



INSTRUCTIONS  
MANUAL

# ADHESIVE AUTOMATIC FEEDER

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# 1. SAFETY GUIDELINES

## General

The information contained in this section applies not only to everyday equipment operation, but also to any procedure carried out on it, whether for preventive maintenance or in the case of repairs and the replacement of worn out parts.

It is very important to observe the safety warnings in this manual at all times. Failure to do so may result in personal injury and/or damage to the equipment or the rest of the installation.

Before beginning work on the equipment, read this manual carefully, and in case of any doubt, contact our Technical Service Center. We are available for any clarification that you might need.

Keep manuals in perfect condition and within reach of personnel that use the equipment and perform maintenance on it.

Also provide necessary safety material: appropriate clothing, footwear, gloves and safety glasses.

In all cases, observe local regulations regarding risk prevention and safety.



## Symbols

The symbols used on both the melter/appliator equipment and in this manual always represent the type of risk we are exposed to. Failure to abide by a warning signal may result in personal injury and/or damage to the equipment or the rest of the installation.

**Warning:** Risk of electrical shock. Carelessness may produce injury or death.



**Warning:** Hot zone with high temperatures. Risk of burns. Use thermal protective equipment.



**Warning:** System under pressure. Risk of burns or particle projection. Use thermal protective equipment and glasses.



**Warning:** Important information for the correct use of the system. May include one or several of the previous hazards, and therefore must be kept in mind to avoid damage and injury.



**Warning:** Dangerous area. Risk of entrapment. Carelessness may produce injury or death.



## Mechanical components



The hot-melt installation, which is installed to this device, requires moving parts that can cause damage. Use the equipment correctly, and do not remove the safety guards while the equipment is in operation; prevent the risk of possible entrapment due to moving mechanical parts.



Do not use the equipment if the safety devices are not in place or appear to be inadequately installed.

For maintenance or repair operations, stop the movement of moveable parts by turning off the main switch.

The device has no moving mechanical parts, so it does not pose risks to consider in this section.

## Electrical components



The system works with single-phase or three-phase current of a certain power. Never handle the equipment with the power connected, as this may result in powerful electrical shocks.



The installation must be correctly grounded.

The installation's power cable conductors must match the required electric current and voltage.

Periodically inspect the cables to check for crushing, wear and tear, as well as to prevent tripping and falls as a result of their placement.

Although the system meets EMC requirements, it is inadvisable to use devices that transmit high levels of radiation, i.e., mobile phones or soldering equipment in their vicinity.

## Hydraulic components



As this is a pressurized system, precautions related to this type of equipment must be observed.

Before each operation, always make sure that the adhesive circuit is completely free of pressure. There is a high risk of hot particle projection, along with the corresponding danger of burns.

Use caution with the residual pressure that may remain in the hoses when the adhesive cools. When reheated, there is a risk of hot particle projection if the outputs are left open.

## Pneumatic components



Some equipment uses compressed air to 6 bar pressure. Before any manipulation, please ensure that the circuit has lost fully air pressure. The risk of projection of particles at high speed can cause injury to a certain severity.

Extreme precautions with the residual pressure that could be contained in the circuit, before disconnecting any pneumatic feeding tube.

## Thermal components

The entire system works with temperatures that can exceed 200°C (392°F). The equipment must be operated using adequate protection (clothing, footwear, gloves and protective glasses) that completely cover exposed parts of the body.

Keep in mind that, due to the high temperatures reached, the heat does not dissipate immediately, even when the power (in this case, electric) source is disconnected. Therefore, use caution, even with the adhesive itself. It may remain very hot, even in a solid state.

In case of burns:

1. If the burn is the result of contact with melted adhesive, do not try to remove the adhesive material from the skin. Do not try to remove it once it has solidified either.
2. Cool the affected area down immediately with lots of cold and clean water.
3. Seek medical attention as soon as possible either from the company's medical service or the nearest hospital. Provide the medical staff with the Safety Information Sheet of the adhesive.



## Materials

Meler systems are designed for use with hot-melt adhesives. They should not be used with any other type of material, and especially not with solvents, which may cause personal injury or damage to internal system components.

Some units are specifically designed to use polyurethane reactive (PUR) hot-melt adhesives. Using PUR on a unit that is not prepared for that purpose may cause severe damage to the unit.

When using adhesive, follow the corresponding guidelines found in the Technical and Safety Sheets provided by the manufacturer. Pay special attention to the advised work temperatures in order to prevent adhesive burning and degradation.

Ventilate the work area adequately in order to remove the vapors produced. Avoid the prolonged inhalation of these vapors.

Always use original Meler components and replacement parts, which guarantee the correct system operation and service.



## Noise emission declaration

The A-weighted emission sound pressure level ( $L_{pA}$ ) of the unit in operation does not exceed 70 dB(A) under any circumstances.

The maximum C-weighted sound pressure level ( $L_{pCpeak}$ ) and the A-weighted sound power level ( $L_{WA}$ ) do not exceed values worthy of mention and thus do not represent a specific risk that must be taken into account.



