KOINE 3.1

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CE

(I) INTONACATRICE
Manuale uso manutenzione.

(F) PLASTERING MACHINE
Manuel utilisation entretien.

(GB) MORTAR MIXER
Operating,maintenance.

(D) VERPUTZMASCHINE
Handbuch fur Bedienung, Wartung.

(E) ENFOSCADORA
Manual de uso, mantenimiento.

Ricambi/Pieces Rechange/Spare Parts Manual/Ersatzteile/Recambios

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Dear Customer,
compliments on your purchase: this IMER plastering machine, the result of long-standing experience in the field, features maximum reliability and innovative technical solutions.

⚠ ***- WORKING IN SAFETY.***
To ensure complete safety, read all the instructions in this manual carefully.
This OPERATION AND MAINTENANCE manual must be kept by the Site Manager and be always available for consultation.
The manual is considered part of the machine and must be stored for future reference (EN ISO 12100-2) through to scrapping of the machine itself. If the manual is lost or damaged, a replacement copy can be ordered from the manufacturer.
The manual contains the EC declaration of conformity (2006-42/EC) important information on construction site procedures, installation, operation, maintenance and requests for spare parts.
Nevertheless, the user must both have adequate experience and knowledge of the machine prior to use: the user should be trained by a person totally familiar with the operation and use of this machine.
To guarantee complete safety of the operator, safe operation and long life of equipment, follow the instructions in this manual carefully, and observe all safety standards currently in force for the prevention of accidents at work (use of safety footwear and suitable clothing, helmets, gloves, goggles etc.).

⚠ ***- Make sure that all signs are legible.***

⚠ ***- Never make any modifications to the metal structure or plastering machine systems.***
IMER INTERNATIONAL accepts no responsibility in the event of failure to comply with laws governing the use of this type of equipment, with particular reference to: improper use, incorrect power supply, lack of maintenance, unauthorised modifications, failure to comply, either wholly or partially, with the instructions set out in this manual.
IMER INTERNATIONAL reserves the right to modify the characteristics of the plastering machine and/or contents of this manual, without the obligation to update the previous machine and/or manuals.

1. TECHNICAL DATA
Table 1 provides the technical specifications of the plastering machine, with reference to figure 1.

2. NOISE EMISSION LEVEL
Table 1 shows the sound pressure levels of the plastering machine measured at the ear of the operator (L_{pA} at 1 m) and noise emission levels in the environment (power L_{WA}) measured according to EN ISO 3744 (2000/14/CE).

3. OPERATIONAL DESCRIPTION OF THE PLASTER SPRAYER
⚠ ***- The plaster sprayer is intended for use on construction sites, to mix and pump all the premixed mortars declared pumpable with these types of machines by the material manufacturers: gypsum-based plasters, anhydrite-based plasters, lime/cement-based plasters, insulating coatings plasters, fire-retardant plasters, mortar for grouting joints, plasters, coating glues, etc. The machine can also be used to pump wet pre-mixed materials.***

3.1 PLASTERING MACHINE DESCRIPTION (Fig. 1)
The plaster sprayer consists of a frame on wheels (ref.1) which supports a hopper unit (ref.2) complete with motor unit (ref.3), a grid (ref.4) and a material outlet unit (ref.5); a water system (ref.6) complete with self-priming water pump (ref.7); an electrical panel (ref.8); a compressor (ref.9) complete with an air unit (ref.10); a scraper with rod (ref.10) and a mixer inside the hopper.
The premixed material is poured into the hopper.
Inside this is the mixer which is moved by the gearmotor. In the case of dry material, this is mixed together with the water, supplied by the water system unit, which in turn takes it from the water mains or from a suitable container.
The water flow is regulated by means of a micrometric valve and displayed via a flow meter. The mixer drives an eccentric screw pump which pumps the material through a rubber tube to the spraying gun. In addition to the material hose, the spraying gun is also connected to an air hose. The air is supplied by the compressor, with which the spraying gun covers the relevant parts with plaster. In the case of pre-mixed material, this is moved by the mixer and descends into the stator to be pumped into the rubber pipe.

4. OPERATION SAFETY
⚠ ***- Before using the plaster sprayer, ensure it is equipped with all the protective devices.***

⚠ ***- Never insert parts of the body and/or tools in the hopper or mixing chamber during operation.***
In the work area, the rules for the prevention of accidents must be observed as well as the safety provisions.
Care must be taken when handling the bags of material not to raise dust to avoid inhaling it; if this is not possible, a mask must be worn to protect the mouth and nose.

