Replenishment Paint Feeder System

PRODUCT DATA SHEET

E-coat paint is being continuously removed from the bath as painted ware leaves the tank. The amount of paint removed is closely related to the number of amp-hours delivered by the DC rectifier(s). The Replenishment Paint Feeder System allows for paint to be added only as required. (Your E-coat paint supplier can assist you with calculating how many gallons of replenishment paint are required for each amp-hour delivered.) Because the resulting E-coat film thickness will be more steady, variable costs will be considerably less. Reduced manpower allows for additional savings since replenishment paint is added throughout the day as needed.

Typical view of Amp-hr controller

Typical view of Piston pump for use with 55 gal drum

Preferred Package Includes:

- Accurate air operated wall-mounted piston pump for resin delivered in a tote.
- Accurate pump for paste delivered in a 55 gal drum. Includes a lift/agitator/lid for easy change over of the drums.
- Piston pumps (Recommended) are Ingersoll Rand ARO brand pumps. 4:1 Ratio, 3" air motor, and 2-ball lower end.
- Stainless steel wetted parts.
- Teflon seals
- Amp-hr controller counts strokes and/or controls pumps
- 2" Flange-style static mixer to properly mix the replenishment paint and the bath.

Note: Alternative Package contains Diaphragm Pumps in place of Piston Pumps

Benefits

- Keeps %NV at a very steady level throughout the day's production cycle
- E-coat film thickness levels are more consistent due to the steady %NV
- Less man-power required for operation
- Easy to manually add paint to bath as required