### Intended use

The equipment are designed to be used in the following conditions:

- Hot-melt adhesive fusion and pumping at temperatures up to 200 °C (392 °F). Consult with Meler technical service to operate with higher working temperatures.
- Use of equipment with Meler accessories.
- Installation of equipment according to the security regulations currently in force and the instructions provided in this manual (anchoring, electrical connection, hydraulic connection, etc).
- Use of equipment in non-explosive, non-chemically aggressive environments.
- Use of equipment following the safety instructions indicated in this manual, as well as on the labels accompanying the equipment, using adequate means of protection during each mode of operation.



### Limited use

The equipment should never be used under the following conditions:

- Use with reactive polyurethane or any other material that might cause safety or health risks when heated.
- Use of equipment in environments where cleaning is necessary using water jets.
- Use of equipment to heat or melt food products.
- In potentially explosive atmospheres, aggressive chemical environments or outdoors.
- Use or operation without adequate safety protection.
- If the person in question does not have the necessary training to use the unit or to apply all of the necessary safety measures.



**Note:** Do not modify the equipment or use components that were not supplied by Meler. For any modification of a component of the equipment or part of the installation, you must firstly consult the After-Sales Service

## 2. INTRODUCTION

### Description

The Meler adhesive automatic feeder ensures a continuous level of adhesive inside the melting tanks, eliminating the task of manually refilling by the user.

Each time the tank sensor detects a low adhesive level it sends a signal to the suction system which, from the container adhesive (or directly from the adhesive bag), transferred a load of adhesive to the melting tank. The loading process is indicated by a light signal.

When the sensor detects the correct level again, the transfer of adhesive stops (a disconnection delay can be programmed).

An alarm system, timed from the detection of low level, warns of possible flaws in the loading or completely emptying the container for its replenishment.

The system triggers a combined signal, noise and intermittent light. The acoustic signal can be cancelled by the available button.

Once corrected incidence signal light turns off the unit by 'RESET' button.

The system provides a level of security in the hot-melt cast within the fuser team, as well as the absence of charred material (the adhesive is melting and contributing as it needs), prevents external contamination of the adhesive (in a totally enclosed system ) and facilitates the tasks of recharge.



The unit can be installed in the range of Meler hot-melt tanks, as well as other units on request.

It supplies the unit load (control, filter, sensors and aspiration mouth suction), together with some specific adaptation to the requested unit.

As an accessory, the system features a container for the adhesive with a capacity of 50 kg, with the aim of providing the system with greater autonomy. This container can also feature its own level control, which operates in the same way as the melter.



Do not use it to transfer liquids or materials other than those specified. Some adhesives can become sticky with moisture, causing a malfunction of the device.

### Operation modes

The automatic feeder has the following service statuses:

**Loading mode**\_The device operates normally, loading the tank of the hot-melt system as often as low level the detector of the loading system, installed on the tank, indicates it. This corresponds to an automatic process where the operator should not act on any element of control.

This mode can also have the 'standby' activation function of the melter enabled. When the melter (at temperature OK and adhesive tank level OK) does not request pellet feeding after a programmable period of time has passed, the feeder control puts the melter into 'standby' mode.

**Alarm mode**\_The device stops the function of load, stopping the expulsion of air, in case the tube is obstructed or lack of adhesive in the adhesive container. In this situation a light and an acoustic signal is emitted, which can be overturned by the operator. After the intervention to replenish the system, the operator must push the RESET button.

**Inhibition mode**\_The automatic loading stops but operator can done manual loads without control by the level detector so there is a risk of overflow.

**Stop mode**\_The device in off stays without tension.

It does not signal any load control. However, the system keeps the air pressure in the input circuit.

### Identification of the hot melt system

When you want to place orders for parts or materials or if you request support from our Technical Service you should indicate the reference and serial number of your equipment.

These data and other information of a technical nature can be located on the identification plate on the electrical control box.

## Main components

### General

1. Flexible Load Tube
2. Rotary fitting
3. Unload Filter
4. Load Sensor
5. Control Board
6. Output air supply to the suction area
7. Electric load valve
8. Input air supply (from the grid)
9. Led for activation of load sensing
10. Sensitivity adjustment of load sensor
11. Sensor Connectors
12. Sensor closed lid
13. Connector power supply
14. Main switch
15. Reset button for acoustic signal
16. Illuminated rearmament button
17. Pneumatic vibrator
18. Suction area
19. Air feeding tube



50 kg container

- 1. 50 kg container
- 2. Flexible feeding duct
- 3. Pellet inlet screen
- 4. Control Board container
- 5. Reset button for acoustic signal
- 6. Illuminated rearment button
- 7. Main switch
- 8. Connector power supply
- 9. Sensitivity adjustment of load sensor
- 10. Led for activation of load sensing
- 11. Pellet level sensor in container (optional)
- 12. Pneumatic vibrator
- 13. Suction area
- 14. Air feeding tube (optional for 1 or 2 units)
- 15. Air inlets towards the suction port
- 16. Lit reset button sensor melter (optional)



**50 kg container settings**

- Basic pellet storage container 1 upper outlet.
- Pellet storage container 1 rear outlet.
- Pellet storage container 2 rear outlets.
- Pellet storage container 1 rear outlet with RESET button for melter.
- Pellet storage container 2 rear outlets with RESET button for melters.
- Pellet storage container 1 rear outlet with level sensor. (\*)
- Pellet storage container 2 rear outlets with level sensor. (\*)

(\*) The level sensor RESET button can be associated with the RESET button of the melters.