⚠ ***- It must not be used in environments where there is a danger of fire explosions or in areas of underground excavations.***
The plaster sprayer does not have its own lighting and therefore the workplace must be sufficiently lit.
The supply lines must be laid in such a way that they cannot be damaged. Do not place the plaster sprayer on the power supply cable.
The electrical connection must be such as to prevent water from entering the connectors. Use only connectors and attachments equipped with protection against water splashing.
- Do not use inadequate, temporary power lines: if necessary, consult with specialised personnel.
- Repairs to electrical systems must only be carried out by specialised personnel. Disconnect the machine from the power supply before carrying out maintenance or repair operations.
-Prevent the electrical conductors from coming into contact with mobile and/or moving parts of the machine, thus becoming damaged and energising metal parts.

⚠ ***-Any maintenance work on the machine or to its accessories must be carried out by a specialized technician unless otherwise specified in this manual.***

5. ELECTRICAL SAFETY
The Koine 3.1 plaster sprayer is produced according to the EN 60204-1 standard, is protected against splashing water and is equipped with protection against overloads and power failure.

6. MECHANICAL SAFETY
In the IMER plaster sprayer the dangerous points are protected by suitable protection devices, which must be kept in perfect condition and always be fitted, such as the protection of the cooling fan of the electric motors and the hopper grid that prevents contact with the mixer.
In particular, opening of the motor support flange or removal of the hopper grid result in stopping of the rotating parts of the machine, thanks to the presence of a suitable safety microswitch.

7. TRANSPORT

⚠ ***- Attention! Before moving the plaster sprayer, always disconnect the power plug.***

Before moving the plaster sprayer, it is advisable to disconnect the water supply pipe and the material delivery pipe.
It is also advisable to move the machine with the hopper empty.
Move the mixer using the dedicated handles (as in figure 2).

FIG. 2

⚠ ***- Attention! Before lifting the plaster sprayer, always disassemble the compressor and transport it separately.***

⚠ ***- Attention! Before lifting the plaster sprayer, always check that all the machine components are correctly locked and secured.*** To lift the machine, use the two rings provided for this purpose, located on the frame near the upper attachment of the hopper (as in figure 3).

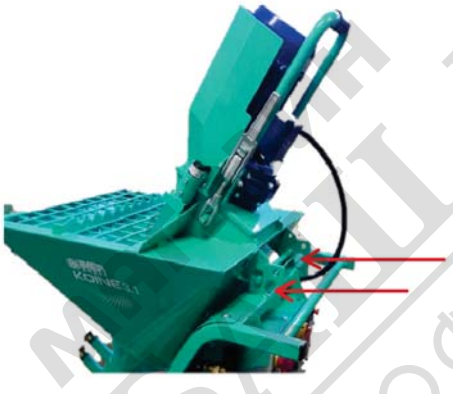


FIG. 3

⚠ ***- Attention! Lifting must be performed carefully and slowly because the machine can swing easily.***

⚠ ***- Attention! To lift the machine, never use any attachment points other than those indicated in figure 3.***

Use lifting devices suitable for the total weight of the machine indicated in tab.1.

Use lifting equipment suited to the overall weight of the machine indicated in table 1.
To facilitate transportation, the machine can be divided into a frame/electrical panel, motor unit, hopper unit and compressor.

⚠ - To reassemble the machine, always open it out horizontally and install the hopper, centring it on the upper pin and locking it with the two lower lever clamps. At this point, raise it to the vertical (working) position and assemble the gearmotor unit; lastly, house the compressor in its seat.

8. INSTALLATION

Position the plaster sprayer on the work surface, in an environment where it does not create an obstacle during use or for cleaning at the end of the work and in such a way as to use as few pipes as possible.
Make sure that the machine is stable and rests correctly on both front supports.

