



## 2025 Digiflow Airfluid Manual Powder System

### Danger!



High voltage!  
Turn power off  
before servicing!  
Read rules for  
safe operation and  
instructions carefully!



[back](#)



### Operating Manual

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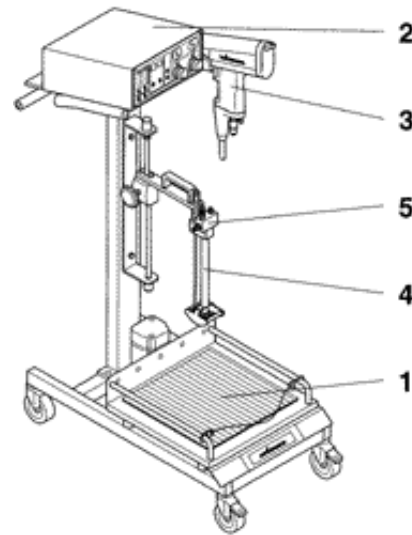
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**Manual powder system 2025 Digiflow Airfluid**





- 1 Equipment trolley 2010 Airfluid    4 Feed unit Integral ME1  
 2 Control unit EPG Digiflow        5 Powder injector PJ-D1  
 3 Spraygun

The manual powder system **2025 Digiflow Airfluid** is designed for use in laboratories and low volume production in industry and trade. You can operate this manual powder system with the following types of sprayguns:

- **Corona** Spraygun: Airmatic PEM-C2
- **Tribo** Spraygun: PEM-T1

The major advantages are:

- Powder supply from the original powder box
- Re-coating in addition to prior automatic coating
- Quick and easy cleaning

The feed unit (4) is inserted directly into the original powder box. The powder is supplied to the powder gun (3) via the powder injector (5). Due to the special arrangement of the fluid hoses in front of the suction tube and the vibration of the entire container, a homogeneous powder/air mixture is ensured

during the entire operation.

The powder quantity and its electrostatic charging are regulated from the control unit EPG Digiflow (2).

### What coating powder can be used?

All types of coating powder can be processed with the manual powder system **2025 Digiflow Airfluid**. The powder has to be selected depending on the type of spraygun:

- With Airmatic spraygun **PEM-C2**: epoxy, polyester, blended powder EP / PES, PUR etc.
- With Tribo spraygun **PEM-T1**: powders which are suitable for friction charging, such as epoxy resin powder or PUR lacquers.



Powders containing metal pigments may only be processed in compliance with the powder manufacturer's instructions.

Detailed information on configuration can be found in the operating instructions of the **EPG Digiflow 2007** control unit.

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## 1. Introduction



This technical manual contains information and hints for the service, repair and maintenance of the equipment. The observation of this manual is element of the warranty agreements.


Wagner powder systems are designed to meet the most stringent safety requirements. They can be operated in compliance with generally applicable safety codes and applicable national safety regulations.

Please pay particular attention to the parts marked by the following symbols. Follow the instructions exactly, in the interests of both your own safety and the correct functioning of the unit.




This symbol draws attention to the fact that if the operating instructions, working

**Warning** instructions, prescribed working sequences etc. are not followed exactly, this can lead to injury or even fatal accidents.

  
**Caution** This warning indicates that if the operating instructions, working instructions, prescribed working sequences etc. are not followed exactly, this can lead to damage to the unit.

  
**Hint** This symbol draws your attention to useful additional information and tips.

 Wagner hereby declares that the unit described in these operating instructions has been designed and manufactured according to the provisions of EU Directive 89/392/EEC.

The following **European** standards have been applied:

EN 50014 EN 50050  
EN 50053


The following **German** standards or guidelines have been applied:

ZH 1/443  
VDMA 2371 Part 1  
VDE 0165

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## 1.1 Safety Regulations



  
**Warning** This equipment can be dangerous if it is not operated in accordance with this operating manual! There might be additional regulations to be observed, put into effect by governmental, state or other official agencies or local security (fire) departments!

The following rules must be observed in order to ensure a safe and efficient use of the equipment:

- Under no circumstance may persons with a
- In the event of faults or defects, repair work is to

cardiac pacemaker come close to the area between the tip of the spraygun and the workpiece to be coated.

The user has to observe particularly the safety guidelines of the VdS or the local professional and security institutions. 2) 3) 6) 9)

- The spraygun may only be operated in the hazard zone created by operation of the manual spraying equipment itself. 2) 3) 6)

- The spraygun may only be operated in powder spray booths or powder spray benches equipped with industrial ventilation. 2) 3) 6)

- The user has to ensure that the medium value of the powder/air concentration does not exceed 50% of the LEL u<sup>1)</sup> (maximum allowed concentration of powder in air). If the LEL is not known, the user should assume a value of 20 g/m<sup>3</sup>. 2) 3) 6)

- The main power connection for operation of the Wagner powder equipment must be electrically interlocked with the exhaust system of the powder coating booth. 2) 3) 6)

- The Wagner control unit must be installed outside the hazard area. 2) 3)

- The user must conduct periodic checks of the powder spray equipment (at least every year) with regard to explosion-protection. 5) 7)

be performed at the user's discretion. 7)

- The user must keep a test certificate of the device type on file at the installation site. 7)

- The execution of repairs must not lead to an alteration in the explosion-protection. 5) 7)

- Repairs may only be carried out by specially trained personnel. 7)

- Repairs must never be performed in an explosion-hazard area. 7)

- The work area must have an electrostatically conductive floor (measured in accordance with DIN 51953) 2) 3) 6)

- All conductive parts in the work area must be electrostatically grounded (work area = 1.5 m at the sides, 2.5 m to the front and rear of every spray location or opening in the booth). 3)

- All persons inside the work area must wear electrostatically conductive footwear. 2) 3)

- If gloves are used, they must be of antistatic material or have cut-out palm areas. 2) 3)

x) See paragraph [8.1 "Applicable Safety Regulations and List of Sources"](#)

## HAZARD

## PREVENTION

Electrostatic arcing may cause an explosion or fire. Mixtures of powder and air can explode or ignite causing property damage and/or severe injury.

Operator must be grounded. Grounding straps must be used when wearing rubber soled shoes.

Operator must be in contact with the spraygun handle; cut out palm section and trigger fingers of any work gloves to be used.

Operator must remove all metal objects from his or her person, which are not grounded.

The object being sprayed must be grounded.

All metal objects within the spray area must be grounded (including spray booth, part hangers, fire extinguishers, etc.)

Grounded conductive floor must be provided in spray area.

Turn off the Power Pack and unplug from outlet before flushing out the gun, cleaning or replacing parts on the gun such as changing tips.

Explosion or fire. Mixtures of powder and air can explode or ignite causing property damage and/or severe injury.

Exhaust and fresh air introduction must be provided to keep the air within the spray area free of accumulation of flammable atmosphere.

Smoking must not be allowed in spray area.

