IS0214 - Vacuum Feeder Installation

Version 7/14

Important Information

WARNING!

Read and follow all instructions, warnings, tags, and labels before operating the equipment. Only qualified personnel should perform this procedure. USE OF THIS EQUIPMENT IN A MANNER OTHER THAN DESCRIBED IN THIS INSTRUCTION SHEET, AND FAILING TO FOLLOW ALL INSTRUCTIONS, COULD RESULT IN PERSONAL INJURY, DEATH, OR EQUIPMENT DAMAGE.

All equipment is to be installed, and all connections made, by only qualified personnel. Components and accessories are to be installed in accordance with the instructions provided, and applicable codes for the region installed. FAILURE TO FOLLOW THESE INSTRUCTIONS COULD RESULT IN A PERSONAL INJURY, DEATH, OR EQUIPMENT DAMAGE.
Protective clothing and gear should be worn at all times when performing hot-melt tasks.

Power Requirements

Voltage (VAC)	Phase (Ø)	Current (A)
120/220	1	1

A 3 ft. power cord is supplied with each system, unless noted otherwise.

Installation

Please follow these instructions for all units then follow the unit-specific instructions.

For unit drawings and parts lists, refer to “Parts Lists” (page 14).

Proceed according to the unit:

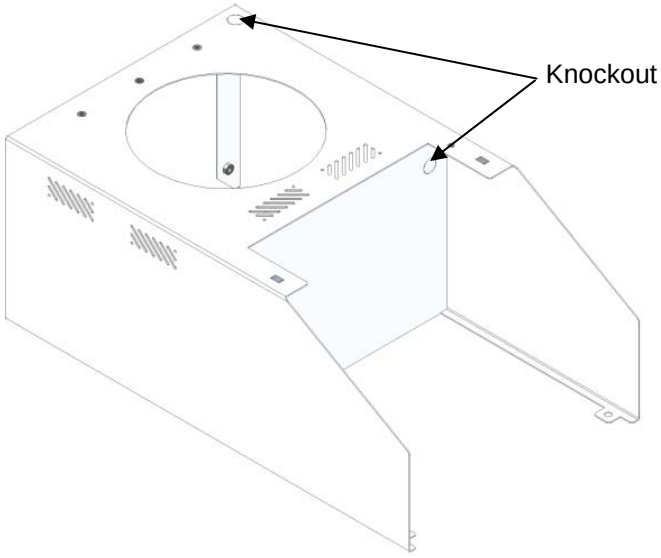
Follow all steps on page 13 after installation.

D-E

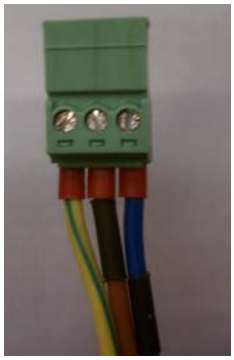
1. Ensure the top of the Level Probe is approximately 1” above the cord grip for a D4-E, and approximately 1/4” above for a D10-E.

> Pull on the wire from the bottom of the auto feed box if more wire length is needed.

2. Remove the current lid and hinge from the unit and discard.
3. Attach the new hinge to the unit using three (3) M6 button head cap screws taken from the old hinge.
4. Attach the new lid with auto feed to the top of the unit.
5. Remove the knockouts from the rear corner of the case, and from the panel separating the electrical cabinet from the reservoir.

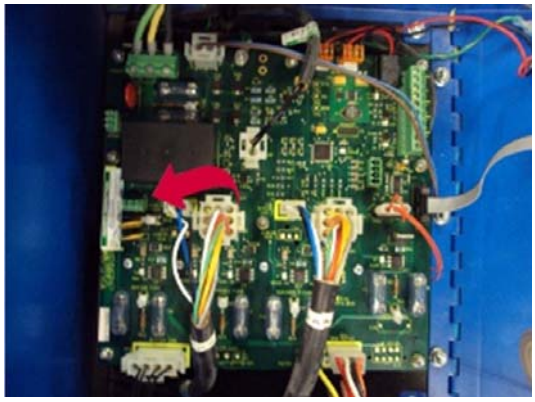


6. Attach cord grips into the holes left by the knockouts.
7. Run the leads through the cord grips to the power board.
8. Connect the wires into the three-pin, inverted connector as shown (yellow/green, brown and blue, respectively).



9. Attach the connector to the open “fused AC connector” on the power board.

D4-E – Continued

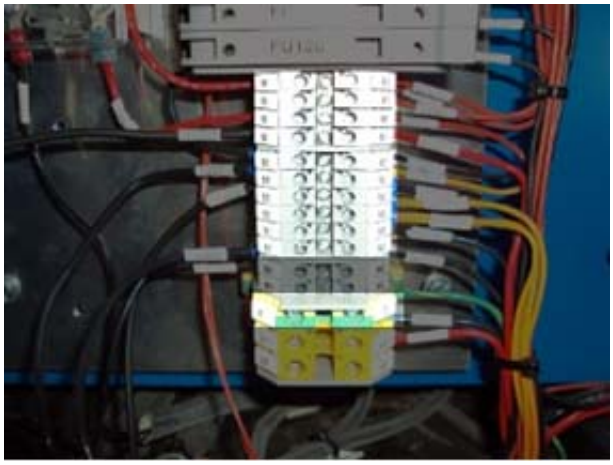


NC 20, 30, and 40

CAUTION! Make sure the top of the level probe is approximately 1/4” above the cord grip.

Pull the wire from the bottom of the auto feed box if more wire length is needed.

10. Remove the current lid from the unit and discard.
11. Attach the new lid with auto feed to the top of the unit.
12. Insert brown wire in to any free “L2” opening.
13. Insert blue wire in to any free “L1” opening.
14. Insert green/yellow wire in to any free green/yellow opening.

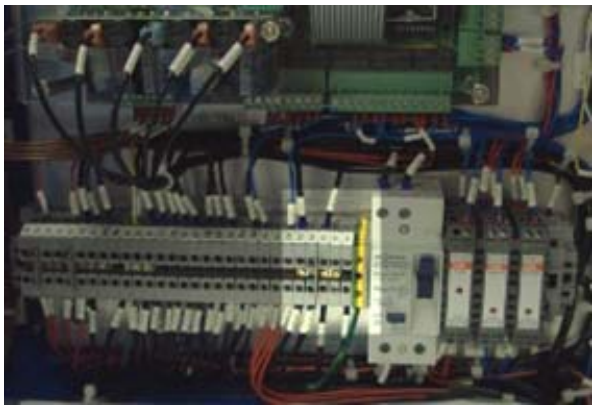


S-18, S-24, S-48, S-90

1. Make sure the top of the level probe is approximately 1/4” above the cord grip.

> Pull on the wire from the bottom of the auto feed box if more wire length is needed.

2. Remove the current lid from the unit and discard.
3. Attach the new lid with auto feed to the top of the unit.
4. Connect the blue wire with terminal 3010.
5. Connect the brown wire with terminal 3011.
6. Connect the yellow/green wire to the yellow/green terminal to the right of terminals 3010 and 3011.



Nordson 3100, 3400, 3500

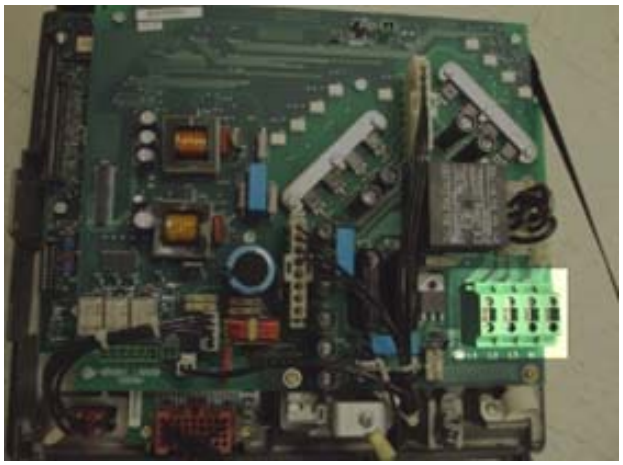
1. Make sure the top of the level probe is approximately 1/4” above the cord grip.

> Pull on the wire from the bottom of the auto feed box if more wire length is needed.

2. Remove the piston cover
3. Remove the lid and base plate from the top of the Nordson unit and place the eight (8) machine screws aside.
4. Discard the old lid and base.
5. Attach the new base plate using the eight (8) machine screws from the previous step.

Nordson 3100, 3400, 3500 - Continued

6. Place the new lid onto the new base plate
7. Push an E-clip onto one of the slotted sections near the end of the hinge rod.
8. Slide the side opposite of the side with the E-clip into of the hinge rod holes on the lid.
9. Push the hinge rod to the other side of the lid until the side with the E-clip is as far over as possible.
10. Push the other E-clip into the other slot on the hinge rod.
11. Attach the blue wire to the terminal labeled “N”.
12. Attach the brown wire to the terminal labeled “L1”, “L2”, or “L3”.
13. Attach the yellow/green wire to an open yellow/green terminal.



Nordson MESA M9

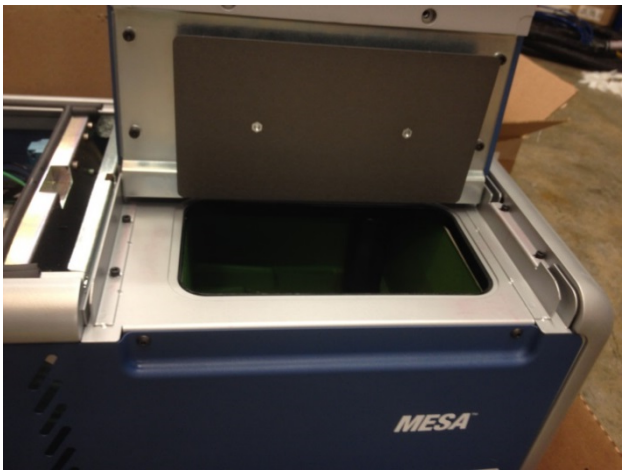
1. Ensure the top of the level probe is approximately 1/4” above the cord grip.

   Pull on the wire from the bottom of the auto feed box if more wire length is needed.

2. Remove the piston pump cover and place the two (2) socket head screws aside.

Nordson MESA M9 – Continued

3. Remove the lid and tank mounting bracket from the top of the Nordson unit and place the seven (7) socket head screws aside.



4. Discard the old lid and tank mounting bracket.

5. Attach the new tank mounting bracket with vacuum feeder using the seven (7) socket head screws from the previous step. Be sure to apply downward pressure to full seat the tank mounting bracket.

6. Reattach the piston pump cover.

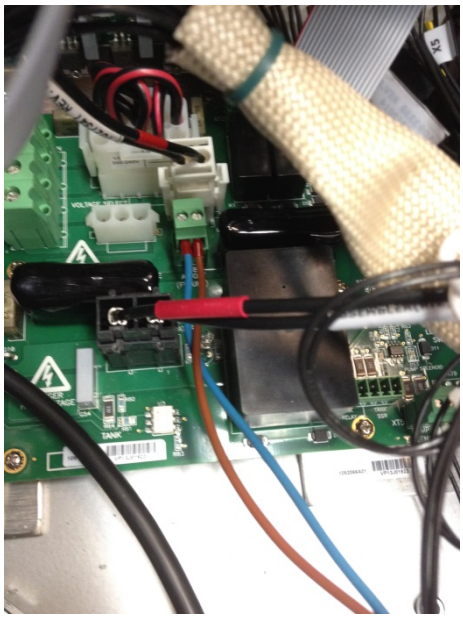
> This auto feed is supplied with a 9’ power cord.

7. Route the cable to back of unit.

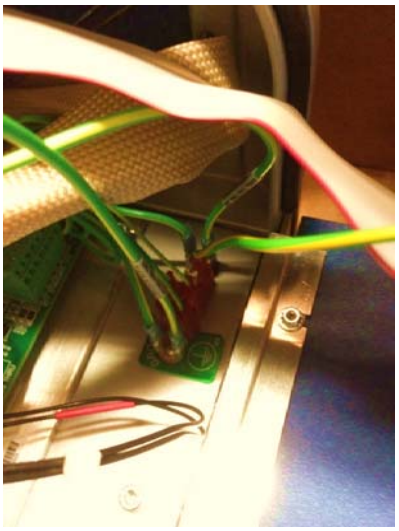
Nordson MESA M9 – Continued

8. Route the cable along the side of unit using the clips provided.

9. Install cord grip and route the cable into the electrical cabinet.
10. Connect the wires to the two pin, inverted connector as shown (blue and brown respectively) and plug in the connector to the open “AC OUT” connector on the power board.



11. Attach the green/yellow wire to an open quick disconnect ground terminal.

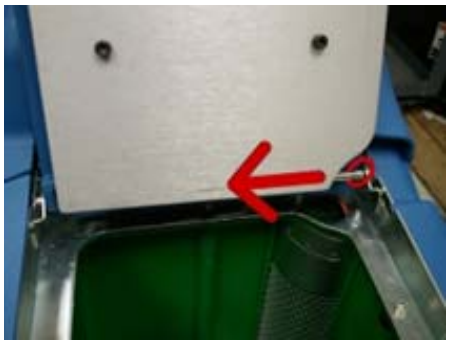


Nordson Pro-Blue 7 and 10 (Left Hinge)

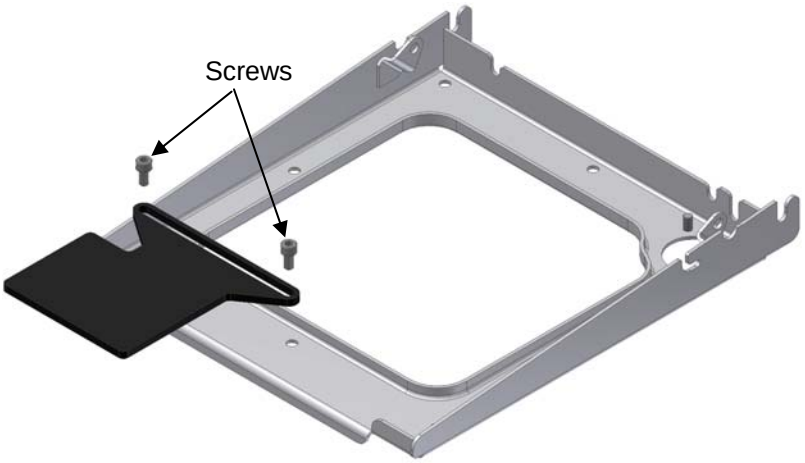
1. Make sure the top of the level probe is approximately 1/4” above the cord grip.

> Pull on the wire from the bottom of the auto feed box if more wire length is needed.

2. Remove the current lid from the Nordson ProBlue 7 or 10 by opening the lid and pulling back of the right side of the hinge rod.



3. Discard the Nordson lid assembly.
4. Remove the two (2) screws from the locations indicated below.



5. Place the foot tap over the holes and reattach, using the two (2) screws that were removed in the previous step.
6. Place the new lid with auto feed to the top of the unit.

Nordson Pro-Blue 7 and 10 (Left Hinge) - Continued

7. Push an E-clip into one of the slotted sections near the end of the hinge rod.
8. Slide the side opposite of the side with the E-clip into the hinge rod holes on the lid.
9. Push the hinge rod to the other side of the lid until the side with the E-clip is as far over as possible.
10. Push the other E-clip into the other slot on the hinge rod.
11. Remove one of the knockouts from the back of the Nordson unit and open the back panel.
12. Feed the three power supply wires from the auto feed through the knockout and into the board as shown below.

WARNING!

The Nordson Pro-Blue series has an option for 480 VAC operation. If operating the unit at this voltage, an external power supply with an output of 110-120 VAC or 220-240 VAC is required to power the auto-feed system.

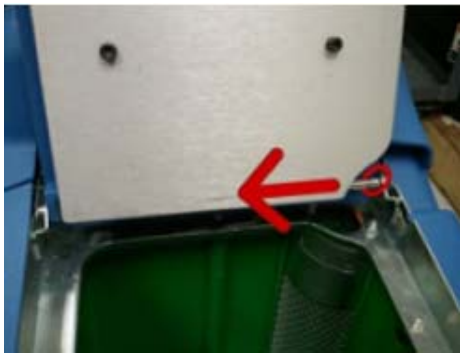
Nordson Pro-Blue 4, 7 and 10 (Front/Rear Hinge)

All pictures included in this section show an auto feed front hinge. The installation procedure is the same for the auto feed with the rear hinge.

