



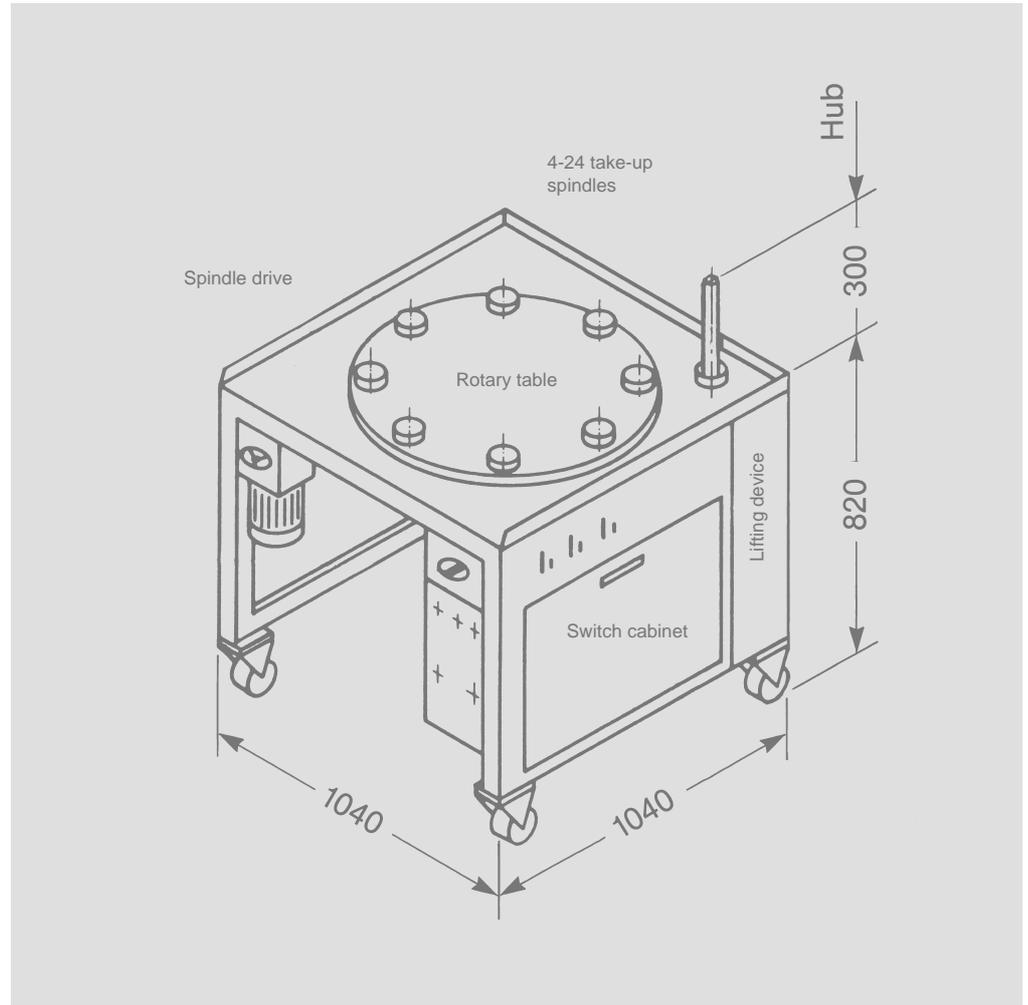
Automatic rotary indexing unit R 700

The Krautzberger R 700 automatic rotary indexing unit is designed for the coating of serial components.

Output is designed for a throughput of 2 – 12 pieces per minute; the size of the workpieces and the skill of the operating personnel determines the actual throughput.

The automatic unit is fitted on castors to ensure flexibility of use. The table-type opening at the front of the unit permits operating from a sitting position. A direction reverser unit is available as an optional extra.

The spray mist can be extracted via a Krautzberger dry exhaust system unit or using a customised solution.