9. CONNECTIONS

9.1 ELECTRICAL CONNECTION

⚠ ***- Check that the power supply voltage, the mains frequency and the electrical connection (socket, fuses, cable) comply with the data shown in tab.1.***

The power supply line must be provided with protection against overcurrents (e.g. with fuses or with a magnetothermic switch) and current leakage to ground (e.g. with a differential type switch). The sizing of the conductors of the power supply cable must take into account the operating currents and the length of the line to avoid excessive voltage drops.
Avoid using coiled extensions on the drums. The power supply conductor must be of the type suitable for frequent movements and the coating must be abrasion-resistant (for example of the type H07RN-F).
Before connecting the plaster sprayer electrically, check that all the safety devices are in place and in a good condition, and in particular the hopper grid is present and equipped with its own safety sensor, that the extension is in a good condition and that the plugs and sockets are not wet.
Connect the power supply to the plaster sprayer plug located on the electrical panel. The blue light will come on indicating the presence of a line (ref.2). In case the blue light is off or emits only a glow, it means that the voltage is higher than 250V.
For the machine in the version with piston compressor, also connect the compressor plug to an independent line socket that has the same characteristics as the one described above for the plaster sprayer and suitable for the absorption shown in tab.1.

9.2 WATER CONNECTION

Connect the water pipe (tab.1) from the pump inlet (see image below) to the water mains. The water mains must guarantee a minimum flow rate of at least 15l/min.
Otherwise it is necessary to prepare a tank of adequate capacity (at least 200 l) of clean water, which must be kept constantly full, from which the self-priming pump supplied with the machine will draw from. In this case the pipe to be used must have a minimum diameter of 3/4", a maximum length of 3m, preferably a base filter and must not deform during use. Check that the water pressure does not fall below 2.5 bar while the machine works with a flow rate of 900 l/h. Turn the main switch to 1, the green light on the panel comes on (ref.8).

⚠ ***- Attention! The first time the water pump is connected to the tank, it must be primed, manually filling the suction pipe. The same operation must be repeated every time the water system is emptied and after a prolonged period of inactivity.***

9.3 AIR CONNECTION

Connect the air hose to the machine panel and spray jet as shown in the figure below.
Open the spray jet air valve.

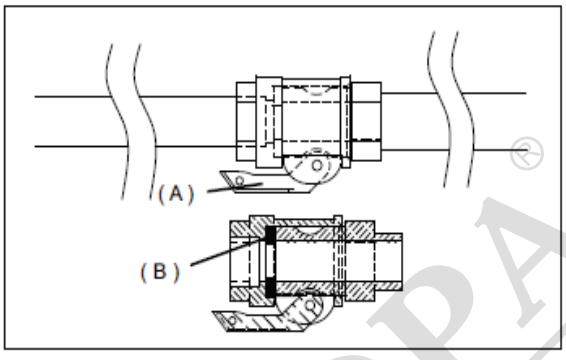
On the air system there are two pressure switches with different calibrations to optimise the operation of the machine in various applications; with piston compressor and in general when using with a gun for smoothing products (higher pressures), keep the valve turned downwards, when using a membrane compressor and traditional plaster gun , keep the valve turned upwards; in any case evaluate the optimum setting for the specific application (see image below).

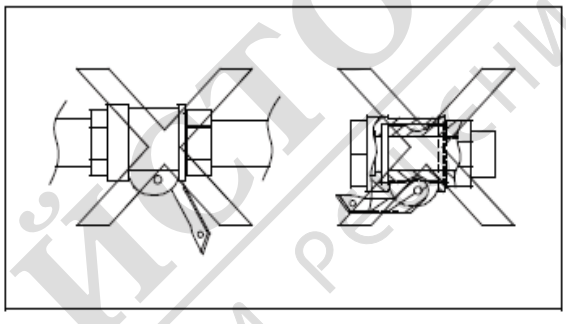
UP: LAUNCH PLASTER

DOWN: LAUNCH FOR SMOOTHING

9.4 CORRECT CONNECTIONS FOR MATERIAL LINES

Take the material hoses and check that they are in perfect condition, that the couplings are intact and all relative seals are present. Check that the cam levers (A) of the couplings have been tightened correctly and that the seal (B) is fitted as shown in the figure below.





