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Irish Standard  
I.S. EN 50177:2009

# Stationary electrostatic application equipment for ignitable coating powders - Safety requirements

## I.S. EN 50177:2009

*Incorporating amendments/corrigenda issued since publication:*

EN 50177:2009/A1:2012

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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN 50177/A1**

August 2012

ICS 87.100

English version

**Stationary electrostatic application equipment for ignitable coating  
powders -  
Safety requirements**

Matériels stationnaires de projection  
électrostatique de poudres de revêtement  
inflammables -  
Exigences de sécurité

Stationäre Ausrüstung zum  
elektrostatischen Beschichten mit  
entzündbaren Beschichtungspulvern -  
Sicherheitsanforderungen

This amendment A1 modifies the European Standard EN 50177:2009; it was approved by CENELEC on 2012-07-23. CENELEC members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this amendment the status of a national standard without any alteration.

Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN-CENELEC Management Centre or to any CENELEC member.

This amendment exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CENELEC member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

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# CENELEC

European Committee for Electrotechnical Standardization  
Comité Européen de Normalisation Electrotechnique  
Europäisches Komitee für Elektrotechnische Normung

**Management Centre: Avenue Marnix 17, B - 1000 Brussels**

## Foreword

This document (EN 50177:2009/A1:2012) has been prepared by CLC/SC 31-8 "Electrostatic painting and finishing equipment" of CLC/TC 31 "Electrical apparatus for potentially explosive atmospheres".

The following dates are fixed:

- latest date by which this document has to be implemented at national level by publication of an identical national standard or by endorsement (dop) 2013-07-23
- latest date by which the national standards conflicting with this document have to be withdrawn (dow) 2015-07-23

## **5 Requirements for the equipment**

In 5.2, Table 2, column 3, row 5.2.4, **delete** the reference to footnote <sup>b</sup>.

In 5.2, Table 2, **delete** footnote <sup>b</sup>.

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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN 50177**

October 2009

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Supersedes EN 50177:2006 + corr. Oct. 2007

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**Stationary electrostatic application equipment  
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Sicherheitsanforderungen

This European Standard was approved by CENELEC on 2009-09-01. CENELEC members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

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European Committee for Electrotechnical Standardization  
Comité Européen de Normalisation Electrotechnique  
Europäisches Komitee für Elektrotechnische Normung

**Central Secretariat: Avenue Marnix 17, B - 1000 Brussels**

## Foreword

This European Standard was prepared by SC 31-8, Electrostatic painting and finishing equipment, of Technical Committee CENELEC TC 31, Electrical apparatus for potentially explosive atmospheres.

The text of the draft was submitted to the formal vote and was approved by CENELEC as EN 50177 on 2009-09-01.

This European Standard supersedes EN 50177:2006 + corrigendum October 2007.

The following dates were fixed:

- latest date by which the EN has to be implemented  
at national level by publication of an identical  
national standard or by endorsement (dop) 2010-09-01
- latest date by which the national standards conflicting  
with the EN have to be withdrawn (dow) 2012-09-01

This European Standard has been prepared under a mandate given to CENELEC by the European Commission and the European Free Trade Association and covers essential requirements of EC Directive 94/9/EC. See Annex ZZ.

CENELEC/TC 31 as the responsible committee has concluded that this new edition of EN 50177 does not contain substantial changes regarding the ESRs.

The State of the Art is included in Annex ZY “*Significant changes between this European Standard and EN 50177:2006*”.

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## 0 Introduction

### 0.1 Process

During the electrostatic coating process the coating powder is transported in an air stream from a powder hopper up to an electrostatic spraying device. As the powder particles flow through the spraying device they are electrostatically charged by means of a high voltage of the order of some tens of kilovolts and ejected in the form of a cloud which is directed towards the workpiece. The charged particles of the cloud are attracted by and applied to the earthed workpiece.

Powder, that is not applied to the workpiece (overspray) is removed by a suction device or other means in the powder collection unit.

After the coating process the workpieces are introduced into an oven where the powder is melted and cured into a coherent coating.

### 0.2 Explosion hazards

An explosion could occur, if

- the concentration of coating powder in air is within the explosion limits,
- an ignition source of appropriate energy for this coating powder cloud is present.

Ignition sources could be, for instance, a hot surface, an open flame, an electric arc or a spark.

An explosion could be prevented, if one – or better both – conditions are avoided. Because it is very difficult to exclude the possibility of ignitable discharges completely, the main focus should be the prevention of ignitable concentrations of coating powder in air.

