Last update: 28.08.2025

**Lipsia Automation GmbH**

# Principles of System Design and Assembly

Customer-side conditions on site:

1. Temperature (+10°C to +30°C), humidity (max. 60%).
2. The access routes allow all systems to be brought into and assembled in the customer's premises in their transport-friendly units.
3. The load capacity and condition of the floors/ceilings/walls allow all systems to be set up, fastened and operated.
4. Equipment for unloading, assembly, cleaning, inspection and maintenance (e.g. lifting equipment, forklift trucks, scaffolding and other equipment) shall be provided by the customer in accordance with our specifications.
5. The customer shall ensure safe and unhindered access to the work site.
6. The connection of all necessary media (electricity, water, compressed air, sewage pipe) is guaranteed on site up to the point of need.
7. All structural changes such as necessary supporting structures for ceiling suspensions, wall breakthroughs, floor drilling, as well as panel and concrete work, are carried out by the customer.
8. Weatherproof interim storage of system parts, materials and tools during assembly is guaranteed by the customer.
9. The customer is responsible for the final cleaning of the system before commissioning (or before the start of production).
10. Sanitary facilities for the assembly personnel must be provided on site in an appropriate proximity to the assembly site.

Standard design of the conveyors/systems:

1. All parts that come into contact with food are made of stainless steel or plastic in accordance with Food Contact Regulation (EC) No. 1935/2004.
2. Colour of the conveyor belts and plastic parts: specific to the supplier.
3. Steel grade for frame and support: 1.4301.
4. Processing of weld seams: at least mechanically treated.
5. Height adjustability +/- 50 mm; greater levelling of uneven floors upon request.
6. Design of the drives according to the design classes.
7. Unless otherwise agreed, execution class A applies.

Standard configuration of the electrical equipment:

1. Cable routing: open mesh trays.
2. The function of the system determines the use of frequency converters.
3. The function of the system determines the type of control (contactor or PLC).
4. The function of the system determines the type of operation (display or button).
5. The decision as to whether a remote maintenance module is installed depends on the requirements of the system.
6. Design of the control cabinet according to the configuration classes; distance to the Lipsia-equipment max. 10 m, same level.

Last update: 28.08.2025

# Configuration Classes according to Cleaning Requirements

| | **Class A**<br><br>**Occasional wet cleaning** | **Class B**<br><br>**Wet cleaning possible; all sensitive areas must be protected by the operator** | **Class C**<br><br>**High-pressure cleaning is generally possible; drives must be protected by the operator** | **Class D**<br><br>**High-pressure cleaning possible without restrictions** |
|---|---|---|---|---|
| **Switch cabinet** | Painted black steel, without sloping roof | Welded with austenitic steel, without sloping roof | Welded with austenitic steel, with sloping roof | Welded with austenitic steel, without sloping roof (hygienic design) |
| **Protection class** | IP 65 | IP 65 | IP 65 | IP 67 |
| **Weld seam** | At least mechanically treated | pickled | pickled | pickled |
| **Drives** | Aluminum painted or anodized, without cover | Aluminum painted or anodized, without cover | Aluminum painted or anodized, with cover | antiseptic design or welded with austenitic steel |
| **Ceiling suspension and mesh cable trays design** | FeZn or austenitic steel | FeZn or austenitic steel | Austenitic steel | Austenitic steel |