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### 3. INSTALLATION

**Warning:** The vacuum feeders are installed in equipment with updated technology with foreseeable risks. Therefore, you should allow only the access to skilled people, with sufficient training and experience in handling, installation or repair of such equipment.



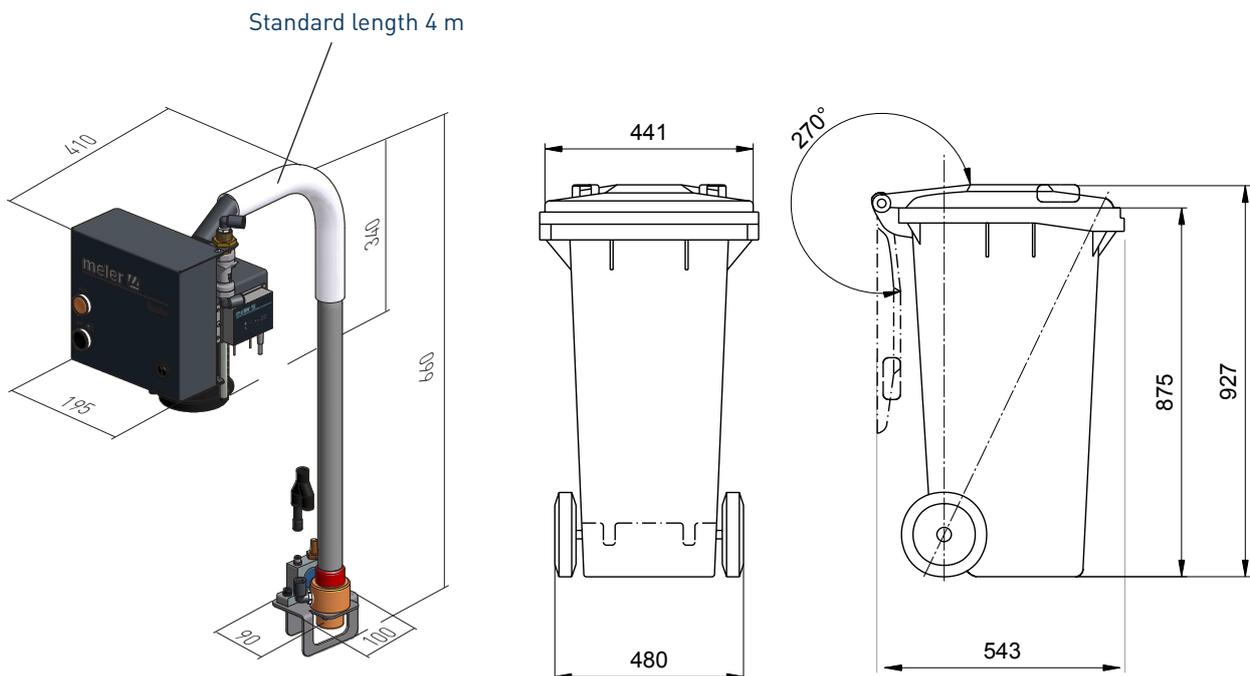
#### Preliminaries

The feeder is normally supplied together with the melter unit, with the elements necessary for installation and use. However, some components must be supplied by the user depending on the location and connections of each facility including:

- Power cable for power supply
- Tube for compressed air and connector
- Appropriate and closed container for the adhesive

#### Installation requirements

Before installing or using a vacuum feeder we must ensure that the space for it allows the location, connection and use of the entire system. We must also ensure that the electrical and pneumatic supplies meet the requirements demanded by the used device.



### Electrical Consumption

Before connecting the vacuum feeder we must take into account the total consumption of the system and provide an appropriate power supply.

Check nameplate of the feeder before the connection, in order to connect device to the appropriate voltage.

Connect and ensure a correct grounding of the device.



**Warning:** Risk of electrocution. Even when the equipment is turned off, voltage remains in the intake terminals, which may be dangerous during internal equipment manipulations.

The control panel of the feeder incorporates a general OFF switch that insulates the unit of its power supply. This protects against short circuits through a fuse with external access to it, but you must protect the entire installation from the power supply against overloads. Install a power switch for disconnecting the melter/appliator equipment from the electrical network.

The power associated with this protection is indicated on the nameplate of the feeder.

### Compressed air

To install 'meler' vacuum feeder, it is necessary to have a dry, non-lubricated compressed air system with a maximum pressure of 6 bars.

The air inlet pipe is installed to 10 mm outer diameter.