Fire extinguishing equipment must be present and in working order.

Electrostatic arcing must be prevented. (See Electrostatic arcing)

When cleaning the system, use only materials recommended by the coatings manufacturer. Be sure Power Pack is turned off and unplugged.

Avoid all ignition sources such as static electricity sparks, open flames such as pilot lights, hot objects such as cigarettes and sparks from connecting and disconnecting power cords and working light switches.

To prevent hazardous concentrations of flammable atmospheres,

spray only in a properly ventilated spray booth.

Never operate spraygun unless ventilation fans are operating properly.

Check and follow all National, State and Local codes regarding air exhaust velocity requirements.

Ventilation must be maintained during the cleaning operation.

Toxic Substances: Some materials may be harmful if swallowed or come in contact with the skin.

Follow the requirements of the Material Safety Data Sheet supplied by the coatings manufacturer.

Exhaust and fresh air introduction must be provided within the spray area to keep the air free of high powder accumulations.

Wear a mask or respirator. Read all instructions for the mask to insure that it will provide the necessary protection against the inhalation of powder.

#### General

Read all instructions and safety precautions before operating.

Comply with all appropriate local, state and national codes governing ventilation, fire prevention, and operation of Electrostatic equipment usage.

The United States Government Safety Standards have been adopted under the Occupational Safety and Health Act. These standards, particularly the General Standards, Part 1910 and the Construction Standard, Part 1926, should be consulted.

NFPA Standard No. 33 is to be followed when setting up your spray area. Contact the National Fire Protection Association, Batterymarch Park, Quincy, Massachusetts, 02269 for more information.

Check with insurance company for additional requirements.

Use only identical replacement parts.



Personnel must be given training in accordance with the requirements of NFPA Standard No. 33 chapter 15.

It is the duty of all personnel responsible for the spray equipment operation and maintenance to read and understand all safety information furnished with this equipment.

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## 1.2 General Safety Rules



### **Keep your workplace well organized**

A disorganized workplace creates a hazard.

### **Take the environmental influences into consideration**

Do not expose the manual system to rain. Do not use the manual system in a damp or wet environment. Ensure good illumination. Do not use power tools near flammable liquids or gases

### **Store your tools carefully**

Unused tools should be stored in a dry, locked room and out of the reach of unauthorized persons.

### **Do not use the cable for purposes other than those intended**

Do not carry the spraygun by the cable and do not use it to pull the plug out of the socket. Protect the cable from heat, oil and sharp objects.

### **Do not over-reach your standing position**

Avoid abnormal body positions. Ensure stable footing and always keep your balance.

### **Wear suitable work clothing**

### **Use breathing protection for work which produces powder**

### **Take good care of the system**

Keep the system clean to ensure that it works well and safely. Check the plug and line cord regularly and have them replaced by customer service if damaged. Check the extension cord regularly and replace it when damaged.

### **Always remain alert**

Watch your work. Proceed in a reasonable manner. Do not use tools when you lack concentration.

### **Check your equipment for damage**

Before using the system, carefully inspect slightly worn parts for proper operation. Check whether the moving parts operate properly, whether they jam and whether parts are damaged.

All parts must be properly assembled in order to ensure proper operation of the unit. Damaged parts should be repaired or replaced by a Wagner customer service.

**Warning**

For your own safety, use only accessories and equipment listed in the operating manual. The use of individual parts other than those recommended in the operating manual may create a hazard to personal safety.

Use only original **Wagner** replacement parts!

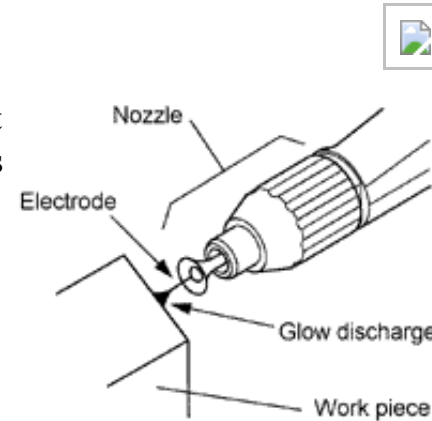
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## 1.3 Information concerning harmless discharge

When the high voltage is turned on, a glow or corona discharge, that is only visible in a dark environment, occurs at the electrode tip. This physical phenomenon can be observed when the electrode approaches the grounded workpiece.

This glow discharge does not provide any ignition power and does not have any influence on the handling of the installation. When the electrode approaches the workpiece, the control device automatically reduces the high voltage to a safe level or turns off the high voltage depending on the setting.

If the plastic parts of the spraygun are touched with the finger, a harmless discharge can be caused, brought about by the high voltage field of the spraygun (so-called brush discharges). However, these do not provide any ignition power.



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## 2. Preparing the manual powder system for initial use

### 2.1 Assemble the manual powder system and connect the spraygun

**Hint**

Before you begin assembling the manual powder system and starting it up, check to see that all components have been supplied for assembly.

In particular, ensure that you understand how to operate the [EPG Digiflow 2007](#) control unit.

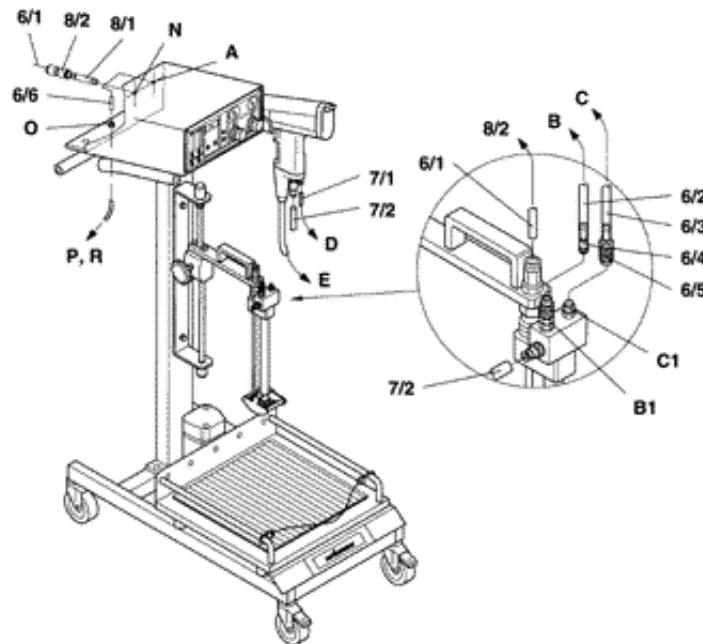
Assembly of this manual powder system is the same for both the Corona and the Tribo spraygun.

The connecting sets (e.g. **6/1** or **8/1**) necessary for assembling are detailed in the list of spare parts in [section 6.2](#). The identifying letters (e.g. **A** or **B**) can be found in the connections diagram.



**Caution**

Valve **8/1** **must** be connected to fluid air connection **N** (air no. 4) of the control unit, so that the fluid air can be set correctly.



