EN

Original Operating Manual

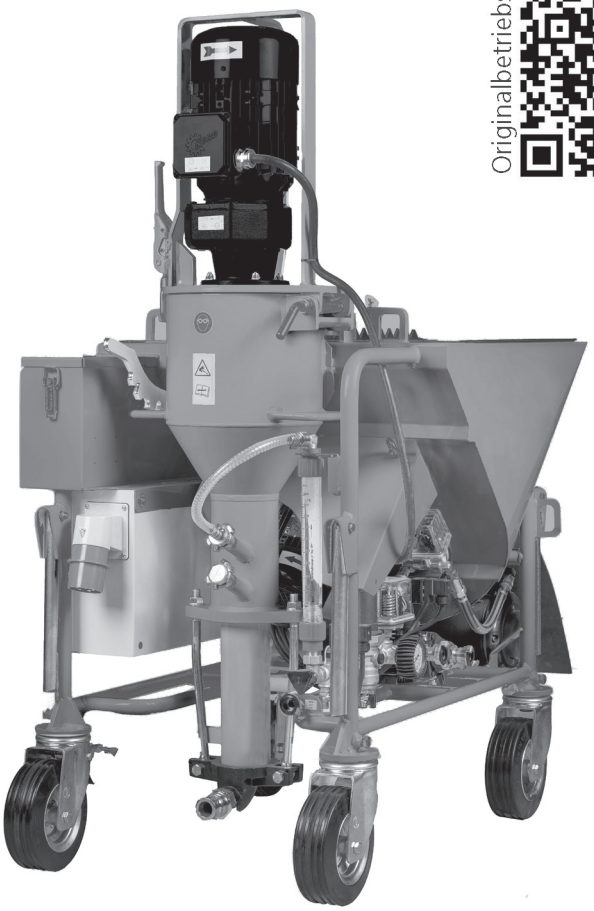
inoCOMB Maxi Power mixing pump

Read this entire original operating manual before starting work.

inoCOMB Maxi Power

Originalbetriebsanleitung

Original operation manual



inotec

EN

Thank you for trusting INOTEC. By purchasing you have opted for a quality product.

If you have any suggestions or any issues, we would be delighted to hear your suggestions for improvement and your feedback. Speak to the sales representative assigned to you or, in urgent cases, contact us directly.

We work constantly to further develop our products and reserve the right to make changes for technical reasons relating to building legislation.

Yours faithfully
INOTEC GmbH

Legal notice

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Inhalt

1 General information

1.1 Information about this manual

- This manual helps to ensure safe and efficient use of the machine.
- Operating personnel must have carefully read through and understood this manual before starting any work.
- Compliance with all the specified safety instructions is a basic prerequisite for working safely.
- This manual is a component of the machine and must be stored within direct proximity of the machine, accessible to operating personnel at all times.
- In addition to the notices in these instructions, the local accident prevention guidelines and national occupational health regulations also apply.

1.2 Symbol explanation

Hazard notices feature symbols to make them easier to identify. These indicate the severity of the hazard.

- You must observe this information.

DANGER indicates an immediate hazard. Death or serious injuries may result from non-compliance.

WARNING indicates a potentially dangerous situation. Death or serious injuries may result from a failure to avoid these situations.

CAUTION indicates a potentially dangerous situation. Minor or slight injuries may result from failure to avoid these situations or damage to the machine or something in its vicinity.

NOTICE draws your attention to useful tips for effectively handling the machine.

1.3 Information about this manual

1.3.1 Purpose of this operating manual

The operating manual is used to provide information to the operating manager, assembly fitters and machine operators on the construction site. It contains important instructions for safe use, optimum results and a long service life.

Risk of incorrect operation

Failure to observe the operating manual could put the operator's life and health at risk and damage the machine.

- Read this operating manual carefully before passing it on to your assembly fitters or operators.
- Please ensure that assembly fitters and operators read this operating manual carefully before they start installing and commissioning the machine.
- Always keep the operating manual to hand and in a legible condition.

1.3.2 Disclaimer

All technical information, data and instructions for use contained in this operating manual reflect the state of the art at the time of printing and are based on our experience thus far and the best of our knowledge.

The manufacturer cannot be held liable for any damages as a result of:

- Failure to comply with this manual
- Improper use
- Assignment of non-trained personnel
- Unauthorised alterations
- Technical changes
- Use of non-approved spare parts

1.3.3 Warranty

Statutory warranty periods of 12 months from the date of purchase/the date of invoice of the industrial end customer apply to our machinery.

1.3.3.1 Exercising claims

In the event of a warranty claim, send the entire machine, along with the invoice, to our headquarters in Waldshut-Tiengen.

Contact our free INOTEC service hotline beforehand on +49 7741 6805 777.

1.3.3.2 Warranty claims

Claims apply only where material or manufacturing faults exist and where machinery has been used properly. Wear parts are not covered by the warranty. All claims shall become void if third-party parts are installed, where the machinery has been improperly used or stored and in the event of obvious non-compliance with the operating manual. In this connection, we refer you to our General Terms of Business.

1.3.4 Carrying out repairs

Repairs may only be carried out by employees at our INOTEC service centres.

2 Safety

2.1 Intended use

You may only operate this machine if the following conditions are met:

- The inoCOMB Maxi Power is suitable for mixing, conveying and spraying all factory pre-mixed and machine-compatible mortars. The machine can be fed with powdery material from bags, one-way containers (with the dry conveying unit inoFLEX Mono), big bags (with the Big-Bag-Box Mono) or silos (with a conveyor system).
- The material is pumped in mortar hoses to the processing location, where it is applied to or poured into walls, ceilings or flooring by means of the appropriate spray guns or glue guns.
- Only use the machine within its limits of application and according to the technical data.
- Pay particular attention to the safety and warning notices outlined in this original operating manual.

Failure to use the inoCOMB Maxi Power properly could put the user's life and limb at risk and damage the inoCOMB Maxi Power or other assets.

Danger due to misuse!

Misuse of the inoCOMB Maxi Power may lead to dangerous situations.

- Never use the inoCOMB Maxi Power mixing pump to create other products, such as food.
- Never operate the inoCOMB Maxi Power mixing pump using values out of the ranges specified in the "Technical Data".

2.2 General risk sources

DANGER **Electrical voltage.**

Danger of death due to electric shock.

- Work on the electronic control system may only be performed by a qualified electrician.
- Connect the mixing pump only to regulation construction site power distribution points with FI circuit breakers (30 mA).
- The connection must be fused with 25 A.
- The cross-section of the supply cable is at least 4.0 mm^2 at 400 V 3 PH
- Connect the supply cable to the feed-in connector of the switching cabinet.
- All operating equipment on the construction site must generally be connected according to BGI/GUV-I 608.

DANGER **Rotating mixing shafts.**

Danger of death due to being pulled into the machine and crushed.

When the motor is running, the mixing shaft rotates in the mixing zone!

- Do not reach into the rotating mixing shaft.
- Do not place any objects into the rotating mixing shaft.

1. Before working on the metering and mixing shaft, interrupt the external power supply (main switch off).
2. Pull out the mains plug.
3. Secure the machine against unexpectedly being switched back on.
4. Open the eccentric lock on the motor and move it away to the side.

DANGER **Pressurised conveyor hoses.**

Risk of injury and risk of property damage due to escaping and/or flying material, and/or bursting conveyor hoses.

- Before disconnecting the conveyor hoses, make sure that the hoses are depressurised. To do so, check the pressure indicator on the mortar pressure gauge. The pressure indicator must display 0 bar!
- Before opening the hose coupling, let the inoCOMB Maxi Power run in reverse to reduce any pressure! To do this, turn the phase-change switch (1) until the red illuminated button on the machine's switching cabinet (2) lights up. Then press the red illuminated button. The pump then runs backwards.

- Use only conveyor hoses which are permissible with an operating pressure of 40 bar and a burst pressure of 120 bar, and are in a technically perfect condition (e.g. are without any cracks or other external damage!).

WARNING **Water jet.**

Risk of injury and risk of property damage due to escaping water.

1. Interrupt the external water supply by closing the water valve.
2. In order to release the pressure (approx. 2 bar), open the water drainage valve on the water measuring system under the pressure reducer.
3. Only remove the hose from the external water supply when the pressure gauge shows "0" bar.
4. Do not point the water jet at other people or yourself.

2.2.1 Notices in the operating manual

CAUTION **Safety notices in the operating manual alert the operating personnel to any immediate danger. Please observe all the technical and hazard notices in this operating manual.**

2.2.2 Performing checks before starting work

WARNING **Defects or damage can put the safety of operating personnel at risk and impair the functionality of the machine.**

- Before commencing work, check the machine for any obvious external damage or defects.
- Do not commission the machine if you notice any damage to or defects in the machine or to the conveyor hoses.
- Ensure that the damage and/or defects are rectified.

2.2.3 Conversions and changes

DANGER **Conversions or changes can put the safety of operating staff at risk and impair the functionality of the machine.**

- Do not make any changes, additions or conversions to the machine without first consulting Inotec GmbH and obtaining its written approval. Otherwise, the operating license will become void.

2.2.4 Cleaning and maintaining the machine

WARNING **Cleaning and maintenance work can put the safety of operating staff at risk and impair the functionality of the machine.**

1. Switch off the machine and pull out the mains plug.
2. Secure the machine against unexpectedly being switched back on.
3. Before cleaning with the water jet, cover all the openings that water must not penetrate into for safety and functional reasons.
4. After cleaning, remove all the covers which were attached to protect against the water.

2.2.5 Changing the location of the machine

The inoCOMB Maxi Power is equipped with four wheels. Convenient handles are fitted at all four corners for moving the whole machine.

CAUTION **Changing location can put the safety of operating staff at risk and impair the functionality of the machine.**

1. Switch off the machine and pull out the mains plug.
2. Move the machine to a new location on the building site.
3. Always install the machine in such a way that it is level and stable.
4. Secure the machine against undesirable movements.

2.3 Notices on the machine

DANGER **Safety notices on the machine make operating staff aware of imminent danger.**

The following warning notices are affixed to the inoCOMB Maxi Power:

Instructions on the mixed zone:

- Pressurised parts! Depressurise the machine before any cleaning or maintenance work (1).

Instructions on the switching cabinet:

- Switch off the main switch before opening the switching cabinet housing (2).
- Read the operating instructions carefully before starting work (3).
- Caution: live parts! Disconnect the mains plug before carrying out any work (4).
- Incorrect direction of rotation (5)
- The device may only be operated via a connector protected with an RCD (FI) $I\Delta\eta \leq 30$ mA (sticker on the side of the switching cabinet below the feeder).

Note on the four fold-out carrying handles:

- If a lifting device is used for transport, the attachment points provided and marked for this purpose must be used.

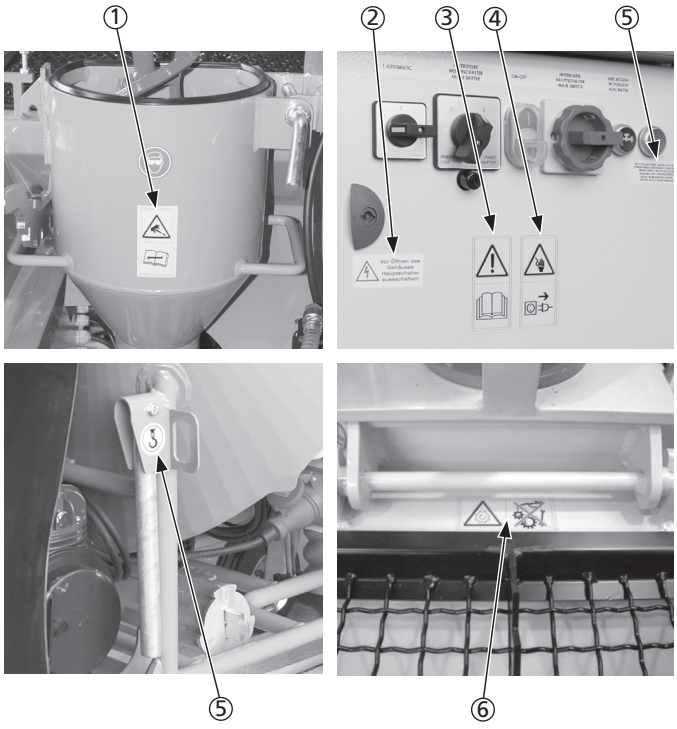
Instructions on the material hopper (6):

- Caution: rotating parts! Do not carry out any maintenance or cleaning work with the machine running or the protective cover removed.

Other notes:

- If there is a risk of frost, drain the water (see water fitting).

Observe all the safety and hazard notices that are attached to the machine. Always keep the safety and hazard notices in a clearly legible condition.



2.4 Personnel qualification

Inotec offers training sessions on operating the inoCOMB Maxi Power. Use INOTEC service for the initial commissioning of the machine; this also serves as an opportunity to provide operators with training on how to operate the mixer.

DANGER **If the inoCOMB Maxi Power is operated by unqualified individuals, this could put the life and health of the operating staff at risk and cause property damage to the inoCOMB Maxi Power or other assets.**

2.5 Responsibility of the operator

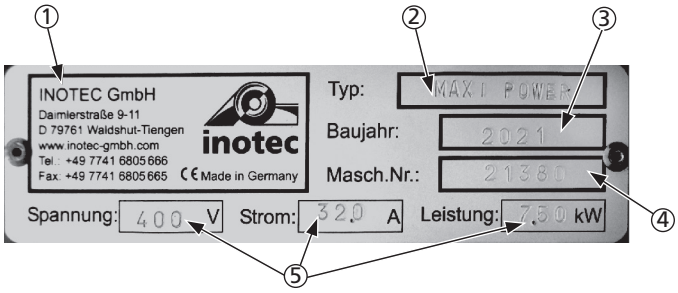
- Only task trained or instructed staff with operating the inoCOMB Maxi Power.
- Define employees' responsibilities for operating, setting up, maintaining and servicing the machine clearly.
- Only task untrained staff or individuals who have not received any instruction with operating the machine when there is a trained or instructed specialist available to supervise them.
- Work on the electronic control system may only be performed by a qualified electrician.
- When using a sprayer, never point it at people or at hazardous objects.

2.6 Personal protective equipment (PPE)

CAUTION **PPE – particularly gloves, safety boots, a safety helmet and safety goggles and respiratory protection – must be used. Even though the inoCOMB Maxi Power mixing pump does not cause any increased noise pollution, we recommend the use of hearing protection on the construction site.**

3 Technical data

3.1 Rating plate



Item	Component	Value
1	Manufacturer, address and contact details, CE marking	-
2	Name and type of machine	-
3	Machine's year of construction	-
4	Machine number	-
5	**Technical data** - Voltage - Current - Output	 400 V 32 A 5.5 kW

You must always state the machine number if you would like to order spare parts, have any queries or would like to make a complaint. You will find this information on the rating plate or on the delivery note.

3.2 Electric control system, pump output, particle size, weight, dimensions

Mains voltage	400 V, 50 Hz
Mains supply line (CEE plug)	32 A (to be supplied by customer)
Pump motor power	5.5 kW
Star feeder motor power	0.55 kW
Fuse	min. 25 A
Delivery rate*	approx. 8-50 l/min. mineral
Delivery range*	up to 50 m
Delivery height*	up to 30 m
external (without compressor)	approx. 250 kg
Dimensions:	
Length	1,050 mm
Width	720 mm
Height	1,530 mm

* Material-dependent and depending on the consistency of the material – observe the material manufacturer's instructions.

3.3 Water measuring system

Pressure being too low	min. 2.5 bar
Pressure reducer ex-works setting	2.0 bar
Solenoid valve	42 V
Supply line	¾ inch water pipe (to be supplied by customer)

3.4 Material hopper

Fill quantity	max. 145 l

3.5 Pump motor

Output/rotation speed	5.5 kW, 419 U/min^{-1}
Installation position	Motor vertical
Electrical data	f = 50 Hz, I = 11.1 A, U = 400 V, IP 55
Insulation class	F, ED = S1
Colour	Black

3.6 Star feeder motor

Output/rotation speed	0.55 kW, 29 rpm
Installation position	Motor horizontal
Electrical data	f = 50 Hz, I = 1.5 A, U = 400 V, IP 55
Insulation class	F, ED = S1
Colour	Black

3.7 Rotor/stator

D6-3	Standard
D4 1/4 output D4 1/2 output D6-3 Helix R7 - 1.5 D8-1.5 D8-2	Depending on the material

3.8 Noise emissions

Sound power level LWA	80 dB (A)

3.9 Operating conditions

Temperature range	2 - 45 °C
Relative humidity, maximum	80 %

4 Assembly and function

4.1 Scope of delivery of inoCOMB Maxi Power set (Item no. 10044216)

The scope of delivery is generated using the components ordered and can be checked using the delivery note.

- Frame, reinforced version
- 4 running wheels
- Material hopper (galvanised)
- Geared motor (with reinforced axial bearing)
- Rotor/stator D 6-3
- Switching cabinet
- Mortar pressure gauge
- Compressor
- Mixing coil
- Water fitting
- Water pump
- Mortar hose Ø 25 mm, 10 m
- Air hose, Ø ½", 15 m
- Tool set
- Straight finishing coat device incl. nozzle with a diameter of 14 mm
- Assembly, spray lubricant
- Operating manual

4.2 Functionality

The mixing pump is filled with powdery material, for instance, bagged goods. The mixing coil and pump unit (rotor/stator) are directly driven by a gear motor. During operation, the powdered material is conveyed from the material hopper over the star feeder into the mixing zone, – where it is mixed with water with the mixing coil – to form a homogeneous, paste-like product. The pump unit (rotor/stator) attached at the lower end of the mixing zone conveys the mixture through flexible conveyor hoses to the spray gun or glue gun. The machine is controlled either pneumatically (via the air valve on the spraying device or electrically via a remote control cable laid from the switching cabinet to the spraying device. Here, the machine is controlled by an on/off switch.