**0.2.1** Mixtures of ignitable coating powder and air could only explode within a given range of concentration, but not, if the concentration is above or below this range.

NOTE 1 If an explosive cloud of coating powder and air is trapped into a closed room, an explosion could lead to a fatal increase of pressure.

NOTE 2 The particle size distribution of coating powders is usually in the range of 5 µm to 120 µm.

**0.2.2** It is important that deposits of powder are not allowed to accumulate within the spraying areas for they may be whirled up and give rise to an explosive atmosphere. This does not apply to deposits on filter devices and accumulations of coating powder in hoppers where filters and hoppers are integrated in the spraying area and are designed to collect the coating powder. [See EN 12981:2005, 4.6].

**0.2.3** Particular attention should be paid to the prevention of electrostatic charges on different surfaces, which are in the vicinity of the powder cloud. This could apply to workpieces during the coating process or the reciprocating devices and the mounting parts of the powder spraying system etc.

### 0.3 Electric hazards

**0.3.1** Electric shock (by direct or indirect contact) could be generated, for instance, by contact with

- live parts, which are not insulated for operational reasons,
- conductive parts, which are not under dangerous voltage during normal operation, but in case of failure,
- insulated live parts whose insulation is insufficient or has been damaged due to mechanical influences.

**0.3.2** Inadequate grounding could occur, for instance, due to

- faulty connections to the protective grounding system,
- a too high resistance to ground.

**0.3.3** Hazards could occur, for instance, if hazardous malfunctions (e.g. shortcut of the electronic safety circuits, of access guards to dangerous areas or of warning devices) occur due to interferences of the high voltage equipment and the components of control and safety systems.

**0.3.4** Hazardous electrostatic discharges could be generated, for instance, by non-earthed conductive components or by large insulating surfaces, especially if they are backed with conductive material.

## 1 Scope

**1.1** This European Standard specifies the requirements for stationary electrostatic application equipment for ignitable coating powders to be used in explosive atmospheres generated by their own spray cloud. A distinction is made between spraying systems corresponding to EN 50050:2001 and spraying systems designed for higher discharge energies and/or currents. The charging of ignitable coating powder can be achieved by applying high voltage or triboelectrically.

This European Standard also specifies the design-related requirements for a safe operation of the stationary equipment including its electrical installation.

**1.2** This European Standard considers three types of electrostatic spraying systems; see 5.1 for more details.

**1.3** This European Standard deals with all hazards significant for the electrostatic spraying of coating materials, which could also contain small quantities of added metal particles, if the work is carried out under conditions recommended by the manufacturer. In particular, this includes ignition hazards resulting from the generated explosive atmosphere, and the protection of persons from electric shocks.

**1.4** This stationary equipment is classified as equipment of group II, category 2D or category 3D for use in potentially explosive areas of zone 21 or 22, respectively.

NOTE For other safety aspects like

- zone classification of the areas in and around spray booths, see EN 12981:2005, 5.6.2.3;
- zone classification of other areas with explosive atmosphere, see EN 60079-10-2;
- selection, erection and application of other electrical and non electrical equipment in areas with explosion hazard, see EN 60079-14 and EN 12981:2005, 5.6.2.4;
- health protection (for instance, noise) see also EN 12981:2005, 5.4 and EN 14462;
- cleaning of spraying areas, see instruction manual of the spraying equipment;
- fire prevention and protection (for instance fire hazards due to other sources) see also EN 12981:2005, 5.6;
- explosion protection system, see EN 12981:2005, 5.6.2.5;
- dust hazards, see EN 12981:2005, 5.5.

Design-related measures for reducing the generation of noise of the stationary equipment for electrostatic coating are given in EN ISO 11688-1. See also EN 14462.

## 2 Normative references

The following referenced documents are incorporated for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 1081, *Resilient floor coverings – Determination of the electrical resistance*

EN 1127-1, *Explosive atmospheres – Explosion prevention and protection – Part 1: Basic concepts and methodology*

EN 1149-5, *Protective clothing – Electrostatic properties – Part 5: Material performance and design requirements*

EN 12981:2005, *Coating plants - Spray booths for application of organic powder coating material - Safety requirements*

EN 13463-1, *Non-electrical equipment for use in potentially explosive atmospheres – Part 1: Basic method and requirements*

EN 13478:2001, *Safety of machinery – Fire prevention and protection*

EN 50050:2001, *Electrical apparatus for potentially explosive atmospheres – Electrostatic hand-held spraying equipment*

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