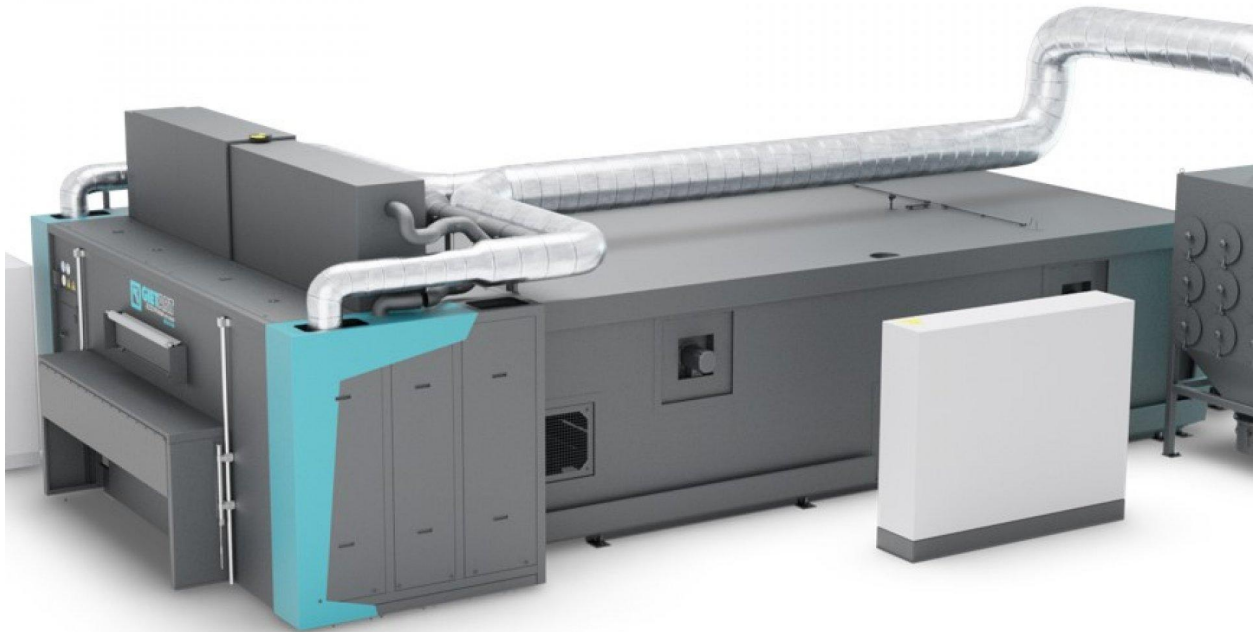


# USM

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**PRE-LOVED GIETART POST-FABRICATION TOP COATING PAINTING SYSTEM**



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## **TECHNICAL DATA TOPCOATING LINE:**

Entrance dimensions : 2600 x 700 mm

Head plates have to be coated manually when loading on conveyor or the semi- automatic painting for head plates has to be used. However here are always areas which can not be reached by the guns at special constructions and have to be prepared manually.

max. part width : 2.500 mm  
max. part height : 600 mm (including possible rack!)

min plate thickness without extra support : 6 mm  
max. transport weight : 800 kg/m  
max. load on 20 m length : 10.000 kg  
min. part length : 3.200 mm  
max. part length : 22.000 mm  
conveyor height : 800 mm

Shorter or thinner parts and e.g. also parts with headplates bigger then 100 mm have to be passed on a rack.

working speed /passage speed range : 0,4–2,0 m/min (depending to paint layer thickness)  
reference working speed : 1,0 m/min at 80 µm d.f.t.  
paint layer thickness : 40-120 m  
paint type : water based paint of first choice quality

