

Making Manufacturers More Competitive™



Horizontal Line Bell Finishing



Do Your Finishing Goals Include?

- 1. Complete System Control***
- 2. Uniform Coverage Top to Bottom***
- 3. Maintain Proper Bell to Part Distance***
- 4. Controlled Atomization***
- 5. Fluid Control - Closed Loop, Gear Pump***
- 6. Color Change Savings***
- 7. Complete Line of Fluid Delivery & Accessories***

HORIZONTAL LINE BELL FINISHING FEATURES & BENEFITS

1. Complete System Control

RECIPE NUMBER 50		SAVE EDITS					
Recipe Number	Recipe Color	Not Assigned	Copy Speed	# Type	Skip Hook	1 inch	
PRIMER BOOTH 1							
Paint Volume	Bell 1	Bell 2	Bell 3	Bell 4	Bell 5	Bell 6	
	28 cc	28 cc	28 cc	48 cc	48 cc	48 cc	
Shaper Air	13 psi	13 psi	13 psi	13 psi	13 psi	13 psi	
High Voltage	78 kv	78 kv	78 kv	78 kv	78 kv	78 kv	
Bells RPM	22 rpm	22 rpm	22 rpm	22 rpm	22 rpm	22 rpm	
Paint Triggering	OFF	OFF	OFF	ON	ON	ON	
Horizontal Lead	8 inches	8 inches	8 inches	8 inches	8 inches	2 inches	
Horizontal Lag	18 inches	18 inches	18 inches	2 inches	8 inches	8 inches	
Vertical Cabot Upstroke	Tip Zone 0	Bot Zone 60		Tip Zone 0	Bot Zone 90		
Vertical Cabot Downstroke	Tip Zone 0	Bot Zone 60		Tip Zone 0	Bot Zone 90		
Recipe Speed	40 FPM	Horizontal Position	8 inches	Recipe Speed	40 FPM	Horizontal Position	8 inches

PART ID

Our PLC control system will accept part ID from any source, ie light curtain. From this ID, a recipe is entered into the system and the following parameters are programmed:

- Color selection
- Flow rate – gear pump flow control per bell
- Shaping air
- Voltage
- Turbine Speed
- Reciprocator Stroke and Speed
- Reciprocator 2nd Axis Stroke and Speed

"Typical recipe interface screen" can be customized

2. Uniform Coverage Top to Bottom

TRIGGERING



Our bells are mounted horizontally and we de-trigger at the top and bottom of the rack. This allows for a uniform finish of the extrusions from top to bottom.

3. Maintain Proper Bell to Part Distance

DUAL AXIS RECIPROCATOR

We use a dual axis reciprocator and a horizontal light curtain to maintain proper bell to part distance. This also allows us to maintain a uniform coating on each rack, top to bottom.



Reciprocator interface screen



4. Controlled Atomization

MAGNETIC BELL CUP

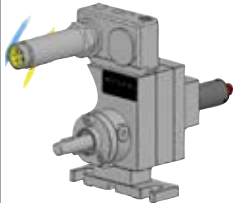


EXEL utilizes a 65EC Magnetic bell cup for optimum transfer efficiency and easy clip off removal.

The unique bell cup design allows for fine finish appearance and enhanced penetration

5. Fluid Control - Closed Loop, Gear Pump

GEAR PUMP



ADLC
Coated-Metallics

Fluid control options from simple regulation to total control with the use of precision gear pumps and PLC control. EXEL normally provides gear pump flow control for each atomizer. The gear pumps will be sized according to the customer's specific flow rate. We also have specific materials of construction for any coating the industry offers.



316 S/S-Waterborne



Steel - Std.
Solvent borne

EXEL provides mechanical installation along with a thorough operator training of the system. This training is a key part of the system that is often overlooked.

EXEL Systems can provide a turnkey system starting in the paint kitchen and ending with the applicator.

Contact EXEL NA and arrange a site visit by EXEL's Aluminum Extrusion Finishing Process Engineer.

Phone: 708-567-5304

www.exel-na.com

6. Color Change Savings

COLOR VALVE ASSEMBLY MOUNT



Our gear pumps and color valve assembly are mounted on the back of the reciprocator to ensure the least amount of wasted material during a color change.

7. Complete Line of Fluid Delivery & Accessories

FLUID DELIVERY

Fluid delivery pumps can also be provided with the system. EXEL can provide long run recirculating systems or short-run color fluid delivery systems. EXEL offers a full line of Paint Kitchen accessories including the ability to supply "Pigable Systems".



04-120
Pump



04-120
Flowmax®



55 gallon
elevator agitator



Recirculation
valve

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