Technical data

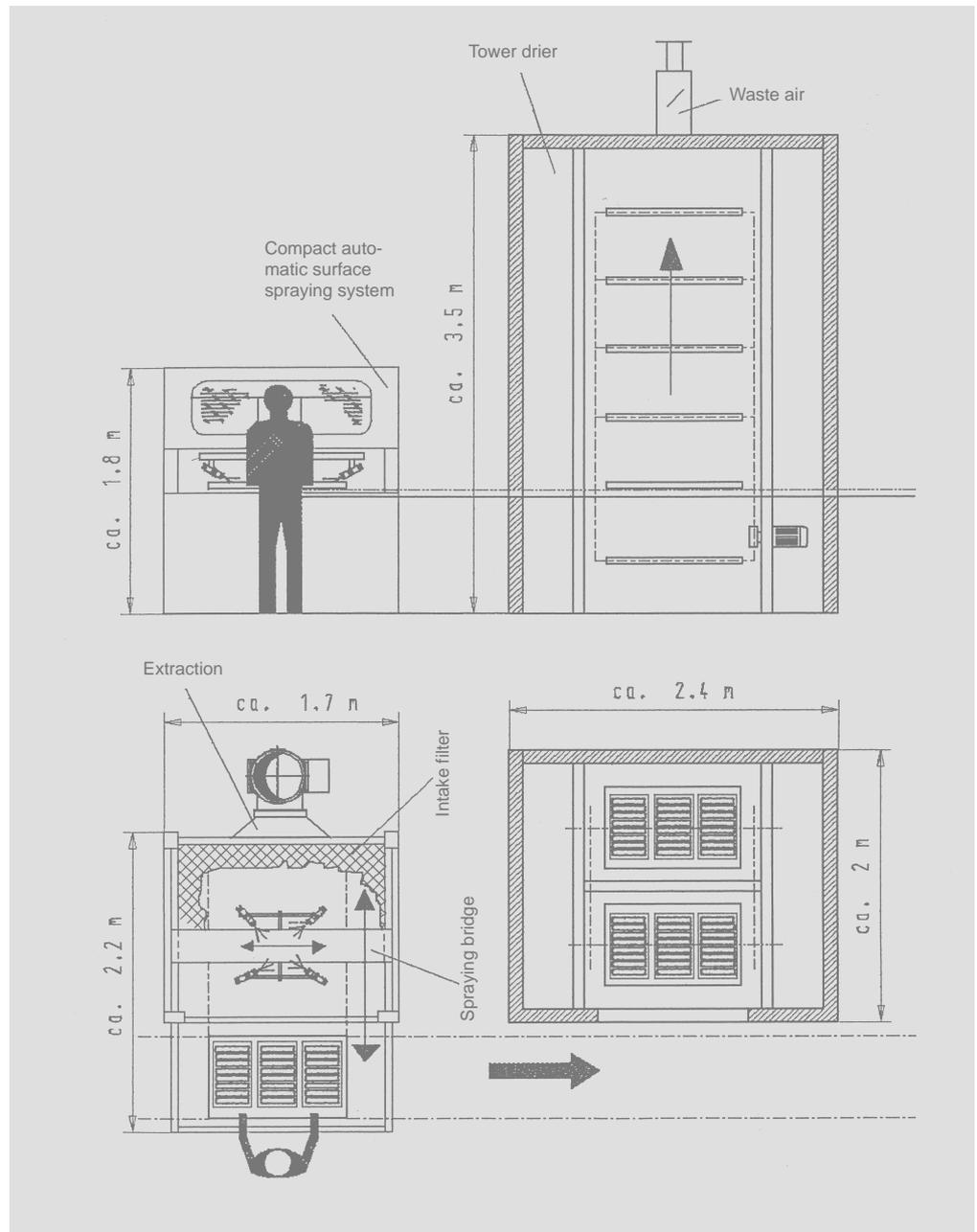
Rotary table drive:	pneumatic rotary indexing table
Output:	2 – 12 cycles per minute
Air consumption at 6 bar:	max. 20 l/cycle (without spray guns)
Working spindle drive:	gear motor 220/380V, 0.09 kW, explosion-proof
Spindle speed:	12.5 – 125 rpm or (optional) 40 – 400 rpm, steplessly variable
No. of spray stations:	as desired
Control:	pneumatic sequence control
Spray time control	
- without lifting device:	max. 4 individually controllable via time relays (0.3-10 secs.)
- with lifting device:	max. 4 3 individually controllable via time relays (0.3-10 secs.), 1 via control bar of lifting device
Air connection:	central connection R 1"
Table standstill time:	adjustable from 0.5 – 10 secs.
No. of spindles:	6 as standard (4, 6, 8, 12, 24 possible)
Table top:	aluminium rotary table, 800 mm dia.
Spindle pitch line:	700 mm
Load per spindle:	max. 1 kg
Spray gun arrangement:	rigid on adjustable tubular frame
Reception thread of spindles:	threaded pin M 12
Lifting device:	hydro-pneumatic, vertical direction, with integrated control bar, stroke 400 mm
Other details:	direction reverser for 2 nd spray station; cycle indexing 6/12 cycles, 3/6 cycles