### Unpacking

Before proceeding with the installation of the vacuum feeder, it should be removed from its location on a pallet and examined in order to detect any possible breakage or deterioration.

Communicate any defect, even to the outer packing materials, to your 'meler' Representative or to the Main Office.

### Content

If the feeder has been issued installed on a hot-melt system, all elements of the system are mounted on it, except the suction tube which should be connected to the swivel connector.

If the system has a pellet container with reset button, also including a feeding system and/or level sensor, all of the necessary components in the container will come already mounted.

## Feeder assembly

If the vacuum feeder installed on an existing melter please follow the correspondent instructions for each model of melter unit.

**Warning:** Ensure that the earth cable of the sensor has been connected to the ground connection of the melter.



## Electrical power supply connections

The vacuum feeder is supplied to be connected to the power supply of single phase 230 VAC, depending on their power consumption.

It is always imperative to install a good ground connection.

The maximum and minimum values are listed on the nameplate of the system.

**Warning:** Risk of electrical shock. Carelessness may produce injury or death.

Connect and fix the power cable (3x0.75mm<sup>2</sup>) to the supplied plug.

Connect the plug to the control box fixing it with the metal clamp.

Connect the other end of the power cable to the power socket.



## Pneumatic connection

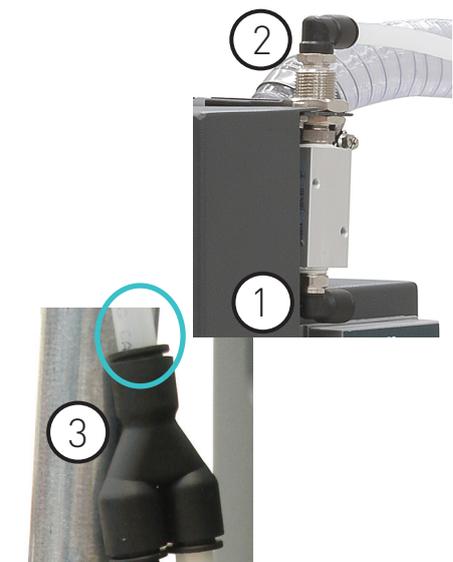
Before connecting the pneumatic power to the vacuum feeder, make sure the pressure regulator on the system and the main air supply is completely closed.

Connect the vacuum feeder through a flexible tube with outside diameter of 10 mm to the general air supply (6 bar max.) (1). The unit has a quick coupling for this connection.

The air outlet grid (2) is connected by a flexible hose outside diameter 10 mm to the Y quick connector (3) located in the area of the suction adhesive.

To be sure about the connection of the tubes in the inlet and the outlet, the valve is marked with the numbers 1 and 2 respectively. See the pictures.

Once connected, open the air supply verify that you have maximum 6 bar pressure. Pressures higher than that causes an unnecessary expense and the possibility to produce turbulences in the hot melt tank with consequent malfunction of the unit.



### Suction tube connection



The suction tube should be connected to the swivel elbow of the vacuum feeder, inserting it into the inside of the metallic mouth down to its bottom.

Place the swivel elbow to the most convenient position for installation, depending on the location of the hot melt container.

Therefore:

- Loose slightly the three fixing screws for the lid of the filter and set the swivel elbow.
- Place the swivel elbow to the desired position, twisting it in the required sense.
- Tight the three fixing screws to the position of the elbow and prevent their movement.

### Connecting control detectors

The vacuum feeder has two control sensors for the control of the operation of the system.

The low level sensor detects a low level of adhesive in the tank, in order to activate the filling of adhesive and when it has reached the right level to stop this filling.

The "lid closed" detector allows the stop the filling procedure when the lid is opened, preventing the projection of adhesive to the outside.

Both sensors are wired in a single connector at the control box. This connection allows the installation of the control box away from the hot melt tank using an appropriate interconnection cable.

### Installation of external control box

In some situations, it will be necessary to place the control box away from the hot melt equipment. It should be taken into account, that the longer the air and the vacuum tubes are, the suction force will be reduced.

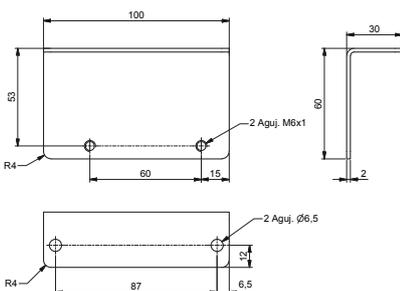
In order to bring the control box and the air supply closer to the adhesive container, you can install the control box away from the hot melt equipment and closer to the mouth of the suction tube.

Therefore take into account the following factors:

- Location and setting of the control box
- Electric connections of the sensors

The control box, with the solenoid valve incorporated, is fixed with two screws to the provided squadron, following the attached drawing. On demand 'meler' will supply this squadron.

For the electrical connection, an interconnection extension cable between the electrical box and the plug of the installed sensors on the hot melt system is required.