NOTE

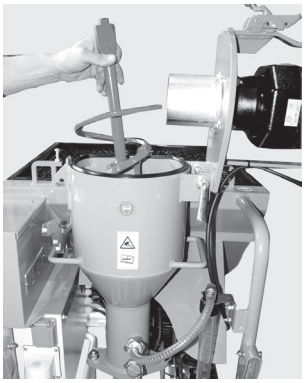
If the machine control is to be changed from electric to pneumatic, the dummy plug must be plugged into the Harting plug of the switching cabinet.

NOTE

Note the optimum assembly sequence.

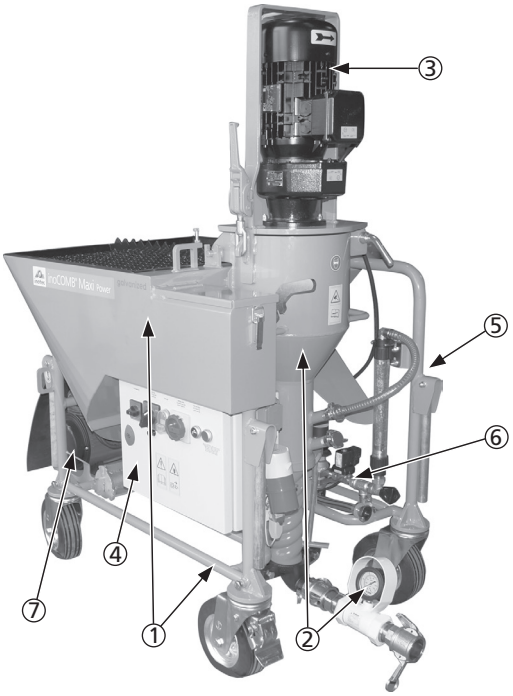
1. Assemble the pump unit (rotor/stator/pressure flange/ pressure gauge) with both tie rods at the lower end of the green mixing zone. For easier installation, the complete mixing zone incl. motor can be placed at an angle.

2. Open the eccentric lock on the motor and move it away to the side. Push the mixing coil into the mixing zone. Then move the motor back again and close the eccentric lock. Ensure that the mixing coil is connected to the motor and rotor of the pump unit via the motor bracket.



3. Connect the input socket to the external (on-site) power supply (400 V / 32 Hz)

4.3 Components

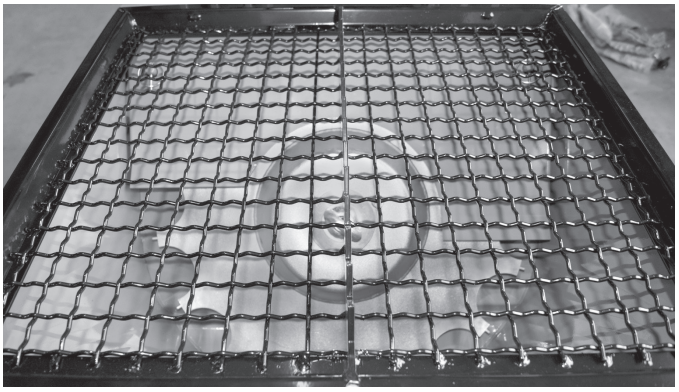


4.3.1 Description of the components

Item	Component
1	Frame with wheels, material hopper, star feeder and star feeder motor
2	Pump unit (mixing zone with mixing coil, rotor / stator with mortar pressure gauge)
3	Mixing pump motor
4	Switching cabinet
5	Air fitting (not visible)
6	Water fitting
7	Compressor

4.3.1.1 Frame with wheels, material hopper, star feeder and star feeder motor

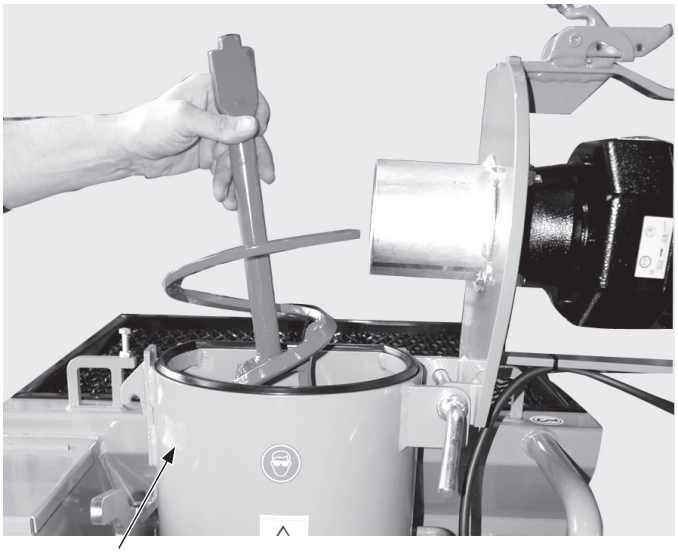
The material hopper, switching cabinet, the mixing pump unit with mixing zone and motor as well as the air and water fittings are assembled on the frame. The star feeder is fixed under the protective grid of the material hopper.



Material hopper with star feeder

4.3.1.2 Mixing pump unit (mixing zone with mixing coil, rotor / stator and mortar pressure gauge)

To insert the mixing coil, open the lateral locking device of the tilting flange and fold down the motor sideways. Depending on the area of application, various rotors and stators are used (see accessories).



Lateral locking of the tilting flange with eccentric lock

4.3.1.3 Pump motor

The motor is attached to the material hopper with an eccentric lock. The power supply for the motor is plugged into the switching cabinet.

4.3.1.4 Switching cabinet

All the necessary connections and controls for operating the machine are located on the switching cabinet. It is firmly screwed to the frame of the machine. The switching cabinet can be removed from the frame for maintenance and repair work.

Connect the power supply plug on the switching cabinet to the external power supply (400 V / 50 Hz). The cross-section of the supply cable is at least 4.0 mm^2 at 400 V 3 PH! The inoCOMB Maxi Power may only be run with an approved FI circuit breaker (30 mA) (RCD).

4.3.1.5 Water fitting

The water fitting is attached to the frame. The optimum water supply quantity is set by opening and closing the needle valve.

4.3.1.6 Air fitting

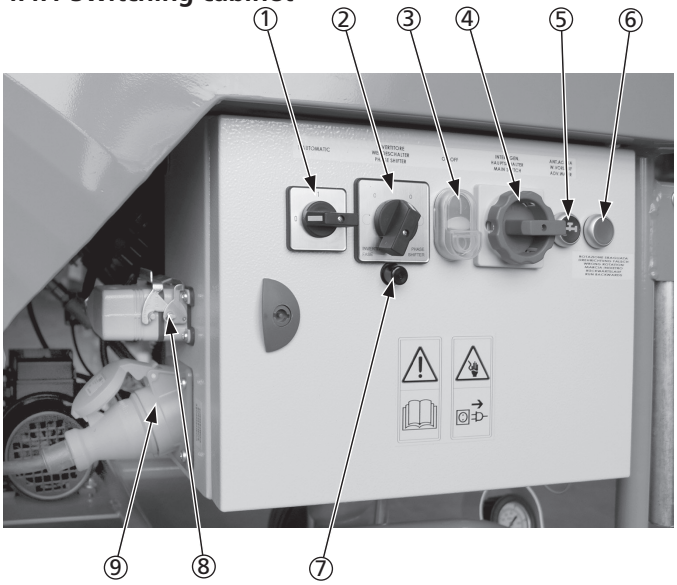
The air fitting is attached to the frame. It is connected to the compressor, which stands on a support frame at the front of the machine.

4.3.1.7 Compressor

A compressor will be required if the mixing pump is to be used for spray applications. This is located at the front on a support frame that is connected to the base frame. The compressor is protected from dust and splash water with a rubber mat.

4.4 Displays and controls

4.4.1 Switching cabinet



Switching cabinet view incl. power supply for compressor (9) and pump motor (8)

Description of the displays, controls and connections

Item	Component
1	Star feeder selector switch
2	Phase-change switch
3	Start-stop button
4	Main and emergency stop switch Horizontal = OFF, vertical = ON
5	"Water supply" push button
6	Return illuminated button
7	Locking button
8	Motor connection socket
9	Socket (400 V) for the compressor

4.4.1.1 Main switch

When you press the main switch (vertical = ON), the machine is powered up and ready for operation.

NOTE **Working with and without electric remote control.**

- When the remote control cable is plugged into the switching cabinet, the machine is switched on and off via the green push button at the end of the remote control cable.

4.4.1.2 Star feeder selector switch

There are two settings:

- 0 = OFF: This setting switches off the star feeder motor and interrupts the material supply to the mixing zone.
- 1 = AUTOMATIC: This setting couples the star feeder to the working cycle of the mixing pump. The star feeder rotates as soon as the pump motor is switched on.

4.4.1.3 Start / stop button

1. Press the green start button ("I") to start the mixing pump.
2. Press the red stop button ("0") to stop the machine.

4.4.1.4 Phase-change switch with locking button

The phase inverter adjusts the direction of rotation of the machine to the power grid on site.

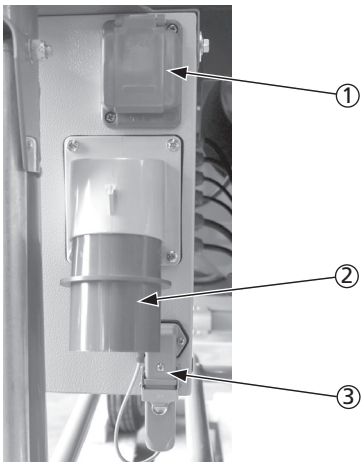
1. Set the main switch to "0" (horizontal).
2. Turn the phase inverter in the opposite direction of its current position and hold down the locking button below the phase inverter switch.

DANGER **The phase inverter may only be operated when the machine is switched off. To do this, turn the main switch to "0" (horizontal).**

4.4.1.5 "Water supply" push button

This push button is used for the manual water feed.

- Pressing this button adds extra water to the mixing zone if required. Keep the push button pressed until the desired amount of water is added.



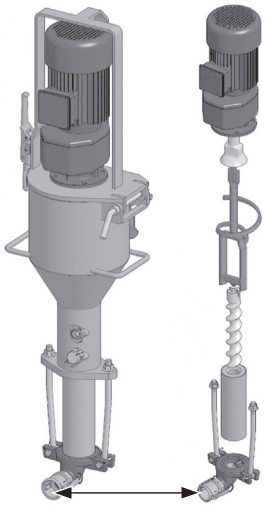
Side view of switching cabinet

Description of the displays, controls and connections

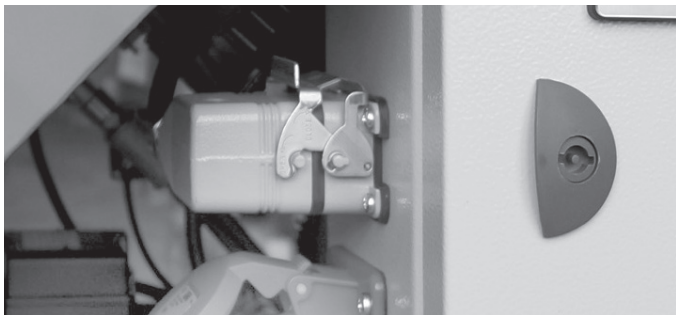
Item	Component
1	Socket 230 V
2	CEE surface-mounted plug 5 x 32 A
3	Remote control socket

4.4.2 Mixing pump unit (motor, mixing coil, rotor/stator and mortar pressure gauge)

The mixing coil is connected to the motor via the drive shaft and rotates during operation in the mixing zone. The mixing coil is also connected to the rotor via a plug-in connection. The mixing coil can be pulled out for cleaning and maintenance work. Before removing the mixing coil, switch off the machine and pull out the mains plug. The choice of mixing coil (see accessories) depends on the planned application. The mortar pressure gauge is used to monitor and display the pressure in the conveyor hose.



This image illustrates the connection from the motor to the mixing coil, and from the mixing coil to (rotor/stator).



Power is supplied to the motor via a plug-in connection to the machine's switching cabinet.

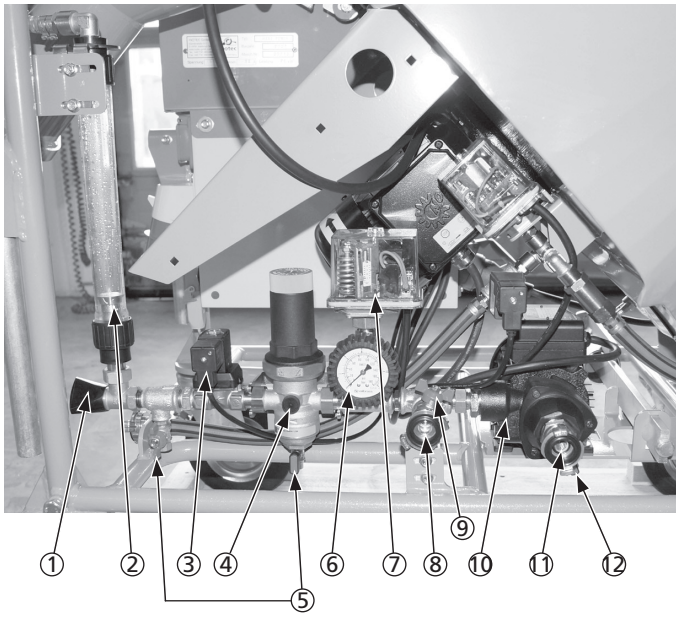
DANGER

Rotating mixing shafts.
Danger of death due to being pulled into the machine and crushed.
When the motor is running, the mixing shaft rotates in the mixing zone!

- Do not reach into the rotating mixing shaft.
- Do not place any objects into the rotating mixing shaft.

1. Before working on the metering and mixing shaft, interrupt the external power supply (main switch off).
2. Pull out the mains plug.
3. Secure the machine against unexpectedly being switched back on.
4. Open the eccentric lock on the motor and move it away to the side.

4.4.3 Water fitting



Description of the components in the diagram

Item	Component
1	Fine adjustment valve
2	Flow meter
3	Solenoid valve
4	Pressure reducer
5	Drainage valve
6	Pressure gauge
7	Pressure switch
8	Connection for the external cleaning hose
9	Ball valve
10	Pressure booster pump
11	Main connection of the external water supply (min. 3.0 bar water pressure)
12	Drainage valve

4.4.4 Installing the water fitting

1. Connect the supply hose to the external water supply.
2. Open the water valve until a steady water jet comes out of the hose in order to both clean the water hose of dirt and ventilate it.
3. Then close the water valve on the external water supply.
4. Connect the external water hose to the GEKA coupling of the water fitting (11).
5. Close both the water drainage valve below the pressure reducer (5) and below the main connection (12).
6. Connect the internal water hose to the GEKA coupling on the mixing zone.

NOTE **To ensure sufficient water pressure regardless of the pressure of the supply line, the machine is equipped with a pressure booster pump.**

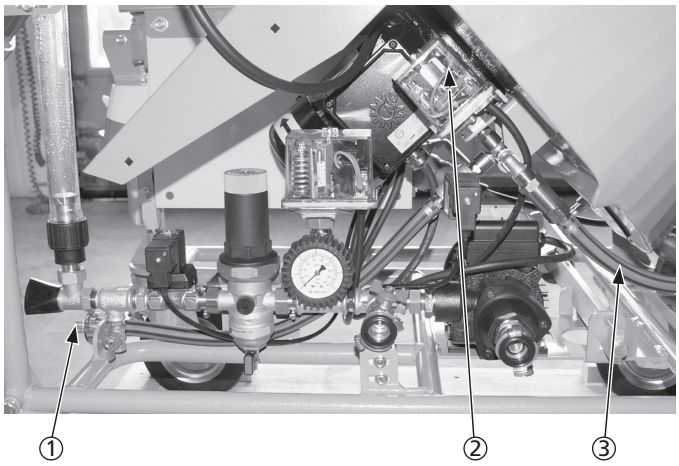
WARNING **Water jet.**

Risk of injury and risk of property damage due to escaping water.

1. Interrupt the external water supply by closing the water valve.
2. In order to release the pressure (approx. 2 bar), open the water drainage valve on the water measuring system under the pressure reducer.
3. Only remove the hose from the external water supply when the pressure gauge shows "0" bar.
4. Do not point the water jet at other people or yourself.

4.4.5 Air fitting

1. Use the air connection (1) to supply a sprayer.
2. Check that the connections fit together before connecting the air hose. If necessary, replace them with suitable connections.
3. The pressure switch (2) is pre-set at the factory and switches the machine on and off.



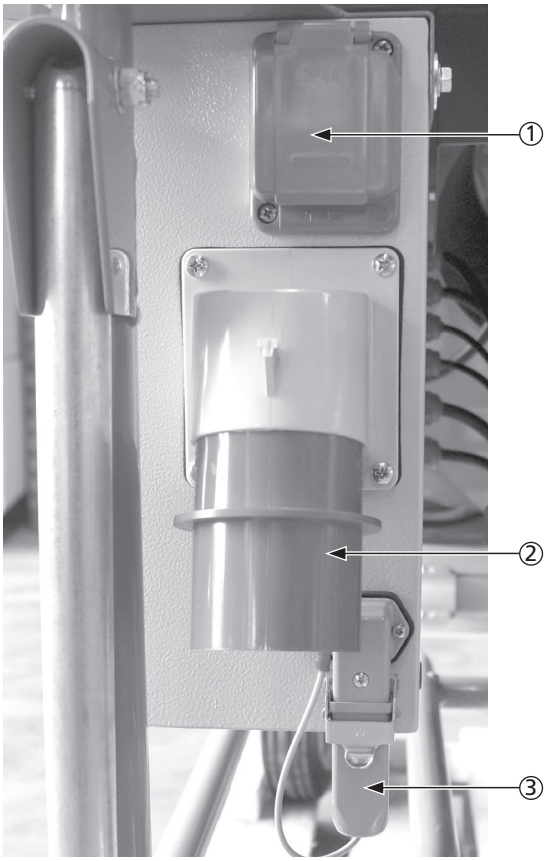
4.4.6 Compressor

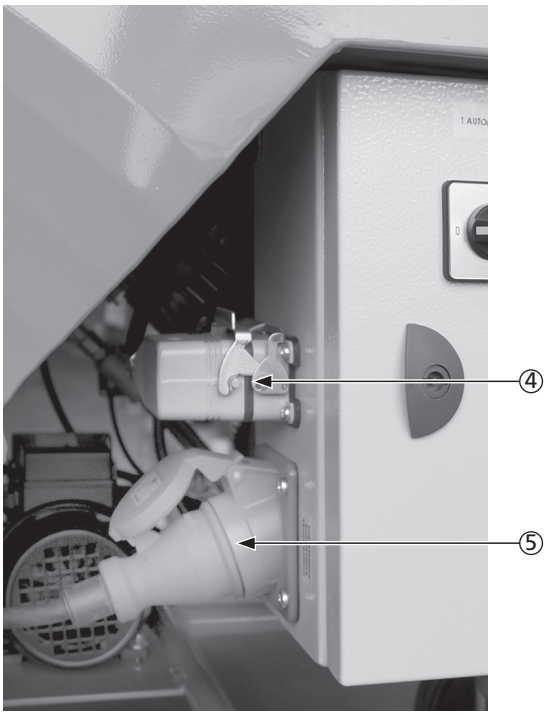
There is an "ON/OFF" switch on the compressor.