1. Ensure that the top of the level probe is about .25” above the cord grip.

Pull on the wire from the bottom of the auto feed box if more wire length is needed.

2. Remove the current lid from the Nordson Pro-Blue unit by opening the lid and pulling back on the right side of the hinge rod.

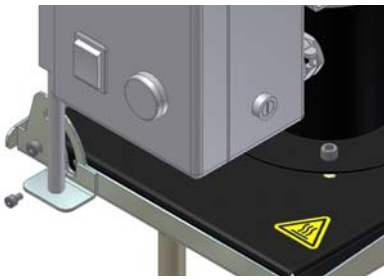


3. Remove the float switch from the tank bracket.

Nordson Pro-Blue 4, 7 and 10 (Front/Rear Hinge) - Continued

4. Remove the Nordson tank bracket by removing the M5 socket head cap screws.
5. Discard the Nordson lid, tank bracket and mounting hardware.
6. Attach the new tank bracket using the M5 button head cap screws provided.
7. Reattach the float switch that was removed in step #3.
8. Insert the new lid with auto feed into the hinge mounting holes on the tank bracket by angling the lid assembly down and to the side.
9. Once the hinge rod is in the hole on the far side, close the lid.
10. Slide the entire lid forward until the hinge rod is in the mounting hole on the closest side.
11. Secure the lid in place using the M5 socket head cap Nyloc screw provided.

12. Insert the M4 socket head cap screw into the slot on the tank bracket and tighten completely.



13. Remove one of the knockouts from the back of the unit and open the back panel.
14. Feed the three power supply wires from the auto feed through the knockout and into the board as shown below.

WARNING!

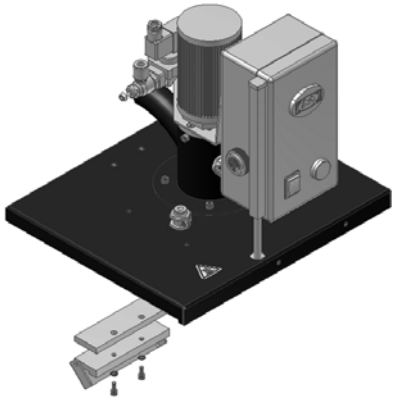
The Nordson Pro-Blue series has an option for 480 VAC operation. If operating the unit at this voltage, an external power supply with an output of 110-120 VAC or 220-240 VAC is required to power the auto-feed system.

Nordson Pro-Blue 15

1. Make sure the top of the level probe is approximately 1/4” above the cord grip.

> Pull on the wire from the bottom of the auto feed box if more wire length is needed.

2. Remove the hinge from the previous Nordson lid by removing the two (2) M5 socket head cap screws attached to the lid and the two (2) fasteners securing the lid to the unit. Save both the hinge and the fasteners used to secure to the unit.
3. Discard the Nordson lid.
4. Place the hinge plate between the hinge and the outer lid, and attach the two (2) M5 socket head cap screws.



5. Secure the lid to the unit using the two fasteners removed in step 2.

> If necessary, push back or anchor the wires running in the location where the activator rod engages with the base of the unit.

6. Close the lid and ensure that the auto feed activates by listening for the click of the switch in the activator rod. If the auto feed does not engage, unscrew the rubber foot of the rod until you hear activation. If necessary, replace the rubber foot with a longer M4 fastener.
7. Remove one of the knockouts from the back of the Nordson unit and open the back panel.
8. Feed the three power supply wires from the auto feed through the knockout and into the board as shown below.

> This auto feed is supplied with a 9’ power cord.

WARNING! The Nordson Pro-Blue series has an option for 480 VAC operation. If operating the unit at this voltage, an external power supply with an output of 110-120 VAC or 220-240 VAC is required to power the auto-feed system.

Slautterback KB100

1. Ensure that the top of the level probe is about .25” above the cord grip.

> Pull on the wire from the bottom of the auto feed box if more wire length is needed.

2. Remove the top portion of the case from the Slautterback KB100 by removing the ten (10) self tapping screws holding the top of the unit on.

3. Remove the current lid from the unit by removing the four (4) button head cap screws and four (4) hex nuts.

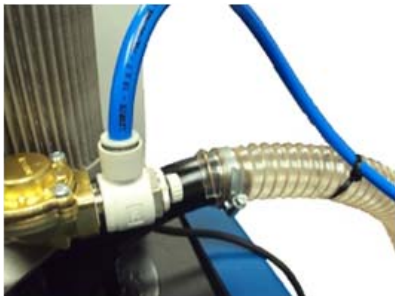
4. Discard the Slautterback lid.
5. Attach the new auto feed to the case that was removed in step #1 using four (4) M5 hex head cap screws four (4) M5 lock washers and four (4) M5 hex nuts.
6. Reattach the top portion of the case that was removed using the ten (10) self tapping screws.

> An external power source is necessary for this auto feed system.

Finishing Attachments

1. If needed, use the supplied 10mm tubing and 10mm to 3/8" adapter for the air line input.
2. If supplied, remove the yellow cap on the end of the adhesive inlet.
3. Using a Phillips head screwdriver tighten the hose clamp so the hose is securely fastened to inlet.

4. Attach the blue air line hose from the adhesive transporting tube to the top of the needle regulator outlet port as shown below.

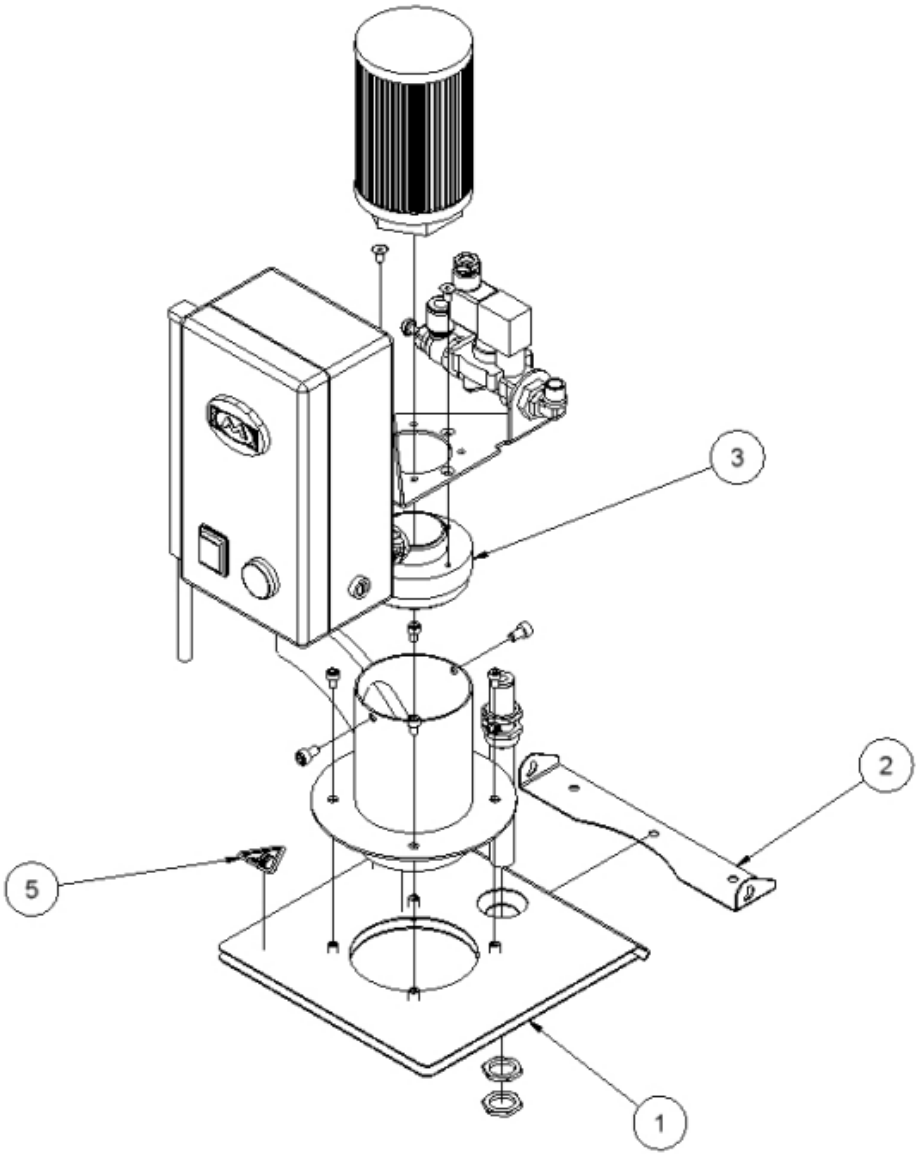


5. Attach the air line from any source to the inlet port on the regulator (needle valve can be turned, to adjust for variations in input pressure).

See IS0274 for Operation and Calibration instructions.

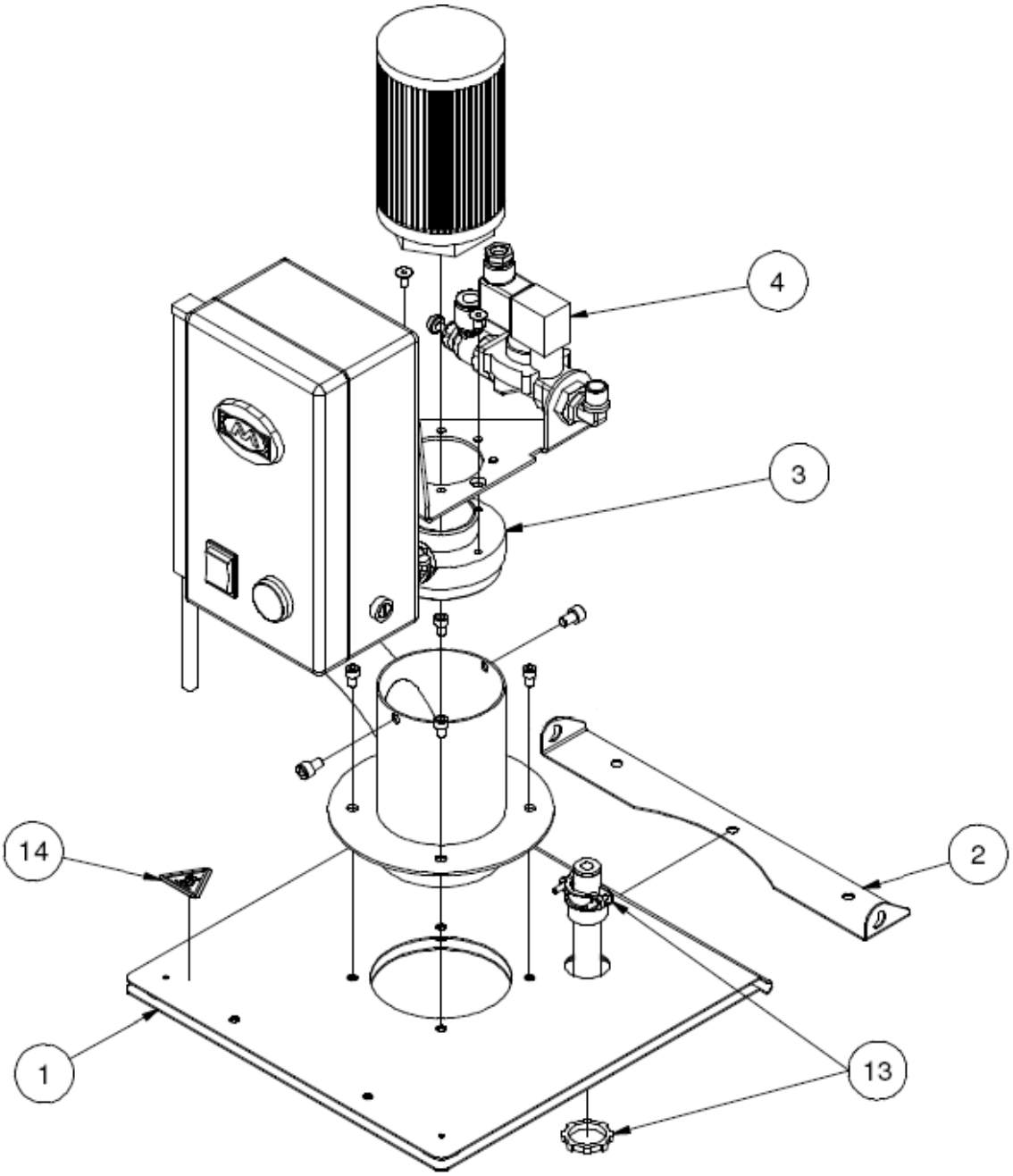
Parts List

External Vacuum Feeder - D4-E (776xx043)



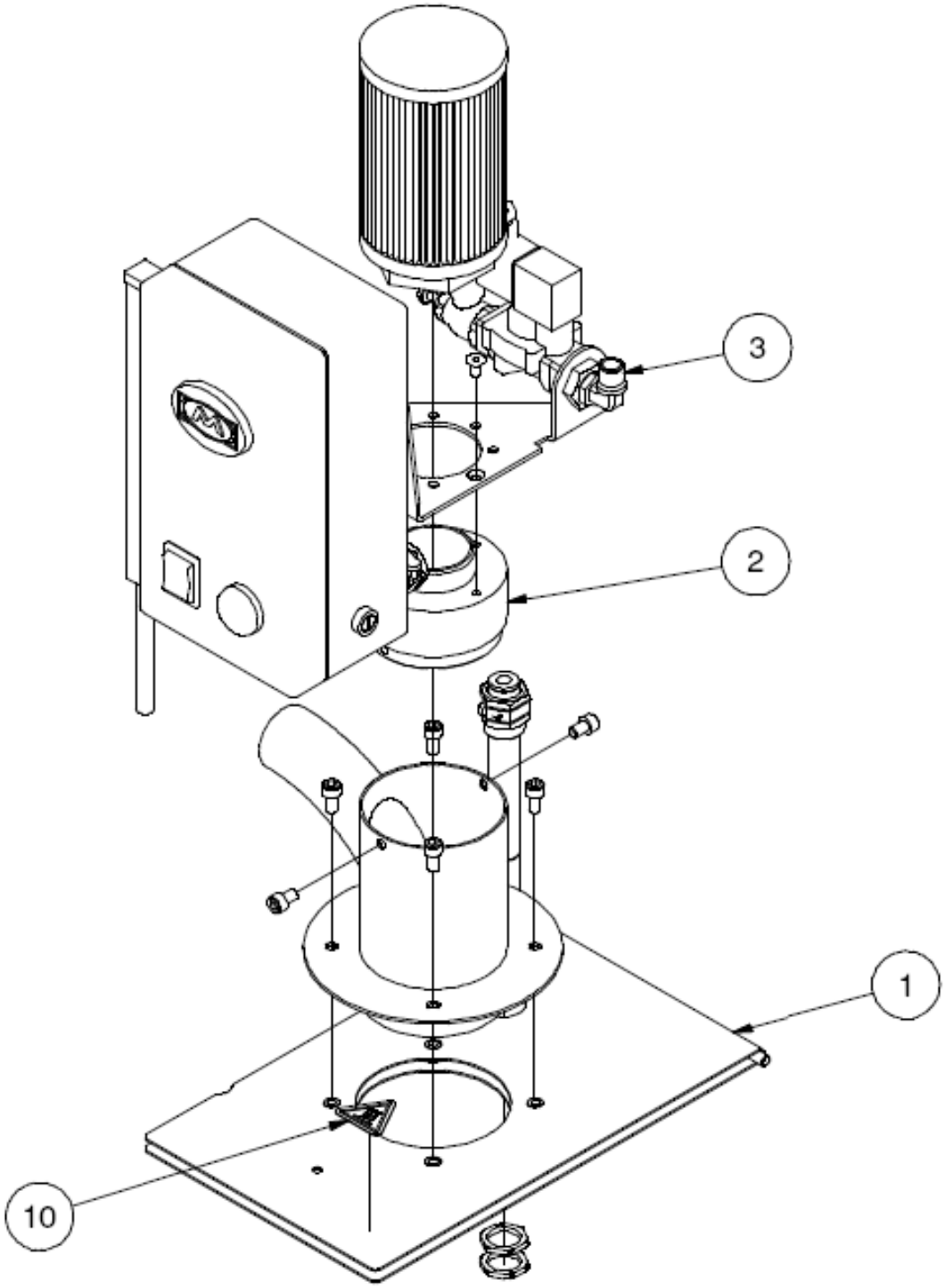
Item	Part #	Description	QTY
1	776XX041	LID, RESERVOIR, D4-E	1
2	776XX042	BRACKET,RESERVOIR LID,D4-E	1
3	776XX123	ADAPTER, AIR FILTER, D4-E	1
4	988XX342	VACUUM FEEDING SYSTEM C, K0342	1
5	781XX629	LABEL,WARNING-HOT SURFACE	1
7	070XX610	PLUG, T.B.,3 PIN 3.81 INVERT	1
8	781XX629	LABEL,WARNING-HOT SURFACE	1
9	IS0214	IS, ASSY: PROC, HOPPER FEEDER	1
12	066XX160	CORD GRIP	2