Compact automatic surface spraying system KFS 1000

This machine is designed for the efficient coating of small parts. In contrast to throughput systems, the KFS 1000 takes up little more space than a manual spray station. It is operated by one person, and the pure feed activity of the operator ensures higher productivity than is possible with conventional manual coating. The control system of the KFS permits easy input of the desired values for spray zone, working speed and switching options for the spray guns. Part-specific inputs can be saved as an overall program and instantly selected for use as a production program.

A feature that drives the unit to individual coordinates is available as an optional extra, combined with a traversing spray gun carrier. Paint mist extraction is effected via a mobile filter trolley in the dry extraction version or using a wet-washing system in the stainless steel version.



Automatic compact surface spraying system with mounted tower drier



Automatic chain-on-edge system

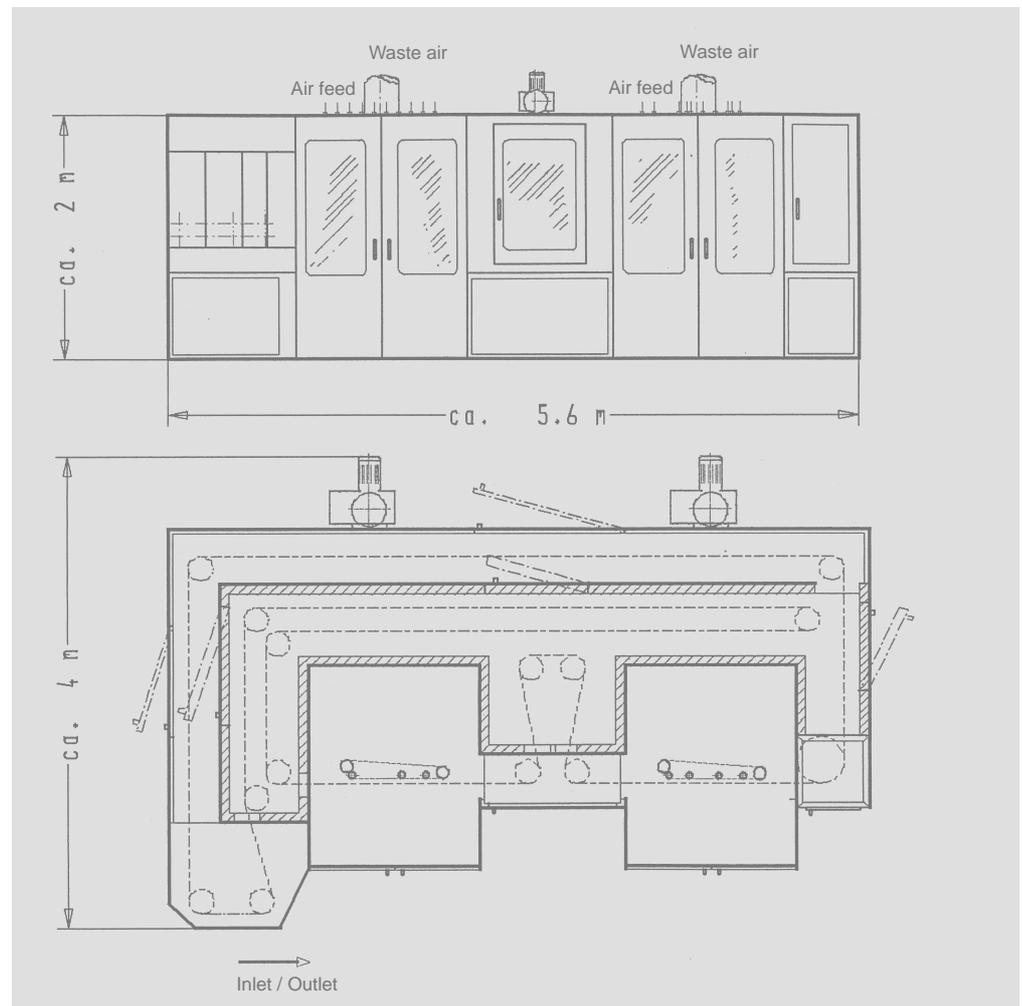
This machine is designed for spray coating of cylindrical workpieces.