### Connection of signals for standby function

It is possible to associate the activation of the melter's standby function with the automatic feeder function. When the melter (at temperature OK and adhesive tank level OK) does not request pellet feeding after a programmable period of time has passed, the feeder control puts the melter into 'standby' mode.

For this, a custom cable must be connected, which connects the XST1 and XST2 terminals to the 'standby' signal input on the melter and the XTOK1 and XTOK2 terminals to the 'temperature OK' output on the melter.

Refer to the instruction manual of the melter and the electrical diagrams of both units for more information.

### Pellet container installation

#### Electrical power supply connections

The pellet container is supplied to be connected to the power supply of single phase 230 VAC, depending on their power consumption.

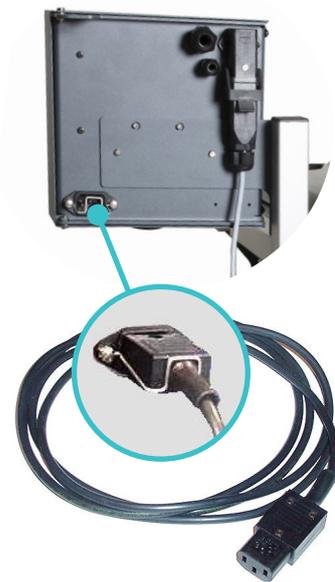
It is always imperative to install a good ground connection.

The maximum and minimum values are listed on the nameplate of the system.

Connect and fix the power cable (3x0.75mm<sup>2</sup>) to the supplied plug.

Connect the plug to the control box fixing it with the metal clamp.

Connect the other end of the power cable to the power socket.



#### Container with reset button

When the installation has a pellet container with a remote reset button for the melter, this button must be connected in the electrical box of the feeder.

For this, guide the custom cable with the button through the PG9 bushing of the electrical box of the feeder and connect it to the 3X21 and 3X22 terminals.





### Container with pellet level control

When the installation has a pellet container with level control, it is possible to associate the reset function for the melter's automatic feeder with the container reset button.

For this, connect the custom cable from terminals 4X51 and 4X52, from the container's level control box to the 3X21 and 3X22 terminals of the automatic feeder's control box, passing the cable through the PG9 bushings of both boxes. If connecting a second melter, the 4X53 and 4X54 terminals must be used.

### Placing the suction tube

To transfer the adhesive from the adhesive container to the hot melt equipment, the suction tube should be inserted to the bottom of the container.

The four flaps that protects the entrance of the suction tube are designed to keep the suction mouth open and without obstructions. It maintains a free way for the suctioned adhesive.

The vibratory element (pneumatic) keeps the adhesive loose around the entrance to facilitate its suction.

The aspiration element uses compressed air. By the help of the venturi effect, a depression is created in it, that absorbs pearled and pallet adhesive and drives it to the shell of the hot-melt system.

The Venturi effect, applied to the vacuum feeder, consists in a decrease of the air pressure by an air flow inside the closed circuit while increasing the air speed when passing through the narrowing of the entry mouth.

As the entry of aspiration is connected to this point, the aspired adhesive stays in it and is transported to the hot-melt tank through the flexible communication hose.



## 4. USE OF THE UNIT

This section presents how to use the vacuum feeder. Even if its operation is very simple, it should not be used by non-trained personnel.

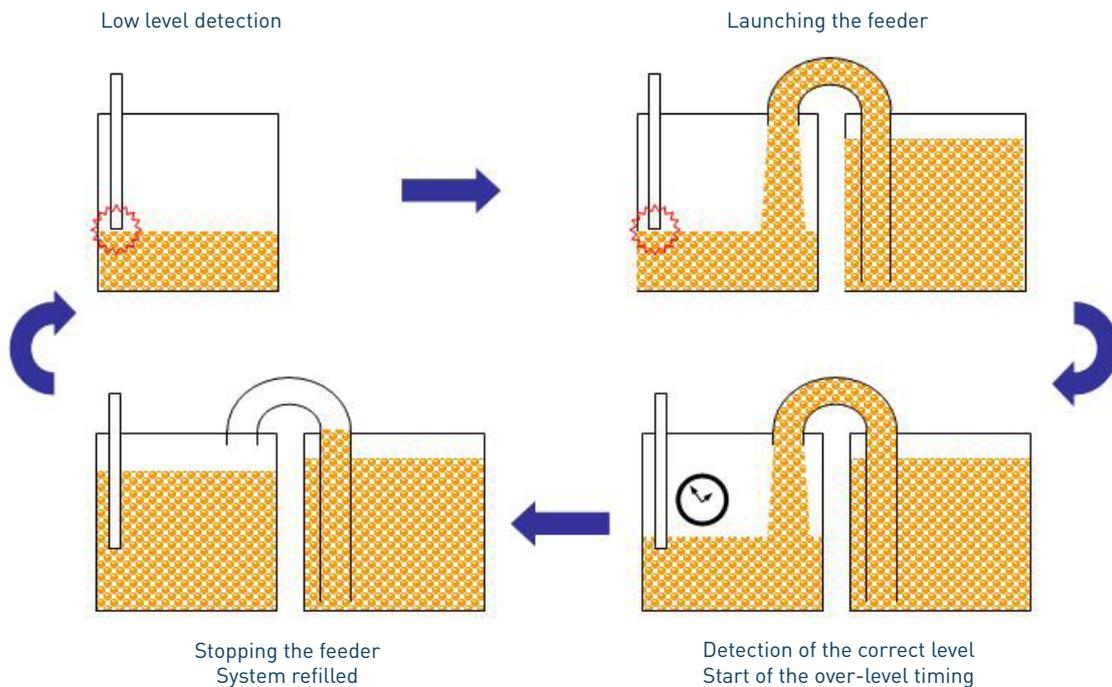
**Warning:** An improper use can cause damage to the equipment itself or to the operator.

