Operating instructions and spare parts list

Powder sieve machine

PS07

Translation of the original operating instructions
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About this instructions

General information

This operating manual contains all important information you will need to work with the PS07. It will safely guide you through the start-up process and give you references and tips for the optimal use of your new powder coating system.

Information about the functional mode of the individual system components should be referenced in the respective enclosed documents.

Keeping the Manual

Please keep this Manual ready for later use or if there should be any queries.

Safety symbols (pictograms)

The following warnings with their meanings can be found in the Gema instructions. The general safety precautions must also be followed as well as the regulations in the relevant instructions.

**DANGER**

Indicates a hazardous situation which, if not avoided, will result in death or serious injury.

**WARNING**

Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.

**CAUTION**

Indicates a potentially hazardous situation which, if not avoided, could result in minor or moderate injury.
Presentation of the contents

Figure references in the text

Figure references are used as cross references in the descriptive text.

Example:

"The high voltage (H) created in the gun cascade is guided through the center electrode."
Safety

General information

This chapter sets out the fundamental safety regulations, that must be followed by the user and third parties using this product.

These safety regulations must be read and understood before the product is put into operation.

The standards and guidelines applied during the development, manufacture and configuration are described in the EC declaration of conformity and in the manufacturer’s declaration.

⚠️ WARNING

Working without instructions

Working without instructions or with individual pages from these instructions may result in damage to property and personal injury if relevant safety information is not observed.

- Before working with the device, organize the required documents and read the section "Safety regulations".
- Work should only be carried out in accordance with the instructions of the relevant documents.
- Always work with the complete original document.

Basic safety instructions

- This product is built to the latest specification and conforms to the recognized technical safety regulations and is designed for the normal application of powder coating.

- Any other use is considered non-compliant. The manufacturer shall not be liable for damage resulting from such use; the user bears sole responsibility for such actions. If this product is to be used for other purposes or other substances outside of our guidelines then Gema Switzerland GmbH should be consulted.

- Start-up (i.e. the execution of intended operational tasks) is forbidden until it has been established that this product has been set up and wired according to the guidelines for machinery. The standard "Machine safety" must also be observed.

- Unauthorized modifications to the product exempt the manufacturer from any liability from resulting damage.
– The relevant accident prevention regulations, as well as other generally recognized safety regulations, occupational health and structural regulations are to be observed.
– Furthermore, the country-specific safety regulations also must be observed.

Product specific security regulations

– This product is a constituent part of the equipment and is therefore integrated in the system’s safety concept.
– If it is to be used in a manner outside the scope of the safety concept, then corresponding measures must be taken.
– The installation work to be done by the customer must be carried out according to local regulations.
– It must be ensured, that all components are earthed according to the local regulations before start-up.

For further security information, see the more detailed Gema safety regulations!
Product description

Intended use

The powder sieve machine is only intended for sieving powder which is used for coating. The powder sieve machine’s sieving capacity is supported by the sieve vibration motor. Depending on customer specifications, the powder is fed in by powder pumps or dense phase conveyor.

fig. 1: Powder sieve machine PS07

The powder sieve machine is certified for using in the following zone, if powder hoses are used, which grounding resistance is less than 1 MOhm!

<table>
<thead>
<tr>
<th>Explosion protection</th>
<th>Zone</th>
</tr>
</thead>
<tbody>
<tr>
<td>EX II 3 D</td>
<td>22</td>
</tr>
</tbody>
</table>

Observance of the operating, service and maintenance instructions specified by the manufacturer is also part of conformity of use. This product should only be used, maintained and started up by trained personnel, who are informed about and are familiar with the possible hazards involved.
Any other use is considered non-compliant. The manufacturer is not responsible for any incorrect use and the risks associated with such actions are assumed by the user alone!