10. START-UP

10.1 STARTING WITH DRY MATERIALS (DRY)

⚠ - The use with dry premixed materials MUST ONLY BE PERFORMED with the water pump selector in position 1.
Before starting the machine, check that the air valve on the gun is open (ref.11).
Act on the main switch (ref.1) of the electrical panel and position it on 1, the compressor starts up. Using the two buttons (ref.3), select mode no. 4 which can be viewed on the display (ref.4).
Remove the water level plug (ref.12), positioned laterally on the lower part of the hopper unit and make sure that the hole from which the plug was removed is completely free from any obstructions. In case of clogging, clean using the long part of the water level plug.
Lubricate the pipe by connecting the material pipe to the side outlet located above the water pump using the dedicated adapter, open the valve and fill it completely, then connect the pipe again to the work position.
Press the additional water button (ref.9) and check that the water comes out of the hole where it starts the water level plug. Use the micrometric valve (ref.13) to set the water flow rate, displayed by the flow meter (ref.14) respectively
- at 280 l/min cement-based products
- at 550 l/min gypsum-based products

Place the water level plug back into the hole, closing it correctly.
Load the hopper with premixed material contained in the bags.
Position the start selector (ref.5) in the running position by turning it to the right, the machine starts.
Wait for material to come out of the gun, while continuing to load the material hopper.
At this point, it is possible to perfect the mixture that comes out of the nozzle, correcting the quantity of water.
Act on the micrometric valve, lowering or increasing the water flow by 20l at a time, thus obtaining the desired consistency.
After each adjustment, wait for the product to be completely renewed in the piping (approximately 15 l of material should come out).
When the material of the desired consistency begins to come out of the gun, it is possible to start operating normally.
By opening and closing the air to the spraying gun, the machine starts and stops.

10.2 STARTING WITH WET MATERIALS (WET)

⚠ - Use with wet premixed materials must be performed by positioning the water pump selector on 2.
Before starting the machine, check that the air valve on the gun is open (ref.11).
Act on the main switch (ref.1) of the electrical panel and position it on 1, the compressor starts up. Using the two buttons (ref.3), display the frequency 50 hz (ref.4) on the display.
Lubricate the pipes by adding approximately 8 l of water or 8 l of grout to the hopper, start the machine for a few seconds to let the liquid flow into the pipes (selector ref.5)
Load the hopper with the appropriate pre-mixed material of the correct consistency. Place the start selector (ref.5) back in the running position by turning it to the right, the machine starts.
Wait for material to come out of the gun, while continuing to load the material hopper.
By opening and closing the air to the spraying gun, the machine starts and stops.
The machine is equipped with protection against the absence or excess of voltage (see paragraph Errors, page 8): in the event that this situation occurs, the protections will intervene, disconnecting the primary power supply and it will be necessary to reset the system in order to restart, using the selector (ref.5).
If the water pressure drops below 2.5 bar (see table Causes and Solutions, page 10), the machine stops, at the same time the green light (ref.8) lights up and the message H2O appears on the display. The machine will restart when the pressure returns above 2.5 bar
In case of emergency, to stop the machine, press the red emergency button (ref.10) - all moving parts stop - and then turn the main switch to position 0 and disconnect the power supply.

⚠ **The water pump selector (ref.7 figure below) can be positioned on 2 exclusively for use with wet or pre-mixed materials; this configuration deactivates the water supply and therefore use with dry materials compromises the functioning of the plaster sprayer and can cause damage to the components.**

ELECTRIC MOTOR PROTECTION:

⚠ ***- The water pump and compressor are protected by the inverter and by the thermal cut-out switch integrated inside the power pressure switches. The pump/mixer motor is monitored and protected at various safety levels and reports any operating anomaly on the display with alphanumeric error codes. The intervention of the protections acts by cutting off the primary supply, eliminating any risk.***

ERROR CODES AND WARNING SIGNALS:

⚠ ***- The error codes and the signals that appear on the control panel display occur in very specific situations, for example:***
- **ERR00**: Grid open, mushroom button pressed, system fault
- **ERR01**: High temperature of the electronic board
etc.
Refer to the Causes and Solutions table on page 10 for the complete list of reportable errors.

11. METHOD OF USE

⚠ ***- The safety grid of the hopper must always be present and correctly positioned.***
It is forbidden to introduce anything other than premixed mortars, premixed substances and cementitious products in general into the hopper.

⚠ ***- Removing the grid from the hopper causes the moving parts of the machine to stop.***
It is necessary to reposition the protection grid and perform a system reset by moving the start/stop/inversion switch (ref.5) to the inversion position (left) for 1 second and then restart the mixer motor returning it to the right.