### Start up and automatic process

The operation of the vacuum feeder is absolutely automatic and only needs to switch it on, to begin the automatic feeding when the low level sensor requests it.

Connect the switch on the front of the control panel.

The automatic loading process is developed according to the following pattern:



## Sensor adjustments

### Sensitivity adjustment



The adjustable sensitivity of the sensor, depending on the material used and the hysteresis admitted to the operation of the vacuum feeder is factory pre-set and therefore it is NOT necessary to change. In most cases the factory setting is perfectly valid to use the vacuum feeder.

If it is necessary to correct the adjustment contact the Technical Services Meler or Area Representative.

### Positioning of the level sensor

The sensor is supplied factory set so that, when the pellet level is around 10 mm below the sensor, it detects a full tank (green LED).

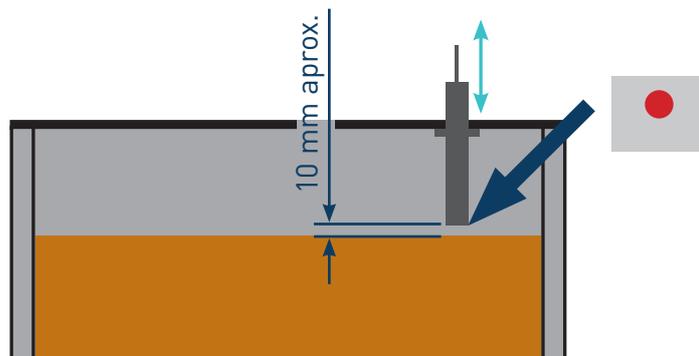
Depending on the type of pellet used, it may be necessary to make a final adjustment when starting up the system:



**Important:** Use the working adhesive at the operating temperature.

**Warning:** Hot zone with high temperatures. Risk of burns. Use thermal protective equipment.

1. With the unit at the operating temperature and the sensor clean, fill the tank with the pellets that you are going to work with, up to what is considered the 'tank full' level.
2. Move the capacitive sensor up/down in relation to the tank lid, right until the colour of the LED changes from green to red. The LED should remain red.



3. We recommend checking that it is properly set by running a few automatic reloading cycles.



**Note:** If the sensor sensitivity setting needs to be corrected, contact Meler's after sales service or the area representative.

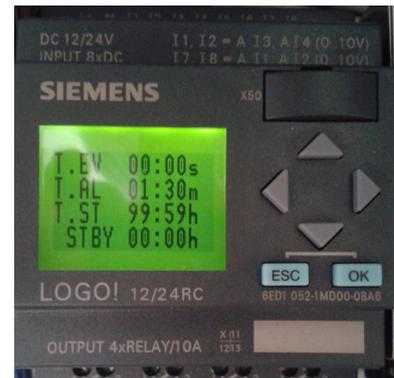
## Level stabilisation time

The level stabilisation time is the time that passes between when the equipment detects that the level is too low and when the electrovalve is activated (EV=ON) to load adhesive. The parameter cannot be programmed by the user. The default time is 2 seconds.

## Programmable times using the timer

### Disconnection delay time

The extra time that the loader operates after the correct level has been reached is called the disconnection delay time. The screen shows 'T.EV 00:00s' and you can program the first digits in seconds and the digits after the ":" in hundredths of a second.



### Operating alarms

#### 1. Load error alarm

Each time the load sensor detects low adhesive a safety timer is connected (Default 90 seconds). That controls of time lap the device is charging. This timer is resetted when the sensor detects correct adhesive level.

In case that within the scheduled time (90 seg) the level sensor has not detected the correct level, the system assumes the existence of a failure in the loading circuit and connects the warning signs:

- Beep buzzer.
- Flashing amber light signal on the RESET button.

Both signals remain activated while they are not restarted.

Pressing the black button the acoustic signal can be overridden.

Pressing the amber light button the system will be resetted. The security time will begin to count again.

You just have to press the reset button after having corrected the existing failures:

- Obstruction of aspiration hose.
- Mismatch of the sensitivity of the level sensor .
- Empty adhesive container.

#### 2. Open lid alarm

When you open the lid of the hot-melt melter grid, the magnetic sensor gives the signal to the programmable relay to interrupt the loading procedure. Closing the lid, after 10 sec. the loading procedure restarts.