**Reasonably foreseeable misuse**
- Use of moist or over-tempered powder
- Incorrectly assembled individual parts
- Use with insufficient compressed air quality
- Operation without the proper training

## Structure

### General view

1. Hose connection  
2. Sieve  
3. Clamp ring  
4. Swivel frame  
5. Sieve base  
6. Vibrator  
7. Sieve cover  
8. Connecting hose

**fig. 2**

**Sieve vibration motor**

The sieve vibration motor supports the sieve performance of the powder sieve machine. After activating the powder coating system, it will run continuously until the entire system is either deactivated or switched into cleaning mode.
Double sieve with cleaning effect

Double sieves consist of two parts, the wire net with large mesh width on the lower side, and the wire net with fine mesh on the upper side.

![fig. 3: Double sieve](image)

1 fine sieve mesh  
2 large mesh supporting sieve  
3 sieve assistance

Both sieve frames are fitted together, so that the inlying rings can not be lost. By using this filter assistance, the sieve mesh on the lower surface is constantly cleaned and the clogging danger is substantially reduced. According to experience, it is well-known that blockages are caused by the powder accumulation on the lower surface of the sieve.

---

Technical Data

Versions

The powder sieve machine is available, depending on sieve cover design, in three versions.

<table>
<thead>
<tr>
<th>Number of connections</th>
<th>PS07-K-E</th>
<th>PS07-K</th>
<th>PS07-M</th>
</tr>
</thead>
<tbody>
<tr>
<td>1, 2, 4, 6</td>
<td>1, 2, 3</td>
<td>2</td>
<td></td>
</tr>
</tbody>
</table>

Operation in (recommended)  
OptiCenter OC04/OC05

Approvals  
CE  
Ex  
EEEx II 3GD IP65 T120
### Electrical data

<table>
<thead>
<tr>
<th>PS07</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Input voltage – vibration motor</td>
<td>3x230 V</td>
</tr>
<tr>
<td>Frequency</td>
<td>50 Hz</td>
</tr>
<tr>
<td>Output</td>
<td>50 W</td>
</tr>
</tbody>
</table>

### Sieve performance

The sieve performance depends on powder type, ageing, grain distribution, machine set-up etc.

### Sieves

<table>
<thead>
<tr>
<th>Mesh width</th>
<th>Double sieve</th>
<th>Single sieve</th>
</tr>
</thead>
<tbody>
<tr>
<td>200 µm</td>
<td>x</td>
<td>x</td>
</tr>
<tr>
<td>250 µm</td>
<td>x</td>
<td>x</td>
</tr>
<tr>
<td>265 µm</td>
<td>x</td>
<td>x</td>
</tr>
<tr>
<td>300 µm</td>
<td>x</td>
<td>x</td>
</tr>
<tr>
<td>315 µm</td>
<td>x</td>
<td>x</td>
</tr>
<tr>
<td>400 µm</td>
<td>x</td>
<td>x</td>
</tr>
<tr>
<td>500 µm</td>
<td>x</td>
<td>x</td>
</tr>
<tr>
<td>750 µm</td>
<td>–</td>
<td>x</td>
</tr>
</tbody>
</table>

### Sound pressure level

<table>
<thead>
<tr>
<th>PS07</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Normal operation</td>
<td>&lt; 70 dB(A)</td>
</tr>
</tbody>
</table>

The sound pressure level was measured while the unit was in operation; measurements were taken at the most frequent operator positions and at a height of 1.7 m from the ground.

The specified value is applicable only for this product itself and does not take into account external noise sources or cleaning impulses.

The sound pressure level may vary, depending on the product configuration and space constraints.
Assembly / Connection

Set-up

The powder sieve machine must be installed vertically and secured by screws (vibration transfer) in order to achieve optimum sieving performance. A non-secured sieve machine can vibrate strongly and deliver up to 20% less sieving performance.

Grounding of the sieve machine

During installation, the sieve machine must be grounded in accordance with local safety regulations. All grounding connections must be checked regularly.

Grounding of the sieve insert

The grounding of the sieve insert is done by a grounding spring which is grounded by continuous contact with the sieve cover.