1. Insert valve **8/1** in connection **8/2** and connect this pre-assembled part to connection **N** (air no. 4) of the control unit.
2. Connect the green hose for the fluid air **6/1** to connection **8/2**.
3. Connect the blue dosage air hose **6/2** to connection **B** (dosage air) and the red feeding air hose **6/3** to connection **C** (feeding air) of the EPG Digiflow and to connections **B1** and **C1** of the powder injector.
4. Connect the black hose for the atomizing air or Tribo air **7/1** to connection **D** (air no. 3) and to

the spraygun.

5. Connect the transparent hose for the powder delivery **7/2** to the spraygun and to the powder injector.
6. Connect the gun cable to socket **E** of the control unit.
7. Connect the shaker motor cable to socket **G** of the EPG Digiflow and secure it with the bar.
8. Connect the equipment trolley ground cable to ground screw **K**.
9. Connect the short black hose **6/6** to connection **A** (air inlet) of the control unit and to connection **O** of the equipment trolley.



**Hint** Screw fitting **O** has been provided on the equipment trolley for connecting the compressed air supply, and this has an R 1/4" internal thread on the connecting side.

For safe operation of the manual powder system, high quality compressed air is required, as described in the technical data in [section 7](#).

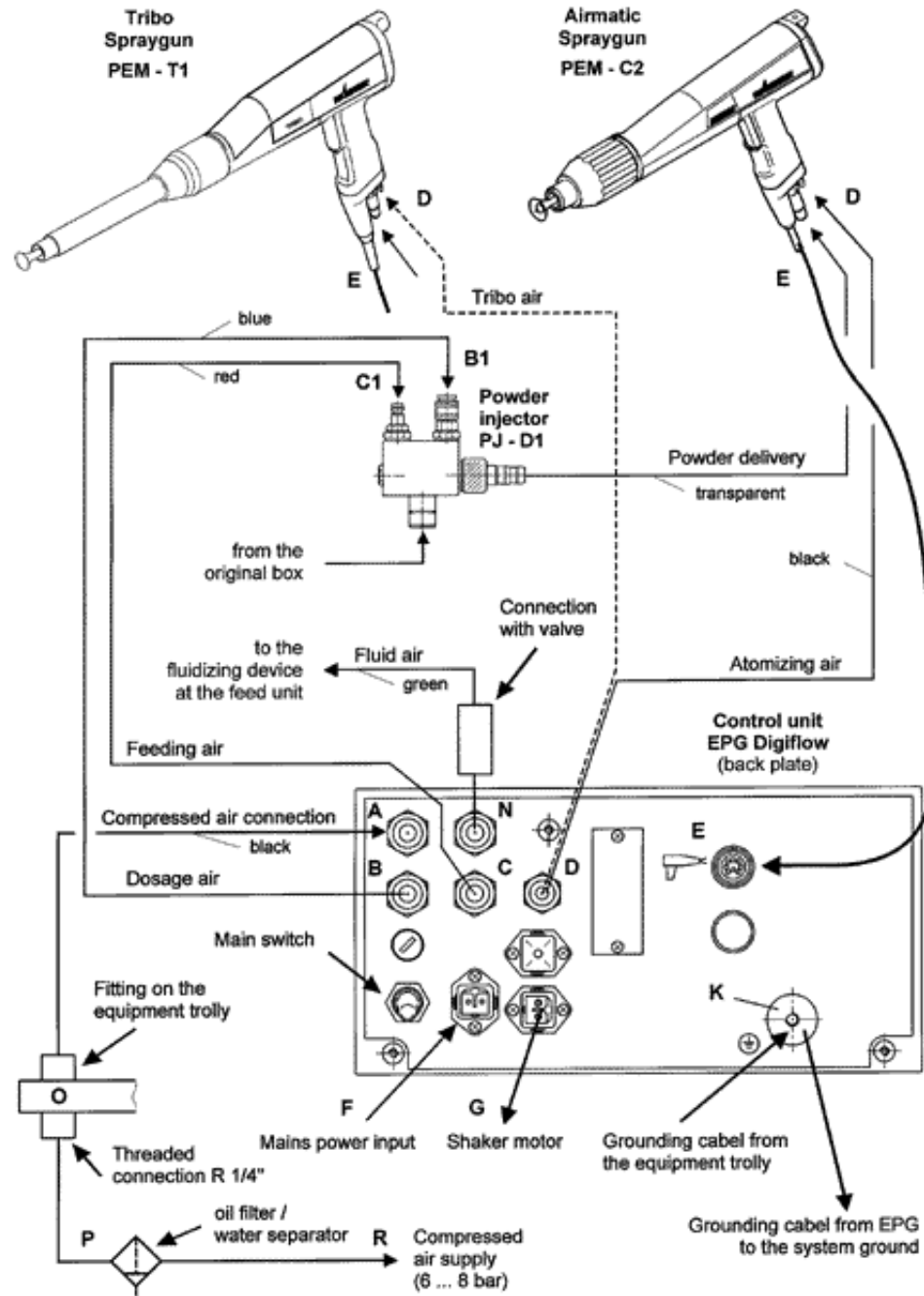
If your compressed air generator does not achieve this quality of compressed air, you **must** connect an oil filter / water separator.

10. If necessary, connect an oil filter / water separator **P** between connection **O** and compressed air **R**.
11. Connect the mains lead to socket **F** (mains power input) of the control unit and secure it with the bar.



**Caution** High ambient temperatures must be avoided; in particular, the hoses must not be routed through factory areas exposed to direct sunlight!

Powders with a gelling tendency should be processed at low temperatures. The hoses should be flushed with compressed air every day in order to prevent powder from sintering.





The mains power connection **must** be electrically interlocked with the exhaust air system of the powder spray booth.

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## 2.2 Grounding the manual powder system



In order to achieve a good powder coating and for security reasons, the **manual powder equipment must** be properly grounded. Normally, this occurs through the mains cable.

A poorly grounded workpiece causes:

- very bad wrap-around
- uneven coating
- back-spray onto spraygun and user
- dangerous electric charging of the workpiece



If the mains cable does not have a separate protective ground terminal, it is absolutely necessary to connect the control unit to the system ground by a separate grounding cable via the grounding screw at the back plate of the EPG Digiflow!

Sparks between workpieces and conveyor hooks (hangers) can occur if hooks or other hanger parts are not completely cleaned! These sparks can cause heavy radio frequency interferences!