⚠ ***- If this occurs, the grid must be refitted and the main switch must be reset to O to enable machine restart .***

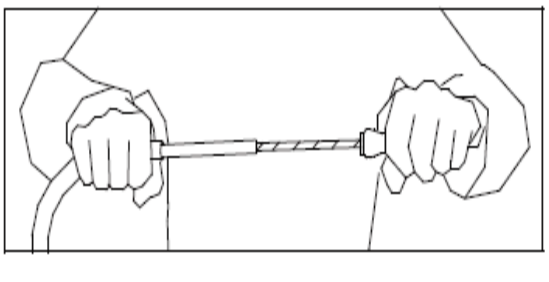
⚠ ***- Wear the personal protection equipment provided before starting to operate.***

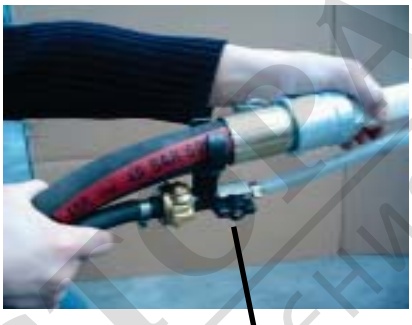
There are deflectors of various diameters (10,12,14,16,18 mm): the small diameter deflectors allow better pulverisation while the larger diameter ones are more suitable for materials with greater granulometry.
For the plaster materials normally used, the deflector with a 14mm hole is recommended.
However it is important to adjust the distance of the nozzle from the outlet so that it is equal to the diameter of the deflector.
In case of insufficient water in the "DRY" work mode, the machine stops.
Before restarting the machine, identify the cause of the problem: closed valve, bent inlet hose, empty tank, clogged filter.
Interruptions longer than 20min should be avoided.
A prolonged stop can cause a blockage in the material delivery pipes: in this case no material comes out of the gun and the pressure gauge indicates a pressure higher than the normal working pressure.
Stop the machine by acting on the start/stop/inversion selector (ref.5), then remove the spraying gun.
Identify the point of the pipes where the blockage occurred and remove it by tapping the pipe itself with a mallet.

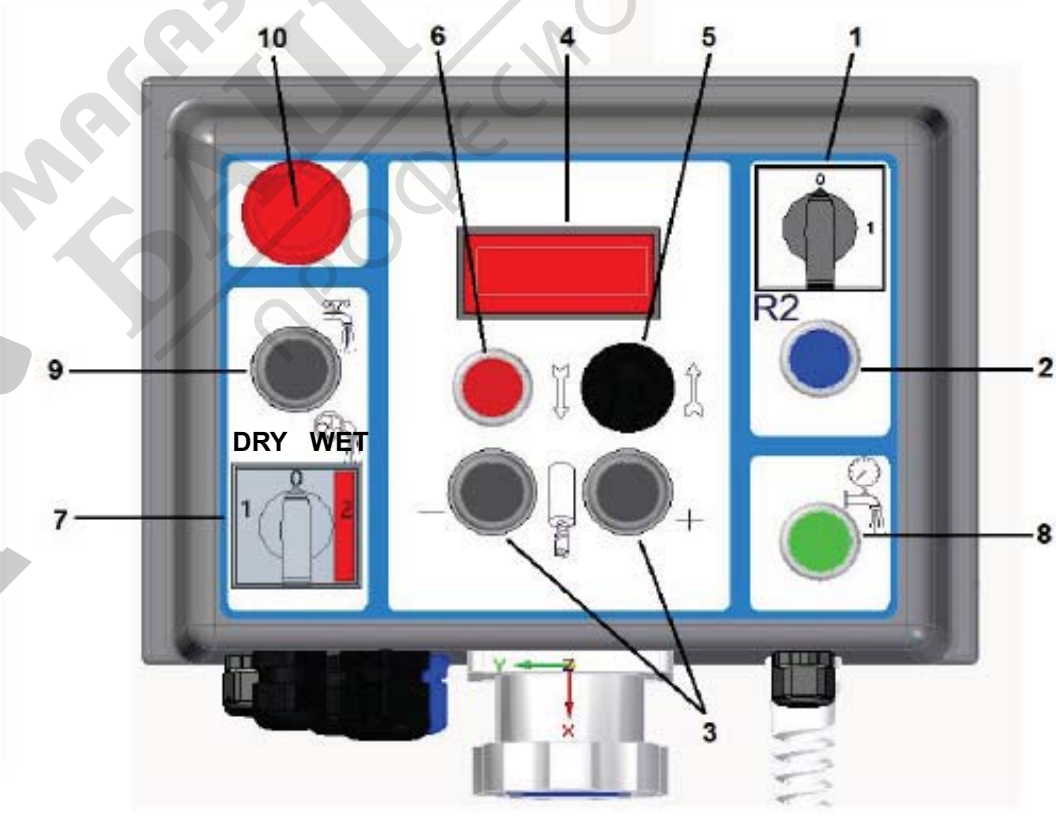
⚠ ***- If it is necessary to disconnect the gun or open the pipe fittings, first make sure that there is no residual pressure inside the pipes.***
The material pressure gauge must indicate 0 bar and the pipes, with the possible exclusion of the part of the pipe where the obstruction is located, must be soft.
The operator carrying out this operation must have received specific training on how to proceed.
If there is even the slightest suspicion that residual pressure may be present, never open the fittings.
Reconnect the pipes and spraying gun, put the main switch in the correct position (the blue light comes on) and restart the machine.