The system is integrated in and mounted on sectional steel frames. The chain cover in the operating and coating zone is made of stainless steel. Transport chain drive is via a variable gear unit with an explosion-protected variable-speed gear motor. The cycle speed is adjustable from 2 to 20 cycles per minute, equivalent to a maximum machine output of 1,200 parts per hour.

The transport chain is supported in a guide rail, and a 1 inch roller chain prevents undesired polygon effects. Chain tension is effected automatically by a pneumatic cylinder. Three spindles at the coating point are variable controlled in a range from approx. 40 to 400 rpm via a control gear with explosion-protected three-phase motor. The rotary motion is transferred via air-cushioned pressure rollers. A lifting device to hold the spray guns can be installed at the coating point. The linear lifting stroke also permits vertical spraying motions with one or more guns.

The lifting speed can be separately adjusted for forward and reverse motion. An electronic path recording unit permits customised programming of traversing paths within the range of the stroke.

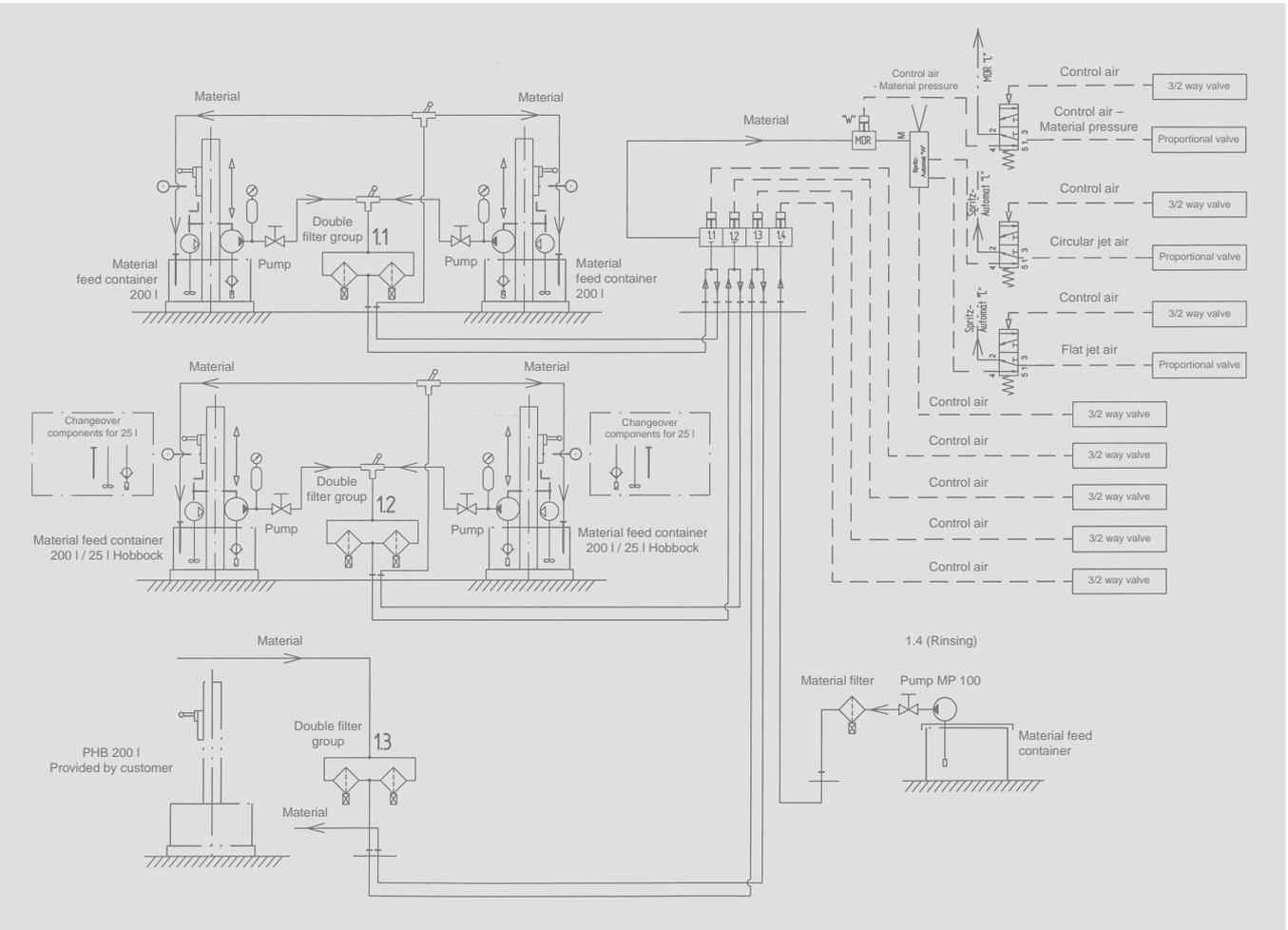
Dry exhaust-extraction is performed using a moveable filter trolley in which labyrinth baffle



filters with downstream fibre glass fine filters are installed. Additional fibre glass fine filters can be fitted in front of the main filter system. The filters are monitored by differential pressure needle pressure gauges with changing point display. There is an encapsulated ventilation zone behind the coating zone. Supply air feed is via an explosion-protected fan.

Two adjustable spraying times and spraying pressures can be set at the spraying point, and up to three spray guns can be connected in each case via rapid-fix couplings.

The spraying time is set via pushbuttons with digital time display. The spray guns connected to the lifting device are controlled in dependence on the lifting motion and the set lifting range. The system can be tailored to suit specific customer needs at any time; there is also a retrofit option for a chain extensions or a mounted drier.



Automatic paint feed system

The paint feed system is designed for the automatic supply of paints to automatic spray guns or hand-operated spraying stations. The system can also be designed for the use of water-based or solvent paints.

Paint changeover can be effected manually or via pneumatic control of the paint changeover valves. During paint changeover, a rinsing process is performed to remove paint residues from pipes, valves and the spray gun.

The paint is stored in 25-litre or 200-litre material feed containers. The system can also be connected to other sizes of container.

The delivery system equipment is mounted on lifting devices to ensure easy changeover of material feed containers.

The paint is conveyed to the draw off points through hoses and pipes. The required delivery pressure is generated by compressed air pumps.