External Vacuum Feeder - D10-E (776XX784)



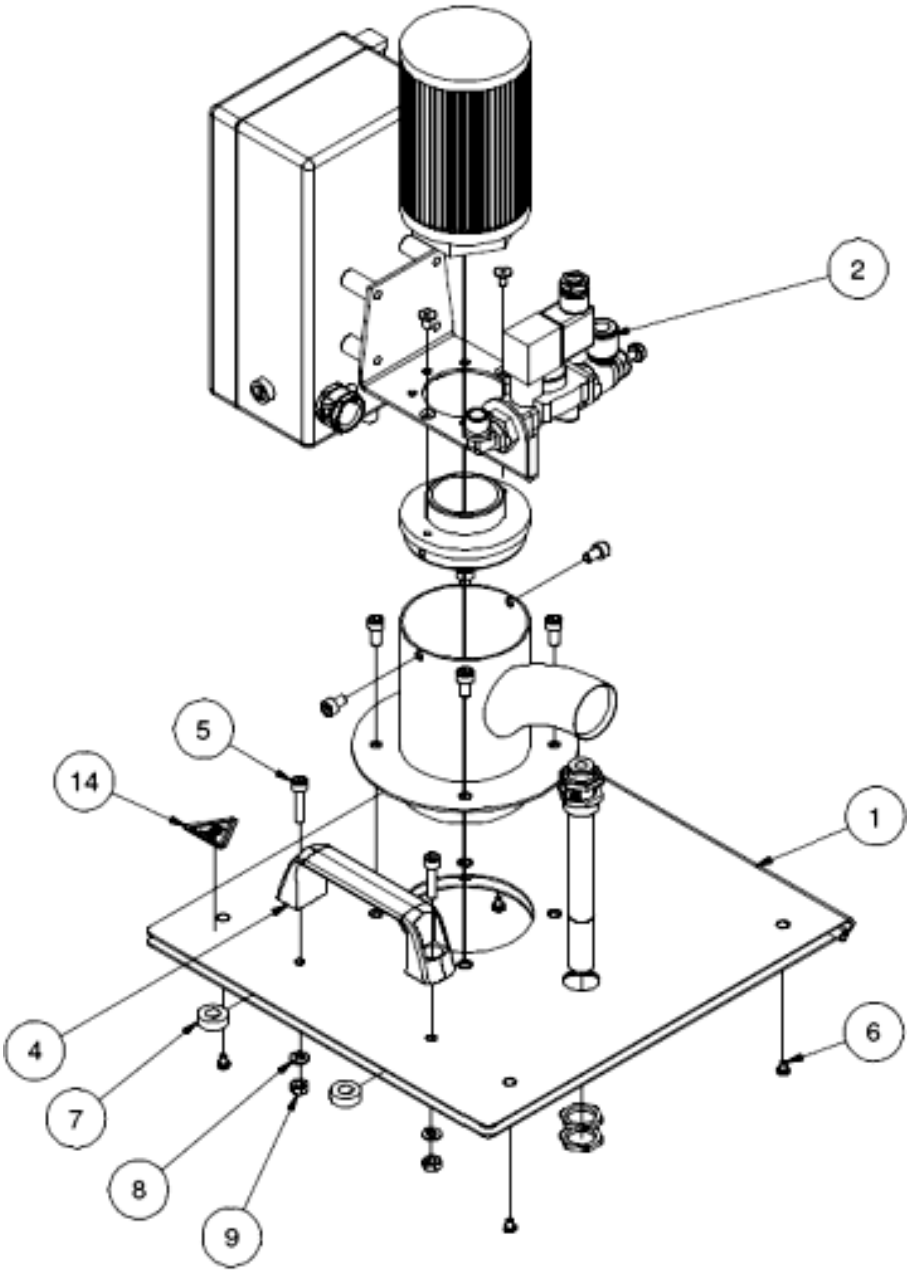
Item	Part #	Description	QTY
1	776XX159	LID RESERVOIR	1
2	776XX158	BRACKET RESERVOIR LID D10	1
3	776XX123	ADAPTER, AIR FILTER, D4-E	1
4	988XX342	VACUUM FEEDING SYSTEM C, K0342	1
7	070XX610	PLUG, T.B.,3 PIN 3.81 INVERT	1
9	IS0214	IS, ASSY: PROC, HOPPER FEEDER	1
13	066XX205	CABLE CLAMP	2
14	781XX629	LABEL,WARNING-HOT SURFACE	1

External Vacuum Feeder - NC 20, 30 or 40 (776XX027)



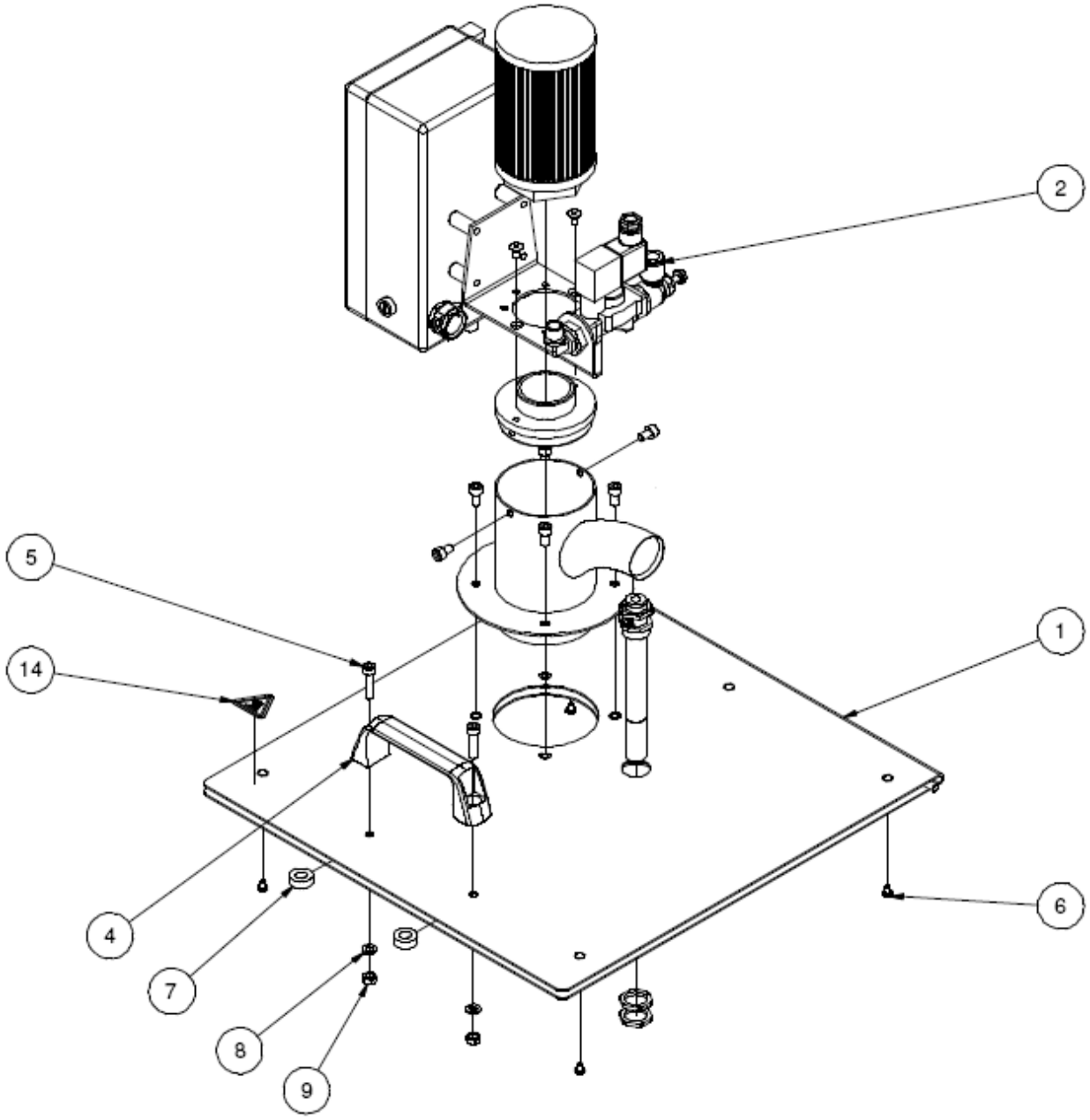
Item	Part #	Description	QTY
1	776XX104	LID, RESERVOIR, NC-20,30,40	1
2	776XX017	ADAPTER, AIR FILTER	1
3	988XX342	VACUUM FEEDING SYSTEM C, K0342	1
7	IS0214	IS, ASSY: PROC, HOPPER FEEDER	1
10	781XX629	LABEL,WARNING-HOT SURFACE	1

External Vacuum Feeder - S18 (776XX055)



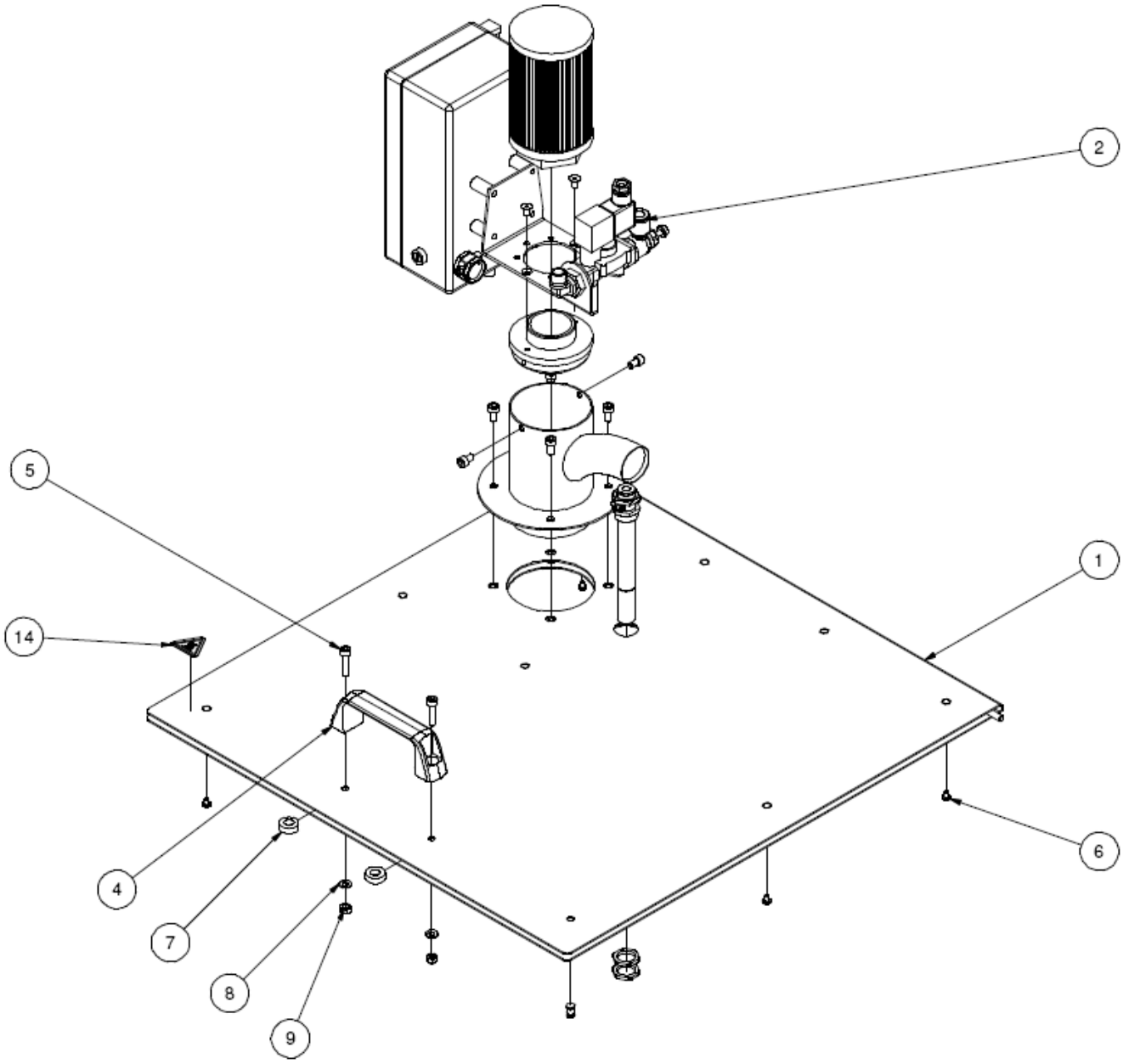
Item	Part #	Description	QTY
1	776XX056	LID, RESERVOIR, S18	1
2	988XX342	VACUUM FEEDING SYSTEM C, K0342	1
4	104XX135	HANDLE, PULL	1
5	798XX192	SCREW	2
6	784XX682	SCREW	4
7	768XX677	SPACER	2
8	784XX600	LOCK WASHER	2
9	793XX491	NUT	2
11	IS0214	IS, ASSY: PROC, HOPPER FEEDER	1
14	781XX629	LABEL,WARNING-HOT SURFACE	1

External Vacuum Feeder - S24, S48 (776XX053)



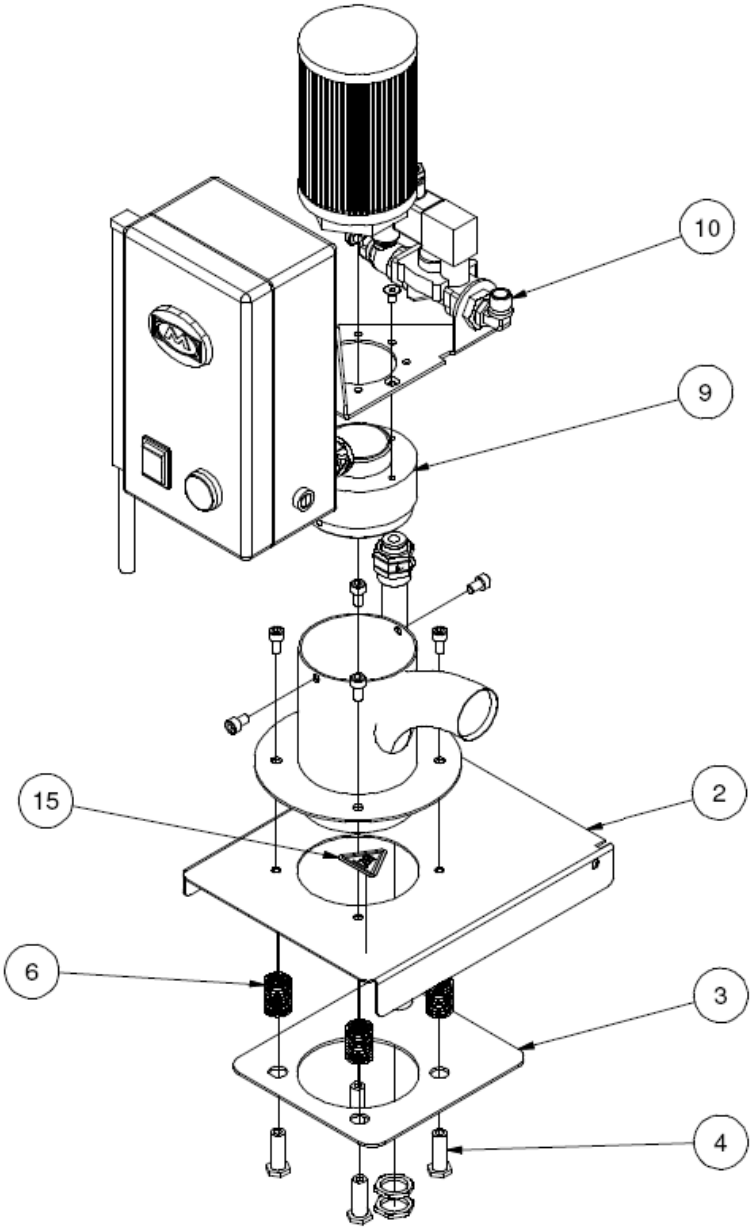
Item	Part #	Description	QTY
1	776XX054	LID, RESERVOIR, S24 & S48	1
2	988XX342	VACUUM FEEDING SYSTEM C, K0342	1
4	104XX135	HANDLE, PULL	1
5	798XX192	SCREW	2
6	784XX682	SCREW	5
7	768XX677	SPACER	2
8	784XX600	LOCK WASHER	2
9	793XX491	NUT	2
11	IS0214	IS, ASSY: PROC, HOPPER FEEDER	1
14	781XX629	LABEL,WARNING-HOT SURFACE	1