⚠ ***- Avoid moving the machine with the hopper full.***
The leakage of alternately hard and soft material can be an indication of a worn pump. To replace the pump, proceed as follows: detach the handle and open the mixer motor unit by turning it. Insert the appropriate socket wrench on the end of the mixer and start loosening until the screw is removed from the inside of the stator. Remove the delivery manifold and replace the stator with a new one that is well lubricated. Refit the material delivery manifold and insert the new lubricated screw from the side of the hopper. Tighten the screw using the mixer and the dedicated socket wrench previously used for disassembly. Close the gearmotor.
To insert the screw inside the stator, use a neutral lubricating spray (silicone or Vaseline). Never use products deriving from petroleum which could irreparably damage the stator rubber.
In the event of a power failure during work, promptly wash the machine and the pipes. Also disassemble the pumping unit, separate the screw from the stator and wash everything thoroughly with water.

12. CLEANING AND STOPPING THE MACHINE
12.1 DRY MODE
At the end of the work, continue pumping until the hopper and material line are empty and very liquid material is perceived coming out of the gun.
Open the gun valve, disconnect the gun itself and wash it thoroughly, cleaning the nozzle with the dedicated tool supplied (as shown below).







- Before disconnecting the gun or the pipes, make sure that there is no residual pressure inside them.

Disconnect the material delivery pipes from the delivery manifold.
Open the closing lever of the mixer gearmotor unit and open the mixing chamber of the hopper unit.
Remove the mixer and wash it. Clean the mixing area with a spatula. Insert the scraper, attaching it to the connection with the mixer gearmotor. Start the machine as in the pumping operations and wait for the scraper to descend completely into the mixing chamber, simultaneously turning.
Stop the machine and remove the scraper; reassemble the clean mixer.
Then proceed with washing of the pipes.
Insert a washing sponge and use the dedicated adapter to connect the material hose to the auxiliary valve of the water pump located above the pump itself. Start the water pump and open the auxiliary valve until the washing sponge comes out on the other side.
Repeat the operation until it is certain that the pipe is perfectly clean and clear water without impurities comes out.
At this point, once the machine has been cleaned, turn off the main switch, disconnect the power plug, close the water supply, open the auxiliary valve and disconnect the water supply pipe.
If there is even the slightest possibility of freezing, open the three valves, located in the hydraulic system, and let the water in the system completely drain out.
Then remember to close the valves again when restarting the machine.

12.2 WET MODE

Continue pumping the pre-mixed material until the lower part of the mixer begins to be visible. Leaving the machine running, pour water into the hopper until the product that exits the spraying gun is very liquid.
Stop the machine, disconnect the pipes and wash the inside of the hopper. Open the hopper by lifting the mixer gearmotor. Remove the mixer and insert the scraper. Close the mixing chamber, fill with water and start the machine for approximately 30/40 seconds.
Open the mixing chamber and remove the scraper, reassembling the properly cleaned mixer. Cleaning the pipe: insert a washing sponge inside the pipe and connect it to the delivery manifold, then fill the hopper with water and start the machine until the washing sponge has come out from the opposite end. Make sure that the water that comes out of the pipe is clear, otherwise repeat the pipe cleaning operation.

13. MAINTENANCE

- Maintenance must be performed by adequately trained personnel, after switching off the machine, disconnecting it from the power supply and emptying the hopper.

Check daily that the water filter is clean.
Check weekly that the compressor air filter is clean. If deteriorated, replace.
Check weekly that the mixer is in good condition and replace if necessary.
Check weekly that the motor connection is in good condition and replace if necessary.
Check weekly that the electric motors are free of dust and dirt and if necessary clean using compressed air.
Check weekly that the plug and socket contacts are clean, dry and rust free.
Every six months arrange for an inspection of the machine by an authorised IMER service centre.