4. Set this switch to "ON" to operate the mixing pump.
5. Set this switch to "OFF" in case of faults or maintenance work.

4.5 Connections

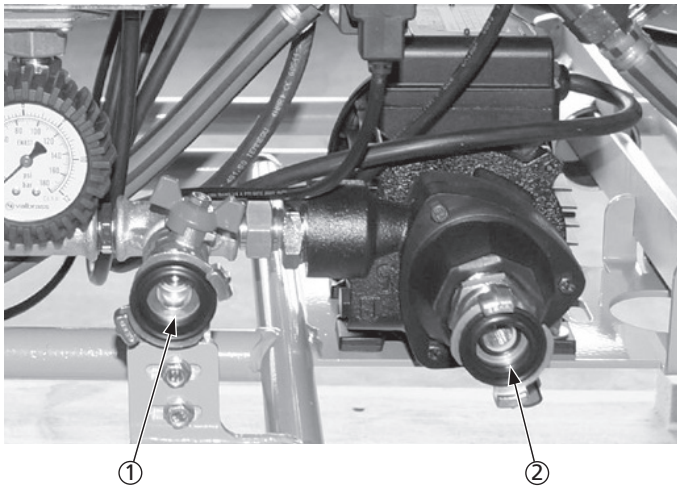
4.5.1 Power connections (230 / 400 V)





230 V connection socket (1) for optional external devices, 400 V attachment plug (2) for the central power supply of the mixing pump, remote control socket with dummy plug (3), plug for the pump motor (4) and socket for the compressor (5).

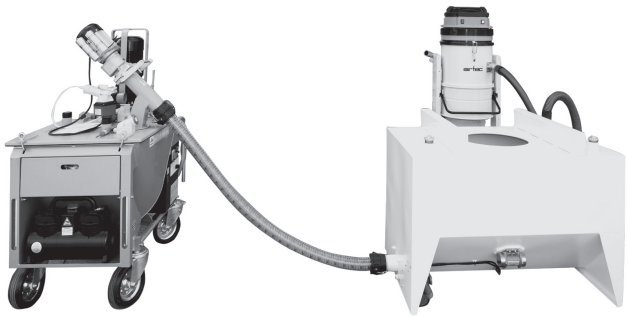
4.5.2 Water fitting connections



Connection for an external cleaning hose or connection of the conveyor hose via a coupling piece for cleaning the hose by means of a sponge ball (1), connection of the external water supply (2).

4.6 Operating modes

The inoCOMB Maxi Power can be fed with powdery material from bags, one-way containers (with the dry conveying unit inoFLEX Mono), big bags (with the Big-Bag-Box Mono) or silos (with a conveyor system).



Material loading of a mixing pump from a Big-Bag-Box Mono with the inoFLEX Mono dry conveying unit.

4.7 Accessories

The following accessories can be supplied for the inoCOMB Maxi Power.

Water/air hose
- For universal use, e.g. air, water
- GEKA couplings crimped with sleeves on both sides

Technical data:
Max. operating pressure: 15 bar
Temperature range: -20 up to +90°C

Ø	Length	Item no.
1/2"	10 m	**10022000**
1/2"	15 m	**10022001**
1/2"	20 m	**10022002**
3/4"	20 m	**10022011**

Ultralight hose

- with mortar coupling

Ø	Length	Item no.
25 mm	10 m	**10043874**

INOTEC mortar hose
- Abrasion-resistant special hose for pumping highly pressurised wet mortar; largely kink-proof
- For an operating pressure of 40 bar with 3 times the reliability
- Yellow on the outside: less heat builds up in the event of sun exposure
- With mortar hose, M-piece couplings and rotating V-piece (only at Ø 25 mm)
- With cam levers on the M-piece

Technical data:
Operating pressure: 40 bar
Bursting pressure: 120 bar

Ø	Length	Item no.
25 mm	10 m	**10008346-001**
25 mm	15 m	**10008346-002**
25 mm	20 m	**10008346-003**
35 mm	10 m	**10022032**
35 mm	20 m	**10008346-007**

Flushing hose
- For clearing blockages in mortar hoses

Length	Item no.
10 m	**10024385**

400 V / 5 x 4 mm² extension cable
- 32 A plug and socket

Length	Item no.
20 m	**10015201**

Remote control cable with remote control switch

Length	Item no.
16 m	**10042464**
32 m	**10042465**

Remote control extension cable without remote control switch
- For remote control cable
- For remote control switch
- For inoCOLL one-handed gun

Length	Item no.
16 m	**10015210**
32 m	**10042463**

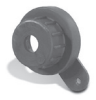
Remote control switch
- With 0.2 m cable, indicator light and 4-pole Harting plug

Item no.
10015134

Plastic starting hose connector with V Part 35

Ø	Length	Item no.
35 mm	0.3 m	**10038433**

	**Hose holder** • For rapidly fixing hoses to the scaffold	**Item no.** **10018503**
	**inoCOLL one-handed gun** • For bonding and basecoat mortars • Whip hose 2 m, Ø 19 mm with an LW 24 mortar connection coupling suitable for a 25 mm mortar hose • For particle sizes up to 1.5 mm	**Item no.** **10024144**
	**inoCOLL PRO one-handed gun** • For applying reinforcing mortar and finishing plaster up to 4 mm particle size • Operating pressure: up to 40 bar	**Item no.** **10041950**
	**Spray attachment for inoCOLL / PRO one-handed gun** • For spraying mineral and paste-like products • With 10 mm nozzle	**Item no.** **10039322**
	**Short spray pipe with mortar coupling 25 mm** Short, lightweight spray pipe with L24 coupling for spraying paste-like materials. Thanks to the special nozzle geometry, a small compressor (air flow rate from 200 l/min.) is sufficient to achieve a very good spray pattern. The air quantity can be regulated using the integrated mini ball valve. • For particle sizes up to 3 mm • Suitable for a 25 mm mortar hose **Scope of delivery:** Short spray pipe with 2 m whip hose (Ø 19 mm), with mortar coupling 25 mm and 2 m air hose with GEKA coupling, <u>without</u> nozzles	**Item no.** **10039887**
	**Nozzles for:** **- Spray attachment for inoCOLL / PRO one-handed gun (10039322)** **- Short spray pipe with mortar coupling 25 (10039887)** **- Angled spray head with GEKA coupling (10039457)** • Made from stainless steel * For particle sizes up to 6 mm	**Ø** / **Item no.** 4 mm / **10039271** 5 mm / **10042461** 6 mm / **10039220** 8 mm / **10039221** 10 mm / **10039222** 13 mm* / **10040941**
	**MAI finishing coat device,** straight • With 25 mm M-piece coupling • Including a 14 mm jet nozzle	**Item no.** **10024362**
	**First aid set for plastering machines in the systainer** **Scope of delivery:** Sealing systems for coupling (5 x 25 mm & 2 x 35 mm), fine plaster nozzles (each 2 x 12 mm & 14 mm), 5 x GEKA sealing system with beaded edging (1 x 1" IT, 2 x 1/2" nozzle, 1 x 3/4" IT, 2 x 3/4" nozzle), 1 x GEKA 1/2" injection nozzle, 1 x special assembly lubricant spray (400 ml can), 2 x cam levers with lock ring, plaster piece (each 1 x 25 V part & 35 M-piece with GEKA coupling), 2 x combination wrenches (19 mm), hose clamps (each 5 x 1/2" & 3/4" clamping range), 1 x screwdriver for slotted screws, sponge balls (5 x 30 & 2 x 45 mm RG250), 5 x clamping sleeves (6 x 30), 1 x pin punch (5 mm), 1 x keyhole saw (5 mm).	**Item no.** **10043925**

	**Jet nozzle** • For MAI finishing coat device	**Ø**	**Item no.**
		10 mm	**10024378**
		12 mm	**10024379**
		14 mm	**10024380**
		16 mm	**10024381**
	**Straight finishing coat device** • With 25 mm M-piece coupling • incl. 14 mm finishing coat nozzle		**Item no.**
			10024098
	**Finishing coat nozzles** • For finishing coat devices, item nos.: 10024098	**Ø**	**Item no.**
		10 mm	**10024089**
		12 mm	**10024090**
		14 mm	**10024091**
		16 mm	**10024093**
	**Straight decorative plaster spraying device** • Not including nozzle with 25 mm M-piece coupling • For particle sizes up to 6.0 mm		**Item no.**
			10024246
	**Nozzle for straight decorative plaster spraying device** • Made from stainless steel	**Ø**	**Item no.**
		8 mm	**10024071**
		10 mm	**10024065**
		12 mm	**10024066**
	**Finishing coat device, long version** • With offset tip • Including a 12 mm nozzle		**Item no.**
			10040697
	**Static mixers** • Prevents/destroys lumps in mortar • Diameter: 35 mm • Length: 200 mm • Including M-piece coupling 35 mm, and V-piece 35 mm		**Item no.**
			10042362
	**35 V -> 25 V reducer coupling** • For connecting two mortar hoses or reducing the machine outlet.		**Item no.**
			10022101
	**Plaster piece with GEKA coupling** • For cleaning mortar hoses		**Item no.**
		25 V-piece	**10022113**
		35 M-piece	**10022114**
		25 M-piece	**10022112**
	**Sponge balls (soft version)** • For cleaning material / mortar hoses	**Ball Ø**	**Hose Ø**	**Item no.**
		14 mm	13 mm	**10008116-001**
		20 mm	19 mm	**10008116-003**
		30 mm	25 mm	**10008116-004**
		45 mm	35 mm	**10008116-005**

Sponge balls (firm version)
• For cleaning material / mortar hoses

Ball Ø	Hose Ø	Item no.
30 mm	25 mm	**10008116-007**
45 mm	35 mm	**10008116-008**

INOTEC Compact C 330 PP compressor, 230 V including pressure switch
The compact 230 V compressor is excellently suited to a multitude of applications, such as spraying decorative coats, plasters, etc.
Technical data:

Operating pressure:	10 bar
Suction capacity:	330 l/min
Output:	2.05 kW
Dimensions (L x W x H):	396 x 473 x 598 mm
Weight:	approx. 32 kg

Item no.
10041150
* as auxiliary compressor

Handy K2 compressor, 400 V, with pressure switch
Mobile, universal use diaphragm compressor for the production of oil-free compressed air. Used in many mixing pumps due to its low maintenance and compact design.
Technical data:

Operating pressure:	5.5 bar
Suction capacity:	250 l/min
Output:	0.9 kW
Dimensions (L x W x H):	495 x 165 x 340 mm
Weight:	23.5 kg

Item no.
10023102

KAESER 230 V Compressor Premium Car 450/30W - with pressure switch
The compact 230-volt compressor is ideal for many applications, such as spraying decorative coatings, plaster or bitumen, for operating compressed air tools, and for painting, etc.
Technical data:

Operating pressure:	10 bar
Suction capacity:	450 l/min
Output:	2.2 kW
Dimensions (L x W x H):	870 x 560 x 590 mm
Weight:	86 kg

Item no.
10039227
* as auxiliary compressor

Injection hood inoCOMB M4G / Maxi Power / G4
consisting of:
• Injection hood
• Rotor sensor
• 50 m control cable for rotor sensor

Item no.
10044221

Mobile delivery system for inoTRANS FF 140
corrosion-resistant (galvanised & powder-coated) free-fall silos
Technical data:
Operating voltage: 400 V / 50 Hz
Nominal rating: 7.5 KW
Fuse: 25 A
Dimensions (L x W x H): 1,220 x 650 x 625 mm
Suction capacity: approx. 140 m³/h
Conveying vessel volume: 70 l
Dimensions: 800 x 540 x 910 mm
Weight of compressor (dry rotor, oil-free with additional air filter), frame and switching cabinet: 208 kg, weight of the conveying vessel: 88 kg
Scope of delivery: Conveying system, conveying vessel (maintenance-free), rotary compressor, connecting hose approx. 3 m with GEKA coupling
The conveying vessel of the **inoTRANS FF 140** mobile conveying system is docked directly to the free-fall silo with quick-release fasteners. Approximately 70 litres of material flows through the open shut-off valve into the conveying vessel, where it is mixed with air and conveyed dust-free at a force of 1.4 bar through a conveyor hose to the mixing pump. Here the material is mixed with water and then pumped on-site. A level probe in the mixing pump tank monitors the level and ensures automatic replenishment.
Areas of application: Suitable for gypsum, lime and cement plasters

Item no.
10044217

Mobile delivery system for inoTRANS P 140 pressure silos
corrosion-resistant (galvanised & powder-coated) free-fall silos
Technical data:
Operating voltage: 400 V / 50 Hz
Nominal rating: 7.5 KW
Fuse: 25 A
Dimensions (L x W x H): 1,220 x 650 x 625 mm
Suction capacity: 140 m³/h
Weight of compressor (dry rotor, oil-free with additional air filter), frame and switching cabinet: 198 kg, weight of the conveyor block: 28 kg
Conveyor block dimensions: (L x W x H) 520 x 360 x 460 mm
Scope of delivery: Delivery system, conveyor block, rotary compressor, 7 m control cable, 3 m silo connection hose (with GEKA coupling), 3 m conveyor block connection hose (with GEKA coupling).
The conveyor block of the **inoTRANS P 140** mobile conveyor system is docked to the pressure silo outlet with standard couplings. The rotary compressor supplies the pressure silo with 1.8 bar operating pressure, which guarantees a continuous material discharge. The dry material is conveyed through a gypsum delivery hose to the mixing pump with a force of 1.2 bar. Here the material is mixed with water and then pumped on-site. A level probe in the mixing pump tank monitors the level and ensures automatic replenishment.
Areas of application: Suitable for long delivery ranges up to 120 m and materials that are difficult to convey

Item no.
10044218

*** On request:**
INOTEC gypsum delivery hose (complete with C couplings)
For delivering dry mortar from the silo to the plastering machine via the delivery system. Abrasion-resistant, flexible at low temperatures, for a BP of 10 bar. Featuring C couplings with special grommets integrated on both sides that guarantee a transition-free flow of material.
Technical data:
Hose dimensions: 42 x 7 mm, operating pressure: up to 10 bar

Length	Item no.
10 m	**10008342-002**
20 m	**10008342-001**

Mixing coil

Item no.
• Standard mixing coil for inoCOMB Maxi Power — **10039464**
• Standard insulation plaster for inoCOMB Maxi Power — **10023186**

Rotor D4-¼ output
• Head marked in black

Item no.
10022534

Stator D4-¼ output (maintenance-free) — **10022524**

Rotor D4-½ output
• Head marked in green

Item no.
10022543

Rotor D4-½ output, with attachment points for after mixers
(applies only to stator D4-½ with clamping strip art. no. 10022501)
• Head tipped in green

10022546

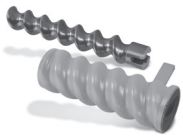
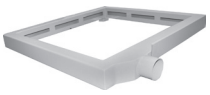
Stator D4-½ output (maintenance-free) — **10022502**

Stator D4-½ output, with clamping strip — **10022501**

Rotor D6-3 C45

Item no.
10022555

Stator D6-3 (maintenance free) — **10022511**

	**Rotor D6-3 Helix** • Head marked in orange	**Item no.** **10036994**
	D6-3 Helix orange stator	**10036995**
	**Rotor R7-1.5**	**Item no.** **10022887**
	Stator R7-1.5 (maintenance-free)	**10022522**
	**Rotor D8 - 1.5** • Head marked in yellow	**Item no.** **10022562**
	Rotor D8 - 1.5 with attachment points for after mixers	**10022563**
	**Stator yellow D8 - 1.5 (maintenance-free)**	**10022517**
	**Stator yellow D8-1.5 with clamping strip**	**10022519**
	**Rotor D8-2 (maintenance-free)**	**Item no.** **10022565**
	Stator D8-2 (maintenance-free)	**10022496**
	**Mixing pipe cleaner for Picco Power / Maxi Power / G4 / M4G**	**Item no.** **10043833**
	Cleaning rod (520 mm) for Maxi Power / G4 / M4G	**10023279**
	**Dust catcher MP as funnel attachment for inoCOMB MaxiPower** for reducing dust pollution by up to 80 % when filling the mixing pump with bagged material. **Scope of delivery:** Frame for mounting on the material hopper, with connection pipe for industrial vacuum cleaner	**Item no.** **10044336**
	**Industrial vacuum cleaner KV-3500-EL-LP** **Technical data** Operating voltage: 3 x 1.2 kW / 230 V / 50 Hz / 16 A Filter surface area: 3 m² Filter class: H Dimensions: 760 x 600 x 1,570 mm (D x W x H) Weight: approx. 83 kg Dust container: Longopac **Scope of delivery:** Vacuum, Longopac, 5 m hose Ø 50 mm, suction nozzle, angled suction pipe, straight suction pipe	**Item no.** **10043881**
	**Big-Bag-Box Mono** The Big-Bag-Box Mono is filled by means of standard big bags **Scope of delivery:** Frame with material hopper, vibrating unit (2 pieces), 230 V double adapter for vibrating units, threaded connector for inoFLEX Mono, connection for industrial vacuum cleaner	**Item no.** **10044205**
	**inoFLEX Mono dry delivery unit** **- for inoCOMB Maxi Power, PFT G4 mixing pumps** The flexible **inoFLEX Mono** delivery shaft transports the material to be processed from the Big-Bag-Box Mono directly into the mixing pump hopper. **Scope of delivery:** OWC Camlock couplings, flexible hose, approx. 2 m, delivery shaft, probe control system with rotor probe, gear motor, transition hood with transition connecting piece	**Item no.** **10041948**
	**Assembly spray lubricant** • For assembling the rotor and stator • 400 ml	**Item no.** **10004591**

4.8 Spare parts and diagrams

The spare parts for the inoBEAM inoCOMB Maxi Power are designated with numbers in the following images. The individual items are described in the table under the respective diagrams.

