



INTERNATIONAL MARKETING, INC. TECHNICAL BULLETIN

SUBJECT: IMI Series 2020 Wheel/Rim Refinishing System Training
DATE: January 2003

Subjects Covered:

1. Safety:
OSHA Lockout/Tagout requirements and procedures _____
Removal of all energy sources _____
Raising, pinning door securely in up position _____

2. Shot Blast Module:
Electrical Disconnect Switch location _____
Electrical Motor E-Stop button location _____
Shot Blast Module timer setting _____
Addition of shot/grit blast media (proper working mix) _____
Operation sequence and controls _____
Non-Contact Thermometer (if applicable) _____
Correct amperage reading to determine proper shot level _____
How to inspect blast module interior for wear _____
When to change tune up kits _____
When to change wear plates _____
How to change tune up kit _____
How to change mil roll, bearings, seals _____
How to change door seal gasket _____
How to change motor felt seals _____
How to change out protection plates _____

4. Dust Collector:
Dust Vent _____
Blast Gate Settings _____
Filter cleaning (auto blow down & magnahelic gauge) _____
Collector dust removal cycle and method _____
Working Mix related to dust collector _____
Indications of cartridge problems _____
Dust hazard _____

5. Monorail:
Lowerator Hoist(brushes) _____
How to hook a wheel or rim to trolley/swivel/hook _____
How to maintain trolley/swivel/hook _____
“H” Frame Lift [powder only] _____

- 6a. Paint Booth [Liquid only]:
 Electrical Disconnect Switch location _____
 Electrical Motor Starter Reset button location _____
 Paint booth fan/paint pump interlock _____
 Paint pump ground strap/wire _____
 Paint pump setup and pressure settings _____
 Paint pump daily cleaning tasks _____
 Paint pump weekly cleaning tasks _____
 Paint heater _____
 Paint heater shut down and cleaning tasks _____
 Paint gun operation _____
 Paint gun cleaning _____
 Paint pump and gun safety _____
 Paint Booth [liquid only] (continued):
 Over-spray collection filter installation _____
 Over-spray collection filter replacement _____
 Exhaust fan duct _____
 Paint Booth sprinkler protection requirement _____
 NFPA #33 Manual _____
 Wheel Lift Rotator operation & control _____
 Wheel Lift Rotator roller speed (150 rpm, 50 rev/20 sec, 25 rev/10 sec) _____
 Dry film thickness (2 1/2 - 3 mil) _____
 Posipen demonstration _____
- 6b. Powder Collection Booth/Applicator [powder only]:
 Electrical Disconnect Switch location _____
 Electrical Motor Starter Reset button location _____
 Powder Booth Control Operation _____
 Booth/Applicator earth ground rod/strap/wire _____
 Booth/Applicator setup and pressure settings _____
 Booth/Applicator daily cleaning tasks _____
 Booth/Applicator weekly cleaning tasks _____
 Powder collection filter installation _____
 Powder collection filter replacement _____
 Final Filter installation/replacement _____
 Sprinkler protection requirement _____
 NFPA #33 Manual _____
7. Painting techniques: Powder _____ Liquid _____
 Wheels _____
 Rims _____
 HVLP _____ Settings 55 – 60 psi fluid & 77 psi air _____
 Airless _____ Pump pressure – 85 psi _____
 Sure-coat Powder Applicator _____ Fluidizing Pressure _____
 Atomizing Pressure _____
 Typical problems with painting:
 Cracks, joints and stop bars _____
 Face rust _____
 Runs _____
 Thin Coating _____
 Proper dry film thickness _____

- Tack free time _____
 - Cure time _____
 - Paint mixing _____
 - Paint agitation _____
 - Changing colors _____
 - Painting environment _____
 - Curing environment _____
 - Storage environment _____
 - Paint color _____
 - Paint Shelf Life _____
 - Distance from gun tip to part _____
 - Wheel/Rim Temperature before painting _____
8. IR Oven [powder only]:
 - Electrical Disconnect Switch location _____
 - Oven Control/zone settings and line speeds _____
 - Powdered Monorail Operation and Maintenance _____
 - Emitter Maintenance/replacement _____
 - Parabolic Reflectors Maintenance/replacement _____
 - Non-contact Thermometer _____
 - Cure Inspection _____
 9. Wheel & Rim Refinishing System Operations & Maintenance Manual:
 - Parts list _____
 - Daily checklist _____
 - Weekly maintenance checklist _____
 - 90-day service checklist _____
 10. Wheel Inspection:
 - Tire Maintenance Council's **Guide to Wheels & Rims** manual _____
 - Wheel lug and hole gauge _____
 11. For assistance on the following, please contact IMI at 800-233-7086
 - Equipment
 - Parts
 - Operation questions
 - Maintenance or repair questions
 - Service
 - Paint
 - Shot

Questions regarding the above technical bulletin may be directed to:

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