Preconditions for good grounding as well as coating are:

- good grounding of the workpiece to be coated, of conveyors and hangers
- grounding of the spraybooth, hooks and hanger parts with a 16 mm<sup>2</sup> cooper cable to the system ground
- regular cleaning of hangers from powder deposits
- resistance to ground of the workpiece less than 1 Mega Ohm

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### 2.2.1 If the manual powder system is operated within zone 11

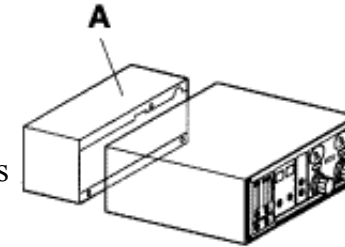


**Warning**

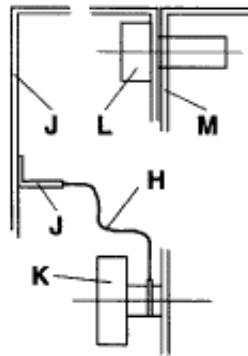
When used inside zone 11 the control unit may only be operated with the mounted protection cover **A**.

In several countries there are country-specific regulations, according to which the control unit must be installed outside the **dust explosion-hazard zone** (zone 11 according to ZH 1/443). With the safety device **A** mounted to the control unit it is allowed to install the equipment inside zone 11 according to the certificate PTB No. Ex-92.C.9102.

Part-No. **0265 902**



This is how the safety device is fitted to the EPG Digiflow:



For use inside zone 11 connect a grounding cable **H** from the cover terminal **J** to the grounding screw **K**. Mount the cover terminal **J** with the fastening screws **L** at the housing back plate **M** of the control unit.

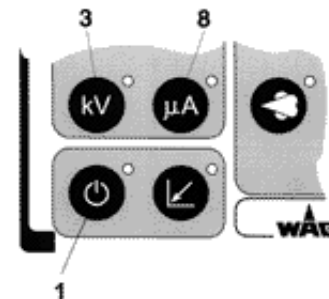
## 3. Working with the manual powder system

### 3.1 This is how the manual powder system is switched on and off



Switch the main switch on the rear side of the control unit upwards to position **"I"** in order to switch the unit's power supply on.

- The control unit is ready for operation in a few seconds.
- In order to switch the control unit to standby mode, press the ON/OFF key **1** on the operating side.
- The shaker motor remains switched on in standby mode.



### 3.2 Make the basic settings for the manual powder system



**Caution**

In order to prevent damage of the powder box due to vibrations (scrub through), a minimum distance of  $\frac{3}{4}$  inch **must** be maintained between the feed unit and the container bottom.

On switching on the control unit, the fluid air should be switched on simultaneously (danger of blockage in the fluid air hoses).

The feed unit should only sink into the powder driven by its own weight.

Refer to the operating instructions of the [EPG Digiflow](#) and make the following settings:

1. Set the fluid air so that it is switched on simultaneously with the control unit.
2. Set the atomizing air or the Tribo air so that it is automatically switched on and off from the powder release.
3. Set the Corona current limitation and automatic switch-off when using spraygun **PEM-C2**.

### 3.3 Corona or Tribo

The EPG Digiflow is configured by default for operation with a **Corona** spraygun. You can switch to **Tribo** mode by **simultaneously** pressing key **3** and **8**. If you press this key combination again, you will switch back to Corona operation. The corresponding LED will tell you which mode is active.



### 3.4 Setting the powder cloud for your coating



1. Check to see if the power supply is switched off, and if necessary, switch it off with the main switch on the rear side of the control unit.
2. Place an opened powder box (25 ... 30 kg) on the shaker table and secure it with the retaining strap.
3. Switch the power supply on.
  - The control unit will be switched on.
  - The shaker motor will be switched on simultaneously.
4. Close the fluid air.
5. Lower the feed unit until it is on the surface of the powder.
6. Slowly open the fluid air, but only so by much (1 ... 2 bar), that the feed system sinks into the powder under its own weight.

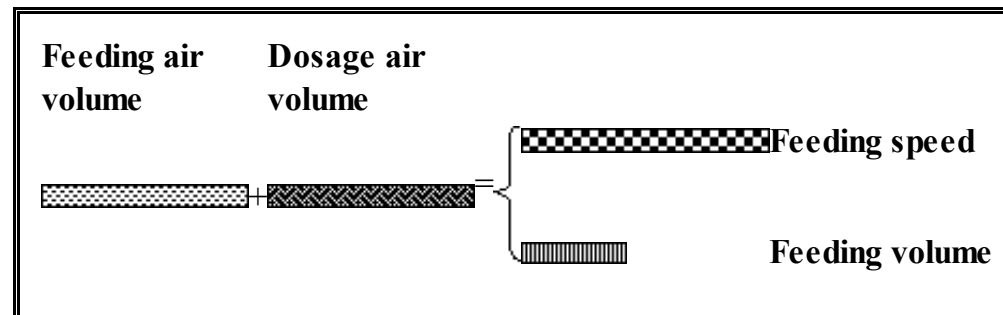


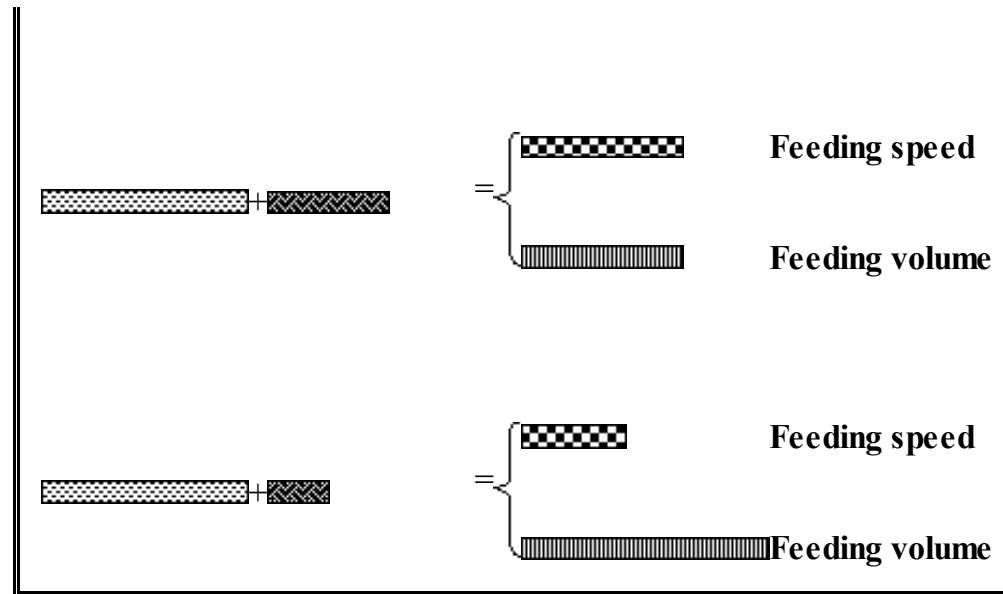
#### Hint

- The necessary fluid air quantity depends on the powder quality.
- The powder should be moving in the suction area of the feed unit (lightly flurrying).
- A development of dust in the powder box must be avoided!