External Vacuum Feeder - S90 (776XX051)



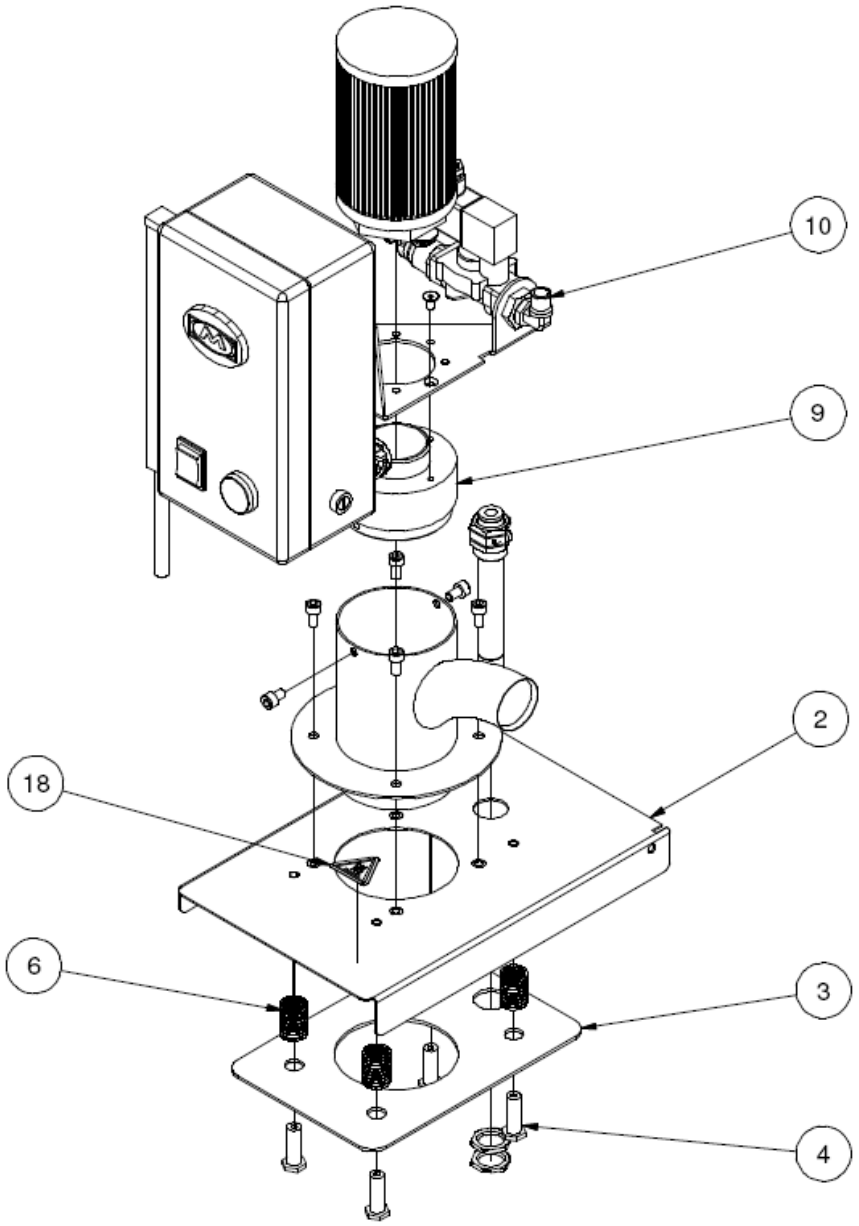
Item	Part #	Description	QTY
1	776XX052	LID, RESERVOIR, S90	1
2	988XX342	VACUUM FEEDING SYSTEM C, K0342	1
4	104XX135	HANDLE, PULL	1
5	798XX192	SCREW	2
6	784XX682	SCREW	9
7	768XX677	SPACER, 0.25 IN.	2
8	784XX600	WASHER	2
9	793XX491	NUT	2
11	IS0214	IS, ASSY: PROC, HOPPER FEEDER	1
14	781XX629	LABEL,WARNING-HOT SURFACE	1

External Vacuum Feeder - Nordson 3100 (776XX045)



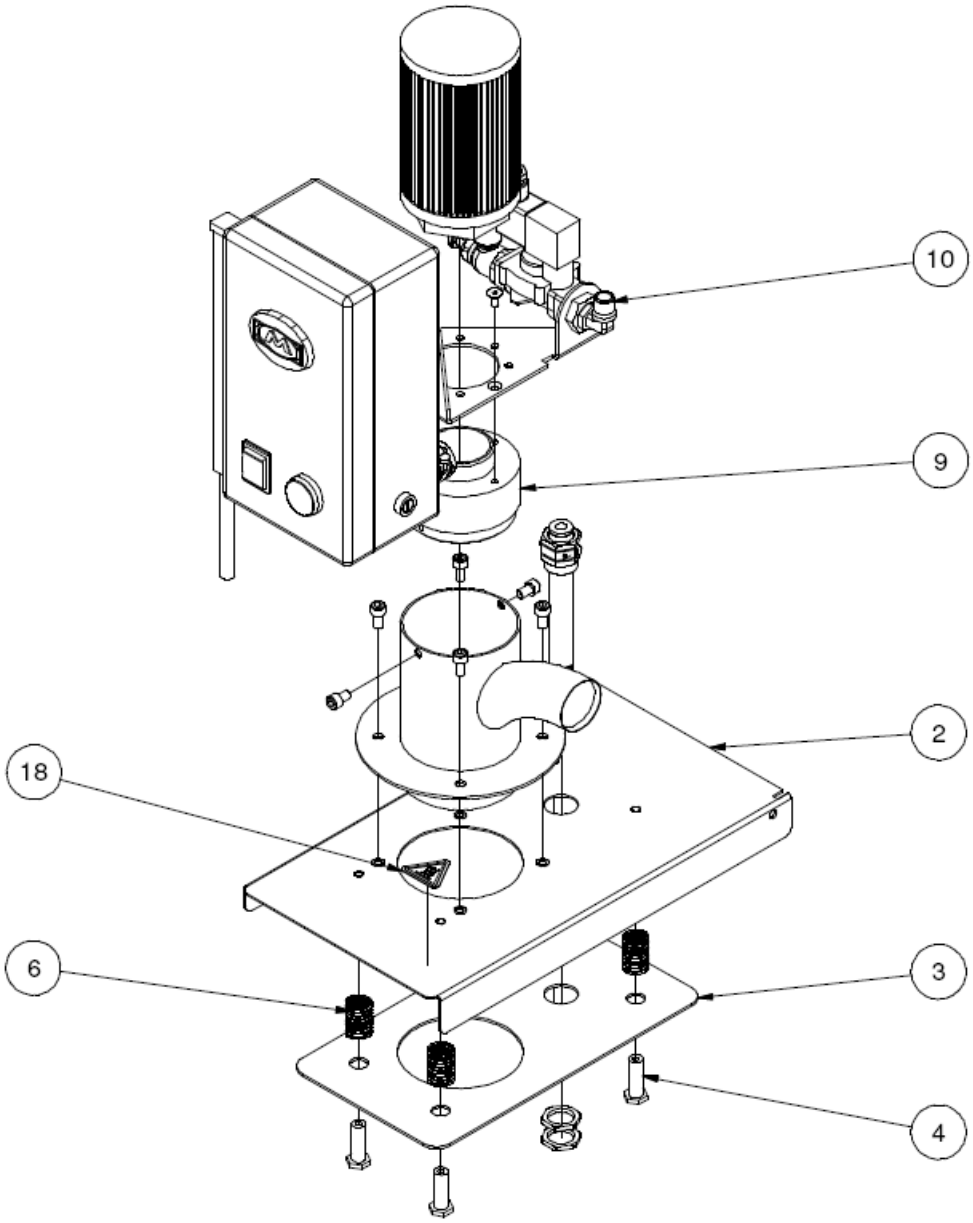
Item	Part #	Description	QTY
1	776XX048	PLATE; BASE	1
2	776XX047	LID; UPPER	1
3	776XX046	LID; INNER	1
4	776XX050	STANDOFF; HOPPER FEEDER	4
5	783XX335	E-CLIP, EXTERNAL	2
6	783XX220	SPRING,COMPRESSION	4
7	798XX758	FLAT WASHER	1
8	776XX049	HINGE PIN, HOPPER FEEDER	1
9	776XX017	ADAPTER, AIR FILTER	1
10	988XX342	VACUUM FEEDING SYSTEM C, K0342	1
12	IS0214	IS, ASSY: PROC, HOPPER FEEDER	1
15	781XX629	LABEL,WARNING-HOT SURFACE	1

External Vacuum Feeder - Nordson 3400 (776XX019)



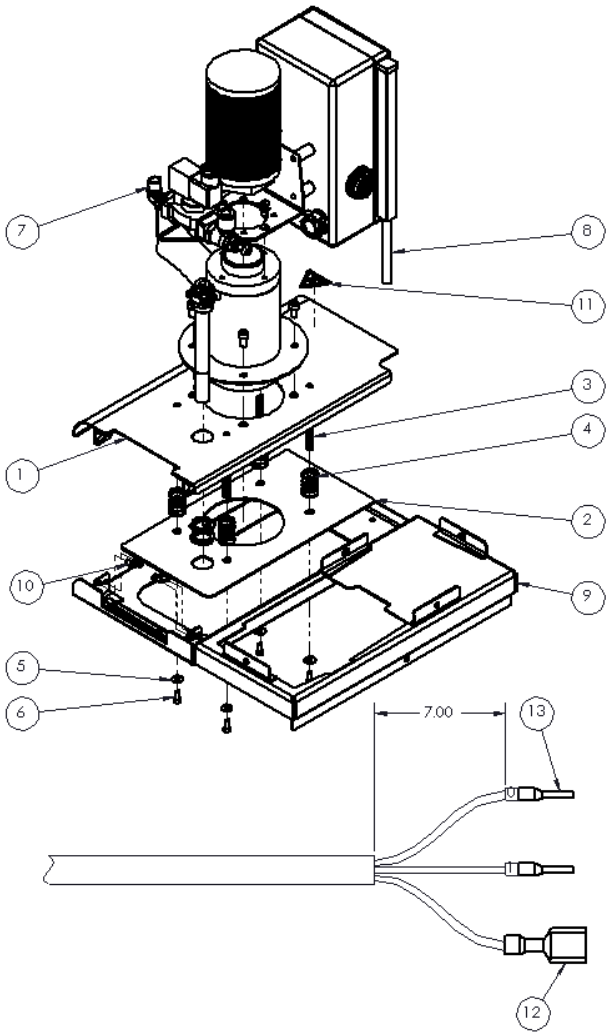
Item	Part #	Description	QTY
1	776XX020	BASE PLATE, HOPPER FEEDER	1
2	776XX021	OUTER LID, HOPPER FEEDER	1
3	776XX018	INNER PLATE,HOPPER FEEDER	1
4	776XX015	STANDOFF,HOPPER FEEDER ASSY	4
5	783XX335	E-CLIP, EXTERNAL	2
6	783XX220	SPRING,COMPRESSION	4
7	798XX758	FLAT WASHER	1
8	776XX016	HINGE ROD,HOPPER FEEDER ASSY	1
9	776XX017	ADAPTER, AIR FILTER	1
10	988XX342	VACUUM FEEDING SYSTEM C, K0342	1
13	IS0214	IS, ASSY: PROC, HOPPER FEEDER	1
18	781XX629	LABEL,WARNING-HOT SURFACE	1

External Vacuum Feeder - Nordson 3500 (776XX011)



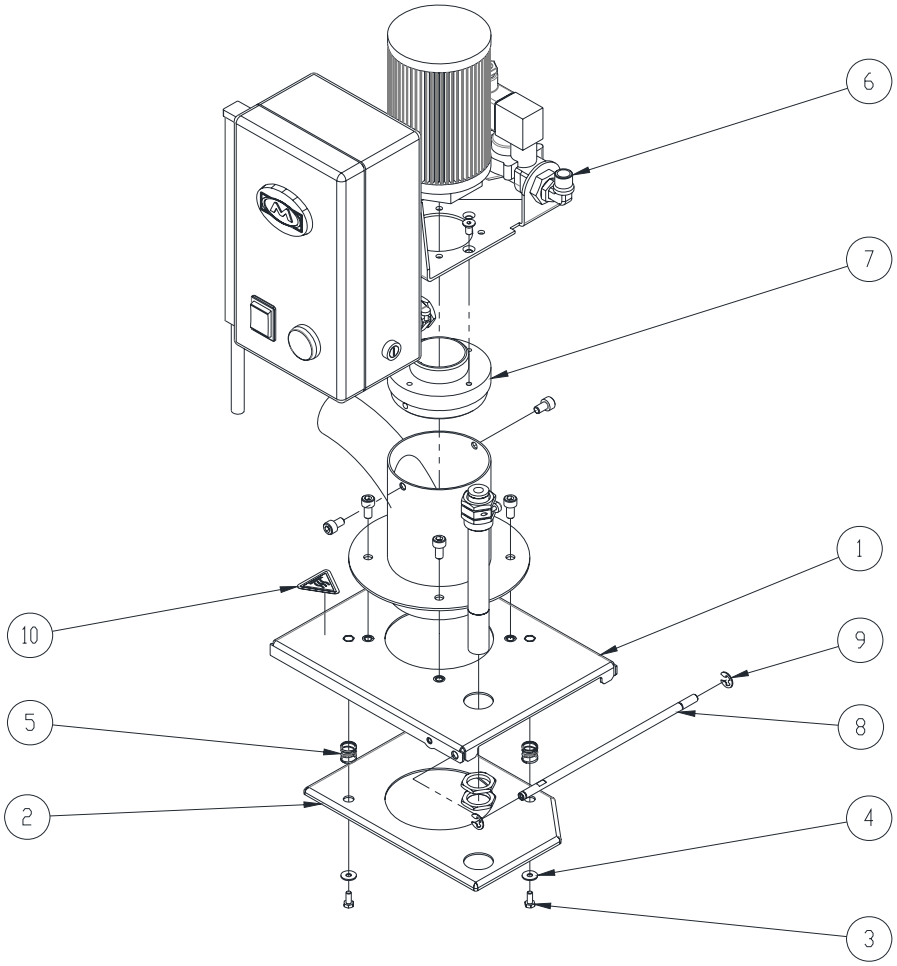
Item	Part #	Description	QTY
1	776XX012	BASE PLATE,HOPPER FEEDER	1
2	776XX013	OUTER LID,HOPPER FEEDER	1
3	776XX014	INNER PLATE,HOPPER FEEDER	1
4	776XX015	STANDOFF,HOPPER FEEDER ASSY	4
5	783XX335	E-CLIP, EXTERNAL	2
6	783XX220	SPRING,COMPRESSION	4
7	798XX758	FLAT WASHER 1/4 ZINC	1
8	776XX016	HINGE ROD,HOPPER FEEDER ASSY	1
9	776XX017	ADAPTER, AIR FILTER	1
10	988XX342	VACUUM FEEDING SYSTEM C, K0342	1
12	IS0214	IS, ASSY: PROC, HOPPER FEEDER	1
18	781XX629	LABEL,WARNING-HOT SURFACE	1