Description of the table columns:

Item: Corresponds to the number in the drawing designating a spare part.

Item no.: INOTEC item number.

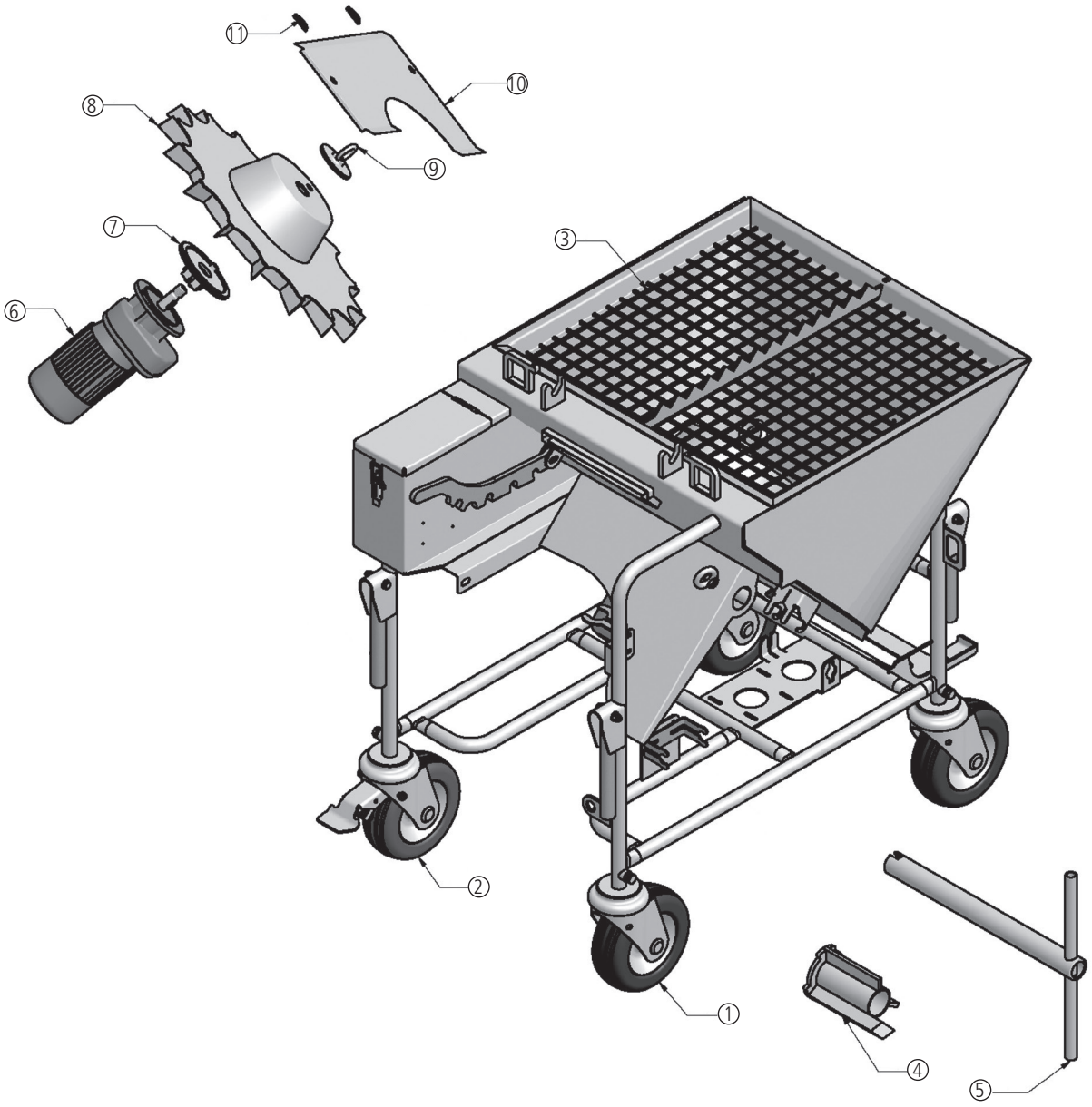
Installation quantity: number of parts of this item when installed in the original inoCOMB Maxi Power.

UQ: Unit of quantity of this item.

Name: Name of the spare part.

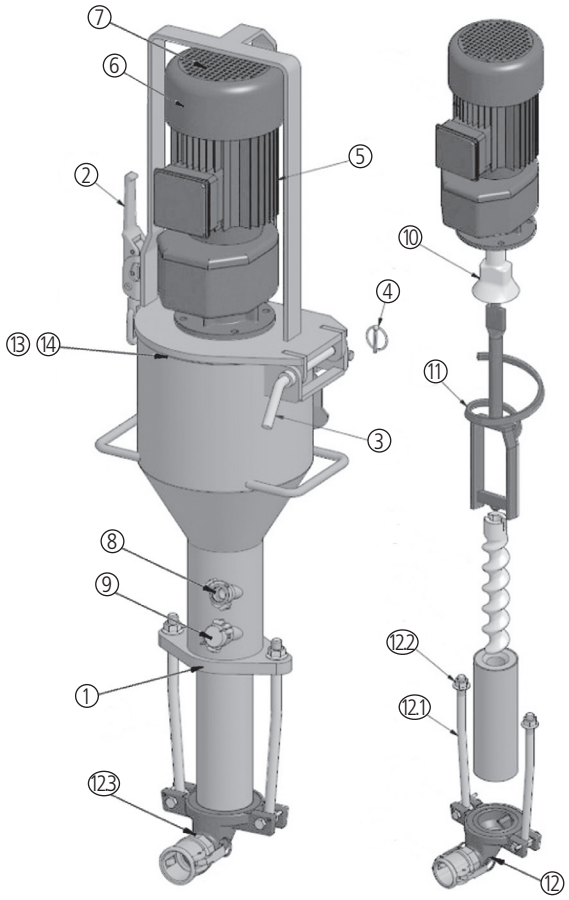
NOTE **Use the order form at the end of this operating manual to order spare parts.**

4.8.1 Overview of frame with material hopper and star feeder



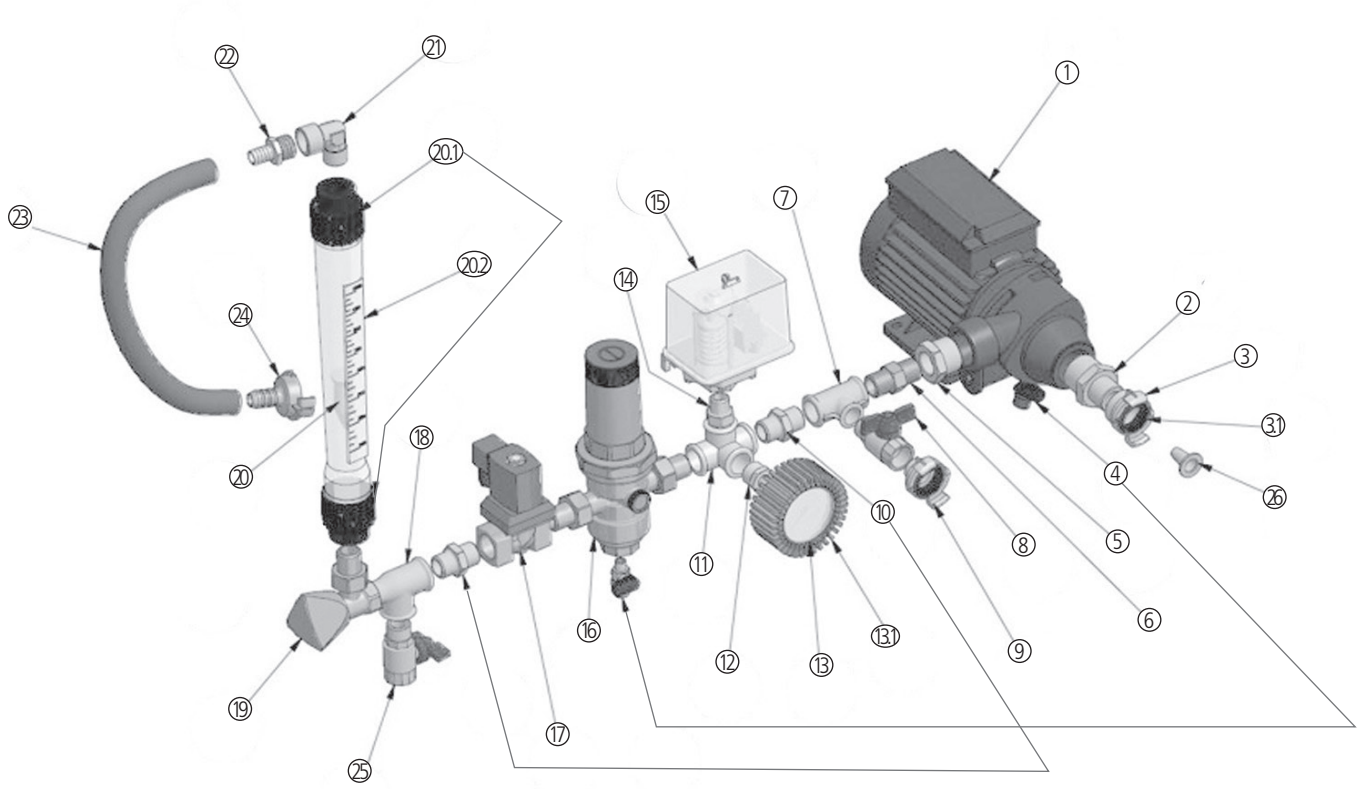
Item	Item no.	Installation quantity	UQ	Name
1	-	1	Units	Castor Ø 200
2	-	1	Units	Castor Ø 200 with brake
3	-	1	Units	Insertion grid
4	10023279	1	Units	Cleaning shaft
5	10043833	1	Units	Mixer cleaner
6	-	1	Units	Gear motor, 0.55 kW, black without cable
7	10023620	1	Units	Star feeder fastening plate
8	10023619	1	Units	Star feeder, grey RAL7037
9	10023622	1	Units	Star feeder ring nut
10	-	1	Units	Anti-dust sheet, grey RAL7037
11	10024516	1	Units	Split pin Ø 5 mm

4.8.2 Mixing zone spare parts list



Item	Item no.	Installation quantity	UQ	Name
1	- -	1	Units	Flange for screw jacket "D" or Flange for screw jacket "R"
2	10017070	1	Units	Tension lock galv. cpl.
3	-	1	Units	Bolt
4	10024516	1	Units	Split pin
5	10044290	1	Units	Geared motor, 5.5 kW "AL" black + cable + plug 6 pol.
6	-	1	Units	Fan wheel for geared motor
7	-	1	Units	Fan hood for geared motor
8	10022370	1	Units	Geka coupling IG 1"
9	10022363	1	Units	Dummy coupling, Geka
10	10044176	1	Units	Tappet bracket – 25 mm
11	10039464	1	Units	Standard mixing shaft
12	-	1	Units	Material outlet 1 1/2" cpl. (Coupl. DN35 MT) for "D+R"
12.1	-	2	Units	Material outlet tension anchor
12.2	10005228	2	Units	M16 collar nut
12.3	10022060	1	Units	M-piece coupling 35, 1 1/2", IT
13	10022720	1	Units	Tilting flange seal
14	10022711	1	Units	Mixing chamber material inlet seal

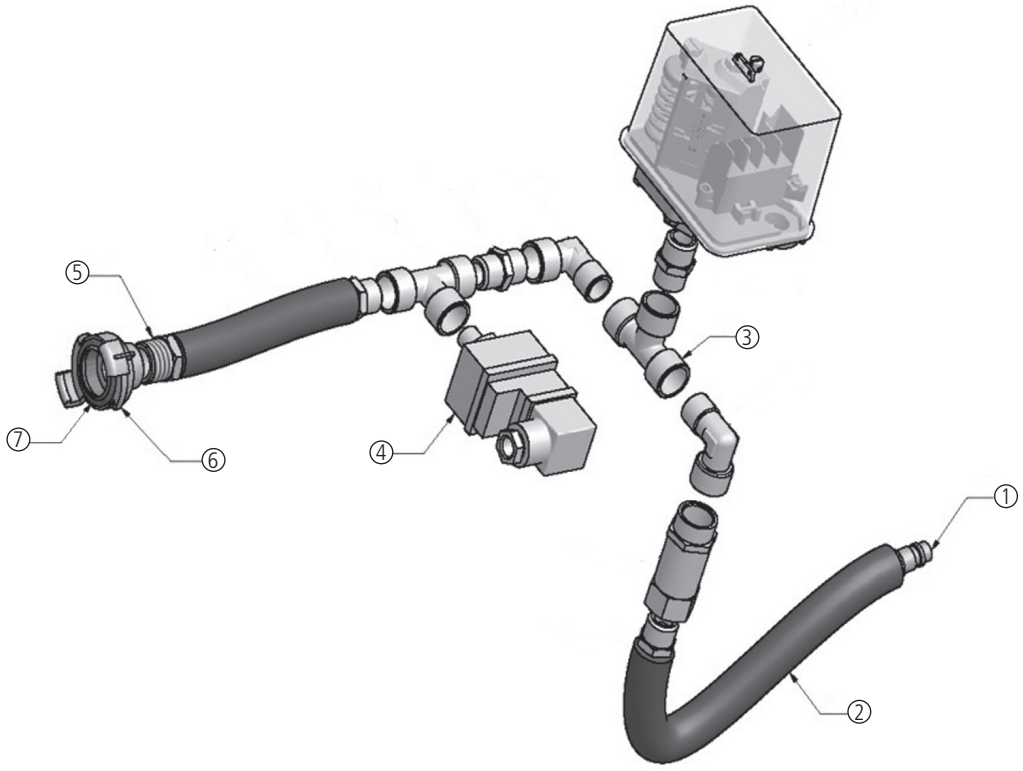
4.8.3 Water fitting



Item	Item no.	Installation quantity	UQ	Name
1	10042683	1	Units	Pressure booster pump
2	10022282	1	Units	Reduction nipple 1″ ET - 3/4″ ET
3	10022378	1	Units	GEKA coupling 3/4″ IT
3.1	10004149	1	Units	GEKA seal
4	-	1	Units	Ball valve 1/8″
5	-	1	Units	Reducer 1″ - 1/2″
6	-	1	Units	Screw connection 1/2″
7	10006494	1	Units	T-piece 1/2″
8	10022412	1	Units	Ball valve 1/2″
9	10022372	1	Units	GEKA coupling, 1/2″ IT
10	10021166	1	Units	Double nipple 1/2″
11	10006479	1	Units	T-manifold 1/2″ IT
12	10006478	1	Units	Reducer 1/2″ - 1/4″
13	10017821	1	Units	0 - 12 bar pressure gauge, axial
13.1	10017855	1	Units	Pressure gauge rubber protection
14	10022276	1	Units	Double nipple 3/8″ - 1/2″
15	10015434	1	Units	Pressure switch
16	10039020	1	Units	Pressure reducer D06 FN 1/2″
16.1	10006518	1	Units	Replacement sieve
16.2	10006515	1	Units	Seal for D06 FN sieve cup
17	10023114	1	Units	Solenoid valve 6213 42V 1/2″

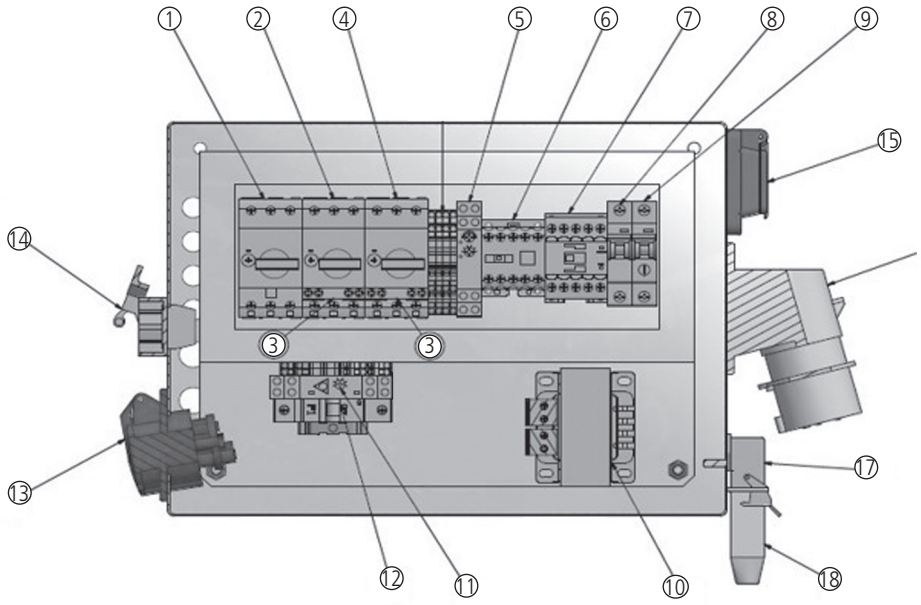
Item	Item no.	Installation quantity	UQ	Name
18	10006493	1	Units	T-piece 1/2" ET -1/4" IT - 1/2" IT
19	10023222	1	Units	Fine adjustment valve 1/2"
20	10023598	1	Units	Complete flow meter 150-1500 lt
20.1	10023072	1	Units	Measuring tube 150-1500 lt
20.2	10023278	2	Units	Reducer
21	10006497	1	Units	Angle 90° IT-ET 1/2"
22	10006470	1	Units	Hose nozzle 14-1/2"
23	10021968	0.36	Meter	Spiral hose 1/2" 360 mm
23.1	10022454	2	Units	Hose clamp 1/2"
24	10022374	1	Units	GEKA coupling, 1/2" PT
25	-	1	Units	Ball valve 1/4"
26	10023377	1	Units	Insertion sieve