7. Hold the spraygun in the spray booth, pull the trigger on the spraygun and adjust the powder cloud.
8. Adjust the feeding air, dosage air and the atomizing air or Tribo air on the control unit.
  - For this, refer to the operating instructions for the EPG Digiflow and / or the spraygun.

The following illustration provides information on the effects of the feeding air and dosage air on the volume being fed or the rate of feed.





### 3.5 This is how you interrupt the coating process



**Hint**

The spraygun and the powder feeding parts should be blown through and cleaned from powder deposits with every interruption of work

1. Release the trigger of the spraygun.
  - The high voltage and the powder delivery will be switched off.
  - The fluid air and the shaker motor remain switched on.



**Caution**

Before turning off the manual powder system, you **must** first pull the feed unit out of the powder box (**danger of blockage** of the fluid air hoses)!

2. Move the feed system out of the box so that no more powder can be fed.
3. Hold the spraygun in the spray booth, pull the trigger of the spraygun and free it from powder.
4. Now you can switch the control unit to standby mode with the ON/OFF button.
  - The fluid air will be switched off
  - The shaker motor remains switched on.

(see [paragraph 3.1](#))

**Hint**

If you want to leave the manual powder system switched off for a long period, it is better to switch off the shaker motor as well. By doing this, you prolong the service life of the shaker table and prevent the powder in the box from compacting unnecessarily.

5. Switch the control unit off with the main switch on the rear side.
  - The shaker motor is now switched off.

If you switch the control unit or manual powder system on again, you can continue coating with the same powder cloud. The last coating parameters which have been set are stored in the control unit and are called again on switching on.

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## 3.6 This is how to carry out a change of color

### 3.6.1 Clean the manual powder system

**Hint**

When changing colors, all powder transporting components must be cleaned thoroughly.

1. Release the trigger of the spraygun.
  2. Move the feed system out of the box so that no more powder can be fed.
  3. Hold the spraygun in the spray booth, pull the trigger and free the gun from powder.
  4. Now you can switch the EPG Digiflow off with the main switch on the rear side.
  5. Clean all powder transporting parts, such as the spraygun, the powder injector, the powder feed hose and the feed system.
- 

### 3.6.2 Re-starting the system with the new powder



If you want to carry out a change of color and want to continue coating with an unchanged powder cloud, you do not need to alter the existing settings, provided the powder characteristics are identical.

1. Place an opened box (25 ... 30 kg) with the new powder on the shaker table and secure it with the retaining strap.
2. You can now switch on the control unit with the main switch on the rear side of the unit.
3. Lower the feed system on to the surface of the powder.
4. Hold the spraygun in the spray booth and begin coating.

### Re-starting with a new type of powder:

- If you change the type of powder when changing the color, you have to re-set the powder cloud as well.
- The other basic settings, as described in [section 3.2](#) do not need to be altered.



It is possible to store and re-call two settings for the powder cloud with the EPG Digiflow control unit.

If you want to use the present powder cloud setting again later, then make a second setting on the control unit.

For this, refer to the operating instructions of the [EPG Digiflow](#).

1. Place an opened box (25 ... 30 kg) with the new powder on the shaker table and secure it with the retaining strap.
2. You can now switch on the control unit with the main switch on the rear side of the unit.
3. Switch on the power supply.
4. Close the fluid air.
5. Lower the feed system until it is on the surface of the powder.
6. Slowly open the fluid air, but only by so much (1 ... 2 bar), that the feed system sinks into the powder under its own weight.
7. Hold the spraygun in the spray booth, pull the trigger and adjust the powder cloud.

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## 4. Maintenance and cleaning



Maintenance, repair or replacement of the powder spray unit or its components may only

**Caution** be performed by trained personnel in a suitable location outside the hazard area.

Weekly cleaning of the manual powder system ensures trouble-free operation.

The control unit is maintenance-free, when used according to this operating manual.

The wear parts of the **powder spraygun** and the **powder injector** must be checked and replaced if necessary.

A list of spare parts can be found in section "[Spare parts lists and accessories](#)" in the corresponding operating instructions.

### Warning

**WHEN CLEANING THE ELECTROSTATIC SYSTEM, THESE SAFETY PROCEDURES MUST BE FOLLOWED. FAILURE TO FOLLOW THESE PROCEDURES MAY RESULT IN AN EXPLOSION/FIRE.**

Turn power pack to the "OFF" position and unplug from power source before starting to clean.

Exhaust and fresh air introduction must be maintained during the clean up operation.

Keep cleaning materials in approved safety containers.

All personnel and cleaning equipment, including container used in cleaning operation, must be grounded.

DO NOT turn on the **POWER PACK** until the cleaning operation has been completed, all cleaning materials have been removed from spray area, and spray area is free of any mixtures of powder and air

### Caution

**Clean equipment immediately after use.**

**NEVER IMMERSE SPRAYGUN OR PARTS OF IT IN ANY FLUID AT ANY TIME.**

**Be sure the Power Pack is turned off and unplugged from the power source.**

#### NOTE

**The powder passages of the spraygun should be cleaned while cleaning the powder hose and powder pump, following instructions, provided with the powder pump (injector).**

(See [operating manual PJ - D1](#))

**Clean the spray tip by removing from spraygun, flushing with air and replacing on spraygun.**

produced by the cleaning operation.

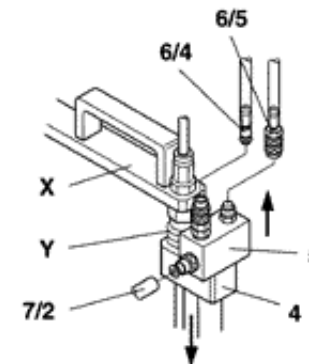
If defects in the equipment are found, DO NOT use until repairs are completed.

## 4.1 Periodically inspecting and cleaning the manual powder system



1. Clean the manual powder system as described in [section 3.6.1](#).
2. Pull out the powder injector **5** from the feed system **4**.
3. Disconnect the powder feed hose **7/2** from the powder injector **5**.
4. Disconnect the red feeding air hose from the powder injector **5** by undoing the coupling **6/5**.
5. Disconnect the green dosage air hose from the powder injector **5** by undoing the plug-in nipple **6/4**.
6. Check the powder injector for wear and replace worn parts as necessary.

Wear and replacement parts can be found in the **PJ - D1** operating instructions.



7. Disconnect the feed system **4** from the unit mount **X** by undoing the coupling **Y**.
  8. Blow out the feed unit suction tube thoroughly and wipe it with a dry cloth.
  9. Check to see if the fluid air hoses are blocked, and replace them if necessary.
- The spare parts can be found in [section 6.5](#) of these operating instructions.

## 4.2 Check the spraygun



### Caution

Never place the spraygun or parts of it into any wet cleaning agent!

Before re-assembling the spraygun, check to see if the contact points on the nozzle insert and the gun casing have been thoroughly cleaned.