External Vacuum Feeder - Nordson Mesa M9 (776XX304)



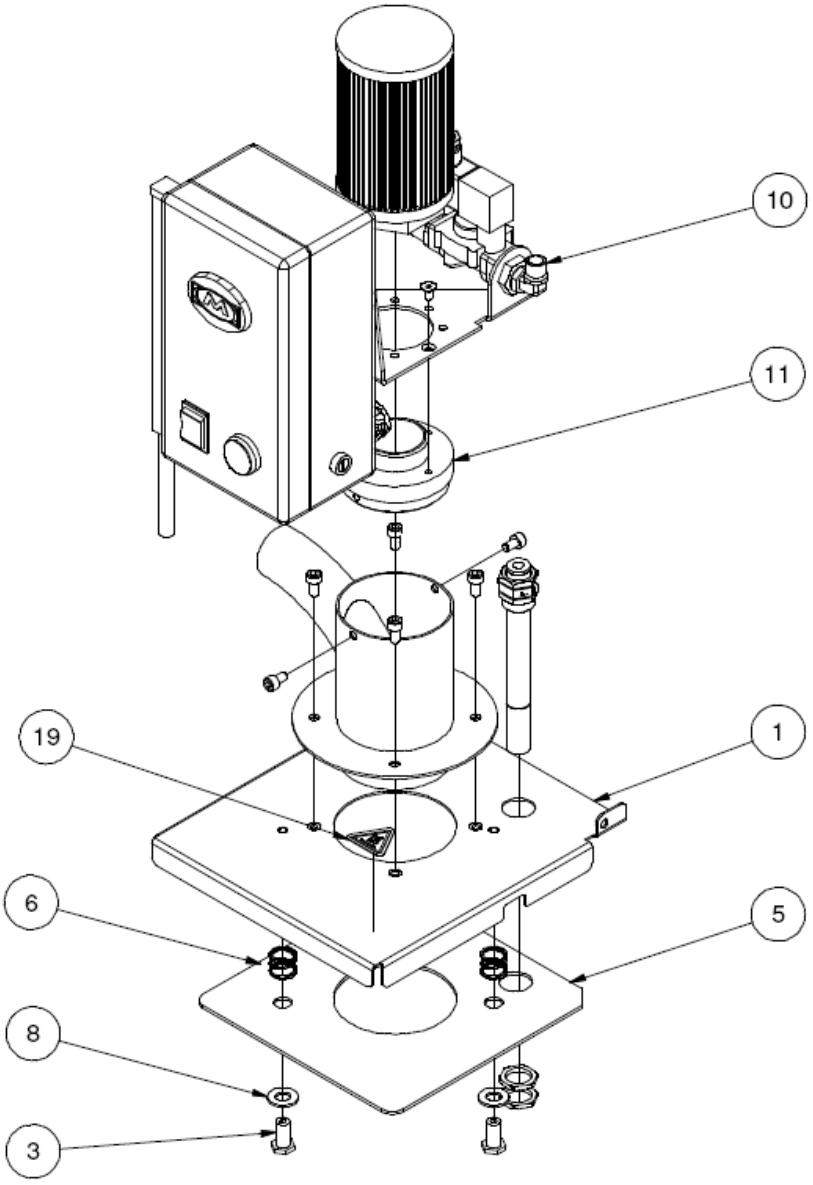
Item	Part #	Description	QTY
1	776XX302	OUTER LID, VACUUM FEEDER, MESA	1
2	776XX303	INNER LID, VACUUM FEEDER, MESA	1
3	091XX714	STANDOFF	4
4	783XX353	SPRING, COMPRESSION	4
5	776XX202	WASHER FLAT	4
6	784XX359	SCREW	4
7	988XX339	VACUUM FEEDING SYSTEM C	1
8	791XX436	ACTIVATOR ROD, MESA M9	1
9	776XX301	TANK MOUNTING PLATE, MESA M9	1
10	798XX188	SCREW	4
11	781XX629	LABEL,WARNING-HOT SURFACE	1
12	075XX217	WIRE TERMINAL, FASTON	1
13	075XX304	FERRULE;INS	2
14	070XX195	CONN;PLUG	1
15	066XX050	CORD GRIP	1
16	795XX825	LOCKNUT	1
17	066XX219	CABLE CLAMP	2
98	IS0214	IS, VACUUM FEEDER INSTALLATION	1
99	IS0274	IS; VACUUM FEEDER OPERATION	1

External Vacuum Feeder - Nordson ProBlue 4 (Rear Hinge) (776XX574)



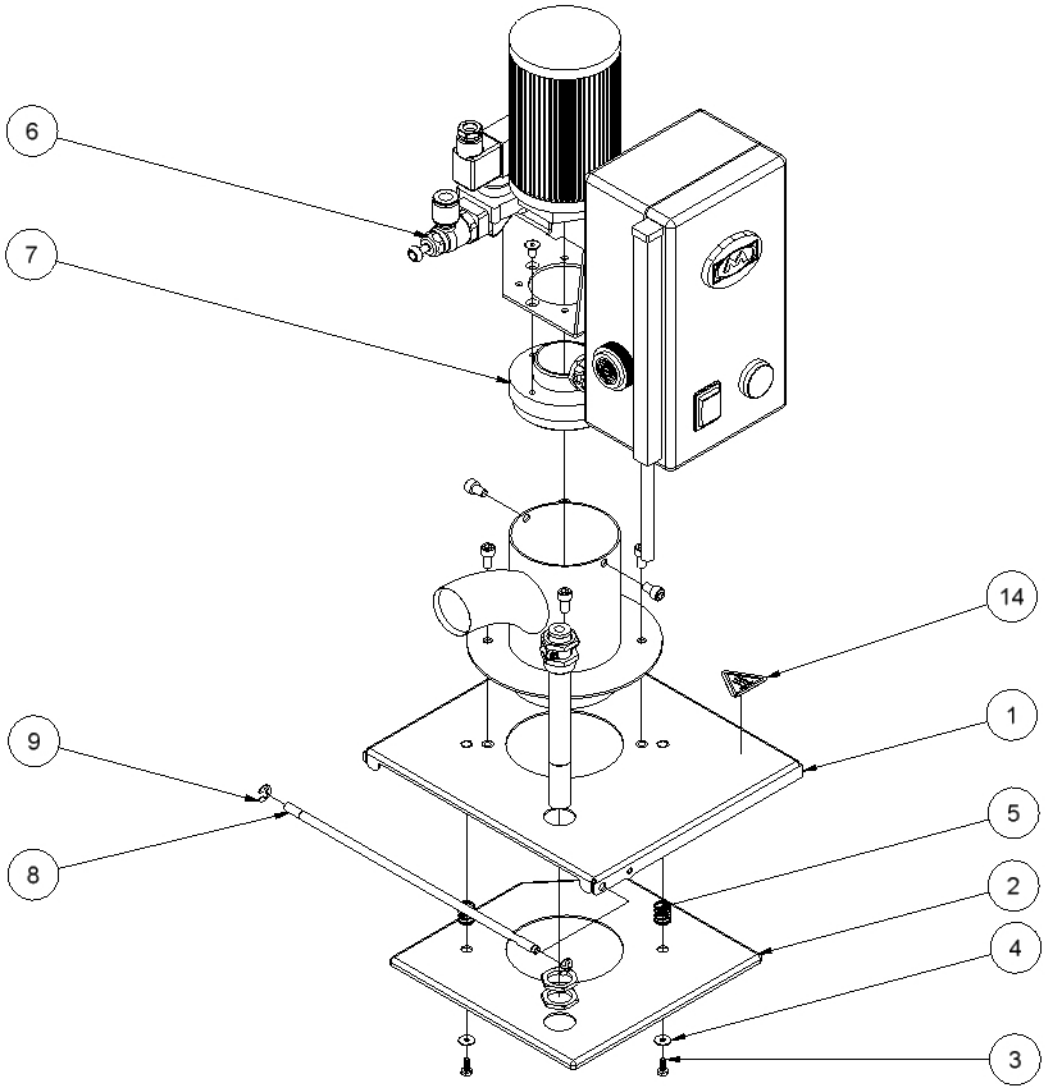
Item	Part #	Description	QTY
1	776XX572	LID OUTER EXT VACUUM FEEDER	1
2	776XX571	LID INNER EXT VACUUM FEEDER	1
3	884XX326	SCREW	2
4	776XX202	WASHER FLAT	2
5	783XX334	SPRING, COMPRESSION	2
6	988XX339	VACUUM FEEDING SYSTEM	1
7	776XX102	THREADED FEEDER TUBE	1
8	791XX438	HINGE ROD, VACUUM FEEDER	1
9	783XX335	E-CLIP, EXTERNAL	2
10	781XX629	LABEL,WARNING-HOT SURFACE	1
11	776XX573	BRACKET; TANK MOUNTING	1
12	884XX328	SCREW	1
13	784XX992	SCREW	1
14	784XX342	SCREW	6
15	IS0214	IS, VACUUM FEEDER INSTALLATION	1
16	IS0274	IS; VACUUM FEEDER OPERATION	1

External Vacuum Feeder - Nordson ProBlue 7, 10 (Left Hinge) (775XX878)



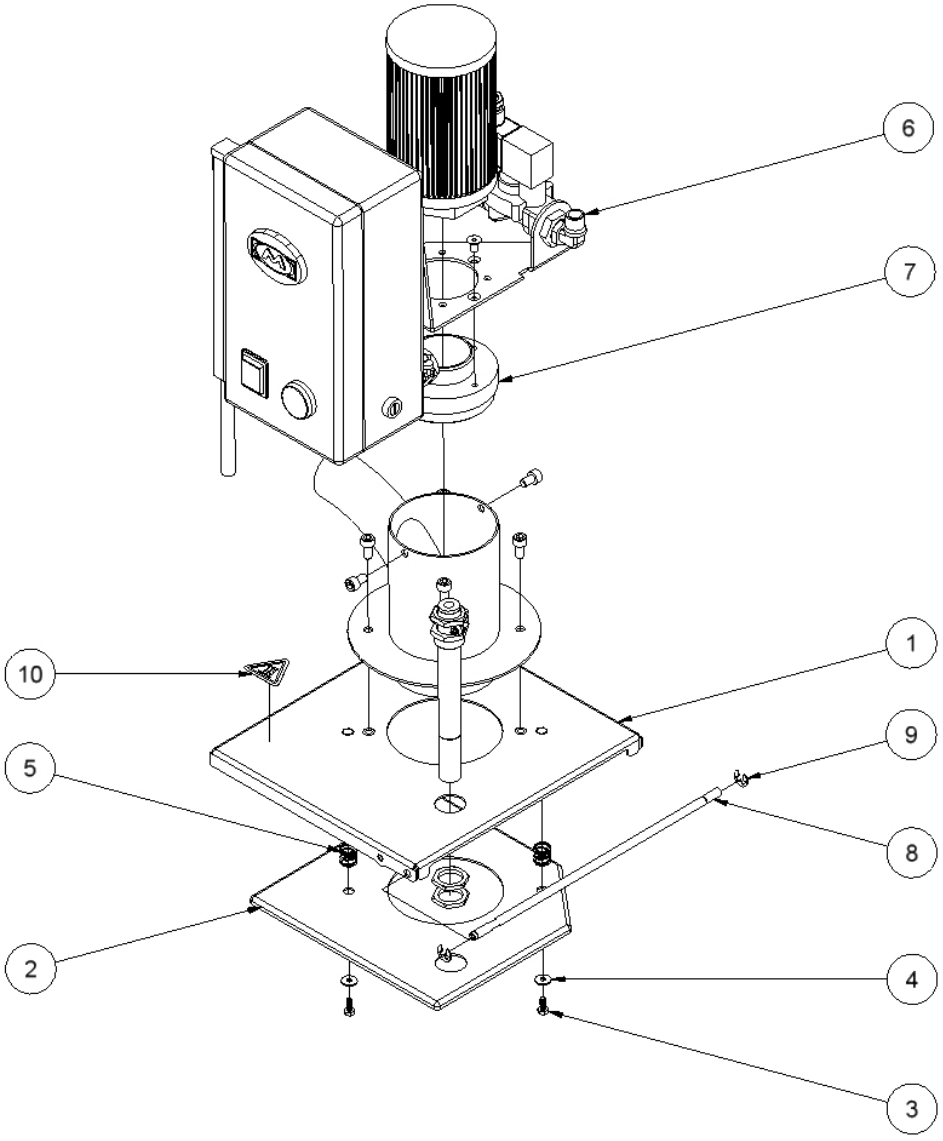
Item	Part #	Description	QTY
1	775XX881	OUTER LID,HOPPER FEEDER,PB	1
2	775XX880	FOOT TAP,HOPPER FEEDER ASSY	1
3	783XX219	STANDOFF,HOPPER FEEDER ASSY	2
4	791XX409	HINGE ROD,HOPPER FEEDER ASSY	1
5	775XX879	INNER LID,HOPPER FEEDER ASSY	1
6	783XX218	SPRING	2
7	783XX335	E-CLIP, EXTERNAL	2
8	798XX762	FLAT WASHER 3/8 ZINC	2
10	988XX339	VACUUM FEEDING SYSTEM C, K0339	1
11	776XX102	THREADED FEEDER TUBE	1
13	784XX409	SCREW	2
14	IS0214	IS, ASSY: PROC, HOPPER FEEDER	1
19	781XX629	LABEL,WARNING-HOT SURFACE	1

External Vacuum Feeder – Nordson Pro-Blue 7 and 10 (775XX640, Front Hinge)



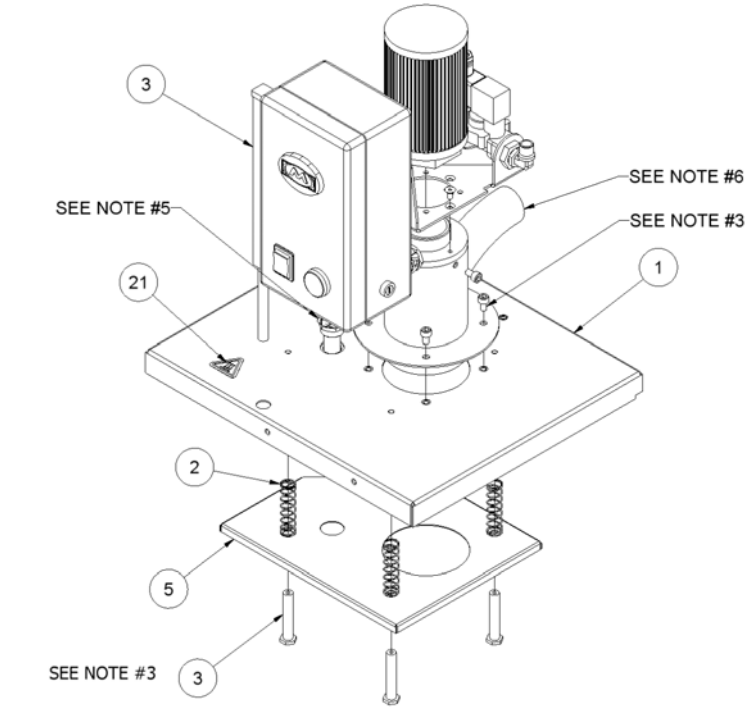
Item	Part #	Description	QTY
1	776XX232	OUTER LID, VACUUM FEEDER, PB	1
2	766XX233	INNER LID, VACUUM FEEDER, PB	1
3	884XX326	HHCS M4 X 10 SS	2
4	776XX202	WASHER FLAT M4 ZINC	2
5	793XX334	SPRING, COMPRESSION	2
6	998XX339	VACUUM FEEDING SYSTEM C, K0339	1
7	776XX102	THREADED FEEDER TUBE	1
8	791XX430	HINGE ROD, VACUUM FEEDER, PB	1
9	783XX335	E-CLIP, EXTERNAL	2
10	781XX629	LABEL,WARNING-HOT SURFACE	1
11	776XX234	TANK MOUNTING BRACKET, PB	1
12	884XX328	SHCS M5 X 12 NYLOC	1
13	784XX992	SHCS M4 X 6 SS	1
14	784XX342	BHCS M5 X 25	8
15	IS0214	IS, ASSY: PROC, HOPPER FEEDER	1