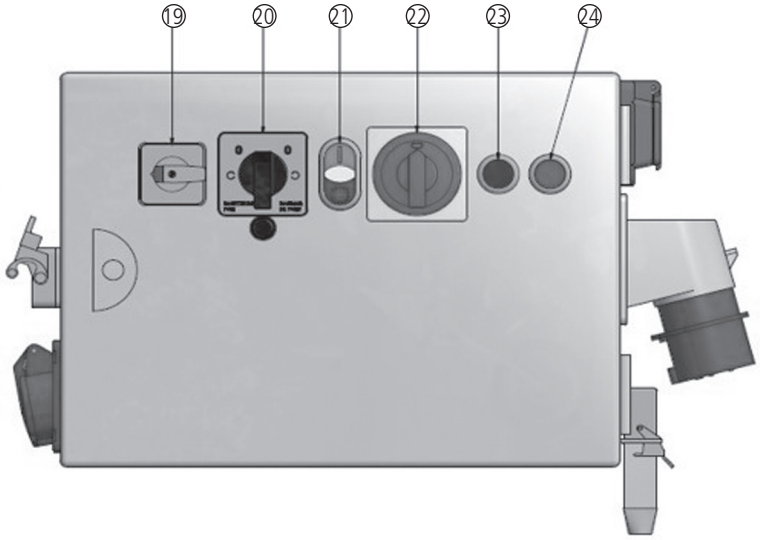
4.8.4 Air fitting



Item	Item no.	Installation quantity	UQ	Name
1	10022200	1	Units	EWO plug V 1/2"
2	10021968	0.4	Meter	Air hose 1/2"
3	10015434	1	Units	Pressure switch FF 4-4 3/8"
4	-	1	Units	Pressure switch PS3
5	10021968	0.43	Meter	Air hose 1/2"
6	10006470	1	Units	Hose nozzle 14 - 1/2"
7	10022373	1	Units	GEKA coupling, 1/2", IT

4.8.5 Switching cabinet





Item	Item no.	Installation quantity	UQ	Name
		1	Units	Switching cabinet inoCOMB Maxi Power cpl.
1	10038262	1	Units	Water pump motor protection switch PKZM 0 - 1.6A
2	10016000	1	Units	Motor protection switch for star feeder motor PKZM 0 - 2.5A
3	-	2	Units	Auxiliary contact NHI-E10 PKZ0
4	10015998	1	Units	Pump motor protection switch PKZM 0 - 16A
5	-	1	Units	Time relay 24-240VAC/DC
6	10023417	1	Units	Contactor DIL EM10 42V
7	10039483	1	Units	Contactor DIL M15-10 42V

Item	Item no.	Installation quantity	UQ	Name
8	-	1	Units	Circuit breaker 0.5A
9	10037942	1	Units	Circuit breaker 1A
10	-	1	Units	Control transformer 400/42 V
11	10037361	1	Units	Phase monitoring relay 400V
12	-	1	Units	Circuit breaker 16A 1P+N
13	-	1	Units	Mounted socket 4x16A
14	10015619	1	Units	Mounted socket 6-pole
14.1	10015400	1	Units	Coupling insert 6-pole
15	-	1	Units	Schuko 230V mounted socket
16	-	1	Units	Mounted plug 5x32A 400V
17	10015616	1	Units	Housing mounting angle 90° 4/5 - pole
17.1	10015398	1	Units	Coupling insert 4-pole
18	10016247	1	Units	Plug insert 4-pole
19	-	1	Units	Star feeder switch 0-I
20	10037360	1	Units	Phase-change switch
21	-	1	Units	Complete on-off button
21.1	10006375	1	Units	On-off button
21.2	10006369	1	Units	On-off button rubber protection
22	-	1	Units	Main switch 32A
23	-	1	Units	“Water supply” push button cpl.
24	-	1	Units	“Return” red illuminated push button cpl.

NOTE

Use the order form at the end of this operating manual to order spare parts.

5 Transport and storage

5.1 Safety notices for transport

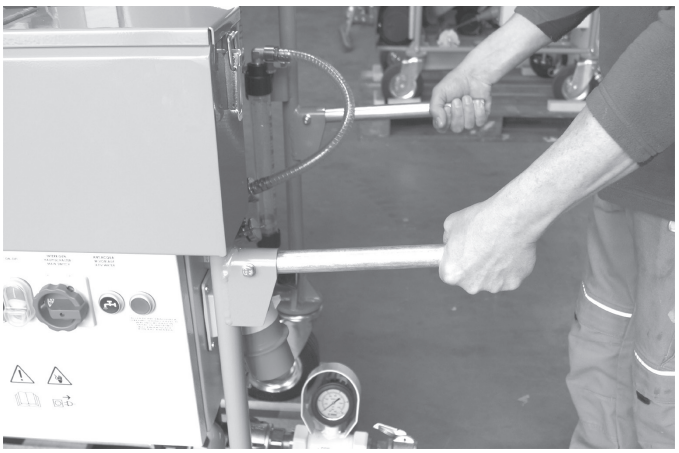
DANGER **Slipping machine**

Danger of death for drivers and transport users.

- Ensure that the machine is in a secure position during transport.
- Secure the machine against slipping.
- Choose a means of transport that has sufficient load capacity.

NOTE **The inoCOMB Maxi Power can be transported as a complete machine or broken down into individual segments.**

- The inoCOMB Maxi Power is equipped with four wheels. Convenient handles are fitted at all four corners for moving the whole machine.



- When transporting the machine in individual segments, the mixing zone, the frame with material hopper, the compressor and, if necessary, the star feeder can be transported separately.
- If a lifting device is used for transport, the attachment points provided for this purpose must be used.

The attachment points are marked with this pictogram.

WARNING **Risk of injury posed by carrying or lifting machine**

- The machine weighs over 250 kg. To prevent overloading and damaging the spine, at least 4 people must move the machine.

5.2 Transport inspection

NOTE **Check the machine to ensure that all components are present and for transport damage immediately upon receipt.**

- Do not leave any parts in the packaging.

5.3 Damage report

Proceed as follows in the event of externally visible transport damage:

1. Write a damage report with the following details:
   - Your client address
   - Name of the transport company and the driver
   - Date and time of the delivery
   - Order number and machine name according to the delivery note
   - Description of the damage
   - Signature of the driver
   - Signature of the recipient at the customer's premises
2. Have the transport damage confirmed by means of the driver's signature.
3. Send one copy of the damage report to the transport company and another to Inotec GmbH.
4. And clarify the possible ways in which the damage could be remedied with one of our service centres (see second last page)

5.4 Complaints

Claims for compensation relating to transport damage can only be made if the delivery company is informed of the same without undue delay.

5.5 Packaging

The new machine will be shipped cellophane-wrapped on a Euro pallet.

- Dispose of the packaging material as required by law.

5.6 Transport of the used machine in vehicle

DANGER **Slipping machine.**
Danger of death for drivers and transport users.

1. Ensure that the machine is stored securely during transport.
2. Secure the machine against slipping.
3. Choose a means of transport that has sufficient load capacity.

NOTE **Leaking material residue**

- Clean the machine before transport.
- Secure the machine in the vehicle using suitable fixing materials.

5.7 Storage

If the machine is not likely to be used for an extended period of time, thorough cleaning will be required.

Store the machine under the following environmental conditions:

- Dry
- Frost-free
- Protected from dust
- Protected against corrosion (e.g. salt water)

6 Installation

Observe the following notices when assembling and positioning the machine:

DANGER **If the inoCOMB Maxi Power is operated by unqualified individuals, this could put the life and health of the operating staff at risk and cause property damage to the inoCOMB Maxi Power or other assets.**

DANGER **Rotating mixing shafts.**
Danger of death due to being pulled into the machine and crushed.
When the motor is running, the mixing shaft rotates in the mixing zone!

- Do not reach into the rotating mixing shaft.
- Do not place any objects into the rotating mixing shaft.

1. Before working on the metering and mixing shaft, interrupt the external power supply (main switch off).
2. Pull out the mains plug.
3. Secure the machine against unexpectedly being switched back on.
4. Open the eccentric lock on the motor and move it away to the side.

DANGER **Pressurised conveyor hoses.**
Risk of injury and risk of property damage due to escaping and/or flying material, and/or bursting conveyor hoses.

- Before disconnecting the conveyor hoses, make sure that the hoses are depressurised. To do so, check the pressure indicator on the mortar pressure gauge. The pressure indicator must display 0 bar!
- Before opening the hose coupling, let the inoCOMB Maxi Power run in reverse to reduce any pressure! To do this, turn the phase-change switch (1) until the red illuminated button on the machine's switching cabinet (2) lights up. Then press the red illuminated button. The pump then runs backwards.

- Use only conveyor hoses which are permissible with an operating pressure of 40 bar and a burst pressure of 120 bar, and are in a technically perfect condition (e.g. are without any cracks or other external damage!).

Installation location requirements

- Ensure that there is enough space around the machine to enable filling of the material hopper and machine operation.
- Install the inoCOMB Maxi Power on an even and horizontal surface.
- Prevent the machine from sliding by locking the brakes on the wheels.
- Cover the floor underneath the machine with a plastic sheet, if it is not on a firm surface.
- Keep the machine in a dry, protected area in wet weather.
- Prevent direct exposure to sunlight, especially while in continuous operation, in order to prevent the motor from overheating.
- Do not use the machine at temperatures below 0° Celsius to prevent the water-carrying parts from freezing. For storage, dry out all water-carrying parts.

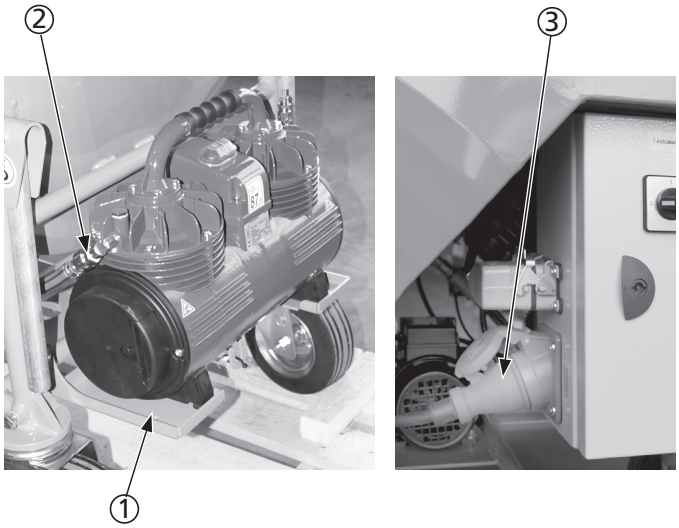
6.1 Delivery condition of the machine

The inoCOMB Maxi Power is delivered from the factory on a pallet as a complete machine. Before initial commissioning, assemble the pump unit with rotor, stator and pressure gauge.

The machine may only be lifted at the attachment points provided for this purpose using suitable lifting equipment!

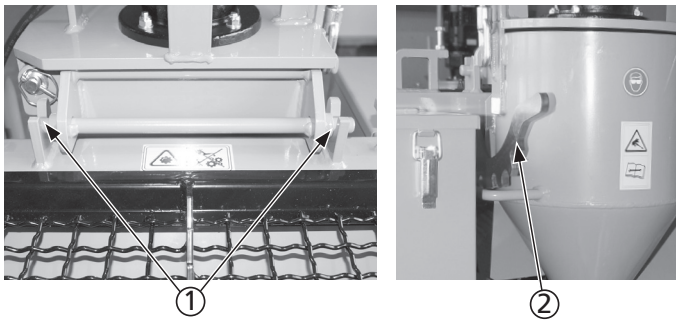
6.2 Connecting the compressor

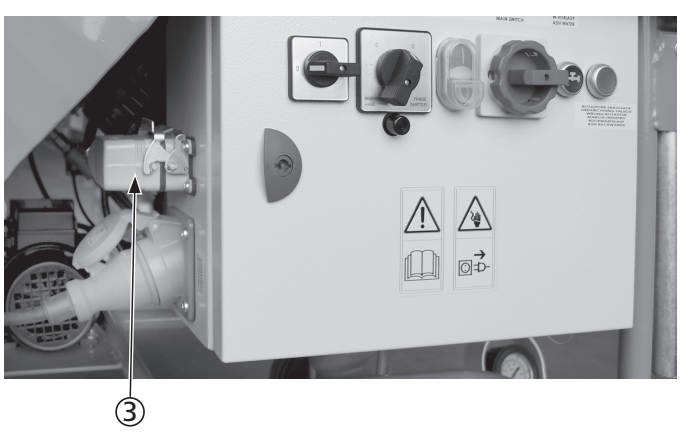
1. Place the compressor on the support frame provided for this purpose on the front of the machine (1).
2. Connect the air hose of the air fitting to the compressor's quick release (2).
3. Plug the electrical cable of the compressor into the socket on the left of the switching cabinet (3).



6.3 Mounting / dismounting the mixing zone

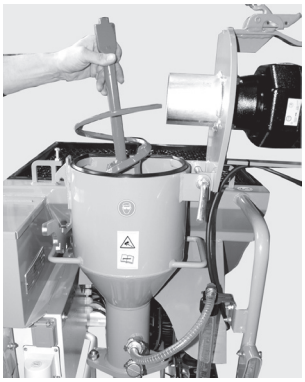
1. Lock the two lateral pegs in the rear area of the mixing zone in the guides attached to the material hopper until they engage (1).
2. Tilt the mixing chamber down and block it with the fixing lever (2).
3. Connect the electric cable of the pump motor to the socket prepared on the switching cabinet (3)





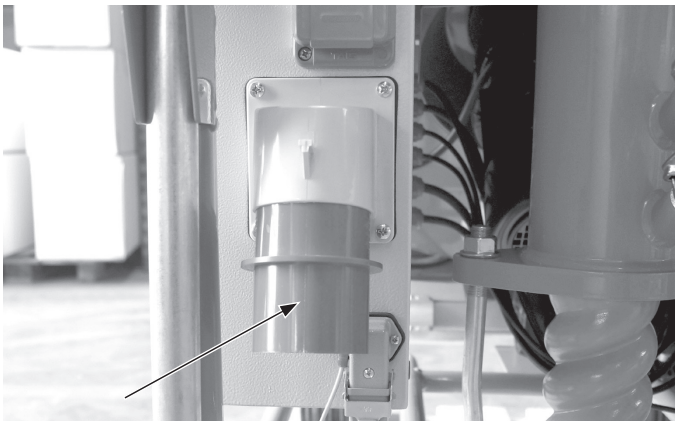
6.4 Installing the mixing coil

1. Open the eccentric lock on the motor and move it away to the side.
2. Push the mixing coil into the mixing zone.
3. Then move the motor back again and close the eccentric lock. Ensure that the mixing coil is connected to the motor and rotor of the pump unit via the motor bracket.



6.5 Connecting the electrical control system

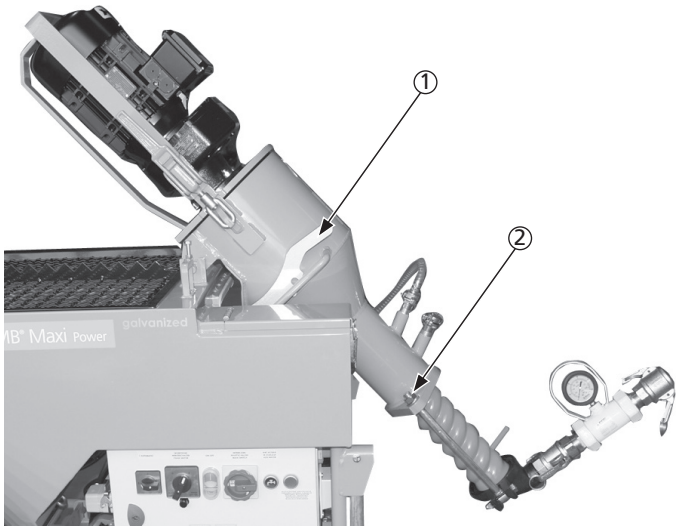
1. Connect the mixing pump only to regulation construction site power distribution points with FI circuit breakers (30 mA).
2. The connection must be fused with 25 A at least.
3. The cross-section of the supply cable is at least 4.0 mm^2 at 400 V 3 PH
4. Connect the supply cable to the feed-in connector of the switching cabinet.
5. Turn the main switch to vertical (= ON)



5-pole power supply plug

6.6 Mounting the pump unit (rotor / stator / pressure gauge)

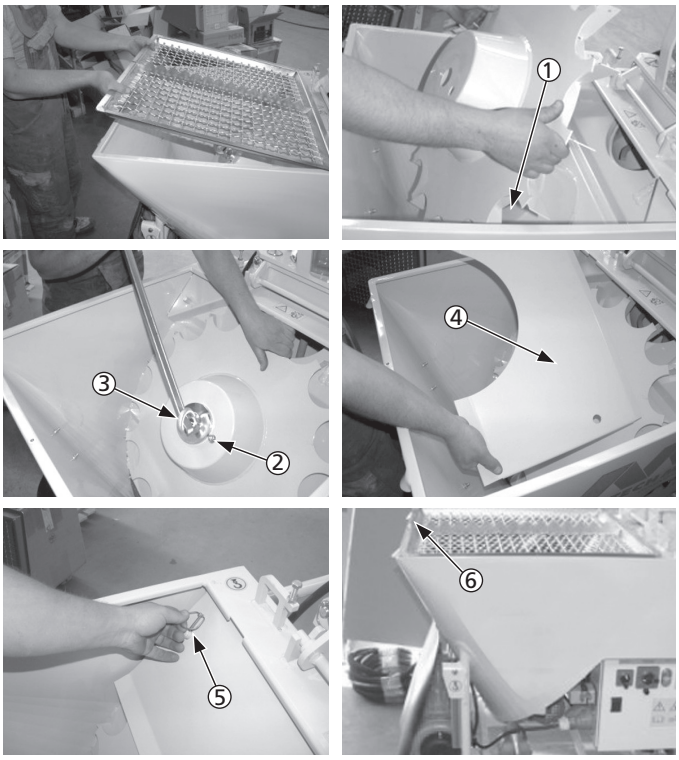
1. To do this, fold the mixing zone upwards and lock it in place by engaging the fastening lever (1).
2. Mount the pump unit and tighten the two nuts with a spanner (2).