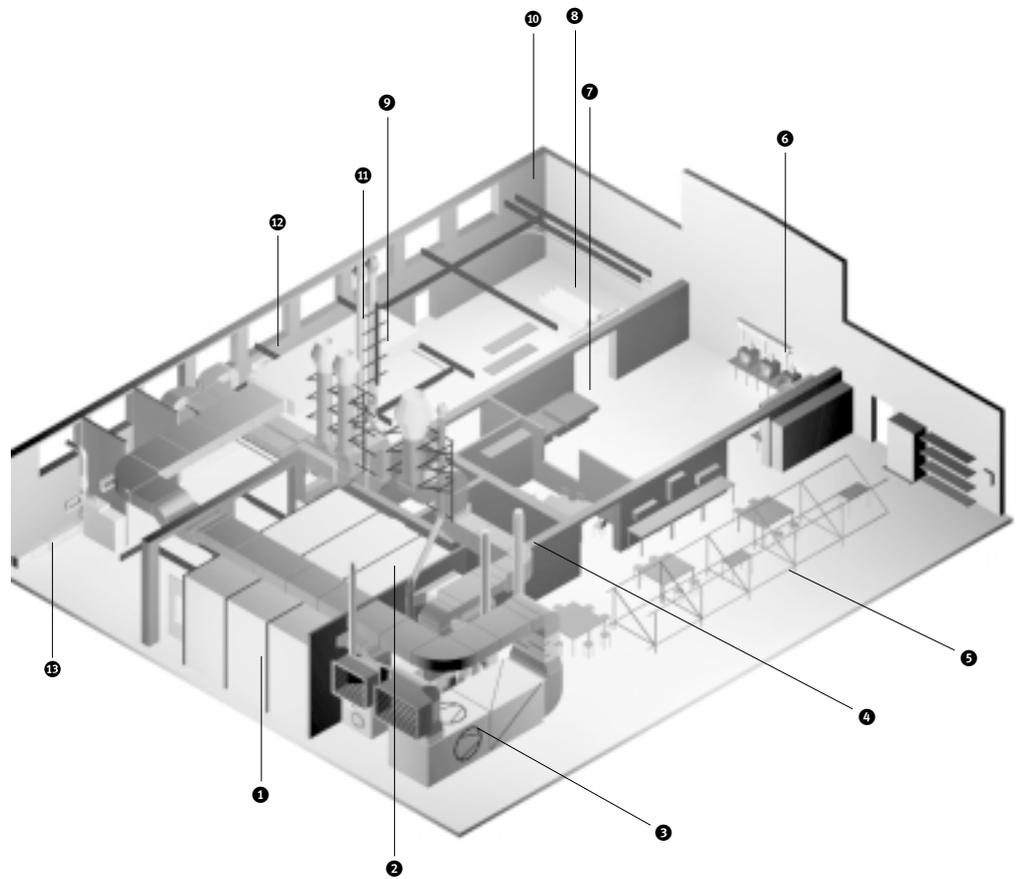
A number of add-on units are available to improve the processing properties of the paints. For example:

- compressed air stirrers can be installed in the material feed containers, and double filter assemblies can be inserted in the material feed lines.
- the material lines can be designed as circulation lines up to the material changeover valves.

- the pumps can be fitted with pressure equalisation containers to balance out pressure surges.

The paint feed systems are operated and controlled exclusively with compressed air. The independent compressed air pump extracts the paint from the material feed container, and the paint is conveyed via the pressure equalisation container and the actuator valve to the double filter assemblies, where it is filtered. The material then travels from the double filter assembly through a flexible hose line into the stainless steel pipe, and from there to the paint changeover valve. The paint changeover valves are pneumatically controlled. Unused paint is routed back to the material feed containers via a circulation line. If the paint changeover valve is open, the

paint flows to the material pressure regulator and from there to the automatic spray gun. The desired material pressure at the automatic spray gun can be variably adjusted on the material pressure regulator. The process is pneumatically controlled.



- ❶ Drying booth in steel cassette design, heating medium optional
- ❷ Coating booth in steel cassette design, heating medium optional
- ❸ Feed air unit for spraying wall and immersion bath
- ❹ VA smoke gas stack
- ❺ Preparation places
- ❻ Airbrush workplaces with exhaust device
- ❼ Sanding tables
- ❽ Immersion bath for priming/impregnation of wooden parts
- ❾ Metal degreasing including exhaust system
- ❿ Hand-operated suspended transport system with steel construction
- ⓫ Feed air filter ceiling
- ⓬ Paint spraying wall, 5 x 2 m
- ⓭ Ventilator for paint preparation stage