If keep the lid open longer than the time programmed into the parameter 'ALARM', the alarm is triggered and connects the warning signs:

- Beep buzzer.
- Flashing amber light signal on the RESET button.

Both signals remain activated while you do not act on them.

Pressing the black button the acoustic signal stops.

Pressing the amber light reset button the system restarts except if the lid is still open.

When either of these alarms occurs, the loading cycle stops if it had not yet begun, or does not begin if the equipment is in standby. The electrovalve output is deactivated, the warning light flashes quickly and the buzzer starts. The screen shows 'T.AL 00:00m' and you can program the first digits in minutes and the digits after the ":" in seconds.

### Change to standby time

Once the equipment temperature is OK and the adhesive level is correct, as soon as loading is finished a timer begins in the program; once the programmed "T.ST" time has been reached an outlet contact is activated that puts the melter into "STBY change to standby" status.

If while the timer is counting down the equipment level drops or the temperature is not OK, the timer will stop. Then, when the equipment returns to OK temperature and correct adhesive level the timer will reset and begin to count down again.

The screen shows 'T.ST 00:00h' and you can program the first digits in hours and the digits after the ":" in minutes.

For this function to be operational, the corresponding signals between the automatic feeder's control and the melter must be connected. See the point "Connection of signals for the standby function".

### Setting programmable times using the timer



Inside the electric cabinet there is a programmable relay to set the disconnection delay time of the electrovalve (T.EV), the error alarm (T.AL) and the standby (T.ST) for periods of inactivity.

To open the electric cabinet, loosen the screw that holds in place the door to the electric cabinet casing on the left side, and slide it out.

The following is the procedure to change the times for each element:

1. Press the ESC key for several seconds until the cursor appears under the first digit of T.EV.
2. Use the left-right arrows to move to the value you want to change. Click OK and you will see the digit in negative (light digit over a dark background).

3. Change the T.ST value with the up-down arrows.
4. Use the left-right keys to move to a different digit.
5. Once finished, click the OK key to validate the changes and exit editing mode by pushing ESC. The change is now in operation.

## Manual feeding

For production needs or if there is any fault in the level detector it is possible to do manual loading.

In this case the automatic feeder must be in inhibition mode (by pressing for 3 seconds stop button).

Once in this mode you can make a manual loading by pressing the RESET button over 2 seconds and keeping it pressed. Load contact and reset button LED will be activated and will remain active until the RESET button is released. Manual loading mode does not depend on level detector so there is a risk of overflow.



## Pellet container level sensor

The sensitivity setting and the control parameters of the pellet container's level sensor are factory programmed and no intervention by the user is necessary.

Each time the load sensor detects low adhesive level connects the warning signs:

- Beep buzzer.
- Flashing amber light signal on the RESET button.

Both signals remain activated while they are not restarted.

Pressing the black button the acoustic signal can be overridden.

Once the container has been filled to above the level sensor, press RESET to continue normal operation.



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## 5. MAINTENANCE

**Warning:** The vacuum feeder is a device with updated technologies but with certain risks. Therefore, you should allow only the right people, with sufficiently enough training and experience, handling, installation or repair of these devices.



The following table summarizes briefly the indications for proper maintenance of the vacuum feeder. Read carefully, in each case, the corresponding section.

If the device does not work or works incorrectly contact the Technical Services 'meler' or Area Representative.

Operation	Frecuency	Refer to
External cleaning	Daily	Cleaning of the unit
Pneumatic system	- Daily: pressure control - Weekly: leakage inspection	Pneumatic circuit
Load sensor	- Daily: load control - Weekly: cleaning	Control of load sensor
Suction tube	Weekly	Inspection aspiration tube
Air exhaust filter	Weekly	Filter maintenance
Pneumatic vibrator	Weekly	Control of pneumatic vibrator

### Cleaning of the unit

To maintain the performance of the vacuum feeder in perfect functioning, all of its components must be maintained clean and especially the exits in the air suction tube.

Eliminate waste that can clog the air outlets.

Keep clean and without obstructions the tube for the adhesive.

Clean items with a soft tissue and aspire the dust that can be accumulated.

### Pneumatic system

Control regularly the pressure feeding circuit. Very low pressures do not allow proper loading of the adhesive. Very high pressures can produce splash of molten adhesive in the tank of the melting unit and even cooling of the hot melt.

Monitor periodically if there is any leak in the pneumatic circuit. In addition to being a useless expense resulting in loss of pressure and thus malfunction of the system load.





### Control of the load sensor

It is necessary to control if the load sensor is working properly and that it allows you to maintain the desired levels.

A low load will cause a decline in the level and the possibility of not having the amount of necessary hot-melt adhesive. By contrast, an overload can cause the overfilling of the tank with subsequent sealing of the loading mouth.

The load sensor should remain clean of charred adhesive that may affect the proper level detection.



### Inspection of the aspiration tube

Monitor that the aspiration tube is not obtured with sticked glue pallets or perls. This tube should be perfectly free of any glue plugs that impedes the smooth transfer of the adhesive from container to the tank of the melting unit.