NOTE **The machine can be equipped with different rotors/stators. Make sure that the pump unit is mounted centred on the mixing zone.**

6.7 Installing the star feeder

1. Before working on the star feeder, interrupt the power supply (main switch off).
2. Pull out the mains plug.
3. Secure the machine against unexpectedly being switched back on.
4. Loosen the screw of the protective grating and remove the protective grating from the material hopper.
5. Then place the star feeder on the centring cone (1) of the machine. Make sure that the centring pin (2) engages on the star feeder.
6. Screw on the flange nut (3) by hand and tighten it with a suitable tool.
7. Secure the guard plate (4) with the two locking pins (5).
8. Mount the protective grating on the material hopper and fix it with the screw (6)



WARNING **Acute Danger of injury!**
The machine must not be operated without the guard fixed in place.

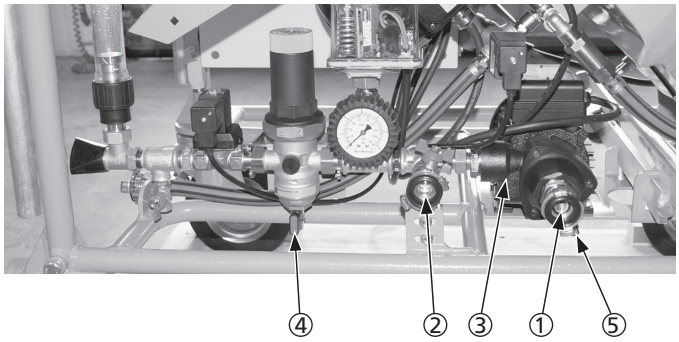
6.8 Installing the water measuring system

The machine is equipped with two water connections. The main connection (1) is used to supply the water required for mixing. A cleaning hose can be connected to the second connection (2).

1. Connect the supply hose to the external water supply.
2. Open the water valve until a steady water jet comes out of the hose in order to both clean the water hose of dirt and ventilate it.
3. Then close the water valve on the external water supply.
4. Insert the filter set at the main connection of the water fitting to prevent contamination. This filter insert must be cleaned regularly and replaced if damaged.

5. Then connect the external water hose to the GEKA coupling of the water fitting (1).
6. Close both the water drainage valve below the pressure reducer (4) and below the main connection (5).
7. Connect the internal water hose to the GEKA coupling on the mixing zone.
8. Open the water tap to the external water supply.
9. Open the ball valve above the GEKA coupling for the cleaning hose (2) until there is no more air in the water fitting and no more bubbles come out.

NOTE **To ensure sufficient water pressure regardless of the pressure of the supply line, the machine is equipped with a pressure booster pump (3).**



NOTE **A rubber hose (min. 10 bar) with a cross-section of at least 3/4" must be used as the connecting hose between the external water supply and the water fitting.**

- Before connecting the hose, check that the connections on the hose and on the machine match. If necessary, replace them with suitable ones.

WARNING **Water jet.**
Risk of injury and risk of property damage due to escaping water.

1. Interrupt the external water supply by closing the water valve.
2. In order to release the pressure (approx. 2 bar), open the water drainage valve on the water measuring system under the pressure reducer.
3. Only remove the hose from the external water supply when the pressure gauge shows "0" bar.
4. Do not point the water jet at other people or yourself.

NOTE **After the end of work (especially if there is a risk of frost), the residual water still in the water measuring system should be drained off via one of the water drain taps.**

6.9 Checking the direction of rotation of the machine

CAUTION **Before using the machine, check that the direction of rotation of the machine is correct, otherwise considerable damage to the machine may occur. Proceed as follows:**

1. Set the main switch to "0" (horizontal).
2. Open the side lock of the tilting flange on the mixing zone and tilt the pump motor to the side.
3. Remove the mixing coil from the mixing zone.
4. Tilt the pump motor back and lock the side tilting flange.
5. Check the direction of rotation by setting the main switch to "I" (vertical), setting the start feeder selector switch to "0" and then briefly pressing the start button "I". The motor starts. You can recognise the direction of rotation by the rotation of the cooling fan wheel on the front of the motor. The direction of rotation is marked with an arrow on the motor.

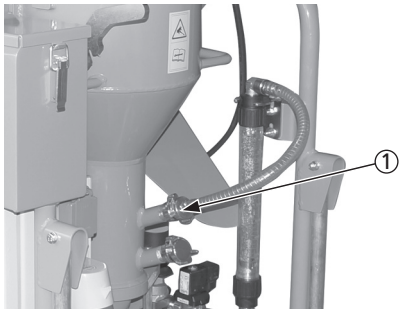
6. If the direction of rotation does not match, switch off the machine with the main switch and position the phase inverter in the opposite direction.
7. To insert the mixing coil, open the side lock of the tilting flange on the mixing zone and tilt the pump motor to the side.
8. Put the mixing coil back into the mixing zone.
9. Tilt the pump motor back and lock the side tilting flange.

NOTE **When tilting back the pump motor, make sure that the coupling of the motor is in the corresponding position to the mixing shaft.**
If the coupling is not positioned correctly, the geared motor cannot be closed.

NOTE **To ensure good material processing, the manufacturer recommends: Direction of rotation of the star feeder clockwise and direction of rotation of the pump motor counter clockwise.**

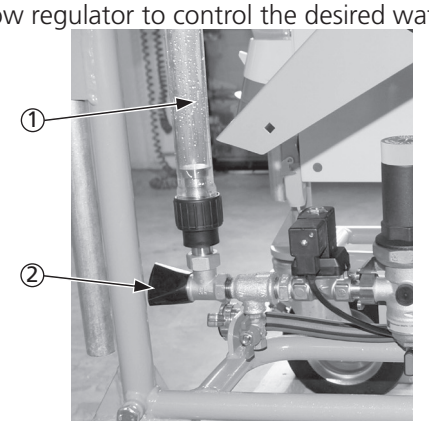
CAUTION **If the mixing pump operates with the direction of rotation inverted, the machine will be damaged!**

10. After checking the correct direction of rotation, connect the hose of the water fitting to the GEKA coupling (1) of the mixing zone.



6.10 Setting the water quantity

Use the flow regulator to control the desired water flow.

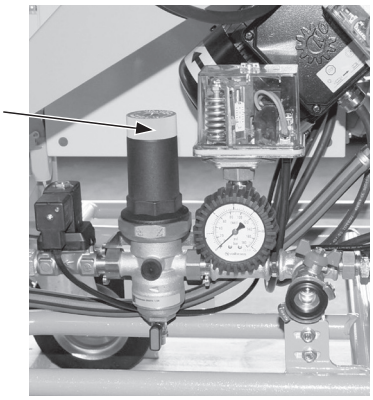


You can read the current flow rate on the inspection glass of the flow meter (1). With the fine adjustment valve (2) you can regulate the fine setting for the desired material consistency. Follow the instructions of the manufacturer of the drying material.

CAUTION **If the amount of water is too low, the conveyor hose in which the mixed material is conveyed to the sprayer can become blocked. This can lead to severe wear of the pump unit (rotor/stator). It is therefore advisable to start with plenty of water so that the amount of water can then be reduced to the required level.**

6.11 Regulating the water pressure

A pressure reducer is installed and pre-set at the factory to regulate the water pressure. The control cap on the pressure reducer allows you to readjust the water pressure if necessary.



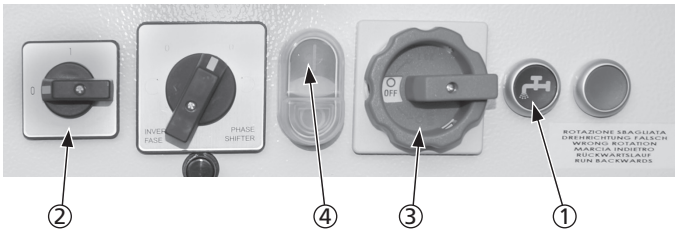
6.12 Material preparation

Fill the material hopper with dry material.

CAUTION **Make sure that no bag parts fall into the material hopper when emptying the dry material. These would mix with the material and could clog the sprayer, causing severe damage to the machine.**

NOTE **Fill the mixing zone with water before starting the machine.**

1. Press the "Water" push button(1) on the switching cabinet.
2. Then set the "star feeder selector switch" (2) to automatic.
3. Turn the main switch (3) to the vertical position ("ON").
4. Press the green start button "I".



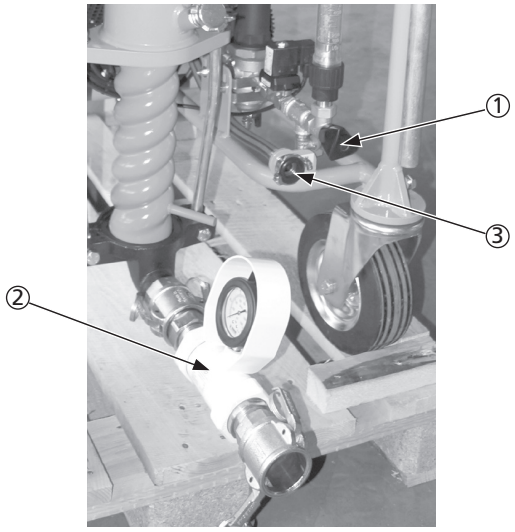
WARNING **Machine does not start. Check the position of the main switch on the switching cabinet and all electrical connections. In the event that all connections are correct and the main switch is in the vertical position ("ON') and the pump motor still does not rotate, have the machine checked by a qualified electrician. Only this person is authorised to open the switching cabinet.**

6.12.1 Adjusting the material consistency

1. Check the material consistency at the pump outlet. Catch the material in a suitable container. Make sure that the first material is relatively liquid. Then you can reduce the amount of water with the fine adjustment valve (1) of the flow meter until the desired material consistency is reached.
2. Then switch off the machine by pulling the main switch to the horizontal position.

6.13 Preparing the machine

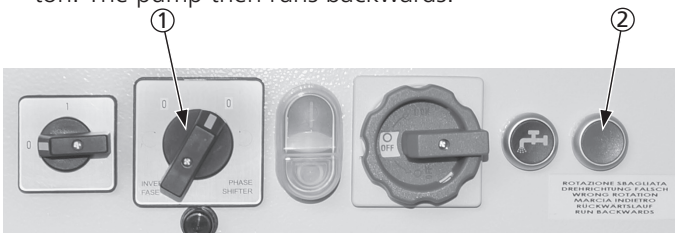
1. Disconnect the machine from the mains voltage and mount the mortar pressure gauge (2) at the pump outlet, which indicates the pressure in the conveyor hose during operation.
2. Fill approx. 2-3 litres of lime milk or wallpaper paste into the conveyor hose as pre-lubrication and then connect it to the mortar coupling of the mortar pressure gauge.
3. Assemble the appropriate spray head or glue gun to the end of the mortar hose and also connect the air hose to the spray head.
4. Close the air valve on the spray head.
5. Connect the air hose to the connection on the machine (3) and the sprayer.
6. If necessary, extend the mortar hose and air hose to the desired and appropriate delivery range/delivery height.



DANGER **Pressurised conveyor hoses.**

Risk of injury and risk of property damage due to escaping and/or flying material, and/or bursting conveyor hoses.

- Before disconnecting the conveyor hoses, make sure that the hoses are depressurised. To do so, check the pressure indicator on the mortar pressure gauge. The pressure indicator must display 0 bar!
- Before opening the hose coupling, let the inoCOMB Maxi Power run in reverse to reduce any pressure! To do this, turn the phase-change switch (1) until the red illuminated button on the machine's switching cabinet (2) lights up. Then press the red illuminated button. The pump then runs backwards.



- Use only conveyor hoses which are permissible with an operating pressure of 40 bar and a burst pressure of 120 bar, and are in a technically perfect condition (e.g. are without any cracks or other external damage!).

6.14 Starting the machine

1. Set the "star feeder selector switch" to "1" (automatic) and the main switch to the vertical position "I". The machine is now ready for operation.
2. Add the dry material to the machine's material hopper.
3. To start the machine, press the green start button "I" on the switching cabinet.
4. Switch on the compressor. From now on, the machine is switched on and off via the air valve on the spray head.
5. First of all, open the material lever on the spray head and then the air valve. The actual spraying process starts. Check the mortar pressure gauge to see if the mortar pressure is within the permissible range.
6. Process the existing material (e.g. spray-on filling compounds on a wall), with a second worker continuously filling the material container with bagged goods.

7 Commissioning

7.1 Adding material to the material hopper

Risk to health due to dust.

When filling and cleaning the machine, inhaled dust can cause long-term lung damage or other adverse health effects.

- The machine operator or people working in the dust area must each wear a dust mask when cleaning the machine.
- Find out about the technical rules for hazardous substances (TRGS 559) "Mineral dust" on the homepage of the German Social Accident Insurance Institution (www.bgbau.de).

Risk of injury posed by powdery and paste-like material

When adding bagged goods to the material hopper, swirling or splashing material may pose a risk of injury, especially in the region of the eye and face.

- Always wear safety goggles.

7.2 Opening and emptying bags of material

Observe the applicable occupational safety regulations (e.g. respiratory protection)

To clean the bags of material, proceed as follows:

1. Place the bag of material on the hopper mesh with the tooth rail.
2. Tear open the bag of material by using short forward and backward movements.
3. Move the bag sideways and upwards and then empty the contents into the material hopper.
4. Observe the applicable occupational safety regulations (e.g. respiratory protection, etc.).
5. Dispose of the empty bags of material and other packaging material in an environmentally friendly manner in accordance with the instructions provided by the packaging manufacturer.

7.3 Changing material

1. Run the material hopper of the inoCOMB Maxi Power until it is empty.
2. Then switch off the mixing pump and compressor.
3. Close the valve on the external water supply.
4. Clean the material container, mixing coil, mixing zone and pump unit (rotor/stator/pressure gauge) incl. the conveyor hoses used.

Operation without any material or with too little material.

Danger of destroying the rotor/stator.

If the machine is operated without any material or with too little material, there is a risk of the rotor/stator being destroyed within an extremely short period of time (< 1 min.)!

7.4 Change of location on the construction site

The inoCOMB Maxi Power is equipped with four wheels. Convenient handles are fitted at all four corners for moving the whole machine.

To do this, disconnect the mixing pump from the electricity and water supply.

8 Operation, use

8.1 Checking operating performance

1. If you notice any deviations in the operating behaviour, decommission the inoCOMB Maxi Power immediately.
2. Ensure that the damage and/or defects which led to the deviating operating behaviour are rectified.

8.2 Checking the consistency of the material

Ensure an even, paste-like material consistency during operation.

- The viscosity may change, especially in warm weather conditions.

Material too rigid	Increase the water supply by re-adjusting it on the needle valve of the water fitting
Material too runny	Reduce the water supply by re-adjusting it on the needle valve of the water fitting

NOTE **Ensure that the change in consistency may take some time to become noticeable, depending on the length of the hose (approx. 20 seconds per 15 m hose length). Therefore, adjust the water supply at the needle valve only by turning it a small amount each time.**

8.3 Correcting flow fluctuations

1. Check the water inlet screen and clean it if it is dirty.
2. Check the water pressure at the supply line and regulate it accordingly, if necessary.
3. Check the pressure reducer and regulate it, if necessary.

8.4 Work break/end of work

If the duration of a work break exceeds the setting time of the material to be processed, there is a risk of the material setting during the break.

1. In the event of short interruptions of the pump process (up to approx. 15 min., depending on the material), close the air valve and the material valve on the spraying device.
2. In the event of longer interruptions, the machine must be run until it is empty and then cleaned.