Typical view of PVC Static Mixer

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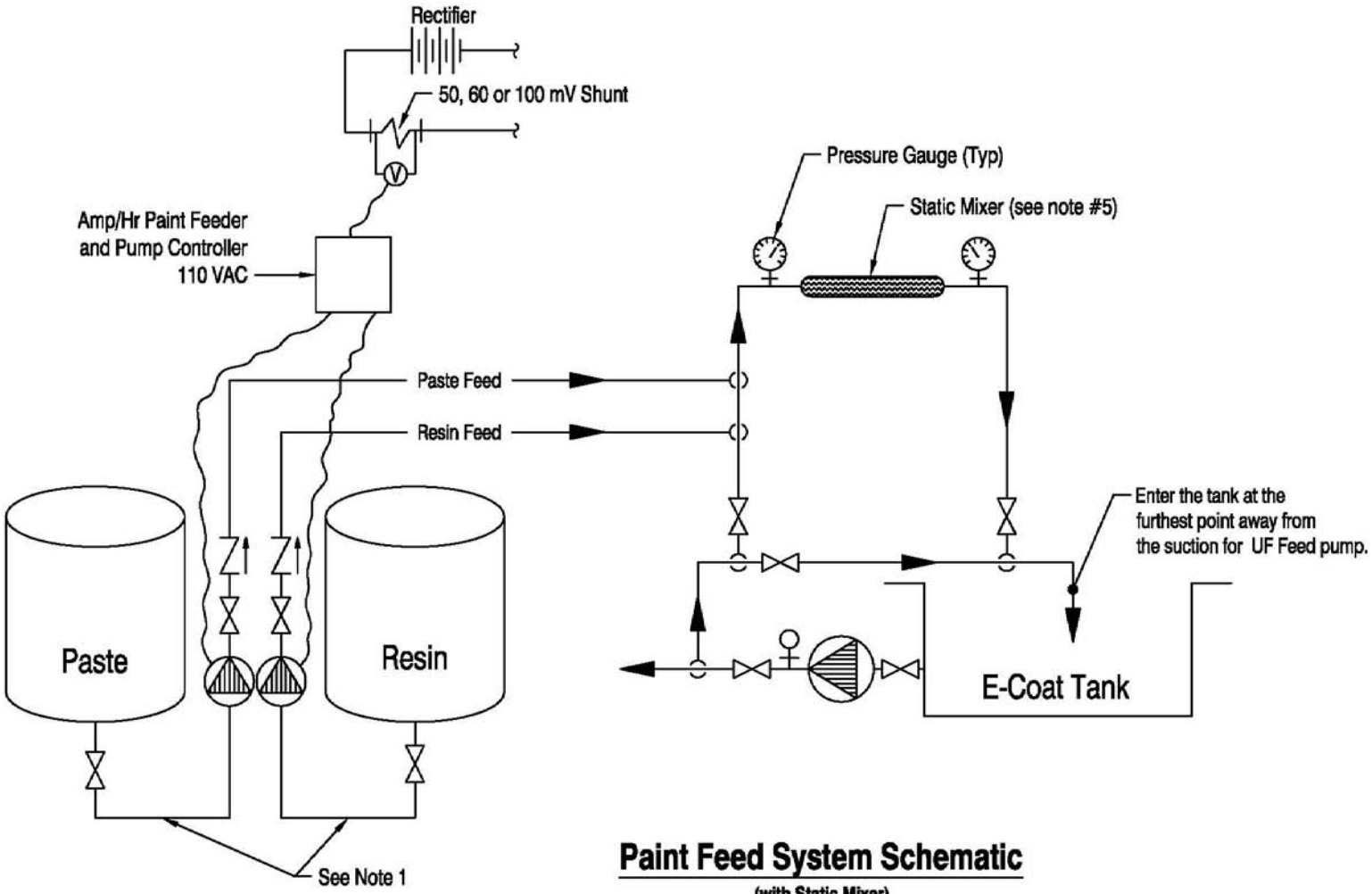
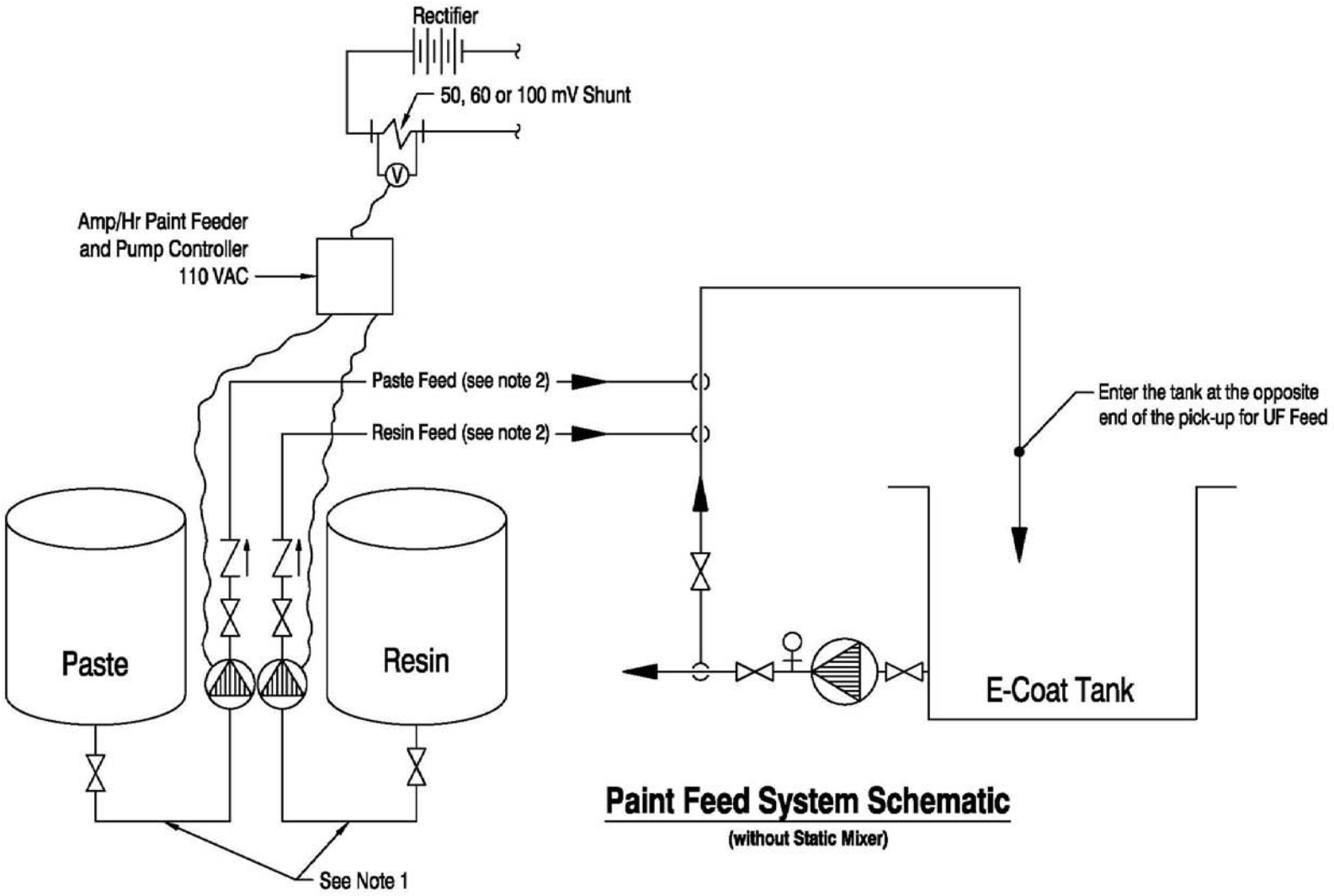


Paint Feed System Schematic

(with Static Mixer)

Notes:

1. **If pulling from the bottom of a tote / paint container, limit pump suction piping to be no more than 36". A 2" or larger suction line is recommended. Only reduce down the pipe at pump inlet if necessary.**
2. **Limit flow through static mixer so pressure drop is ~3.5-4.0 PSI.**
3. **Do not exceed 8-12 ft/sec for paint velocity in any pipe line.**
4. **Total replenishment paint feed flow rate is 1-3 gpm max.**
5. **Actual flow rate will depend on static mixer model.**



Paint Feed System Schematic

(without Static Mixer)

Notes:

1. If pulling from the bottom of a tote / paint container limit pump suction piping to be no more than 36". 2" or larger suction line is recommended. Only reduce down the pipe at pump inlet if necessary.

2. Feed Rate is 1.0 GPM into the middle leg of the tee for every 100 gpm flowing straight through the tee in order to achieve proper mixing.

3. Do not exceed 8-12 ft/sec for paint velocity in any pipe line.