⚠️ WARNING

Incorrect or no grounding

Take care to install the sieve correctly!

fig. 4:

1. Sieve mesh
2. Grounding spring
3. Gasket
4. Clamp ring
Seating of the clamp ring

**ENVIRONMENT**

Powder leak
An incorrectly seated clamping ring may cause damage to the sieve insert seal and powder leaking into the environment.

► Check clamping ring for secure seating!

Installing the double sieve insert

In order to obtain the maximum sieve performance of the powder sieve machine, the double sieve insert must be correctly installed. The fine sieve mesh must show upwards and the rough sieve mesh downwards.

**ATTENTION**

Damage to sieve mesh
The fine-meshed screen may be damaged by careless handling.

► Only hold the sieve insert by the flange!

![fig. 5: Double sieve](image)

1 fine sieve mesh
2 large mesh supporting sieve
3 sieve assistance

Connecting the powder sieve machine

The powder sieve machine is delivered ready-to-use by the manufacturer. Only a few cables and hoses still have to be connected.

Connecting the supply

**Connecting the electrics**

Only locally authorized specialists may install and inspect the electrical elements of the machine.

In the event of customizations, the wiring diagram may differ.

**Connecting the pneumatic system**

The compressed air must be free of oil and water!
Start-up

ATTENTION
Cross-contamination
For technical reasons, the sieve consists of fine-meshed material and is therefore able to capture residual amounts of powder particles
- Always use the sieve corresponding with the processable powder and end product!

Cleaning the interior of the sieve machine
The interior of the sieve machine must be clean before start-up.
1. Clean the interior of the sieve machine. See chapter "Cleaning the interior of" page 24.
   - The interior of the sieve machine is clean.

Start-up inspection

<table>
<thead>
<tr>
<th>No.</th>
<th>Inspection</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>All screw connections are tight.</td>
</tr>
<tr>
<td>2</td>
<td>The interior of the sieve machine is clean.</td>
</tr>
<tr>
<td>3</td>
<td>The operating manual is stored with the machine close to the work station.</td>
</tr>
<tr>
<td>4</td>
<td>The operator has been told that he is responsible for instructing the personnel.</td>
</tr>
<tr>
<td>5</td>
<td>Assembly and installation have been concluded in accordance with the operating manual.</td>
</tr>
<tr>
<td>6</td>
<td>Electrical and mechanical safety equipment is in perfect working order.</td>
</tr>
</tbody>
</table>
Operation

Safety

Product contamination through foreign matter
Foreign matter entering the sieve machine through the open cover may contaminate the powder.
1. Take measures to ensure that foreign matter is unable to enter the sieve machine.

Preparing for production

⚠️ DANGER
Explosive atmosphere.
Death or severe injuries.
► Only use products and materials that are approved for the explosion hazard.
► Stop the machine immediately if you hear unusual noises during operation.

1. Switch on the plant
2. After a prolonged shutdown of the system or before a product change, clean the interior of the sieve machine. See chapter "Cleaning the interior of the sieve machine" page 24.
Operation

ATTENTION
Clattering or hitting noise. A loose vibration motor or worn motor bearing may cause mechanical damage.

► Deactivate the vibration motor immediately!
► Empty the sieve machine and eliminate the cause!

1. Refer to the operating manual of the system control unit.

Ending production

1. Switch off the installation.
2. In the event of impurities, clean the sieve machine.
   – Clean the exterior of the sieve machine.
   – Clean the interior of the sieve machine.
Deecommissioning / Storage

Introduction

Requirements on personnel carrying out the work
All work should be carried out only by authorized technical personnel.

Storage conditions

Hazard notes
There is no danger to personnel or the environment if the unit is stored properly.

Type of storage
For safety reasons, the product should only be stored in a vertical position.

Storage duration
If the physical conditions are maintained, the unit can be stored indefinitely.

Space requirements
The space requirements correspond to the size of the product. There are no special requirements concerning distance to neighboring equipment.

