spray gun pos. 23 is to respected not to damage the heating spiral.

- For cleaning and maintenance work see separate manual of the spray gun.

9. Maintenance of the pressure tank

Cleaning of the pressure tank and of the soil filter

We advise carrying out a visual check of the soil filter pos. 34 for dirt before each new filling.

- ⇒ Switches main switch pos. 22 (OFF), plug off power supply pos. 24 and mark out compressed air plug pos. 4
- ⇒ Open breather ball valve pos. 39
- ⇒ Take off compressed air clutch pos. 2
- ⇒ Open and remove cover with star grasps pos. 25
- ⇒ Fill out existing material remainder
- ⇒ Clean container wall with solvent (wear protection gloves and eye protector)
- ⇒ Remove cleaning arrears
- ⇒ Solve filter screw pos. 33 with box spanner size 17
- ⇒ Remove soil filter pos. 34 by raising
- ⇒ Hold steel pin against filter owner pos. 35 and dismantle soil filter pos. 34
- ⇒ Clean soil filter pos. 27 and filter owner pos. 28 with suitable cleaner and blow it out with compressed air
- ⇒ Clean tank bottom of the pressure tank pos. 4
- ⇒ Assembly takes place in reverse order

To refill the equipment see chapter 6

10. Causes of malfunction

| Problem | Cause | Solution |
|--|---|--|
| Equipment does not heat. Hose line pos. 21 does not heat. | <ol style="list-style-type: none"> 1. Mains cable pos. 24 not plugged in. 2. Main switch pos. 22 off (OFF). 3. Power switch pos. 19 off. | <ol style="list-style-type: none"> 1. Plug in mains cable pos. 24. 2. Switch on main switch pos. 22 (ON). 3. Switch on power switch pos. 19. |
| Hose line pos. 21 does not heat. LED pos. 15 flashes. | <ol style="list-style-type: none"> 1. Plug pos. 20 not plugged in. 2. Heating wire broken. | <ol style="list-style-type: none"> 1. Plug in plug pos. 20 2. Call service department. |
| Pressure tank blows out air | <ol style="list-style-type: none"> 1. Breather ball valve pos. 39 open. 2. Material pressure high. 3. Pressure tank cover loose. 4. O-Ring pos. 31 dirty or damaged | <ol style="list-style-type: none"> 1. Close breather ball valve pos. 39. 2. Reduce material pressure at pos. 28. 3. Screw tight star grasps pos. 25 4. Clean or renew o-ring. |
| No spray air in the spray pistol pos. 23. | <ol style="list-style-type: none"> 1. Compressed air connector pos. 4 is not connected. 2. Spray pressure too low. | <ol style="list-style-type: none"> 1. Connect compressed air connector pos. 4. 2. Adjust pressure via pressure regulation unit pos. 6. |
| No wax from spray pistol pos. 23. | <ol style="list-style-type: none"> 1. Operating temperature no yet attained. 2. Compressed air connector pos. 2 is not connected. 3. Operating temperature set too low, wax does not melt. 4. Material pressure too low. 5. No wax in pressure tank. 6. Soil filter pos. 34 and filter owner pos. 35 clogged. 7. Pistol clogged. | <ol style="list-style-type: none"> 1. Heating phase approx. 30 minutes. 2. Connect compressed air connector pos. 2 3. Adjust wax producer temperature indication at pos. 7 and pos. 12. 4. Increase material pressure pos. 1. 5. Fill pressure tank with wax. 6. See maintenance chapter 9. 7. See maintenance chapter 8. |



11. Guarantee conditions

WISECO guarantees that all devices made by WISECO and wearing the name WISECO are free of material and production faults at the time they are sold by authorized sales representatives to the original buyer.

WISECO will repair or replace all parts of the device which have been accepted by WISECO to be faulty within a period of 12 months after the date of sale.

This warranty is only valid if the device has been installed, operated and maintained according to the written instructions issued by WISECO.

This warranty does not include general wear or any kind of malfunction or damage caused by incorrect installation or operation, abrasion, corrosion, inadequate or incorrect maintenance, negligence, unauthorized modifications or fitting of parts that are not original WISECO parts. Moreover, WISECO will not be liable for any malfunctions, damages or wear caused this way.

Furthermore, WISECO will not be responsible for malfunctions, damages or wear resulting from incompatibility of WISECO devices with structures, spare parts, devices or materials not supplied by WISECO or those resulting from improper design, production, installation, operation or maintenance or which are caused by structures, spare parts, devices or materials not supplied by WISECO.

This warranty will be valid under the condition that the device to be guaranteed is sent free of charge to WISECO to repair the indicated fault. If the indicated fault is confirmed, WISECO will repair or replace any kind of faulty part free of charge. The device will be sent back to the sender not free. If no material or production defect should be found during testing we will repair the device according to our valid prices which include the costs for spare parts, work and transport.

WISECO's sole liability as well as the purchaser's only appeal in case of lacking warranty result from the above said. The purchaser agrees to the fact that no other appeal will be admitted (inclusively but not exclusively claims for damages following profit losses, not concluded sales, personal and material damages or other). Any kind of lacking warranty has to be claimed within two (2) years after date of sale.

WISECO's warranty does not include any accessory parts, materials or components delivered by WISECO but not produced by WISECO. Those parts delivered by WISECO but not produced by WISECO are subject of guarantee bonds of the respective producers, as far as available. Should such a producer not fulfil his warranty, WISECO will support the purchaser with any kind of adequate assistance.

This WISECO warranty does not include:

- Necessary replacement of sealings and packings as a result of normal wear.
- Heating cartridges.

Normal wear is not considered as material or production failure.

LIMITATION OF LIABILITY

WISECO will not be liable in any case for indirect damages following or for particular damages resulting from the delivery of devices by WISECO, neither for damages resulting from the breach of a contract or from the lacking of warranty nor for damages due to negligence by WISECO or other circumstances. This also applies to damages possibly resulting from the design, the product features or the use of WISECO devices or other devices delivered by WISECO but not produced by WISECO.

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