9 Areas of application

inoCOMB Maxi Power

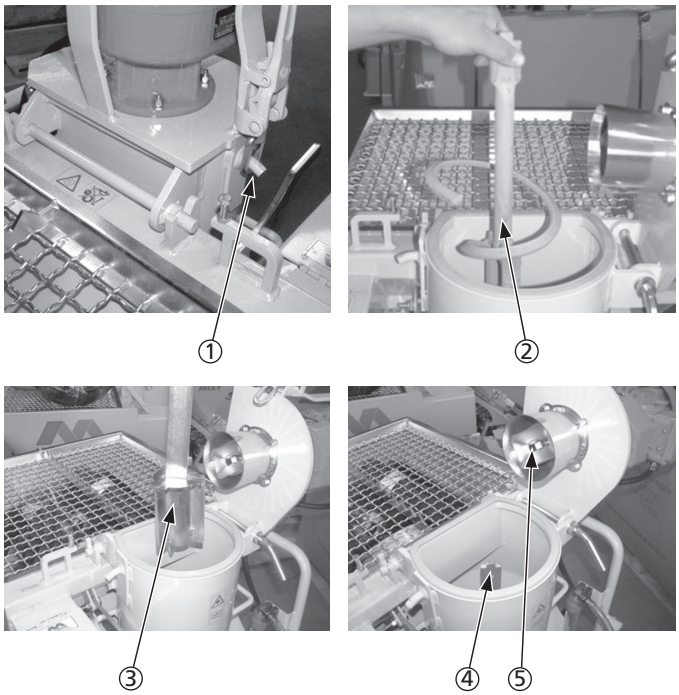
Floor filling compounds	✓
Fire protection mortar	✓
Floating screeds	✓
Lime-based finishing plasters	✓
Lime plasters	✓
Lime cement plasters	✓
Machine-applied gypsum plasters for indoor applications	✓
Mineral textured plasters	✓*
Renovating plaster systems	✓*
Spray-on filling compounds	✓
ETICS glue, mineral	✓
Cement plasters	✓

It is essential that the information the manufacturer has provided about the material be observed!
* Pre-mixed material (paste-like)

10 Cleaning & decommissioning

10.1 Cleaning process

1. Stop filling with bagged goods in sufficient time. Turn the star feeder switch to "0" and continue spraying until only water comes out of the sprayer and the pressure indicator on the mortar pressure gauge shows 0 (zero). Catch the escaping residual material in a suitable container.
2. Close the air valve on the spray head.
3. Close the ball valve on the spray head.
4. Open the screw connection on the spray head and remove the nozzle.
5. Clean the nozzle with a sponge or a cleaning brush.
6. Uncouple the now depressurised mortar hose from the pump unit of the mixing pump and put a sponge ball into the hose.
7. Connect the hose to the left-hand GEKA coupling of the water fitting by means of a coupling reducer, and open the ball valve and the ball valve on the spray head.
8. The sponge ball is carried through the material hose by the water and removes any adhering residual material from the walls of the material hose.
9. Once the sponge ball has emerged from the spray head, close the ball valve on the spray head and the mini ball valve on the water fitting.
10. Repeat the cleaning process with the sponge ball up to twice depending on how dirty the machine is.
11. Insert the cleaned nozzle back into the spray head and close the screw connection.
12. Switch off the mixing pump. To do this, turn the main switch to the horizontal position "0".
13. Pull out the mains plug.
14. To clean the mixing zone, open the side lock of the tilting flange (1) and fold the motor away to the side.
15. Remove the mixing coil (2) from the mixing zone and clean it.
16. Place the mixing tube cleaner (3) in the mixing zone and turn it until it clicks into place. Make sure that the coupling (4) of the mixing tube cleaner corresponds to the position of the material claw (5) of the pump motor.
17. Fold the motor back onto the mixing zone and lock the side tilting flange.
18. Switch on the machine for approx. 30 seconds to start the cleaning process of the mixing zone.
19. Open the lateral locking of the tilting flange and fold the motor away to the side.
20. Remove the mixing tube cleaner from the mixing zone.
21. Clean the inside walls of the mixing zone by hand and rinse with water.

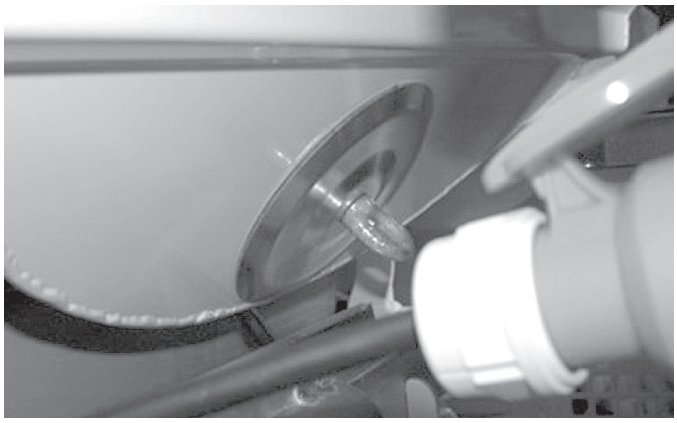


NOTE **In the event of a power failure, you can also clean the mixing zone manually. To do this, insert the mixing tube cleaner into the mixing zone and turn it manually.**

NOTE **Make sure that no water enters the dry area between the mixing zone and the material hopper. The dust inside could clump and cause jamming when the machine is started up again.**

22. To clean the pump unit (rotor/stator), fill the mixing zone with clean water and start the machine with the star feeder switched off.
23. Switch off the mixing pump. To do this, turn the main switch to the horizontal position "0".
24. Then screw the rotor out of the stator and store it in a dry location after cleaning.
25. Before reassembly, coat both the rotor and the stator generously with assembly spray lubricant (item no. 10004591) in order to make it easier to screw the rotor into the stator. Ensure that the rotor is correctly installed in the stator.
26. Put the mixing coil back into the mixing zone. Make sure that the coupling of the mixing coil corresponds to the position of the material claw of the pump motor.
27. Fold the motor back onto the mixing zone and lock the side tilting flange.

28. Loosen and remove the screw on the protective screen of the material hopper.
29. To clean the star feeder, first remove the guard plate.
30. Pull the star feeder off the centring cone.
31. Clean the material hopper and the star feeder and loosen any adhering dry material with a scraper. Alternatively, you can clean with water. In this case, dry the material hopper and star feeder carefully. Remove the cleaning residues through the cleaning opening at the bottom of the material hopper and catch them with a suitable container.



Cleaning opening on the lower side of the material hopper. It is closed with a disc and fixed with an eyebolt.

32. Replace the cleaned star feeder and close the protective grating on the material hopper.
33. Open the drain taps located on the pressure reducer and the flow indicator to drain the water fitting.

DANGER **Rotating mixing shafts.**

Danger of death due to being pulled into the machine and crushed.

When the motor is running, the mixing shaft rotates in the mixing zone!

- Do not reach into the rotating mixing shaft.
- Do not place any objects into the rotating mixing shaft.

1. Before working on the metering and mixing shaft, interrupt the external power supply (main switch off). Loosen the screw of the protective screen above the material hopper only when the machine is switched off.
2. Pull out the mains plug.
3. Secure the machine against unexpectedly being switched back on.

DANGER **Pressurised conveyor hoses.**

Risk of injury and risk of property damage due to escaping and/or flying material, and/or bursting conveyor hoses.

- Before disconnecting the conveyor hoses, make sure that the hoses are depressurised. To do so, check the pressure indicator on the mortar pressure gauge. The pressure indicator must display 0 bar!
- Before opening the hose coupling, let the inoCOMB Maxi Power run in reverse to reduce any pressure!
- Use only conveyor hoses which are permissible with an operating pressure of 40 bar, and are in a technically perfect condition (e.g. are without any cracks or other external damage!).

WARNING **Water jet.**

Risk of injury and risk of property damage due to escaping water.

1. Interrupt the external water supply by closing the water valve.
2. In order to release the pressure (approx. 2 bar), open the water drainage valve on the water measuring system under the pressure reducer.
3. Only remove the hose from the external water supply when the pressure gauge shows "0" bar.
4. Do not point the water jet at other people or yourself.

10.2 After cleaning

NOTE **Note the optimum assembly sequence.**

1. Assemble the pump unit (rotor/stator/pressure gauge/ pressure flange) with both tie rods at the lower end of the green mixing zone. For easier installation, the complete mixing zone incl. motor can be placed at an angle.
2. Open the eccentric lock on the motor and move it away to the side. Push the mixing coil into the mixing zone. Then move the motor back again and close the eccentric lock. Ensure that the mixing coil is connected to the motor and rotor of the pump unit via the motor bracket.
3. Connect the input socket to the external power supply (400 V / 32 Hz)

11 Maintenance

Have the machine inspected once a year by a specialist workshop. Replace parts which are subject to wear as soon as the wear limits have been reached. Portable machines, like the inoCOMB Maxi Power, must be subject to an annual electrical inspection according to the implementing regulation for electrical plant and operating resources (DGUV V3). This inspection may only be carried out by a qualified electrician (e.g. electrical engineer, electrical technician, master electrician, senior electrician, foreman electrician or assistant electrician). Electrical specialists work at all INOTEC service centres, conducting electrical inspections in line with DGUV V3. To arrange an inspection, call the INOTEC service hotline on +49 7741 6805 777.

Cleaning and maintenance work can put the safety of operating staff at risk and impair the functionality of the machine.

1. Switch off the mixing pump. To do this, turn the main switch to the horizontal position "0".
2. Pull out the mains plug.
3. Secure the machine against unexpectedly being switched back on
4. Before cleaning with the water jet, cover all the openings that water must not penetrate into for safety and functional reasons.
5. After cleaning, remove all the covers which were attached to protect against the water.

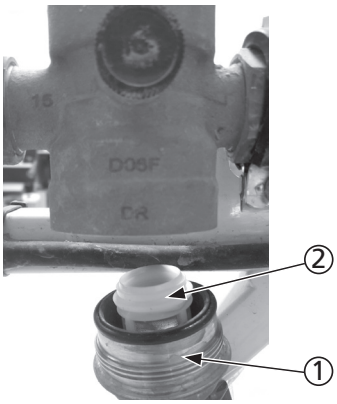
11.1 Maintenance plan

Have the machine inspected at a specialist workshop or at an INOTEC service centre	Once a year (Recommended)
Electrical inspection (DGUV V3) by a qualified electrician or at an INOTEC service centre	at least once a year (mandatory, specified by DGUV V3)
The dirt trap sieve in the water inlet is to be cleaned/ replaced by the operator	Daily
The dirt trap sieve in the pressure reducer is to be cleaned/replaced by a service technician	Monthly

11.2 Dirt trap sieve in the water inlet

1. Remove the dirt trap sieve from the GEKA coupling.
2. Clean the dirt sieve trap daily.
3. Replace the dirt trap if it is very dirty.
4. Re-install the dirt trap sieve.

11.3 Dirt trap sieve in the pressure reducing valve



1. Unscrew the sieve cup (1) from the pressure reducer.
2. Remove and clean the dirt trap sieve (2) once a month.
3. Replace the dirt trap if it is very dirty.
4. Install a new dirt trap sieve and screw the sieve cup onto the pressure reducer.

11.4 Set values

Water pressure switch	ON: 2.1 bar	Off: 2.0 bar
Air pressure switch	ON: 1.5 bar	Off: 2.5 bar
Pressure reducer	2.2 bar	
Protection type	IP 54	

11.5 Pump and star feeder motor

Have the pump motor and the star feeder motor checked and serviced by a qualified electrician every 300 operating hours.

12 Faults, causes and solutions

The inoCOMB Maxi Power is designed for fault-free operation. However, should a fault occur, please follow the instructions below on analysing, checking and remedying the fault or contact the Inotec Service team (see the address list for INOTEC service centres at the end of the document) or call the INOTEC service hotline on: +49 7741 6805 777.

Faults can put the safety of operating staff at risk and impair the functionality of the machine.

Proceed as follows where a fault occurs:

1. Cut off the power supply in the event of any faults which pose a direct risk to people or material assets. To do this, press the red pushbutton.
2. Pull out the mains plug.
3. Secure the machine against unexpectedly being switched back on
4. Determine the cause of the fault.
5. Report the fault to the responsible person on site.
6. Depending on the type of fault you can either rectify this yourself or have it rectified by a qualified electrical specialist.

The faults listed below feature recommendations as to who is authorised to rectify the fault.

Symptom		Potential cause	Check / solution	Personnel qualification
Machinery cannot be switched on.		No input voltage available.	• Have the voltage supply checked at the worksite distribution board, at the sockets, the supply cables and the fuse protection. • Have the voltage supply restored if it was interrupted.	Service technician/ qualified electrician
		No or too low water pressure.	• Check the water supply. • If necessary, clean the dirt trap sieve. • Check the water pump.	Machine operator
		Pump drive motor is folded up or the machine is not level.	• Fold the motor onto the mixing zone and lock the side tilting flange. • Make sure the machine is horizontal.	Machine operator
Pressure booster pump isn't running.		Motor protection switch of the booster pump has tripped.	• Switch on the motor protection switch.	Service technician/ qualified electrician
		Pressure booster pump impeller is blocked.	• Arrange for the pressure booster pump to be dismantled and the impeller to be made operable again. • Have the pressure booster pump replaced if it is defective.	Service technician/ qualified electrician
The machine has stopped.		Pump unit motor protection switch has tripped.	• Switch on the motor protection switch.	Service technician/ qualified electrician
		Mixing coil or rotor/stator mechanically blocked.	• Check whether any hardened material or foreign bodies are around the mixing coil or in the rotor/stator; if necessary, remove the hardened material or foreign bodies.	Machine operator / Service technician
		Star feeder motor protection switch has tripped.	• Switch on the motor protection switch.	Service technician/ qualified electrician
			• Clean the material hopper and the star feeder.	Machine operator
		Delivery pressure too high because the material is too thick, the conveyor hose is too long or a smoke plug has formed.	• Set the material consistency correctly. • Shorten the conveyor hose or use a larger hose diameter. • Change the direction of rotation on the phase-change switch until the pressure on the mortar pressure gauge shows 0 bar. Then clean the hoses and remove the plug. Danger: Open hose couplings only when the display is depressurised, your face is turned away and you are wearing protective goggles.	Machine operator
Material consistency	too thick	Fine adjustment valve is set incorrectly.	• Open the fine adjustment valve.	Machine operator
	too thin		• Close the fine adjustment valve.	Machine operator
	Consistency fluctuations	Dry material supply is not uniform.	• Check the material flow • If necessary, clean the mixing pipe inlet	Machine operator
		The pump unit (rotor/ stator) is worn out.	• Replace the pump unit (rotor/stator)	Machine operator
		The pressure reducer is set incorrectly	• Have the pressure reducer setting checked and adjusted correctly if necessary.	Service technician/ qualified electrician

Symptom	Potential cause	Check / solution	Personnel qualification
Water rising in the mixing tube during operation	Worn pump unit (rotor/stator) or hose plug.	• Replace the pump unit (rotor/stator) • Remove the hose plug. To do this, change the direction of rotation on the phase-change switch until the pressure on the mortar pressure gauge shows 0 bar. Then clean the hoses and remove the plug. Danger: Open hose couplings only when the display is depressurised, your face is turned away and you are wearing protective goggles.	Machine operator
Machine does not stop with air control when the air tap on the sprayer is closed.	Air pressure switch adjusted or defective.	• If necessary, have the air pressure switch checked and adjusted correctly. • If necessary, have the defective air pressure switch replaced.	Service technician/ qualified electrician
	Air hose or seal defective.	• Replace the defective air hose if necessary. • Replace the defective seal if necessary.	Machine operator
	Compressor does not deliver enough power.	• Have the compressor checked or use a compressor with a higher capacity.	Service technician/ qualified electrician
Machine does not switch on when opening the air tap on the sprayer.	Air pressure switch adjusted or defective.	• If necessary, have the air pressure switch checked and adjusted correctly. • If necessary, have the defective air pressure switch replaced.	Service technician/ qualified electrician
	Air hose kinked or blocked.	• Check the air hose. • Replace the defective air hose if necessary.	Machine operator
	Air nozzle tube clogged.	• Clean the air nozzle tube.	Machine operator

13 Dismantling and disposal

After the machine's period of use has expired, the machine must be dismantled and sent for environmentally conscious disposal.

13.1 Safety

- Only task trained or instructed staff with dismantling the inoCOMB Maxi Power.
- Work on the electronic control system may only be performed by a qualified electrician.

WARNING **Risk of injury posed by improper disassembly.**

Stored residual energy, sharp components, points and corners on and in the machine can cause injuries.

- Ensure there is enough space for disassembly.
- Wear gloves and safety boots to avoid injuries.
- Handle sharp-edged parts with care.
- Ensure that the workplace is tidy and clean. Loose components and tools lying around or on top of each other can cause accidents.
- Adopt good practice when dismantling the components.
- Note that some individual parts may be very heavy.
- Secure the individual parts to ensure these do not fall down or topple over.
- In the event of uncertainty, call the INOTEC service hotline on +49 7741 6805 777.

DANGER **Electrical voltage**

Danger of death due to electric shock.

When switched on, electrical components can cause uncontrolled movements and lead to serious injury.

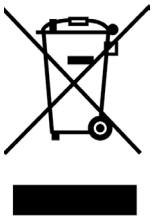
1. Switch the machine off. To switch on, turn the red rotary switch to the vertical position "0".
2. Pull out the mains plug and finally disconnect the machine from the electrical supply.

13.2 Dismantling

Clean and dismantle the machine before sorting the parts in compliance with the applicable occupational health and environmental protection regulations.

13.3 Disposal

According to European Directive 2012/19/EU on waste electrical and electronic equipment and its implementation in national law, this machine should not be disposed of in general household waste, but recycled in an environmentally conscious manner!



The inoCOMB Maxi Power primarily of high-quality metal. Observe the following if you are decommissioning the inoCOMB Maxi Power for the final time:

- Send the metal to a recycling facility.
- Dispose of the inoCOMB Maxi Power via a scrap metal dealer or your local scrap metal collection centre.

Your used INOTEC equipment will be taken back by us and disposed of in an environmentally conscious manner. Please contact one of our service centres to arrange this.

14 Systems

The following documents are enclosed as annexes and form part of this operating manual:

14.1 EC declaration of conformity

Name/address of the issuer: **INOTEC GmbH**
Daimlerstraße 9-11
DE 79761 Waldshut-Tiengen

We hereby declare
that the machine described below, on the basis of its design and construction, as well as the version that we have put into circulation, complies with the relevant fundamental safety and health regulations of the EC Directive 2006/42/EC.

This declaration will become void in the event of any modification made to the machine without our approval.

Name of the device:	inoCOMB Maxi Power
Machine model:	Mixing pump
Item number:	10044216

Applied harmonised standards

DIN EN 12100	Safety of machinery
DIN EN 60 204.1	Electrical equipment of machines - Part 1: general requirements
DIN EN 13857	Safety of Machinery - Safety distances to prevent hazard zones being reached by upper and lower limbs

Authorised representative for the compilation technical documentation:

INOTEC GmbH
Daimlerstraße 9-11
DE 79761 Waldshut-Tiengen

Jörg Tetling
Managing Director

Waldshut-Tiengen, August 2021

14.2 General Terms of Business of the company INOTEC GmbH

Valid from April 2021

§ 1
General, scope

I. All offers, deliveries and other services provided by INOTEC GmbH — including in the future — are exclusively subject to these general terms and conditions.
Terms and conditions of the customer that deviate from or are not included in our terms and conditions are not recognised unless INOTEC GmbH has explicitly agreed to their validity in writing. Counter-confirmations by the customer with reference to their terms and conditions of business or purchase are hereby rejected.