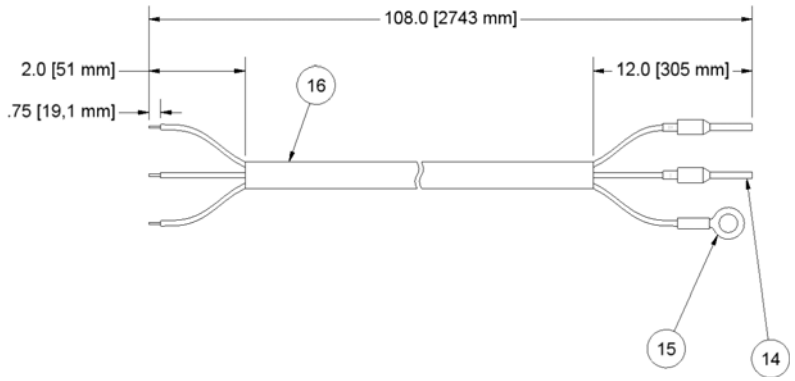
External Vacuum Feeder – Nordson Pro-Blue 7 and 10 (775XX639, Rear Hinge)



Item	Part #	Description	QTY
1	776XX232	OUTER LID, VACUUM FEEDER, PB	1
2	766XX233	INNER LID, VACUUM FEEDER, PB	1
3	884XX326	HHCS M4 X 10 SS	2
4	776XX202	WASHER FLAT M4 ZINC	2
5	793XX334	SPRING, COMPRESSION	2
6	998XX339	VACUUM FEEDING SYSTEM C, K0339	1
7	776XX102	THREADED FEEDER TUBE	1
8	791XX430	HINGE ROD, VACUUM FEEDER, PB	1
9	783XX335	E-CLIP, EXTERNAL	2
10	781XX629	LABEL,WARNING-HOT SURFACE	1
11	776XX234	TANK MOUNTING BRACKET, PB	1
12	884XX328	SHCS M5 X 12 NYLOC	1
13	784XX992	SHCS M4 X 6 SS	1
14	784XX342	BHCS M5 X 25	8
15	IS0214	IS, ASSY: PROC, HOPPER FEEDER	1

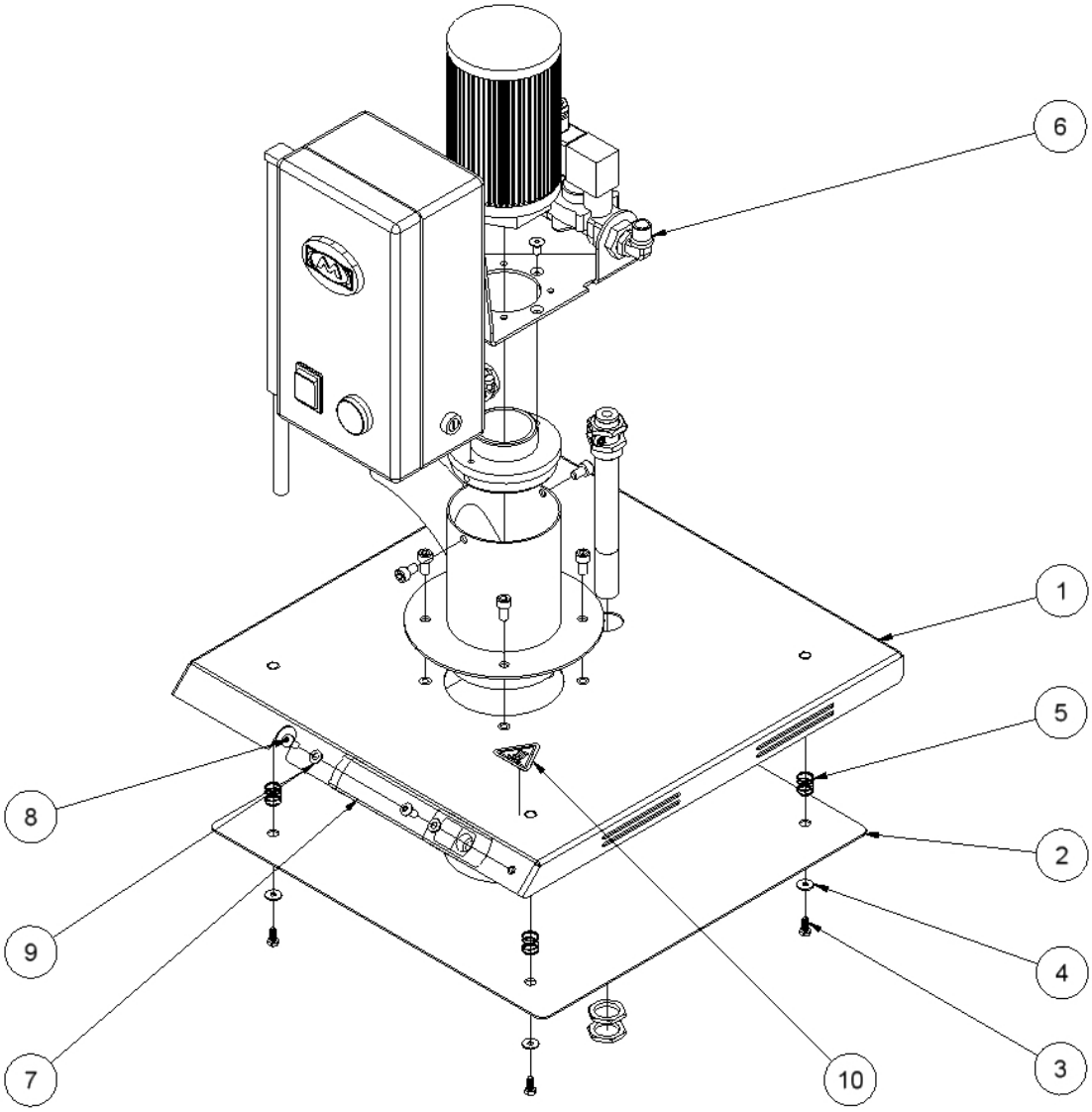
External Vacuum Feeder - Nordson ProBlue 15 (776XX163)





Item	Part #	Description	QTY
1	776XX162	OUTER LID, PB15 HOPPER FEEDER	1
2	783XX315	SPRING, COMPRESSION	4
3	783XX314	STANDOFF, HOPPER FEEDER ASSY	4
4	776XX164	HINGE PLATE, PB15 HOPPER FEED	1
5	776XX161	INNER LID, PB15 HOPPER FEEDER	1
7	784XX125	SCREW	2
8	988XX339	VACUUM FEEDING SYSTEM C, K0339	1
11	IS0214	IS, ASSY: PROC, HOPPER FEEDER	1
13	061XX356	WIRE NUT,BLUE,22-14 AWG	3
14	075XX305	FERRULE;INS,16AWG,BLACK,10MM	2
15	075XX075	WIRE TERMINAL; RING	1
16	029XX609	CABLE 3 COND 16 AWG	9
20	784XX060	LOCKWASHER	2
21	781XX629	LABEL,WARNING-HOT SURFACE	1

External Vacuum Feeder – Slautterback KB100 (776XX226)



Item	Part #	Description	QTY
1	776XX227	OUTER LID, VACUUM FEEDER, KB	1
2	776XX228	INNER LID, VACUUM FEEDER, KB	1
3	884XX326	HHCS M4 X 10 SS	4
4	776XX202	WASHER FLAT M4 ZINC	4
5	783XX333	SPRING, COMPRESSION	4
6	988XX339	VACUUM FEEDING SYSTEM C, K0342	1
7	104XX135	HANDLE, PULL	1
8	784XX300	BHCS M5 X 12 BO	2
9	784XX568	FLAT WASHER M5	2
10	781XX629	LABEL,WARNING-HOT SURFACE	1
11	884XX327	HHCS M5 X 12 ZINC	4
12	784XX349	HEX NUT M5 ZINC	4
13	IS0214	IS, ASSY: PROC, HOPPER FEEDER	1

IS0274 - Vacuum Feeder Operation Instructions

Version 5/13

Declaration of Conformity

The product _____

Model no.: _____

Serial no.: _____

Year of manufacture: _____

Described in the enclosed documentation is in conformity with:

- Directive 98/37/EC of 22 June 1998 relating to the *approximation of the laws of the Member States relating to machinery,* combining in a single text Directives 89/392/EEC of 14 June 1989, 91/368/EEC of 20 June 1991, 93/44/EEC of June 14, 1993 and 93/68/EEC of 22 July 1993.
- Directive 73/23/EEC of 19 February 1973 relating to electric equipment.
- Directive 89/336/EEC of 3 May 1989 relating to electromagnetic compatibility.
- Directive 93/68/EEC of 22 July 1993, amending Directive73/23/EEC, and Directive 89/336/EEC.

This is within the scope of the specifications indicated in the chapter describing the equipment with a B1 risk level. Since it is intended to form part of a set of machines which, to obtain a result, are arranged and connected to perform together, it cannot be operated until the set of machines has been declared in conformity with the applicable Directives by the person responsible for the final assembly.
*Orcoyen, on :*_____

*Signed.*_____
Gonzalo Marco, Managing Director

VALCO MELTON
Polígono Industrial Agustinos, calle G, nave D-34
Tel.: +34.948.321.580 Fax: +34.948.326.584
31160 ORCOYEN (Navarra) SPAIN

CONTROL REGISTRATION

CONTROL #: _____

DATE: _____

ELECTRIC CHECK: ☐

CONTROL BOARD CHECK: ☐

TEMPERATURE CONTROL CHECK 150/180°C: ☐

APPLICATOR SERIAL NUMBER:

VALCO MELTON

GUARANTEE CARD

DISTRIBUTOR:.....
CONTACT:.....
ADRESS:.....TELEPHON.....

OEM:.....
ADDRESS:.....
TYPE:.....BRAND:.....MODEL:.....

USER:.....
CONTACT:.....
ADDRESS:.....TELEPHONE :.....
SYSTEM LOCATION:.....
DATE OF INSTALLATION: ..... GUARANTEE UNTIL: .....

APPLICATOR SERIAL NUMBER:

IMPORTANT!

THIS INSTRUCTION MANUAL SHOULD BE KEPT IN AN ACCESSIBLE PLACE KNOWN TO ALL OPERATORS AND MAINTENANCE PERSONNEL.

READ THE INSTRUCTIONS CAREFULLY BEFORE OPERATING THE MACHINE AND FOLLOW THEM WHILE THE MACHINE IS IN OPERATION.

FOLLOW THE SAFETY INSTRUCTIONS PROVIDED IN THIS MANUAL WHEN USING AND HANDLING THE MACHINE.

IF YOU FAIL TO FOLLOW THE SAFETY INSTRUCTIONS, THIS MAY GIVE RISE TO BURNS, INJURIES AND EVEN IRREVERSIBLE DAMAGE. YOU MAY ALSO DAMAGE THE EQUIPMENT OR OTHER MATERIALS.

WARNING!

If you alter the function, performance or safety aspects of the machine, replacing original parts with other similar but not identical components (substantial alterations), without the authorization of MELTON and as specified in Directive 89/392/EEC, you will be classified as a manufacturer and therefore become liable for the alterations made.

SAFETY INSTRUCTIONS

SYMBOLS AND TERMS


Miscellaneous prohibitions


Danger: hot surface


Miscellaneous precautions


Precaution: electric current


Precaution: flammable liquid


Precaution: risk of fluid leakage under high pressure


Precaution: risk of entrapment between mobile parts


European Community markings


Note of special interest


Use of goggles required


Use of safety gloves required

Burns

Burns can be caused by the uncovered parts of the applicator, such as the guns or by splashes of hot melt. The hot adhesive under pressure in the nozzles can cause serious injuries to the skin.

Qualified personnel

These are personnel (technical staff) who have acquired sufficient know-how in a specific field, either through training or from experience. These personnel must be familiar with safety and accident prevention standards, and have general knowledge of the technical aspects of the machine.

Protective clothing

This clothing will be compliant with EN510 and EN340 standards, protecting against fast moving particles and high temperatures. It will be as tight as possible to prevent it from catching on mobile machine parts, and the sleeves, waist, legs, etc. will be adjustable to the size of the wearer.

Goggles and face shields

They will be compliant with the EN 166 standard, protecting against fast-moving particles and high temperatures. Goggles only protect the eyes. Face shields are therefore preferable, since they protect the entire face.

Protective gloves

They will be compliant with EN 407 and EN 420 standards, protecting the hands against the burns caused by external thermal masses at temperatures of above 100 °C.

PURPOSE

This unit has been manufactured according to current safety standards.

This unit has been designed for the purpose described in this manual (“Description”).

To use the machine correctly, follow the instructions provided in the Operation Manual, particularly:

- The machine should only be installed and used by qualified personnel, previously familiarized with the operating instructions (contacting the manufacturer whenever necessary) and the risks involved, the safety measures required, including adjustment and maintenance, and expressly forbidden operations.
- This unit has not been manufactured to operate in hazardous, explosive and/or flammable atmospheres.
- When working with this machine, wear protective clothing, gloves and face shields and remove rings, bracelets and watches.
- This machine should never work without the guards provided (which should not be removed). These guards should be checked and maintained with the specified frequency.
- Make sure that the equipment is properly grounded.
- Never operate the machine if you are aware that there is a leak in the glue circuit.
- Maintenance operations and/or repairs should be performed by personnel with basic knowledge of the machine and the mechanical, pneumatic and electric circuits involved.
- Maintenance operations and/or repairs should always be performed with the machine switched off at the mains, and with the main switch blocked.
- Maintenance operations and/or repairs should always be performed with the machine de-pressurized and disconnected from the pressure circuit.

DESCRIPTION

INTRODUCTION

This equipment fills your hot-melt unit with adhesive pellets by means of pneumatic pressure.

MAIN PARTS

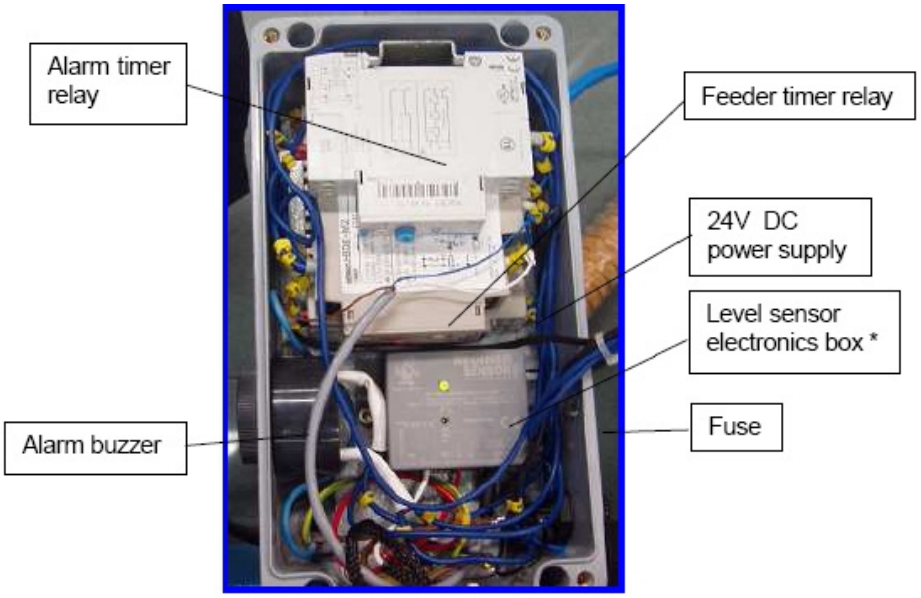
The main parts are shown in the pictures below*

N.	DESCRIPTION
1	Electric cabinet
2	Level sensor
3	Feeder
4	Electrovalve
5	Tank door microswitch

* The feeder model may vary depending on the hot-melt unit it is designed to be fitted to.