Physical requirements
Storage must be inside a dry building at a temperature between +5 – 50 °C.
Shut-down

Decommissioning
1. Deactivate the system and secure against reactivation.
2. Empty the sieve machine completely.
3. Clean the interior of the sieve machine. See chapter "Cleaning the interior of the sieve machine" page 24.

Maintenance during storage

Maintenance schedule
No maintenance schedule is necessary.

Maintenance works
During long-term storage, periodically perform a visual check.
Maintenance / Repairs

ATTENTION
Any unauthorized modifications and alterations to the product are not permitted for safety reasons and exclude the manufacturer’s liability for any resulting damage!

Regular, careful cleaning and maintenance extends the service life of the product and ensures long-lasting, uniform coating quality!

– The parts to be replaced during maintenance work are available as spare parts. These parts can be found in the corresponding spare parts list!

General information
The product is designed to require a minimum of maintenance.

Safety

Securing against unexpected start-up
The machine starting unexpectedly may cause serious injuries to persons working on the machine.

1. Set the safety switch to <0> and lock it.
2. Remove the key and keep it with you.

Explosion protection
Lack of maintenance and a lack of ignition protection can lead to explosions.

– Do not modify the machine.
– Do not use potentially explosive products, operational material or cleaning liquids.
– Maintain, clean and lubricate the machine correctly.
– Only use original spare parts.
Pressurized pneumatics system

The pressurized pneumatics system may trigger dangerous situations.
1. Disconnect the compressed air supply before working on the pneumatics system.
2. Depressurize the pneumatics system.
3. Secure the compressed air supply against reactivation.

Cleaning

The sieve machine and (optional) accessories must be cleaned daily. Cleaning can be carried out by means of industrial vacuum cleaner and/or clean, soft cloth.

ATTENTION

Machine components may be damaged during the cleaning process.
Observe the operating tools!
► Clean individual parts and, if required, dissolve any sintering on metal parts with cellulose thinners.
► Do not scratch the surfaces!

ATTENTION

Damage to sieve mesh
The fine-meshed sieve may be damaged during cleaning with an overly strong jet of compressed air.
► Do not use compressed air for cleaning!

Cleaning intensity depends on the powder used. For optimal cleaning results, we recommend dismantling the entire sieve machine into its dismantable components.

ATTENTION

Individual parts may be damaged during the cleaning process.
– Please dismantle carefully to avoid damages!
Cleaning the interior of the sieve machine

fig. 6

1. Hose connection
2. Sieve
3. Clamp ring
4. Swivel frame
5. Sieve base
6. Vibrator
7. Sieve cover
8. Connecting hose

1. Switch off the plant on the main control cabinet.
2. Loosen the clamping ring.
3. Remove the sieve cover and clean with an industrial vacuum cleaner.
4. Remove dirt deposits on the sieve with an industrial vacuum cleaner and soft suction brush.
5. Remove the sieve.

ATTENTION

Damage to sieve mesh
The fine-meshed screen may be damaged by careless handling.
► Only hold the sieve insert by the flange!

6. Remove powder residues from the interior of the sieve machine with an industrial vacuum cleaner
7. Use a plastic spatula to remove hard deposits.
8. Clean all metal parts with an industrial vacuum cleaner and/or with a clean, soft cloth.
9. Clean the sieve.
ATTENTION
Damage to sieve mesh
The fine-meshed sieve may be damaged during cleaning with an overly strong jet of compressed air.
► Do not use compressed air for cleaning!
► Never scratch!

10. Reassemble the parts.

ATTENTION
Incorrectly assembled parts may cause malfunctions or defects
► The assembly takes place in reverse order!

Dirt removal
To ensure that the powder is sufficiently clean, you should check the screen for cleanliness and clean if necessary every day before starting work and at shift change.