- Spent oil is a special waste. Therefore it must be disposed of according to current legislation.

- Always keep notices and symbols on the machine legible

14. REPAIRS

- Never start up the plastering machine during repairs.

Repairs to the electrical installation must be performed exclusively by specialised personnel.
Use exclusively original IMER spare parts; modifications to parts are strictly prohibited.

- If any guards are removed for repairs, ensure they are refitted correctly at the end of work.

15.SILICA DUST WARNING

Grinding/cutting/drilling of masonry, concrete, metal and other materials with silica in their composition my give off dut or mists cintainig crystalline silica. Silica is a basic component of sand, quartz, brick clay, granite and numerous other minerals and rocks. Repeated and/or substantial inhalation of airborne crystalline silica can cause serious or fatal respiratory diseases, including silicosis. In addition, California and some other authorities have listed respirable crystallinesilica as a substance known to cause cancer. Whwn cutting such materials, always follow respiratory precautions.
Use appropriate NIOSH-approved respiratory protection where dust hazard may occur. Paper masks or surgical masks without a NIOSH approval number are not recommended because they do little to protect the worker. For more information about respirator programs, including what respirators have received NIOSH approval as safe and effective, please visit the NIOSH website at:
http://www.cdc.gov/niosh/topics/respirators

Observe OSHA regulations for respirator use (29 C:F.R. § 1910.134).
Visit http://www.osha.gov for more information.

California proposition 65 message

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contain chemicals know (to the State of California) to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

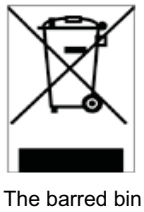
-Lead, from lead-based paints
-Crystalline silica, from bricks and cement and other masonry products
-Arsenic and chromium, from chemically treated lumber

For further information , consult the following sources:
http://www.osha.gov/dsg/topics/silicacrystalline/index.html
http://www.cdc.gov/niosh/docs/96-112/
http://oehha.ca.gov/prop65/law/P65law72003.html
http://www.dir.ca.gov/Title8/sub4.html
http://www.P65warnings.ca.gov

Your risk from these exposures varies depending on how often you do this typer of work. To reduce your exposure to these chemicals, work in a well-ventilated area, and work with approved safety equipment, such as dust masks that are specially designed to filter out microscopic particles. Where use of a dust extraction device is possible, it should be used. To achieve a high level oof dust collection, use an industrial HEPA vacuum cleaner. Observe OSHA 29 CFR part 1926.57 and 1926.103.

17.SCRAPPING

The machine must be disposed of according to the current regulations.



The barred bin symbol indicates that at the end of its service life the product must be scrapped separately from other materials.

The manufacturer is responsible for separate scrapping of the equipment at the end of its service life. The user must therefore contact the manufacturer and follow the instructions given by the latter for separate scrapping of the equipment at the end of its service life.
Separate scrapping for subsequent recycling, treatment and eco-compatible disposal contributes to avoiding negative effects for the environment and for the health of persons, and promotes the reuse/recycling of the materials of which the equipment is fabricated.
Incorrect/illegal scrapping is punishable by law.