- Disconnect the air connections from the spraygun.
- Disconnect the electrical connections from the spraygun and the control unit.
- You can now begin cleaning the spraygun.
  - For this, refer to the operating instructions for the spraygun.
  - The wear and spare parts can also be found in the corresponding operating instructions.

## 5. Trouble shooting



<b>Malfunction</b>	<b>Cause</b>	<b>Remedy</b>
Power indicator does not light up	<ul style="list-style-type: none"> <li>- Mains power not turned on</li> <li>- 1 AT slow blow fuses defective</li> </ul>	<ul style="list-style-type: none"> <li>- Turn on mains power</li> <li>- Replace fuses</li> </ul>
No Corona current reading	<ul style="list-style-type: none"> <li>- Break in the interconnect cable to spraygun.</li> <li>- The Spraygun is too close to the workpiece.</li> <li>- The Grounding between control unit and spraygun is interrupted.</li> </ul>	<ul style="list-style-type: none"> <li>- Notify Wagner service center or trained personnel for the replacement of the interconnect cable.</li> <li>- Turn off high voltage. Increase distance between spraygun and workpiece. Turn on high voltage again. Inform Wagner service center if error message reoccurs.</li> <li>- Inform Wagner service center.</li> </ul>
Powder output bursts (spatters)	<ul style="list-style-type: none"> <li>- Air speed in powder hose too low.</li> <li>- Reduced diameter of powder hose due to bending.</li> <li>- Fluctuations in compressed air caused by short-term increase in compressed air consumption in the supply network.</li> </ul>	<ul style="list-style-type: none"> <li>- Increase the sum of the feed and dosage air and re-set the ratios the flows have to each other.</li> <li>- Use a quality of powder hose where the diameter cannot pinch (choose one with thicker walls).</li> <li>- Immediately before extensive use, fit a pressure accumulator for the compressed air supply.</li> </ul>
Dust build-up in powder box	<ul style="list-style-type: none"> <li>- Too much fluid air volume</li> </ul>	<ul style="list-style-type: none"> <li>- Reduce fluid air volume at control unit.</li> </ul>

	- The valve is not connected to the control unit fluid air connection.	- Connect the valve to the control unit fluid air connection and re-set the volume of the flow of fluid air.
Poor wrap-around	- Bad or no grounding	- See <a href="#">paragraph 2.2</a>
Back-spray		
No powder output	- The powder box is empty	- Refill powder box
	- The spraygun is blocked	- Blow through spraygun.
	- The powder hose is blocked.	- Blow through powder hose.
	- The powder suction system is plugged up in powder container.	- Blow through powder suction system.
	- The feeding air hose is kinked.	- Straighten hose or replace.
	- The powder hose is kinked.	- Straighten hose or replace.
Feed unit does not sink into powder	- Guide rod of the mount for the feed unit binds.	- Improve guide rod smoothness.

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## 6. Spare parts lists and accessories

### 6.1 How to order



Faulty and useless parts are replaced according to our general delivery conditions.

To ensure a correct spare part order and delivery, the following information is required:

- **Billing address**
- **Delivery address**
- **Name of contact persons for further inquiries**
- **Way of delivery**





To order any spare parts and for further information refer to the drawings mentioned in the spare parts list.

We can only accept liability for original Wagner spare parts supplied by the factory.

We wish to point out specifically that only Wagner original spare parts and accessories are tested and approved by Wagner. It is therefore possible that the installation and/or use of other products may detrimentally affect the design characteristics of the equipment and may therefore jeopardize their active and/or passive safety. All liability and any guarantee is excluded for damage resulting from the use of spare parts and accessories from other manufacturers.

## 6.2 Manual powder system 2025 Digiflow Airfluid

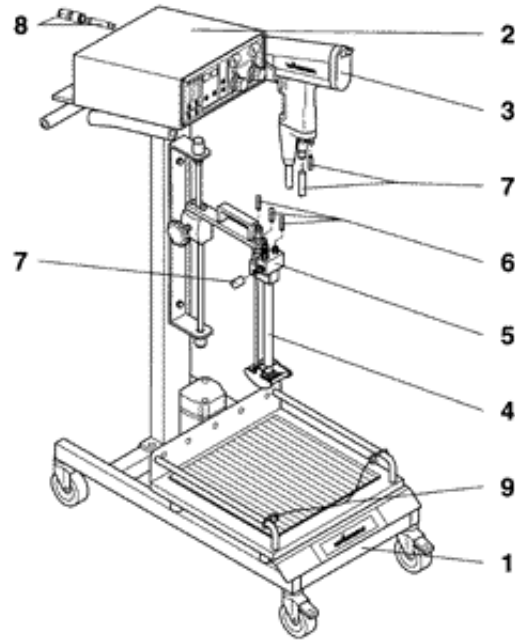


### Manual powder system 2025 Digiflow Airfluid C2:

	<b>Standard</b>	<b>Japan</b>	<b>USA</b>
(shaker motor version)	(230 V/ 50 Hz)	(100 V/ 50-60 Hz)	(120 V/ 60 Hz)
<b>Part No.</b>	<b>0265 006</b>	<b>0265 026</b>	<b>0265 016</b>

### Manual powder system 2025 Digiflow Airfluid T1:

	<b>Standard</b>	<b>Japan</b>	<b>USA</b>
(shaker motor version)	(230 V/ 50 Hz)	(100 V/ 50-60 Hz)	(120 V/ 60 Hz)
<b>Part No.</b>	<b>0265 007</b>	<b>0265 027</b>	<b>0265 017</b>



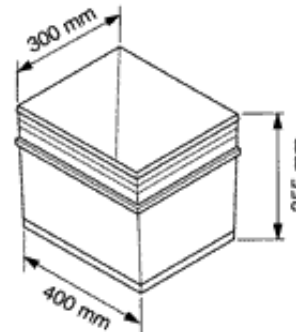
Item	Part No.	Quantity	Description
1	0264 188	1	Equipment trolley 2010 Airfluid (standard)
	0264 189	1	Equipment trolley 2010 Airfluid (Japan)
	0264 190	1	Equipment trolley 2010 Airfluid (USA)
2	0265 111	1	Control unit EPG Digiflow (standard)
	0265 112	1	Control unit EPG Digiflow (Japan)
	0265 113	1	Control unit EPG Digiflow (USA)
3	0351 021	1	Airmatic spraygun PEM-C2 1.)
	0259 003	1	Tribo spraygun PEM-T1 2.)
4	0264 193	1	Feed unit Integral ME 1
5	0241 294	1	Powder injector PJ - D1
6	0264 326	1	Airfluid connecting parts consisting of: Item 6/1 ... 6/6
6/1	9982 077	1.5 m	Hose green (5.5 x 8)

6/2	9982 062	1.5 m	Hose blue (5.5 x 8)
6/3	9982 063	1.5 m	Hose red (5.5 x 8)
6/4	9992 200	1	Fitting plug-in nipple
6/5	9992 711	1	Coupling joint
6/6	9982 078	0.35 m	Hose black (5.5 x 8)
7	0264 417	1	Powder hose-Set 2020 consisting of: Item 7/1 ... 7/2
7/1	9982 079	6 m	Hose black (4 x 6)
7/2	9998 259	6 m	Powder hose transparent (inner Ø 11 mm)
8	0265 199	1	Set 2025 Airfluid consisting of: Item 8/1 ... 8/2
8/1	0263 403	1	Valve
8/2	9998 553	1	Double hose socket
9	0264 329	1	Retaining strap

- 1.) included in the manual powder system 2025 Digiflow Airfluid C2.
- 2.) included in the manual powder system 2025 Digiflow Airfluid T1.

