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Model 1264*i* and 1264WL Powder Feeders

The 1264*i* powder feeder is a major, thoughtful 3 year redesign of the world renowned model 1264 feeder. The redesign includes the latest generation electronics, improved ergonomics, and enhanced features that current 1264 feeder users desired to help boost productivity, reduce costs, and improve consistency. The 1264*i* includes a sophisticated **Operator Interface Terminal (OIT)** pendant with touch-screen that can be remotely located, a **Programmable Logic Controller (PLC)** for powder feeder control, state-of-the-art electronics, and a removable, **50% larger powder hopper**. Features such as Plasma/HVOF mode selection, total run time, and a resettable run time are accessed from the user-friendly OIT. A set-temperature heater blanket keeps the powder warm and helps prevent the absorption of moisture. The Model 1264WL version has these same features and includes closed-loop feed rate control.

Increased spray time Importantly, the 1264*i* incorporates a *50% larger by volume, quick-change hopper*. This removable design allows hoppers to be used for storage of excess powder or dedicated for specific powders to prevent cross-contamination. This allows for rapid hopper replacement for increased uptime when switching between powders.

" Quick-change hopper design allows faster, easier powder changes, better purity control and increased uptime "

The Model 1264*i* Powder Feeder is a closed-loop pressurized unit specifically designed for thermal spray applications. Based on the proven volumetric-feed technology, the 1264*i* is high quality yet economical powder feeder for all powder-based thermal spray processes. Its proven design has become a standard in the thermal spray



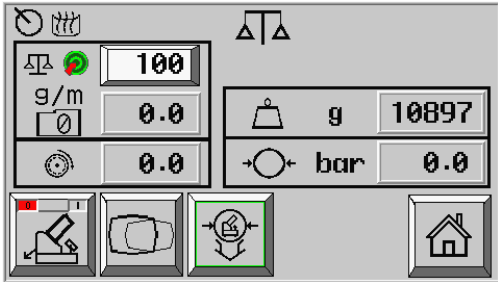
1264*i* / WL Powder Feeder

industry and offers unparalleled powder feeding accuracy and repeatability.

" A superior feeder using highly advanced technology and design, backed by over 3 decades of production use "

How it operates The 1264*i* feeder operates on a volumetric principle that directly controls the powder feedrate by the speed of the powder wheel. During operation, the slots in the powder wheel fill with powder. Gravity, carrier gas, and rotation of the variable-speed powder wheel deliver the powder to the powder hose. An inert carrier gas that provides hopper pressurization transports the powder through the hose to the thermal spray gun. A user-settable High/Low RPM warning informs the operator when the wheel RPM is beyond set tolerances. The feeder is not back-pressure sensitive and is rated for pressures of up to 125 PSI (862 kPa).

Control of powder feedrate by weight The Model 1264WL offers a new level of reliability and weight-loss control capability. Through rapid weight-loss over time calculations, the 1264WL automatically brings the powder feeder to the pre-programmed powder feedrate and maintains that feedrate for the duration of the spray run. Closed-loop feedrate control eliminates the apparent powder density variations and powder flow characteristics by adjusting the feeder wheel speed (RPM) to maintain the desired feedrate. The uncertainties associated with wheel speed feedrate control are thus eliminated.



1264WL Weight-Loss Control Screen

Due to the 1264WL's sophisticated PLC control program, the time to reach the desired feedrate is minimal. The program uses an algorithm based on the powder's apparent density to rapidly bring the feedrate to the desired set-point and simultaneously, the feeder RPM is adjusted to maintain the desired set point. The 1264WL allows the operator to save the set-points and powder apparent density data in its memory, allowing for quick powder feeding parameter changes.

The 1264WL has additional features such as user-settable Low Powder and High/Low Feedrate warnings which inform the operator when the hopper is almost empty of powder and out of feedrate set point respectively.

The 1264*i* / 1264WL are equipped with a powder shutoff valve that can be activated at the user's discretion. The valve is internally mounted and provides instantaneous, positive powder feed shutoff while maintaining hopper pressure which allows quick restarts and reduced powder consumption. Activation of the powder shutoff valve feature is recommended when the feeder is used with TAFE HP/HVOF[®] systems.

The 1264*i* and 1264WL can function as stand-alone units or be incorporated as an integral part of the sophisticated JP-8000 HP/HVOF and 7700

UPC Plasma and other systems requiring a better, more accurate powder feeder.

Features

- Removable, high capacity powder hopper
- Variable powder wheel speed
- Different wheels extend / optimize feedable powder choice
- Touch-screen controller (Remote Mountable)
- PLC control
- High/Low wheel RPM warning
- Powder hopper pressure display
- Powder hopper pressure-relief valve
- Plasma/HVOF mode selector
- Heater blanket with on/off control
- Low powder warning (1264WL only)
- High/Low feedrate warning (1264WL only)
- The 1264*i* and 1264WL Powder Feeders meet the stringent CE requirements.



1264*i* / WL Multi-Hopper Storage Rack

Options

- Model 1264WL Weight-Loss powder feed control
- Extra hoppers
- Powder Feeder cart
- Multi-hopper storage cart with heater blanket plug-in



1264i & 1264WL Powder Feeder Specifications	
Dimensions	33.7" (85.6 cm) high x 11.8" (29.9 cm) wide x 21.25" (54 cm) deep
Weight (w/out Powder Hopper)	84.5 lbs. (38.4 kg)
(with Powder Hopper)	106.5 lbs. (48.3 kg)
Hopper Weight (Empty)	22 lbs. (10 kg)
Powder Wheel Speed	2.0 – 25 RPM
Hopper Capacity	300 cubic inches (4916 cc)
Hopper Pressure Rating	125 PSI (862 kPa) maximum
Heater Blanket Temperature	125° F (52° C) ± 5° F
Utility Requirements	
Electrical	110/220 VAC @ 50/60 Hz, 10/5 A
Gas:	
Nitrogen (Carrier) OR	100 SCFH (47 l/min) max. at 100 psi (690 kPa)
Argon (Carrier)	140 SCFH (66 l/min) max. at 100 psi (690 kPa)

Ordering Information

Part Number	Description
800899	1264i Powder Feeder package
800900	1264WL Weight-loss Feed Control Powder Feeder
Options	
600979	Hopper Assembly (Spare)
800901	Hopper Storage Cart
1250-141	Fine powder wheel
1253-109	High-volume powder wheel
5008643	120-hole powder wheel
451760	240-hole powder wheel
	Powder Feeder Cart

For unparalleled closed-loop control of powder feedrate, either the 1264i or 1264WL are excellent choices that offer outstanding reliability, repeatability and accuracy.

Please contact our sales or customer service representatives to find out more about the 1264i and 1264WL options.

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