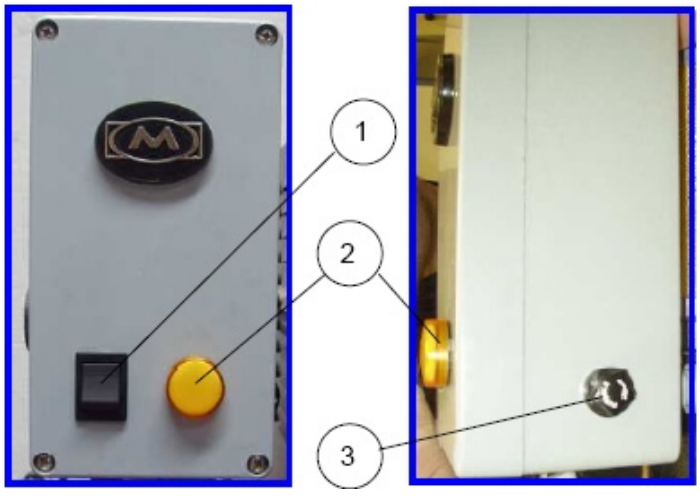
Electric cabinet

This contains the 24V DC power supply, feeder timer relay, the level sensor electronics box and the alarm buzzer.



* Shown without the potentiometer screw plastic cap.

The main switch (1), alarm indicator (2) and the fuse socket (3) are placed on the outside of the electric cabinet.



Level sensor

This controls the adhesive level inside the tank.

Vacuum feeder

This is composed of a container for the adhesive pellets, a feeder tube with the vibrator module fitted to its end, the electrovalve, the tank door assembly and the hose.

Electrovalve

This controls the airflow to the vibrator module.

Tank door microswitch

This switch gives clearance to the adhesive feeder when the tank door is closed, and denies it when it is opened.

TECHNICAL CHARACTERISTICS

ELEMENT	DATA
Power supply	IP 220V+N+T (50/60Hz)
Compressed air inlet	2-6 bar (43 to 87 PSI) – 350 l/min (92 gallon/minute)
Hose length	1-30 m (up to 98 feet)

MACHINE INSTALLATION

INTRODUCTION

This chapter explains how to install the machine correctly.

WARNING!  The operations described in this chapter should be performed by qualified personnel, following safety instructions.

TRANSPORT

The equipment is supplied packed with a paperboard box. Approximate weight of the package: 7 kg.

CAUTION!  Unpack carefully to prevent damage to the unit. Inspect the equipment for damages caused during transport.

MECHANICAL INSTALLATION

Remove the adhesive tank door assembly from your hot-melt unit. Place the vacuum feeder tank door assembly on your hot-melt unit. Place the adhesive hose on the assembly. The adhesive hose should not, if possible, be placed horizontally for many meters. Place the feeder tube in the adhesive pellets container.

PNEUMATIC INSTALLATION

Connect the electrovalve air hose to an appropriate pressurized air source.

ELECTRIC INSTALLATION

Connect the electrical cabinet to an appropriate power socket. Connect the ground wire to the hot-melt unit ground. (Very important)

CALIBRATION/OPERATION

WARNING! This equipment should only be used by qualified personnel who understand all of the procedures and are familiar with the necessary safety measures.

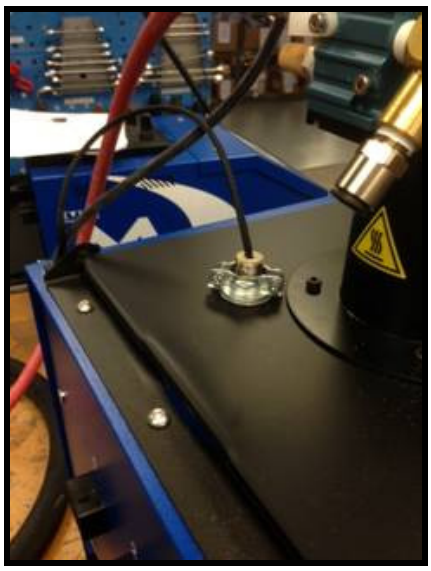
CALIBRATION

Make sure the autofeed is installed correctly, using the installation sheet included with the autofeeder.

This procedure is best used when the unit is cool.

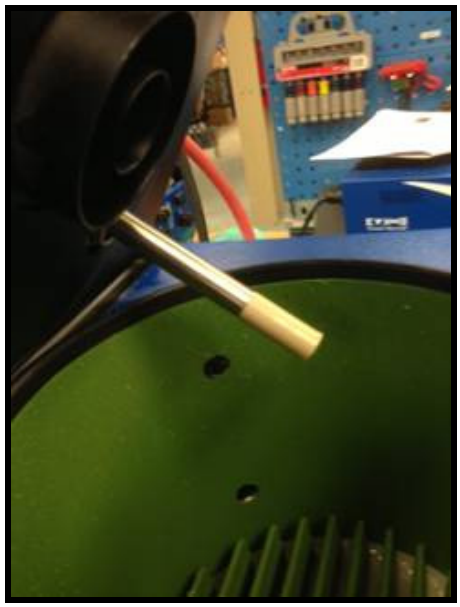
1. Make sure the flow control valve is completely closed; turn it clockwise until the screw stops.

2. Make sure the probe is inserted into the lid to its lowest possible point.



3. Fill the adhesive so that the adhesive is level with the middle of the probe tip. The probe tip is the tan, plastic tip.

Calibration - Continued



4. With the lid closed, check the LED on the sensor amplifier.

IF THE LIGHT IS RED:
Turn the potentiometer clockwise until it turns green. Continue to "IF THE LIGHT IS GREEN"

IF THE LIGHT IS GREEN:
Turn the adjustment potentiometer counterclockwise until the LED begins to flash. it should eventually turn red. With the LED in the red state, turn the potentiometer clockwise SLOWLY until it turns green.

5. The autofeed sensor is now calibrated.
6. Connect the autofeeder to the incoming air supply.
7. Open the flow valve slowly, counterclockwise (from step # above), until adhesive begins to flow into the tank.

WARNING! DO NOT open this valve too far, as it will result in adhesive splashback onto the lid and into the top filter.

OPERATION

INTRODUCTION

This section explains how to use the equipment.

WARNING! Make sure that the person operating the machine is duly protected and that all safety instructions are followed. All safety equipment should be in perfect condition.

START-UP

1. Press the main switch.
2. Check that the equipment is correctly adjusted. Readjust if necessary.
3. Close the tank door.
4. The application can start.

TANK FILLING PROCESS

When the level sensor detects a low adhesive level in the tank, the electrovalve will open and the vacuum feeder will transfer adhesive pellets from their container to the tank, until a correct adhesive level is detected in the tank. If the tank is not loaded after 4 minutes (programmable), the amber indicator will light up and the alarm buzzer will sound. The feeder will continue trying to fill the tank until the level sensor detects a correct adhesive level again. To reset the feeder alarm, press the main switch. When the equipment is switch on, the alarm time timer is also reset to 0.

STOPS

Press the main switch to completely disconnect the equipment.

MAINTENANCE

WARNING! The maintenance operations described in this chapter should only be performed by qualified personnel understanding the processes and familiar with the safety measures involved.

INTRODUCTION

This chapter contains the procedures involved in the maintenance of the follower plate. These maintenance procedures guarantee safe operations and increase the life of the follower plate. Before starting a maintenance operation, read “Safety” carefully.

WARNING! Make sure that you are duly protected and follow all pertinent safety measures:

1. Switch off and isolate from the power source.
2. Lock the main switch in place.
3. Check that there’s no energy left in the unit.
4. Follow all applicable safety standards.

MAINTENANCE RECOMMENDATIONS

The following table shows the frequency with which maintenance operations should be performed:

Frequency	Maintenance
Weekly(40 hours)	Clean the outer surface of the equipment. Use a liquid cleaner following the instructions of the adhesive that is going to be used.
	Inspect all the electric, pneumatic and hydraulic connections. Replace or repair when necessary.
When necessary	Check and clean de vacuum feeder filter.
	Clean the adhesive around the micro switch.

The frequency of this operation depends on the type of adhesive used and the environmental conditions where the equipment is placed.

MAINTENANCE PROCESSES

Cleaning the equipment

1. Vacuum the dust or glue remains or remove with a soft cloth.
2. Clean the control panel periodically with a soft cloth.

CAUTION! Do not use solvents, which could rust the controls. *If you use a cleaning agent, make sure that it is compatible with the adhesive being employed. When in doubt, contact the adhesive manufacturer.*

Cleaning the feeder filter

1. Reduce air pressure in the unit to 0.
2. Remove the feeder filter with a wrench tool.
3. Use a screwdriver or other long tool to remove the adhesive from the filter inner mesh and cap.
4. If necessary, clean the filter screen with the appropriate adhesive solvent. Contact the adhesive manufacturer for details.
5. Assemble in reverse order.

FAULT FINDING GUIDE

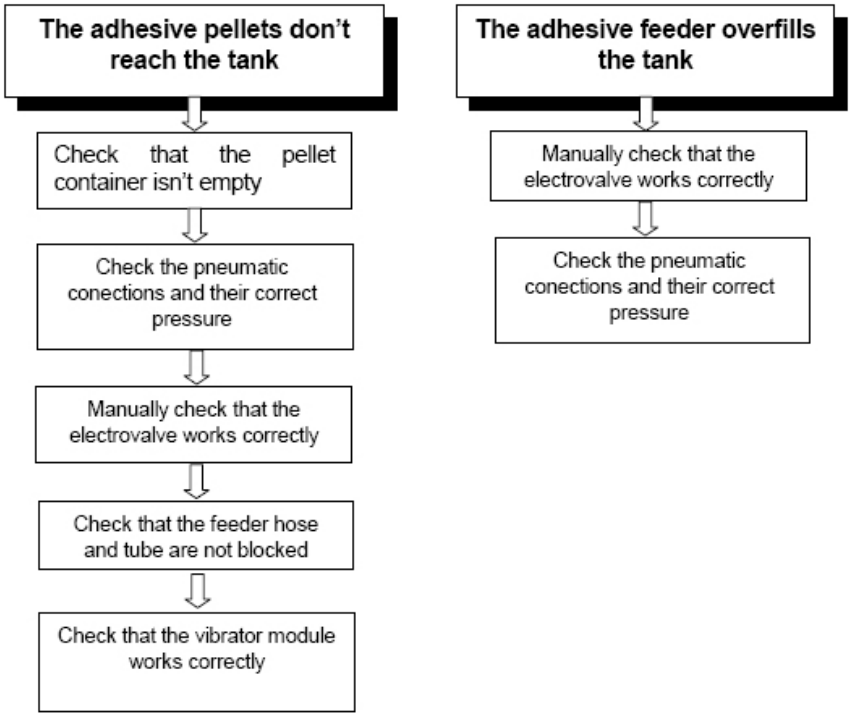
WARNING!

The maintenance operations described in this chapter should only be performed by qualified personnel understanding the processes and familiar with the safety measures involved.

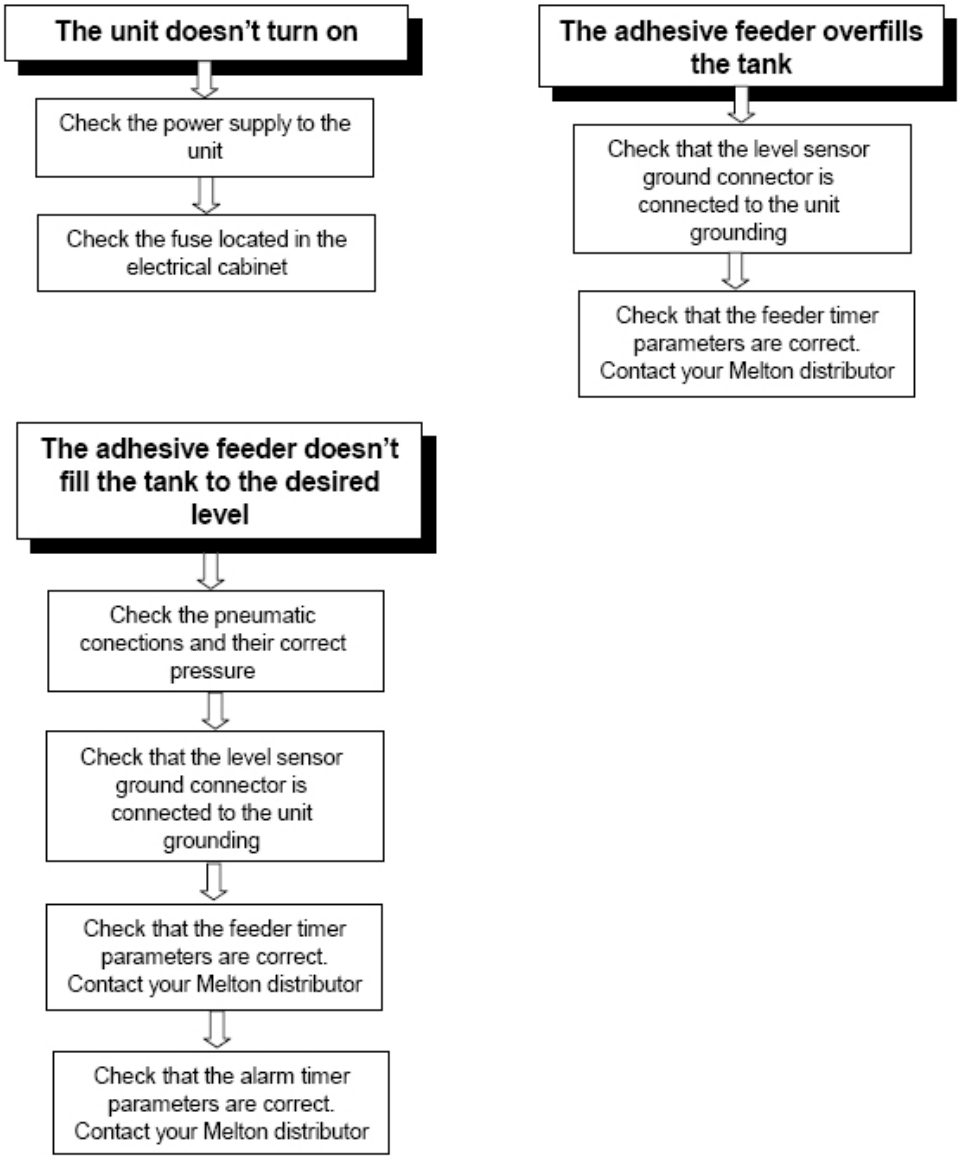
INTRODUCTION

This chapter refers to the most common faults in your equipment. Breakdowns occur when the flow of glue is reduced or stopped, or the alert system informs of a fault. Try to solve the problem with the help of this manual. If the problem cannot be solved with the information provided here, contact your Melton representative.

MECHANICAL FAULTS



ELECTRICAL FAULTS



EQUIPMENT REPAIR GUIDE

WARNING! The maintenance operations described in this chapter should only be performed by qualified personnel understanding the processes and familiar with the safety measures involved.

INTRODUCTION

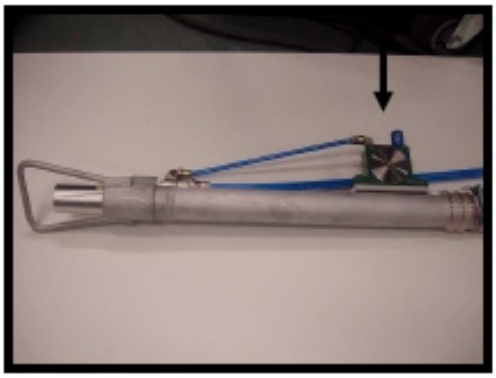
This chapter describes the procedures to remove and change some components. These procedures should be followed during maintenance or repair operations. First of all, make sure that you are duly protected and follow all safety measures:

1. Close the air supply.
2. Switch off and isolate the power to the unit.
3. Lock the main switch in place.
4. Make sure that there's no energy left in the unit.
5. Follow applicable safety and health standards.