**NOTE: If you also want to runs partly with solvent based paint please reconfirm explicitly!**

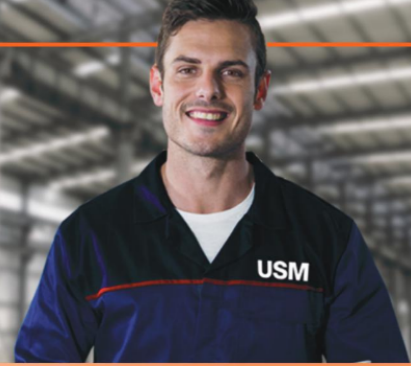
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|                          |                                     |
|--------------------------|-------------------------------------|
| current type :           | 400 V triangle with N and PE, 50 Hz |
| supply current :         | app. 60 kW                          |
| gas type :               | propane or natural gas              |
| supply gas :             | 550 kW                              |
| flow pressure gas :      | 50-100 mbar                         |
| quality compressed air : | 7 bar, clean, dry, free of oil      |
| supply compressed air :  | app. 80 m <sup>3</sup> /h           |

## **1 INLET CHAIN CONVEYOR**

|                       |  |
|-----------------------|--|
| Width :               | 2.500 mm                                     |
| Length :              | 1 x 1.400 mm<br>4 x 2.800 mm<br>1 x 8.200 mm |
| T-profiles distance : | 400 mm                                       |
| T-profiles type :     | T 120  |

## **1 SYNCHRONISED DRIVE SYSTEM FOR CHAIN CONVEYOR**

Consisting of :

- 1 drive 2.6 kW
- 5 drives 1.3 kW
- 1 automatic speed synchronization
- 1 switch in starter panel of machine

The position donator included in the drive and the special drive design allows to synchronise the several chain conveyors without mechanical connections. The position donator included in the drive and the special drive design allows to synchronise the several chain conveyors without mechanical connections. At long chain conveyors above 6m the prolongation of the chain is compensated automatically to avoid scratches from the bottom side.

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## **PREHEATING**

PREHEATER GO 2500-2

|                               |  |
|-------------------------------|--|
| Width :                       | 2.500 mm   |
| Length :                      | 3.600 mm   |
| Temperature difference (T) :  | 5-10 K<br>(Base for the capacity calculation is a material weight of 141 kg/m) |
| Burner :                      | 250 kW   |
| Average consumption :         | 30 – 35 %  |
| Circulating fans :            | 2 x 5,5 kW   |
| Circulating air volume :      | 2 x 8.000 m <sup>3</sup> /h  |
| Circulating air temperature : | max. 250 oC  |
| Heat isolation thickness :    | 120 mm   |
| Control system :              | automatic  |

Heater for indoor operation. Gas connection to the heater to be delivered by customer. The control will be included in the main switch board of the shotblast machine. The complete preheater is manufactured from zinc covered steel plates and cannot be painted.

*Excluding the exhaust ductwork gas connection to heater, installation of the burners by customer.*

## **1 DUCTWORK**

FROM HEATER TO DRYING TUNNEL

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## PAINTING

### 1 AUTOMATIC PAINT SPRAYING MACHINE GVT 2500

with automatic length- height- and width detection for plates and profiles.

Consisting of :

- 4 suction openings in floor level with cascade pre cleaning
- 2 inlet filters integrated in the cabin roof
- 2 trolleys for the spray guns
- 1 frequency inverter controlled drive for the trolleys 2,2 kW, with width adjustment and automatic control of even paint layer
- 4 airless spray guns with paint circulation along the nozzles
- 8 additional airless spray guns with paint circulation along the nozzles for semi
- automatic painting head plates and stiffeners
- 1 high pressure pump WIWA for the paint 32:1 with 500 ccm3/doublestroke in stainless steel
- 1 automatic height adjustment for the upper spray guns to  $\pm 5$  mm
- 1 starter panel with PLC Siemens S7 including pre-cabling
- 1 in feed rubber curtains (manually adjustable)
- 1 out feed rubber curtains (manually adjustable)
- 1 lighting 2 x 40 Watt with paint protection
- 1 revolving control panel with TFT- display in English language for easy operation
- 2 PE foil rollers for easy cleaning of cabin floor
- 1 program switch for double stroke coating at reduced conveyor speed
- 1 special "easy" control switch for applying higher paint thickness with more painting strokes per running meter at lower running speed

**WITHOUT** air pressure connection (compressor), paint, transport rollers, exhaust ductwork and eventual after burning systems.