Daily cleaning of the sieve
1. Switch off the plant on the main control cabinet.
   – The vibration motor and powder feed are only halted for a short time.
2. Loosen the clamping ring.
3. Remove the sieve cover and clean with an industrial vacuum cleaner.
4. Remove dirt deposits on the sieve with an industrial vacuum cleaner
   – Check the sieve for damage
5. In the event of severe soiling, remove the sieve and clean thoroughly with an industrial vacuum cleaner.

Interval

Daily maintenance
– Clean the exterior of the sieve machine with a dry cloth
– Remove dirt from the screen. See chapter "Dirt" page 25.
– Check hose connections.

Repairing the sieve mesh
Small holes can be filled with adhesive (e.g. Araldit).

Let the adhesive harden before to reinsert the sieve!
Wearing parts

Wearing parts replaced during maintenance can be individually purchased (see spare parts list).
Fault clearance

Safety

Securing against unexpected start-up
The machine starting unexpectedly may cause serious injuries to persons working on the machine.
1. Set the safety switch to <0> and lock it.
2. Remove the key and keep it with you.

Explosion protection
Lack of maintenance and a lack of ignition protection can lead to explosions.
- Do not modify the machine.
- Do not use potentially explosive products, operational material or cleaning liquids.
- Maintain, clean and lubricate the machine correctly.
- Only use original spare parts.

Pressurized pneumatics system
The pressurized pneumatics system may trigger dangerous situations.
1. Disconnect the compressed air supply before working on the pneumatics system.
2. Depressurize the pneumatics system.
3. Secure the compressed air supply against reactivation.
Troubleshooting

**PS-Sieve clogged up**

- **Vibrator on?**
  - yes
  - **Check control unit**
    - Correct error
  - no
    - **Reduce powder pump output**

- **Powder development per time unit too large?**
  - Approx. 250 gr/min x number of guns
  - yes
  - **Select the appropriate mesh width**
  - no

- **Mesh width sufficient for powder quantity?**
  - (ca.250 gr/min x number of guns)
  - yes
  - **Sieve performance**
    - 500 my = ..kg
    - 1000 my = ..kg
    - 1500 my = ..kg
  - no

- **Too much dirt?**
  - yes
  - **Screen cleaned daily?**
    - yes
    - **Cabinet environment clean?**
    - no
    - **Eliminate dirt and install a surrounding cabinet, if necessary**
    - **Daily cleaning**
  - no

- **Powder sintering?**
  - yes
  - **High humidity?**
    - yes
    - **Cabinet climate?**
    - no
  - no

- **Grounding OK?**
  - yes
  - **Ensure grounding**
  - no

- **Fluidization in powder container too severe?**
  - yes
  - **Reduce fluid air**
  - no

- **Increase Airmover output, reduce counter flow**

- **Compressed air moist?**
  - yes
  - **Adjust client’s oil and water separator**
  - no

- **Contact powder supplier**
Disposal

Introduction

Requirements on personnel carrying out the work

The disposal of the product is to be carried out by the owner or operator.
When disposing of components that are not manufactured by Gema, the instructions in the respective third-party manufacturer’s documentation must be observed.

Disposal regulations

The product must be disassembled and disposed of properly at the end of its service life.

- When disposing of the product, the applicable local and regional laws, directives and environmental regulations must be complied with!

Materials

The materials must be sorted according to material groups and taken to the appropriate collection points.
Spare parts list

Ordering spare parts

When ordering spare parts for powder coating equipment, please indicate the following specifications:

– Type and serial number of your powder coating equipment
– Order number, quantity and description of each spare part

Example:

– Type OptiGun GA03 automatic powder gun
  Serial number 1234 5678
– Order no. 203 386, 1 piece, Clamp – Ø 18/15 mm

When ordering cable or hose material, the required length must also be given. The spare part numbers of this bulk stock is always marked with an *
.

Wearing parts are always marked with a #.