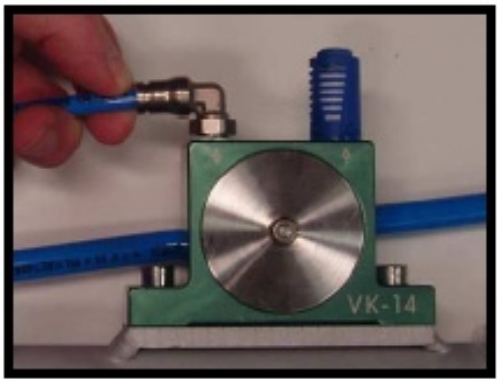
REPAIRING MECHANICAL ELEMENTS

Changing the vibrator module

1. Locate the vibrator module fitted on the feeder arm.

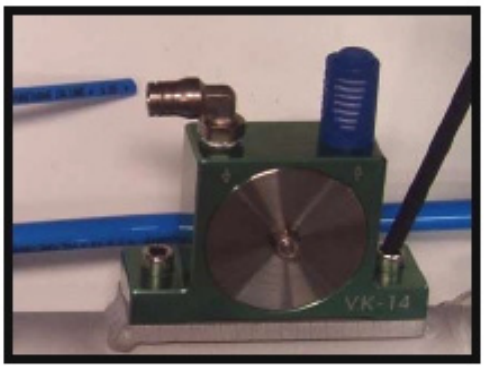


2. Pull out the air hose by pressing the end of the quick connection fitting.

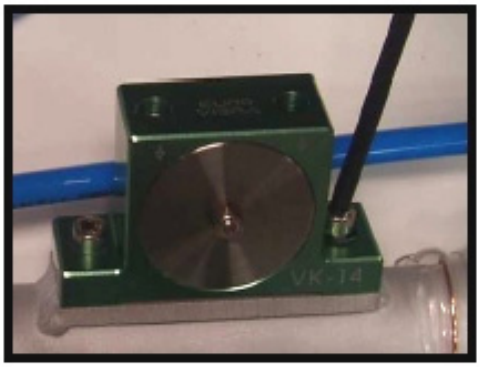


Changing the vibrator module – Continued

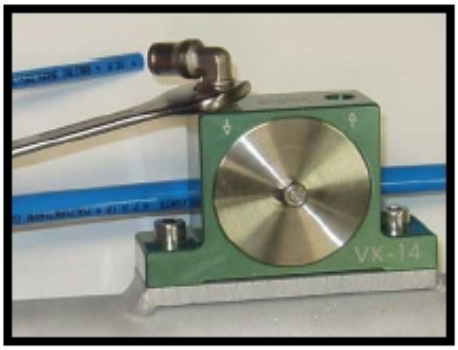
3. Unscrew both screws and remove the module.



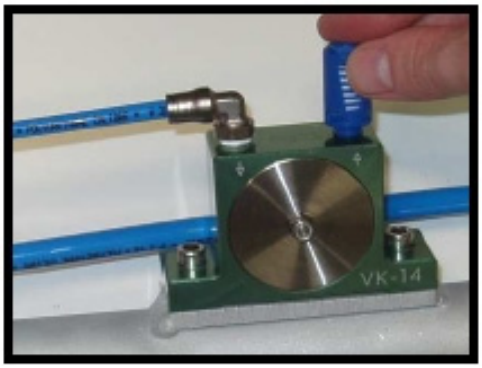
4. Fit the new vibrator module with the screws.



5. Screw the quick connection air fitting in the air inlet.

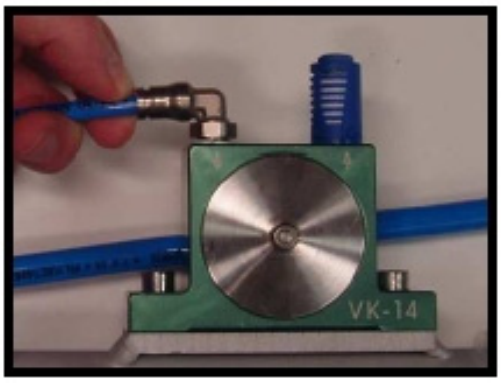


6. Screw the air filter in the module air outlet.

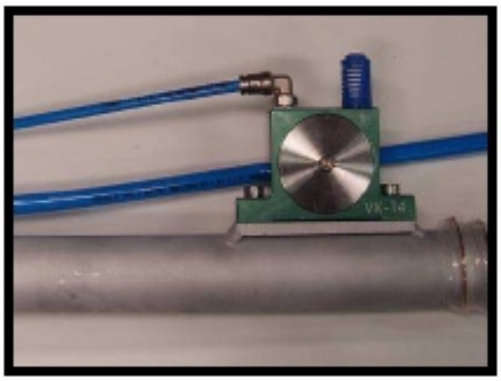


Changing the vibrator module – Continued

7. Press the fitting end and pull in the air hose.



8. Assembled vibrator module:



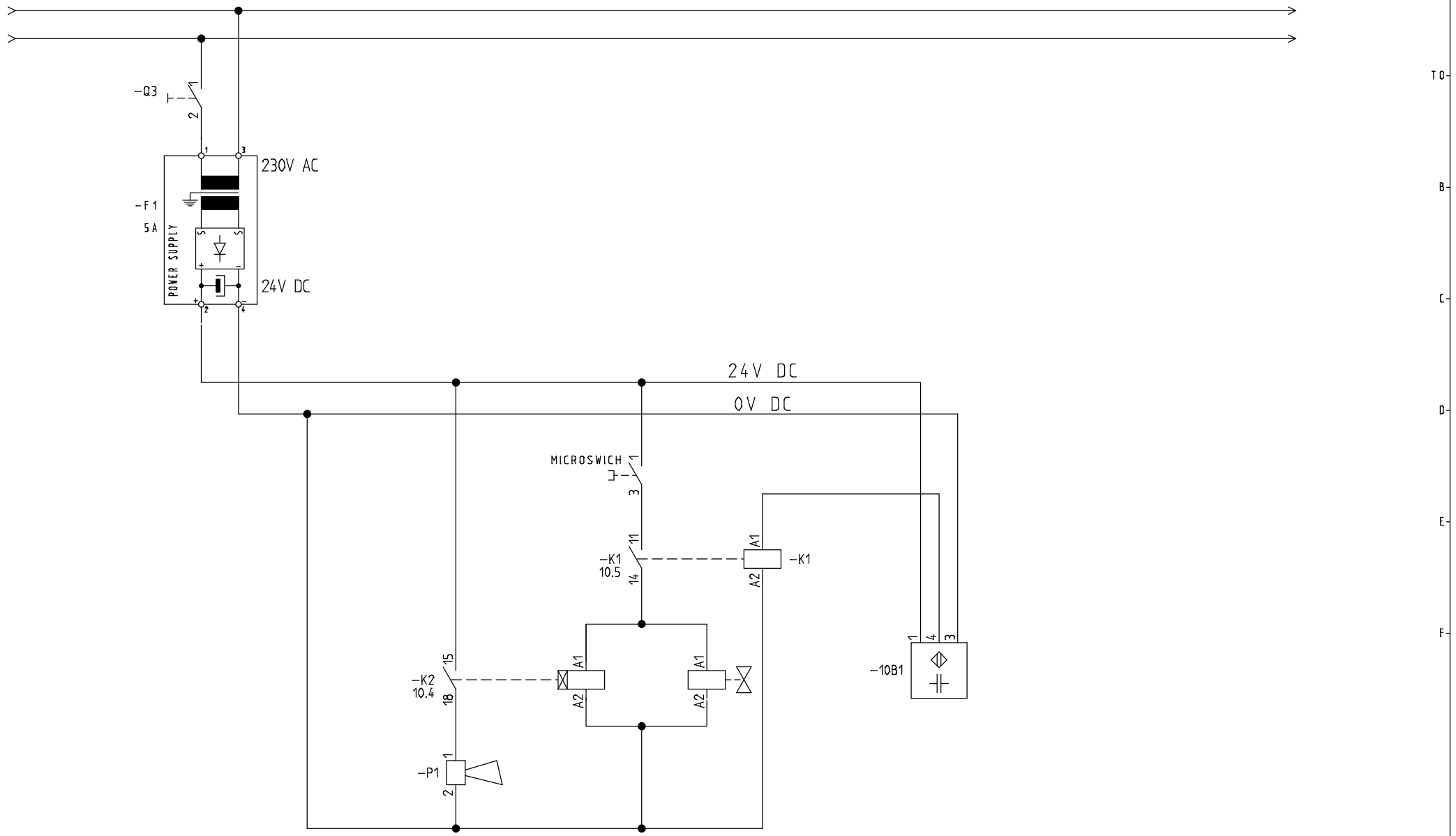
9. Open the main air supply.
10. Switch on the unit.

The feeder is ready to work again!

REPAIRING ELECTRICAL ELEMENTS

Should any of the electrical components need replacement, contact your Melton distributor.

ADHESIVE LEVEL SENSOR



0	20.05.2002	F.CASEDAS	
TO			
B			
C			
D			

CLIENT: MELTON

DETECTOR OF LEVEL OF ADHESIVE

DESCRIPTION: LEVEL

DEVICE: =

SITUATION: +

PROJECT: S031010201

JOB No.:

PAGE No.: 10

E:

S860080201

VACCUM FEEDING NC SERIES

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COVER PAGE

PROJECT: S860080201 VACCUM FEEDING NC SERIES

REV.	DATE	NAME	CHANGES
0	21/12/2015	mayestaran	

REVISION 0

SCHEME 01

1-Document book

Drawing	Function	Location	Revision	Date	Created by	Description
01	F1	P1	0	21/12/2015	mayestaran	Cover page
02	F1	P1	0	21/12/2015	mayestaran	Drawing list
03	F1	P1	0	21/12/2015	mayestaran	Wiring line diagram
04	F1	P1	0	21/12/2015	mayestaran	VACCUM FEEDING NC SERIES
05	F1	P1	0	22/12/2015	mayestaran	Vaccum feeding box
06	F1	P1	0	26/01/2016	mayestaran	Bill of materials
07	F1	P1	0	26/01/2016	mayestaran	Bill of materials
08	F1	P1	0	26/01/2016	mayestaran	List of wires
09	F1	P1	0	26/01/2016	mayestaran	List of the cables
10	F1	P1	0	26/01/2016	mayestaran	List of cable strands

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DRAWING LIST

PROJECT: S860080201 VACCUM FEEDING NC SERIES

REV.	DATE	NAME	CHANGES
0	21/12/2015	mayestaran	

REVISION 0

SCHEME 02

1	2	3	4	5	6	7	8	9	10

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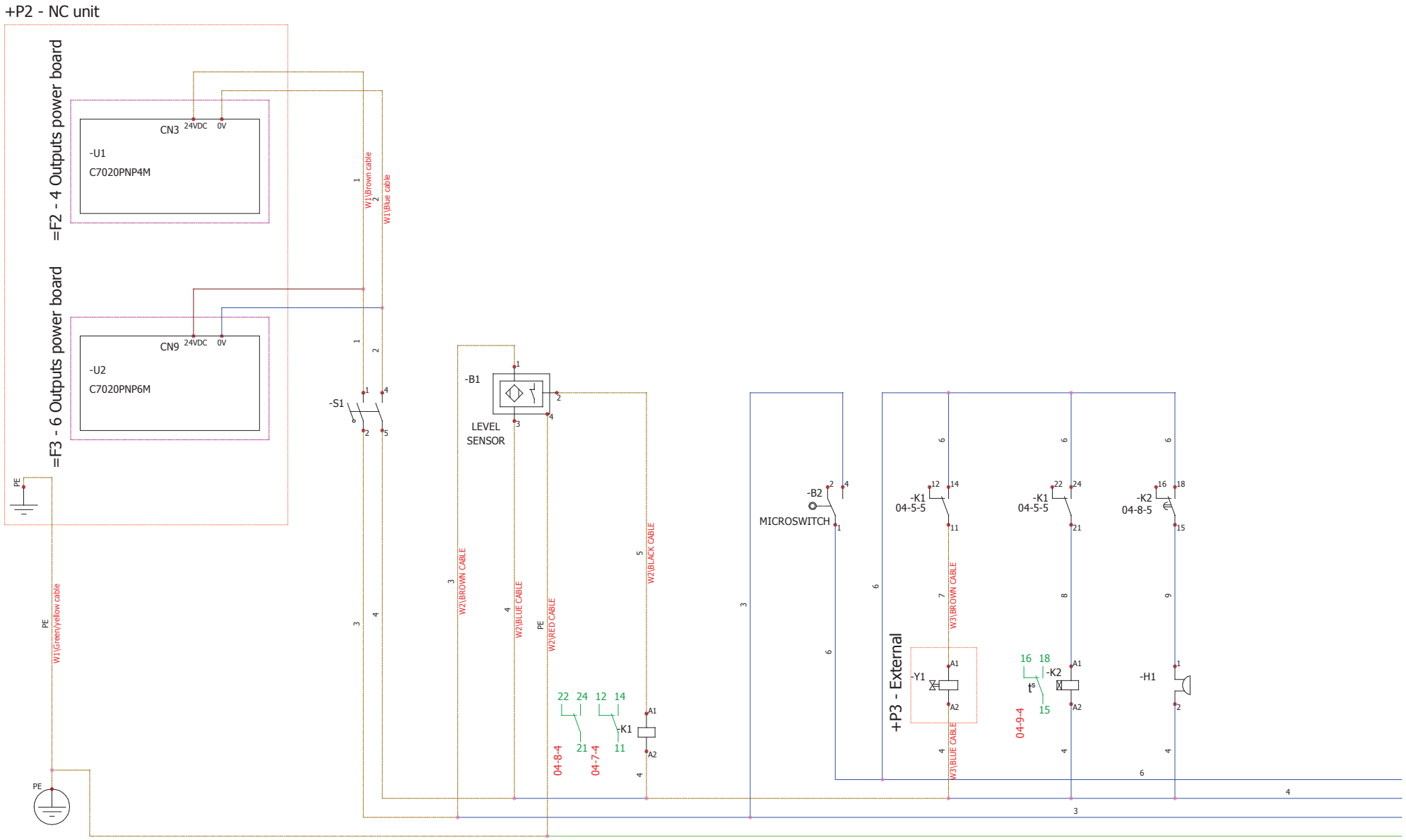
WIRING LINE DIAGRAM

PROJECT: S860080201 VACCUM FEEDING NC SERIES

REV.	DATE	NAME	CHANGES
0	21/12/2015	mayestaran	

REVISION 0

SCHEME 03



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VACCUM FEEDING
NC SERIES

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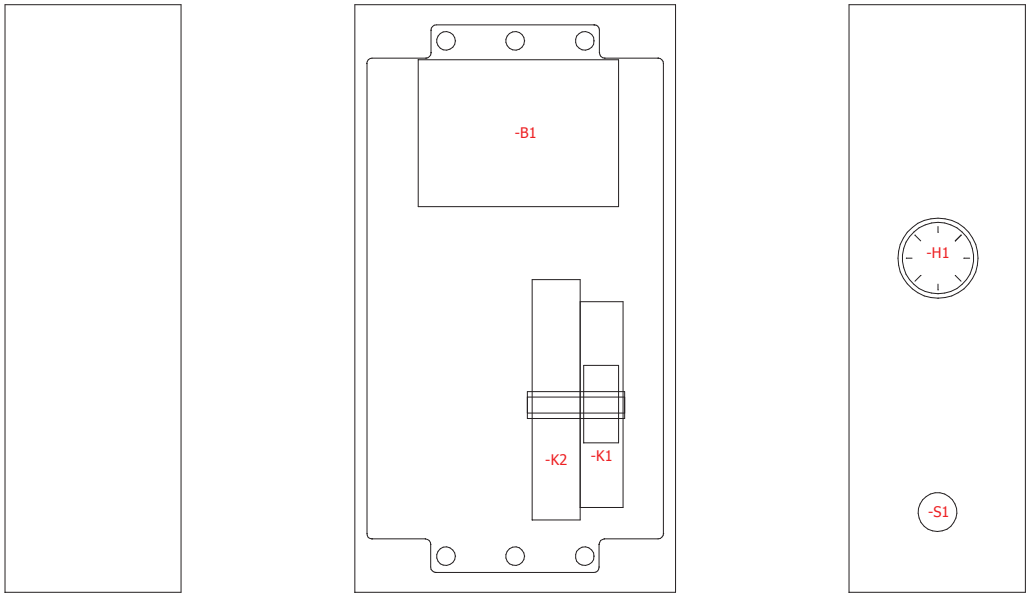
REV.	DATE	NAME	CHANGES
0	21/12/2015	mayestaran	

REVISION 0

SCHEME 04



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VACCUM FEEDING BOX CONSTRUCTION

PROJECT: S860080201 VACCUM FEEDING NC SERIES

REV.	DATE	NAME	CHANGES
0	22/12/2015	mayestaran	

SCALE 1 / 2

REVISION 0

DRAWING 05