PROBLEMS	*CAUSES*	*REMEDIES*
Machine does not start	**Water** Water pressure too low: the gauge shows pressure below 2 bar (green lamp on?), the display shows the text H_2O	- Check that water is delivered from the supply hose - Check that the water filter is clean - Check that the water pump is switched on - If the pump collects from a tank, check that it has been primed and there are no leaks from couplings
Machine does not start	**Material** **-** Product too dry in mixing chamber (mortar pump seized? red lamp on?)	- Initial start-up not performed correctly (see para.11) - Water flow rate setting too low (see para.11) - No water delivered to mixing chamber (water inlet obstructed, water solenoid valve malfunction)
Machine does not start	**Grid** -Grid not inserted completely, the display shows the text Bloc	-Check that the grid is positioned correctly
Machine does not start	**Air** **-** The air pressure, with jet valve completely open, does not fall below the minimum pressure value on the machine pressure switch (table 1)	- Check that the air hose is not bent or obstructe-do - Check that the jet nozzle is perfectly clean
Machine does not start and compressor does not start and the blue light is OFF	**Electrical current** **-** No current delivered to connector of site panel (fuses?) - No power delivered to machine (defective connector connection? loose cable?) - Main switch not ON	- Check points listed alongside
Machine does not start but compressor starts	**Electrical current** - Start selector switch not in correct position - Mixing chamber open (start/stop pushbutton lamp on?) - Mortar pump motor connector not inserted (start/stop pushbutton lamp on?) - Low water pressure switch trips on start-up (water pump switched on *?see also "machine does not start due to water)*	- Check points listed alongside
Machine does not stop and/or compressor does not stop	**Air** **-** Air hose defective (hose cut? Air leaks from couplings? - Compressor air supply low - Jet air valve faulty (blocked in open position)	- Check the air hose and couplings in particular and replace if necessary - Check air filter (see para. 12) - Check compressor relief valve
Machine stops after starting up	**Water** **-** Intake filter clogged - Pressure reducer filter clogged **-** Water hose too long and/or too narrow - Water supply insufficient	- Check points listed alongside: clean filters, check for adequate flow rate from the water hose (at least 10-12 l/min if working with lime-cement based plaster, at least 15-20 l/min with gypsum based plasters) and replace hose if necessary or collect water from an auxiliary tank

PROBLEMS	CAUSES	REMEDIES
The machine stops during operation **The following texts appe-ar on display**	**- ERR00 :** Hopper grille open or incorrectly located. - Connection plug not inserted - Emergency button pressed - System malfunction.	- Ensure the grille is properly located - Insert connection plug - Reset the emergency button - Contact Assistance Service
	- ERR01 : High circuit board temperature (Inverter).	- Wait for it cool down.
	- ERR02 : High screw pump motor temperature. - The motor has been subjected to overloading for a long time.	- Wait for it cool down, then restart.
	- ERR03 : Too much power required from screw pump motor (motor jammed).	- Check the mixture - Resize the lenght of the piping
	- ERR04 : Screw pump motor overload warning.	- Check the mixture - Decrease the speed of the screw pump motor -Ensure that the power voltage is >205V
	- ERR05 : The compressor turns on and off too frequently (<5 start/min) - High leakage from the piping -The water pump and compressor has been turn on but not used for more than 15 minutes	-Replace the gaskets -Reset the machine
	- ERR06 : -Supply voltage higher than 256V	- Check the connection to the network
	- ERR07 : Current loss to ground or system malfunction.	-Contact Assistance Service. -Check for water in system.
	- ERR 08 : Supply voltage too low below 190 V	- Check power supply connection
	- ERR 09: Compressor blocked at start	- Switch the compressor off and on again
	- BLOC : Motor screw pump jammed	-Check if the rotor and stator are jammed together
	- STOP : Inlet air on compressor is closed - Gun air cock closed - Spray gun air nozzle obstruction - Obstruction of the air hose between the machine and the spray gun - Remote or past button hold (injections)	- At the end of the stop, when the machine restarts, the signal disappears automatically - Clean the air nozzle or clear the air line
	- H2O : Water pressure below 2.5 bar	- Switch on the machine's water pump. - Check the water supply line - Check that the water circuit filters are clean. - Check the water flow
Material flow stops (air bubbles)	**Mixing** **-** Mixer not suited to product - Material damp in hopper	- Clean the mixer and if necessary repla-ce with one more suited to products used - Clean the mixer and if necessary repla-ce with one more suited to products used
Material flow stops	**Clogging** **-** Material hose clogged - Spray jet clogged	- Remove obstruction
Material delivered to jet not constant, too hard or too liquid	**Pre-mixed material deteriorated** **Screw-stator pair worn** **Screw-stator pair worn** **Water pressure reducer faulty (ref.)** **Water solenoid valve faulty** **Water system settings incorrect** **Electric cable too long and too narrow**	- Check points listed alongside
Water increases in mixing chamber during operation	**Screw-stator pair worn** **Pipeline clogging**	- Replace screw-stator - Remove obstruction
Water increases in mixing chamber with machine stationary	**Solenoid valve faulty**	- Check

INDICATOR LAMP TABLE

INDICATOR LAMP (SEE PAG.25)	*ON*	*OFF*
BLUE (rif.2)	Power supply ok, line present	-No electric power supply -No line -Main switch set to 0
RED (rif.6)	Grid not fitted correctly	-Grid fitted correctly
GREEN (rif.9)	Water pressure ok	-No water pressure