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## ORDERED OPTIONS

- Top cover in stainless steel for 200 L drum to take off rinsing water
- Pneumatic lifting device for paint stirrer
- Paint heater 3 kW for constant paint temperature, explosion protected
- Automatic anti-freeze system. At temperatures lower than 8° C the paint heated point as well as the paint pump will be activated and will slowly circulate the paint through the paint system to avoid freezing of the paint
- Pre-coat system for extended filter lifetime or water based paint use
- Modem in switchboard for remote diagnostic – ISDN connection by customer

## 2ND PAINTING SYSTEM

- Second paint system complete with paint pump 32:1, 500 ccm and 12 spray guns
- Paint stirrer with top cover, stainless steel, for 200 L-drum
- Pneumatic lifting device for paint stirrer
- Paint heater 3 KW for constant paint temperature, explosion protected
- Automatic anti-freeze system. At temperatures lower than 8° C the paint heated point as well as the paint pump will be activated and will slowly circulate the paint through the paint system to avoid freezing of the paint

## 1 DUCTWORK

FROM PAINTING MACHINE TO THE OUTSIDE :

**customer supply**

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## **DRYING**

### 1 HEATED DRYER GN 2500 LOW ENERGY

in isolated construction, built over the chain conveyor.

|  |                      |
|--|----------------------|
| Length :                               | 25.000 mm            |
| Installed capacity :                   | 2x 50 kW<br>1x100 kW |
| Average consumption :                  | 30 % full load       |
| Temperature range of circulating air : | 20 - 70 C            |
| Number of fans :                       | 8 pcs                |
| Electrical power :                     | 8 x 3 kW             |
| Circulating air volume :               | 72.000 m3/h          |
| Exhaust air volume :                   | 8.000 m3/h           |

Dryer complete with recirculated air ventilators, universal burners, gas control system with regulator for sensitive adjustment, filter, stop valve, electrical regulation and security installations and part of switch panel. Drying tunnel including 1000 mm sideopening with rubber curtains.

### 1 DUCTWORK

FROM FUNNEL TO THE OUTSIDE : **customer supply**

### 1 DRYING CHAIN CONVEYOR

|                       |           |
|-----------------------|-----------|
| Width :               | 2.500 mm  |
| Length :              | 25.800 mm |
| T-profiles distance : | ±400 mm   |
| T-profiles type :     | T 120     |

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## 1 SYNCHRONISED DRIVE SYSTEM

for chain conveyor

Consisting of :

- 2 drives 2.6 kW
- 1 automatic speed synchronisation
- 1 switch in starter panel of machine

The strong double drive is used as “master” for the smaller synchro-drives. The position donator included in the drive and the special drive design allows to synchronize the several chain conveyors without mechanical connections. At long chain conveyors above 6m the prolongation of the chain is compensated automatically to avoid scratches from the bottom side.

## OUTLET TRANSPORT SYSTEM TOPCOATING LINE

### 1 OUTLET CHAIN CONVEYOR

in isolated construction, built over the chain conveyor.

|                       |                              |
|-----------------------|------------------------------|
| Width :               | 2.500 mm                     |
| Length :              | 1 x 1.400 mm<br>4 x 2.800 mm |
| T-profiles distance : | ±400 mm                      |
| T-profiles type :     | T 120                        |

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## 1 SYNCHRONISED DRIVE SYSTEM

for chain conveyor

Consisting of :

- 5 drives 1.3 kW
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