

Customers performance for installation and start - up
of the „Impact Spray System“

>>> Media supply <<<

Electricity

- Power supply to the control cabinet (If applicable: Power supply to the transformer and from the transformer to the control cabinet)

Interface: Screw connection terminals
⇒ Single wire / multiple wire max. 50 mm²
⇒ Fine wire with wire end sleeve max. 35 mm²
⇒ Tightening torque 6 Nm

Supply voltage: 400 V / 480 V / 3 Ph AC
⇒ Clockwise field of rotation

Power : Max. 42 kW

Pre - fuse: Max. 80 A
⇒ No RCD allowed

- If applicable: Power supply to the water cooling unit

Interface: CEE - plug 16 A ; 5 - pole ; 3L + N + PE ; 6h
⇒ If applicable: Alternative plug possible

Supply voltage: 400 V ; 50 Hz / 480 V ; 60 Hz / 3 Ph AC
⇒ Clockwise field of rotation

Power: Max. 8 kW

Pre - fuse: Max. 16 A

- Signal cable for connection of the „Impact Spray System“ to the safety system of the work cell

Interface: Han - Quick Lock connection terminal (HARTING)
⇒ Fine wire without wire end sleeve 18 x 0.5 - 1 mm² + PE

Signal voltage: 24 V / DC

Connection scheme: According to the specification of the Impact Innovations GmbH
⇒ „Impact Spray System“ = Slave

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- If applicable: Signal cable for connection of the remote control - interface of the „Impact Spray System“ to a superordinate PLC (Robot)

Interface: Han - Quick Lock connection terminal (HARTING)
⇒ Fine wire without wire end sleeve 15 x 0.5 - 1 mm² + PE

Signal voltage: 24 V / DC

Connection scheme: According to the specification of the Impact Innovations GmbH
⇒ „Impact Spray System“ = Slave

- If applicable: Data cable for connection of the remote maintenance - interface of the „Impact Spray System“ to the customer - network

Interface: RJ45 - socket

Connection specification: According to the specification of the Impact Innovations GmbH

- If applicable: Data cable for connection of the HDD - data storage of the „Impact Spray System“ to the customer - network

Interface: RJ45 - socket

Connection specification: According to the specification of the Impact Innovations GmbH

Gas

- High pressure - gas - supply to the control cabinet

Interface: Compression fitting Ø 12 mm (Swagelok)

Inlet pressure: Min. 53 bar / Max. 63 bar (5/8 ; 5/11)
Min. 63 bar / Max. 75 bar (6/10)

Flow rate: Up to max. 220 m³/h i. S. (Nitrogen)
Up to max. 270 m³/h i. S. (Helium)

Quality class: Nitrogen 5.0 / ≥ 99.999 %
Helium 4.6 / ≥ 99.996 %

Pressure variations: Max. 0.1 bar/15 sec.

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Compressed air

- Compressed air supply to the control cabinet

<u>Interface:</u>	2x compressed air connector ND 7.2 ⇒ Alternative: Female thread G ½
<u>Inlet pressure:</u>	7 - 10 bar
<u>Flow rate:</u>	Up to max. 1.4 m ³ /min i. S.
<u>Quality class:</u>	DIN ISO 8573 - 1 / class 1

- If applicable: Compressed air supply to the water cooling unit

<u>Interface:</u>	Compressed air connector ND 7.2
<u>Inlet pressure:</u>	5 - 10 bar
<u>Flow rate:</u>	Up to max. 0.5 m ³ /min i. S.
<u>Quality class:</u>	DIN ISO 8573 - 1 / class 1

Coolant

- If applicable: Water coolant for water cooling unit

<u>Medium:</u>	Water (Distilled)
<u>Min. filling capacity:</u>	60 L
<u>Max. filling capacity:</u>	120 L
<u>Recommended filling capacity:</u>	100 - 120 L

>>> General work <<<

- Preparation of a suitable installation area for all components of the „Impact Spray System“
- Wall ducts and covers (Cables and hoses in to the work cell, etc.)
- Installation of control panel
- If applicable: Installation of gas supply panel
- Installation of trays for cables and hoses, etc.
- Preparation of adaptor for the installation of the cold spray gun on a handling unit (e.g. Robot)

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>>> General utilities <<<

- If necessary: Ladder, working platform, lifting tool, etc.
- Power source for tools
- Internet access

>>> During delivery and installation <<<

- Unloading and transportation of the components of the „Impact Spray System“ on site
- Assistants and tools for unloading und unpacking of the components of the „Impact Spray System“
- Waste disposal after installation

>>> Assistants for installation and start - up <<<

- Skilled mechanic
- Skilled electrician