All dimensions of plastic hoses are specified with the external and internal diameter:

Example:

Ø 8/6 mm, 8 mm outside diameter (o/d) / 6 mm inside diameter (i/d)

ATTENTION

Use of non-original Gema spare parts

When using the spare parts from other manufacturers the explosion protection is no longer guaranteed. If any damage is caused by this use all guarantee claims become invalid!

➤ Only original Gema spare parts should be used!
### PS07 – Spare parts list

<table>
<thead>
<tr>
<th></th>
<th>Description</th>
<th>Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Double sieve – complete</td>
<td></td>
</tr>
<tr>
<td></td>
<td>200 µm</td>
<td>388 785#</td>
</tr>
<tr>
<td></td>
<td>250 µm</td>
<td>388 793#</td>
</tr>
<tr>
<td></td>
<td>265 µm</td>
<td>357 758#</td>
</tr>
<tr>
<td></td>
<td>300 µm</td>
<td>357 740#</td>
</tr>
<tr>
<td></td>
<td>315 µm</td>
<td>388 823#</td>
</tr>
<tr>
<td></td>
<td>400 µm</td>
<td>357 731#</td>
</tr>
<tr>
<td></td>
<td>500 µm</td>
<td>357 723#</td>
</tr>
<tr>
<td></td>
<td>Single sieve – complete (not shown)</td>
<td></td>
</tr>
<tr>
<td></td>
<td>200 µm</td>
<td>355 267#</td>
</tr>
<tr>
<td></td>
<td>250 µm</td>
<td>355 259#</td>
</tr>
<tr>
<td></td>
<td>265 µm</td>
<td>388 807#</td>
</tr>
<tr>
<td></td>
<td>300 µm</td>
<td>388 815#</td>
</tr>
<tr>
<td></td>
<td>315 µm</td>
<td>355 240#</td>
</tr>
<tr>
<td></td>
<td>400 µm</td>
<td>355 232#</td>
</tr>
<tr>
<td></td>
<td>500 µm</td>
<td>355 224#</td>
</tr>
<tr>
<td></td>
<td>750 µm</td>
<td>366 064#</td>
</tr>
<tr>
<td></td>
<td>1.1 Sieve insert for double sieve – 300 µm</td>
<td>388 696#</td>
</tr>
<tr>
<td></td>
<td>Sieve insert for double sieve – 265 µm</td>
<td>388 688#</td>
</tr>
<tr>
<td></td>
<td>Sieve insert for double sieve – 400 µm</td>
<td>388 718#</td>
</tr>
<tr>
<td></td>
<td>Sieve insert for double sieve – 500 µm</td>
<td>388 726#</td>
</tr>
<tr>
<td></td>
<td>1.2 Mesh support for double sieve</td>
<td>388 653#</td>
</tr>
<tr>
<td></td>
<td>1.3 Sieve assistance for double sieve</td>
<td>357 669#</td>
</tr>
<tr>
<td></td>
<td>1.4 Gasket</td>
<td>388 750#</td>
</tr>
<tr>
<td>2</td>
<td>Clamp ring</td>
<td>369 969</td>
</tr>
<tr>
<td>3</td>
<td>Motor cable</td>
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<td>4</td>
<td>Lock washer – M5</td>
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<td>5</td>
<td>Hexagon screw – M5x25 mm</td>
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<td>6</td>
<td>Vibrator motor – HV 0.4/2-230 V</td>
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<td>7</td>
<td>Bolt</td>
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<td>8</td>
<td>Washer – Ø 7/30x2 mm</td>
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<td>9</td>
<td>Rubber damper – Ø 20x25 mm</td>
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<td>10</td>
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<td>11</td>
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<td>GEKA blind coupling (not shown)</td>
<td>1002 405</td>
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<td>12</td>
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<td>Screw – M5x10 mm</td>
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<td>14</td>
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<td>236 675</td>
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<td>A</td>
<td>Connecting hose – L=550 mm, complete</td>
<td>359 602</td>
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<td>211 125</td>
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* Please indicate length  
# Wearing part
PS07 – Spare parts

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