A powder container made of plastic which exactly fits the shaker table is available as a **special accessory**.

**Plastic container**  
3130 567



The following operating instructions are necessary for this manual powder system:

**Control unit EPG Digiflow**  
[0263911en](#)



**Airmatic Spraygun PEM-C2**  
[0351 801 USA/UK](#)



**Tribo Spraygun PEM-T1**  
[0259 846 USA/UK](#)



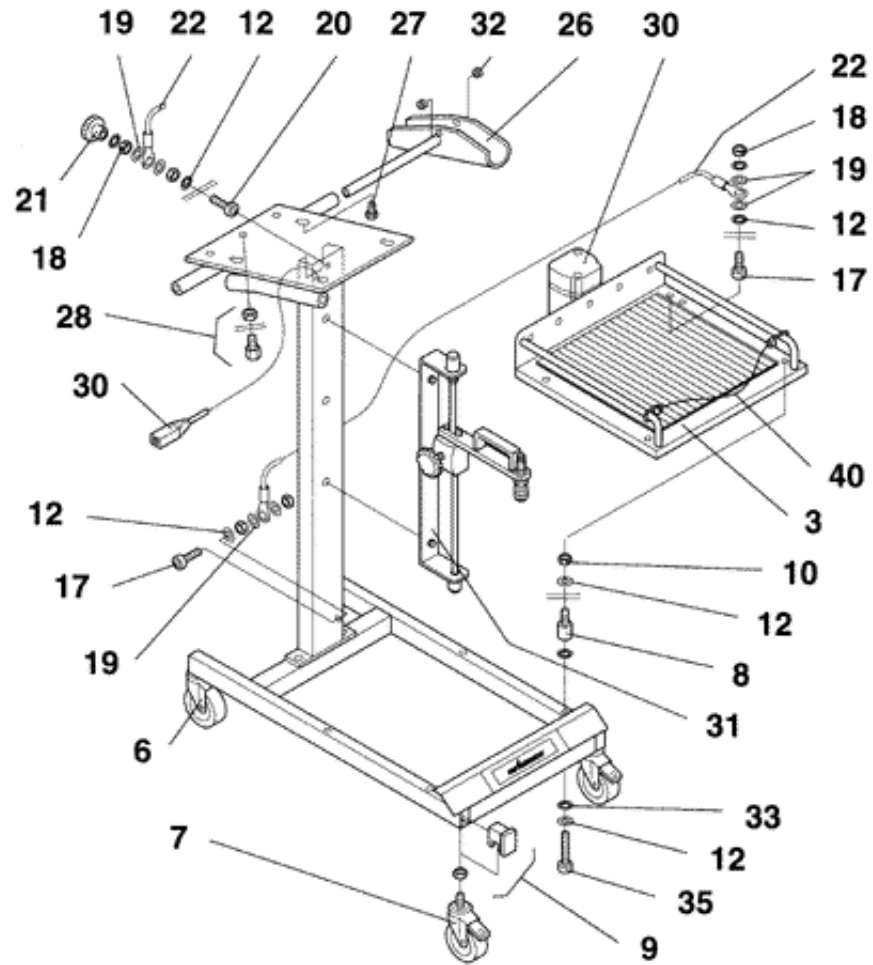
**Powder injector PJ-D1**  
[0241871en](#)



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## 6.3 Equipment trolley





Item	Part No.	Description
3	0264 307	Shaker table
6	9994 946 *	Single caster
7	9994 947 *	Caster with double stop
8	9994 531 *	Swivel element
9	9990 581	Dust cover
10	- **	Hex nut with jam piece (M6)

11	- **	Filister head screw (M6x40)
12	- **	Serrated lock washer (A6.4)
17	- **	Filister head screw (M6x20)
18	- **	Hex nut (M6)
19	- **	Washer (A6.4)
20	- **	Filister head screw (M6x30)
21	9910 522	Lug nut (M6)
22	- **	Grounding cable (assembly)
26	0264 330	Tubular holder (assembly)
27	- **	Hex bolt (M6x10)
28	9992 741	Fitting straight (R1/4"-D8)
30	- ***	Shaker motor (230V/50Hz)
30	- ***	Shaker motor (100V/50-60Hz)
30	- ***	Shaker motor (120V/60Hz)
31	0264 202	Feed Unit Mount
32	9950 817	Cable socket
33	- **	Washer (6.4)
40	0264 329	Retaining strap

\* wear part

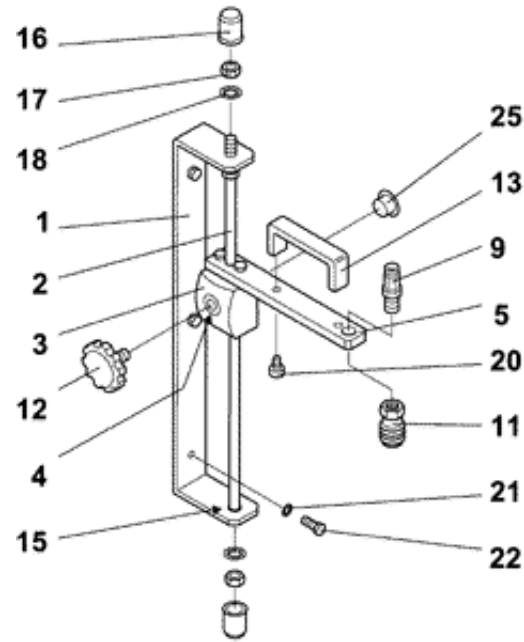
\*\* no wear part (just for information); not available as spare part!

\*\*\* ask Wagner service center

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## 6.4 Feed unit mount





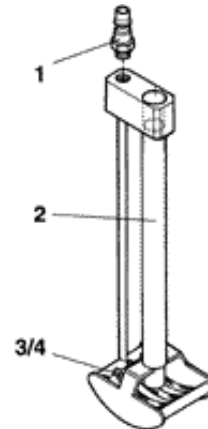
Item	Part No.	Description
1	- **	Bar
2	- **	Guide rod
3	- **	Clamp
4	0236 360 *	Pressure piece
5	- **	Adapter plate
9	0264 243	Fluid air valve
11	9991 638	Quick coupling (R3/8)
12	9910 512	Compact control knob
13	9994 110	Handle
15	- **	O-ring (12x2)
16	- **	Dust cover
17	- **	Hex nut (M12)

18	- **	Serrated lock washer (J12.5)
20	- **	Phillips head self tapping screw (4.2x25)
21	- **	Hex bolt (M8x20)
22	- **	Serrated lock washer (A8.4)
25	9990 533	Stop

\* wear part

\*\* no wear part (just for information); not available as spare part!