II. INOTEC GmbH's general terms and conditions of leasing apply to leasing services we provide.

§ 2
Product descriptions, application-related information, subject to change

I. Machine descriptions in brochures, technical data sheets, etc. do not constitute quality guarantees. Application-related information and recommendations that INOTEC GmbH issues verbally and in writing to support the customer or processor are based on our current level of knowledge. They are non-binding and do not establish any contractual rights nor any secondary obligations from the purchase contract, unless explicitly agreed otherwise.

II. We reserve the right to make design and material changes, provided that normal use of the delivery item or use required under the contract is not significantly or adversely affected and the change is reasonable for the customer.

§ 3
Delivery period, assembly deadline

I. Agreed delivery periods start on conclusion of the contract, but not before the customer has provided the necessary documents and approvals and has fully clarified all of the details regarding the requested execution and all technical questions. Compliance with the delivery period always requires the customer to meet its contractual obligations.

II. In the event of force majeure and any unforeseeable obstacles which were unknown on conclusion of the contract, where we are not responsible for such obstacles, the delivery period shall be extended appropriately — including within a delay — insofar as it is proven that such obstacles impacted the provision of the service owed.
This also applies if these circumstances apply to sub-suppliers. We shall notify the customer of the start and end dates of such obstacles as early as possible.
If the obstacle lasts for more than three months or if it is determined that this will last for more than three months, both we and the customer may withdraw from the contract.

III. If we have agreed the time of delivery, assembly or installation with the customer, the customer is obliged to take all precautions at their place of work to be able to carry out their planned work. In particular, the customer is obliged to provide electrical connections, compressed air connections and adequate lighting at the place of work.
If the customer is responsible for the fact that we are unable to complete the planned work, are unable to complete it in full, or are unable to complete it within a reasonable period of time, the customer is obliged to compensate us for any damages incurred, and is particularly obliged to reimburse use for any additional costs incurred as a result of additional journeys and wasted working hours additionally required from our employees.
The assembly deadline is met if assembly has been carried out for acceptance by the customer by the deadline. If a test is stipulated by the contract, the deadline is met if assembly has been carried out for execution by the deadline. If there are any delays as a result of force majeure or circumstances for which the customer is responsible, the assembly deadline shall be extended to a reasonable extent.

IV. If the customer has demonstrably suffered damage as a result of a delay by INOTEC GmbH as an assembly company, they are entitled to demand compensation for the delay. In the case of simple negligence on the part of INOTEC GmbH, this is a fixed amount totalling 0.5% for each full week of the delay, but this amount shall not exceed 5% of the value of the part of the total delivery that cannot be used on time or in line with the contract as a result of delayed assembly.

§ 4
Transportation, transfer of risk, packaging, partial deliveries

I. Unless otherwise agreed, INOTEC GmbH shall deliver goods carriage forward and uninsured to the named destination at the risk of the recipient. If there are any damages in transit, the damage must be confirmed by the carrier before the goods are accepted. If carriage paid delivery is owed, this only applies to shipping and transportation standard in the industry. Additional costs, e.g. for express freight requested by the customer, shall be borne by the customer.

II. Unless otherwise agreed, risk for shipping transactions transfers to the customer as soon as the delivery has been handed over to the person providing transportation. If dispatch is not possible for reasons for which INOTEC GmbH is not to blame, risk transfers to the customer upon notification that the goods are ready for dispatch. If the customer collects the goods, risk transfers when the goods are handed over.

III. Unless explicitly agreed otherwise, INOTEC GmbH shall provide deliveries without packaging.

IV. INOTEC GmbH is entitled to partial delivery and partial performance to a reasonable extent.

§ 5
Prices and payment, returns

I. Unless otherwise agreed, prices do not include packaging, transportation, insurance, unloading, installation, assembly and commissioning, namely for delivery ex works or from the delivery warehouse, and are exclusive of statutory VAT at the respective rate. The prices quoted are only valid for the respective individual order. Assembly is billed based on time spent, unless a fixed rate has been explicitly agreed.

II. If contracts have an agreed delivery period of more than two months, both contracting parties may request a change in the agreed price if costs decrease or increase after the contract is concluded and the contracting parties cannot avoid this, particularly if such decreases or increases are caused by collective bargaining agreements or changes in the cost of materials. The price change must be limited to the amount required to compensate for the cost decrease or increase. A party is entitled to a similar price adjustment if delays arise for which the other party is responsible and these result in an actual delivery period of more than two months.

III. Unless otherwise agreed (e.g. when the invoice is sent), payments are to be made immediately on delivery of the goods. Payment is only considered to have been made when INOTEC GmbH has the amount at its disposal.

Granting a payment term once or several times only applies to the invoice amount referred to and not to other receivables (e.g. receivables from other or future deliveries).

IV. If the customer defaults on payment, INOTEC GmbH may demand statutory default interest as a minimum.

V. Offsetting payments or retaining payments where such retention equates to offsetting is only permitted if the customer has legal claims that are recognised by INOTEC GmbH, are not disputed, are pending judgement or have been established by law.

VI. Despite any of the customer's provisions to the contrary, INOTEC GmbH is entitled to initially offset payments against their older debts and will notify the customer about the type of offsetting that has taken place. If costs and interest have already been incurred, INOTEC GmbH is entitled to offset the payment against the costs first, then against the interest and finally against the main receivable.

VII. If the customer defaults on acceptance of the delivery items or on payment, INOTEC GmbH may withdraw from the contract and/or may demand compensation instead of performance after a reasonable grace period passes to no avail, where such a grace period is required by law and is set by INOTEC GmbH. If a compensation claim for damages is asserted, INOTEC GmbH may demand compensation at the amount of 15% of the purchase price, without being required to provide evidence to compensate for lost profit. The contracting parties are free to provide evidence of higher or significantly lower actual damage.

VIII. If we take back goods after consultation without any legal obligation, a credit note will be issued that totals a maximum of the value of the goods. With respect to the expenses incurred (loss of value, testing, cleaning, freight, packaging, administrative expenses, etc.), we reserve the right to deduct the working hours spent at current billing rates and/or a percentage of the value of the goods from the credit note, and with respect to machine returns, we reserve the right to carry out a leasing calculation using current leasing rates.

§ 6
Retention of title, extended retention of title

I. INOTEC GmbH retains title to the delivered goods until all receivables from the concluded contract, including all accessory claims (e.g. exchange costs, financing costs, interest) have been met in full. If several items are delivered for a total price, ownership of all items remains reserved until full payment has been made.
If a current account agreement has been made with the customer, retention of title exists until the recognised current account balance has been paid in full.
If cheques or bills of exchange are accepted, fulfilment only occurs when the cheque or bill of exchange has been cashed and INOTEC GmbH has the amount at its disposal without any recourse risks.

II. The customer is obliged to treat the goods subject to retention of title with care and to immediately notify INOTEC GmbH in the event of seizure, confiscation, damage or loss. Any breach of this obligation gives INOTEC GmbH the right to withdraw from the contract. The customer shall bear all of the costs that have to be paid, particularly in the context of third-party action against seizure being lifted and, if necessary, for the replacement of the delivery items, unless they can be recovered from third parties.

III. If the customer defaults in payment with respect to a not inconsiderable portion of its obligations, INOTEC GmbH is entitled to temporarily take back the goods subject to retention of title. Exercising the right of withdrawal does not constitute a withdrawal from the contract, unless INOTEC GmbH has explicitly declared withdrawal. The customer shall bear any costs that arise from the exercise of the right of withdrawal (in particular for transportation and storage) if INOTEC GmbH threatened withdrawal within a reasonable period of time. INOTEC GmbH is entitled to dispose of the goods subject to retention of title that have been taken back and to offset its claims with the proceeds, provided that INOTEC GmbH has previously threatened to dispose of them. In the threat, INOTEC GmbH must have set the customer a reasonable deadline to meet their obligations.

IV. The customer hereby assigns to INOTEC GmbH the purchase price, wages or other receivables (including the recognised balance from a current account agreement or, in the event of insolvency on the part of the customer's business partner, the 'causal balance' available) at the amount of the invoice value for the goods subject to retention of title (inclusive of VAT) from the onward sale or further processing of the goods subject to retention of title, or which arise because of another legal reason (insurance, tort, loss of ownership caused by connecting the delivery item to a property); INOTEC GmbH hereby accepts the assignment. INOTEC GmbH revocably authorises the customer to collect receivables assigned to INOTEC GmbH for the account of INOTEC GmbH in their own name. This collection authorisation can only be revoked if the customer does not properly meet their payment obligations. In such a case and at the request of INOTEC GmbH, the customer must provide information on the assigned receivables which is required for collection, in addition to making corresponding documents available and notifying the debtor of the assignment. The assignment of receivables under sentence 1 serves to secure all receivables —
including in the future — from the business relationship with the customer.

§ 7
Notice of defects, rights in the event of material defects

I. If a contract is established with a consumer (§13 of the Civil Code [Bürgerliches Gesetzbuch, BGB]), the statutory provisions that entered into force on 01/01/2002 shall apply.

II. If the purchase is a commercial transaction for both parties, the customer must provide immediate notice of any defects in writing, provided that this is in line with the normal course of business. Notice of hidden defects, however, must only be given after they are discovered; otherwise the goods are considered to be accepted.

III. Insofar as the delivery item and/or the associated assembly service is defective, the customer can either request that the defect is remedied (repair) or that an item free of defects is delivered (replacement delivery) as supplementary performance, at INOTEC GmbH's discretion, for a period of 12 months from transfer of risk. If we are not prepared or are unable to carry out the repair/replacement delivery, particularly if this is delayed beyond a reasonable period for reasons for which we are responsible, or if the repair/replacement delivery fails in any other way, and if further attempts at supplementary performance are unreasonable for the customer, they shall be entitled to withdraw from the contract or to reduce the purchase price, at their discretion. If there is a negligible defect, the customer may only withdraw from the contract with our consent.

IV. No claims for material defects arise in the event of unsuitable or improper use or treatment of the goods, incorrect assembly or commissioning by the customer or third parties, natural wear and tear (especially for wearing parts), unsuitable equipment or operating conditions, inadequate maintenance, etc.

V. If the defective goods are third-party products, we are entitled to assign our claims for material defects against our sub-suppliers to the customer and to refer them to their (judicial) claim. A claim can only be made against us if claims against our sub-suppliers are not enforceable despite the (judicial) claim being made on time, or if the claim is unreasonable in the individual case.

§ 8
Limitation of liability

I. INOTEC GmbH shall be liable for intent and gross negligence.

II. INOTEC GmbH shall only liable for simple negligence if essential contractual obligations (cardinal obligations) have been breached, except in the case of injury to life, limb or health. Liability is limited to foreseeable damage typical for the contract.

III. Liability for indirect and unforeseeable damage, loss of production and use, loss of profits, loss of savings and financial losses due to claims by third parties is excluded in the case of simple negligence, except in the case of injury to life, limb or health.

IV. Further liability that goes beyond this contract is excluded, regardless of the legal nature of the asserted claim. However, the above limitations or exclusions of liability shall not apply to no-fault liability that is mandatory by law (e.g. in accordance with the Product Liability Act [Produkthaftungsgesetz]).

V. Insofar as liability under points II and III is excluded or limited, this shall also apply to the personal liability of INOTEC GmbH's employees, workers, representatives, bodies and vicarious agents.

§ 9
Fixed compensation for damages

I. If the buyer cancels the order before execution, INOTEC GmbH is entitled to demand 15% of the total order amount as compensation.

II. INOTEC GmbH's right to claim higher damage amounts remains unaffected.

§ 10
Documents, demonstration equipment, property rights

We shall retain title and copyrights to drawings, drafts, cost estimates and other documents provided by us, particularly samples and demonstration equipment. Documents and items may not be reproduced or made accessible to third parties without our explicit, specified consent.

§ 11
Place of jurisdiction, applicable law

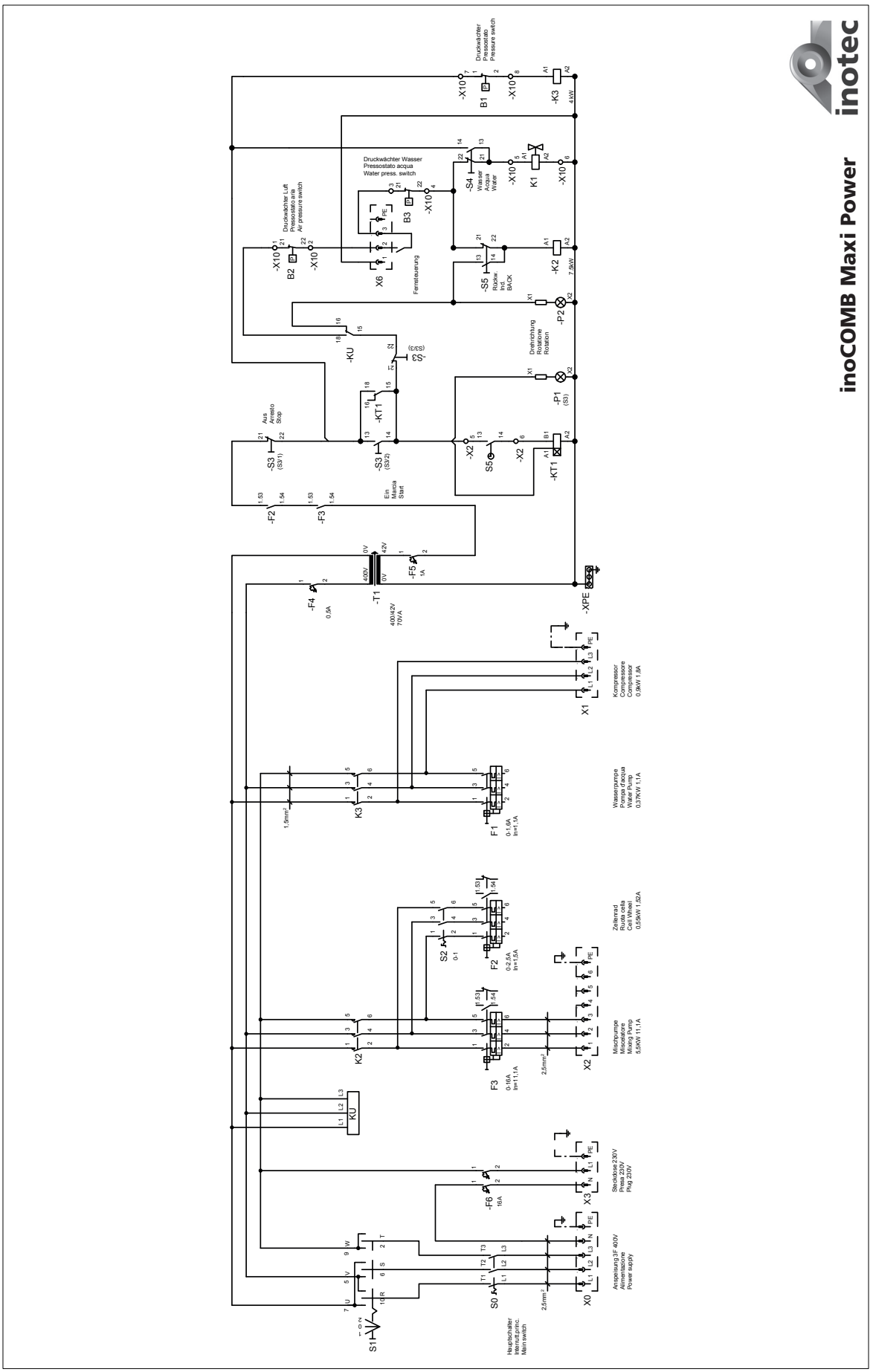
I. The law of the Federal Republic of Germany applies to these general terms and conditions and the entire legal relationship between INOTEC GmbH and the customer, excluding the UN Convention on Contracts for the International Sale of Goods (CISG).

II. If the customer is a merchant within the meaning of the Commercial Code (Handelsgesetzbuch), a legal entity under public law or a special fund under public law, the place of jurisdiction for all rights and obligations of the parties to the contract from any transaction — including those involving bills of exchange and cheque disputes — is Waldshut-Tiengen (Federal Republic of Germany). The same shall apply if the customer does not have a general place of jurisdiction in Germany, has moved their domicile or usual place of residence outside of Germany after concluding the contract, or their place of residence or usual place of residence is not known at the time when the action is filed. However, we are also entitled to sue the customer at their general place of jurisdiction.

INOTEC GmbH
Daimlerstraße 9-11
D-79761 Waldshut-Tiengen

Managing Director:
Manfred Schmidt
Jörg Tetling
Commercial Register:
Freiburg District Court HRB 621 131

14.3 Circuit diagram for inoCOMB Maxi Power



EN

15 Order form

Fax to: +49(0)7741-6805-665

Delivery address

Invoice to

Name of customer

Consultant

Date

Number	Item no.	Item name

Our General Terms of Business, Delivery and Payment apply. The customer has been made aware of these terms and agrees to the application of the same.
All goods shall be owned by us until we receive complete payment pursuant to Section 449 of the German Civil Code.

16 Index

17 Locations
Your sales partner (English language)

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Wherever you are, we're there, too.

inotec

Product range

Delivery pumps

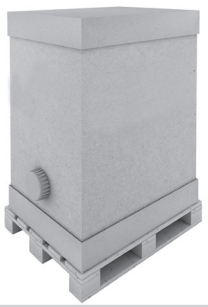
Mixing pumps

Mixers

Delivery systems

Silo technology

OWC technology



Airless devices

Cutters

Grinders

One-handed guns

Waste water systems

Tillage

Compressed air / compressors

Heaters / air dehumidifiers / high-pressure cleaners

Accessories & spare parts

Power tools / electrical appliances

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