## 6.5 Feed unit Integral ME 1



Item	Part No.	Description
1	9998 035	Plug-in nipple (8-1/4")
2	0264 453	Suction tube (Assembly) ME – 1
3	9982 064 *	Fluid tube (specify length)
4	8000 155	Reinforcing wire (specify length)



\* wear part

## 7. Specification



### Dimensions:

Width:	466	mm
Height:	1182	mm
Depth:	770	mm
Weight:	approx. 39	kg

### Electrical:

Mains power: *	220 V ... 240 V 110 V ... 120 V 100 V
Frequency:	50 ... 60 Hz
Input power:	max. 130 W
EMI filter:	EN 55022 class B VDE 0878 PT3 class B

\* For corresponding countries see [paragraph 6.2](#) .

### Display:

			actual	reference
High voltage:	0 ... 100 kV	Resolution:	5 kV	1 kV
Corona current:	0 ... 200 $\mu$ A	Resolution:	10 $\mu$ A	5 $\mu$ A

Tribo current: 0 ... 4  $\mu\text{A}$  Resolution: 0.2  $\mu\text{A}$  - -

### **Pneumatic:**

Input air pressure: 6 ... 8 bar min. 6 bar

Output air flows:

Feeding air volume: 0.1 ... 4.5  $\text{Nm}^3/\text{h}$  Resolution: 0.1  $\text{Nm}^3/\text{h}$

Dosage air volume: 0.1 ... 4.5  $\text{Nm}^3/\text{h}$  Resolution: 0.1  $\text{Nm}^3/\text{h}$

Atomizing / Tribo air pressure: 0 ... 2.5 bar Resolution: 0.1 bar

Fluid air pressure: 0 ... 2.5 bar Resolution: 0.1 bar

Air throughput: max. 19  $\text{Nm}^3/\text{h}$

### **Compressed air quality according to ISO 8573.1:**

Residual water content in compressed air: max. 1.3 g  $\text{H}_2\text{O}/\text{Nm}^3$  at a dew point of 7 °C

Residual oil content in compressed air: max. 0.01 mg oil/ $\text{Nm}^3$

Residual dust content in compressed air: max. 1 mg dust/ $\text{Nm}^3$

### **Ambient conditions:**

Working temperature: 5 to 45 °C

If low temperature powders are used, the ambient temperature may have to be lower than 30 °C.



**Hint**

#### **Volume measures:**

All volume indications ( $\text{m}^3/\text{h}$ ) are  $\text{Nm}^3/\text{h}$ . (norm cubic meters per hour). One cubic meter of a gas at 0 °C and 1.013 bar is called norm cubic meter.

$$1 \text{ Nm}^3/\text{h} = 35.3 \text{ ft}^3/\text{h}$$



## 8. Supplement

### 8.1 Applicable Safety Regulations and List of Sources

- |    |  |  |  |
|----|--|--|--|
| 1) | EN 50050<br>DIN VDE 0745<br>part 100     | Electrostatic manual powder coating equipment  | (published by<br>VDE-Verlag, Berlin)             |
| 2) | EN 50053 – 2<br>DIN VDE 0745<br>part 200 | Selection, installation and use of electrostatic spraying equipment, manual electrostatic equipment for powder | (published by<br>VDE-Verlag, Berlin)             |
| 3) | ZH 1/443                                 | Electrostatic powder coating with manual powder coating equipment  | (published by<br>C. Heymanns-Verlag,<br>Cologne) |
| 4) | EX-RL / ZH<br>1/10                       | Guidelines for explosion protection  | (published by<br>C. Heymanns-Verlag,<br>Cologne) |
| 5) | VDE 0165                                 | Installation of electrical equipment in explosion-hazard areas   | (published by<br>VDE-Verlag, Berlin)             |
|    | EN 50014                                 | Electrical equipment for explosion-hazard areas  | (published by<br>VDE-Verlag, Berlin)             |
| 6) | VDMA 24371<br>part 1                     | Guidelines for electrostatic coating using synthetic resin powders   | (published by<br>Beuth-Verlag, Berlin)           |
| 7) | ELEX V                                   | Regulation for electrical systems in explosion-hazard areas  | (published by<br>VDE-Verlag, Berlin)             |
| 8) | VDE 0134                                 | Instructions for first aid in case of accident   | (published by<br>Beuth-Verlag, Berlin)           |
| 9) | VDS 2093                                 | Association of insurance companies   | (Riehlerstr. 36<br>50668 Cologne)                |

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### 8.2 Warranty



#### What is covered by this warranty:

Faulty parts are replaced according to our general delivery conditions.

Within the applicable warrant period, Wagner will repair or replace, defective parts without charge if such parts are returned with transportation charges prepaid to the nearest authorized service center. If Wagner is unable to repair this product so as to conform to this limited warranty after a reasonable number of attempts, Wagner will provide, either a replacement for this product or a full refund of the purchase price of this product.

**These remedies are the sole and exclusive remedies available for breach of express and implied warranties.**

**What is not covered by this warranty:**

This warranty does not cover any damage or defects:

1. Caused by use or installation of repair or replacement parts or accessories not manufactured by Wagner,
2. Caused by repair performed by anyone other than a Wagner authorized service center, or
3. Caused by or related to abrasion, corrosion, abuse, misuse, negligence, accident, normal wear, faulty installation or tampering in a manner which impairs normal operation.

**Limitation of remedies:**

IN NO CASE SHALL WAGNER BE LIABLE FOR ANY INCIDENTAL, SPECIAL OR CONSEQUENTIAL DAMAGES OR LOSS, INCLUDING TRANSPORTATION COSTS, WHETHER SUCH DAMAGES ARE BASED UPON A BREACH OF EXPRESS OR IMPLIED WARRANTIES, BREACH OF CONTRACT, NEGLIGENCE, STRICT TORT, OR ANY OTHER LEGAL THEORY.

**Disclaimer of implied warranties:**

THE FOREGOING WARRANTIES ARE IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING BUT NOT LIMITED TO THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

**No ability to transfer:**

This warranty is extended to the original purchaser only and is not transferable.

**Your rights under state law:**

Some states do not allow limitations on how long an implied warranty lasts or the exclusion of incidental or consequential damages, so the above limitation and exclusion may not apply to you. This warranty gives you specific legal rights, and you may also have other rights which vary from state to state.