The tube is mostly transparent to facilitate visual inspection of the same.



### Filter maintenance

Periodically review the state of the filter located inside the discharge zone. Blow compressed air impurities that may have acceded to.

This filter avoids dust particles or glue pallets itself being spilled outside with the exhaust air. If it arrived to be plugged the system might not work properly.

To clean, unscrew the three screws of the rotary elbow lid and extract the filter.



### Control of pneumatic vibrator

Reviewing the correct operation of the pneumatic vibrator located in the suction mouth. Ensures that it vibrates and its vibration is adequate.

Clean up the exhaust silencer of impurities and adhesive dust.

## 6. TECHNICAL CHARACTERISTICS

### General

Adhesive type	pads or pearls up to 12 mm
Max. transfer length	25 m (*)
Max. transfer height	8 m (*)
Max. refilling speed	400 kg/h (*)
Tube standard dimensions	Ø30 mm x 4 m
Recommended air pressure	6 bar (aire seco, filtrado y sin lubricar)
Consumption at 6 bar	360 l/min (cargando)
Power supply	LN ~ 230V 50/60Hz + PE
Container capacity	50 kg
Melter units	for the full range 'meler'
Dimensions	
Control box + loading input	190 x 290 x 210
Filter	20 mesh (< 1mm)

(\*) Depending on the type and form of the adhesive



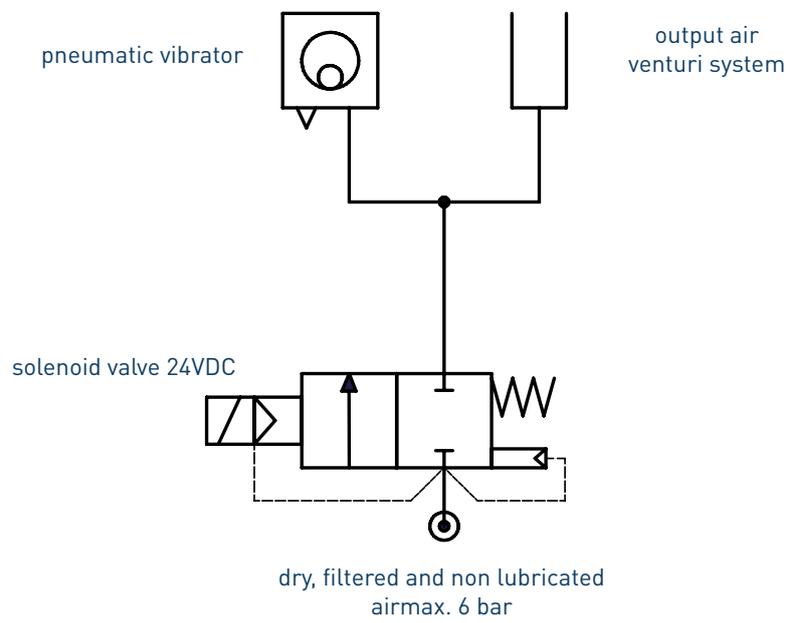
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## 7. ELECTRICAL DRAWINGS

To view the the electrical drawing of the purchased equipment, see the USB of electrical drawings included.

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# 8. PNEUMATIC DIAGRAM



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## 9. SPARE PARTS

The list of the most common spare parts of the vacuum feeder appears in this chapter in order to provide you with quick and safe information.

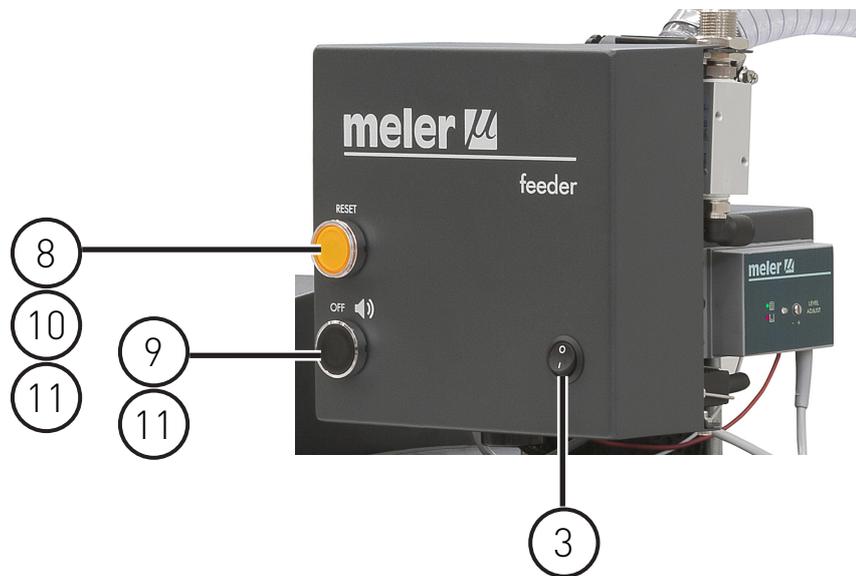
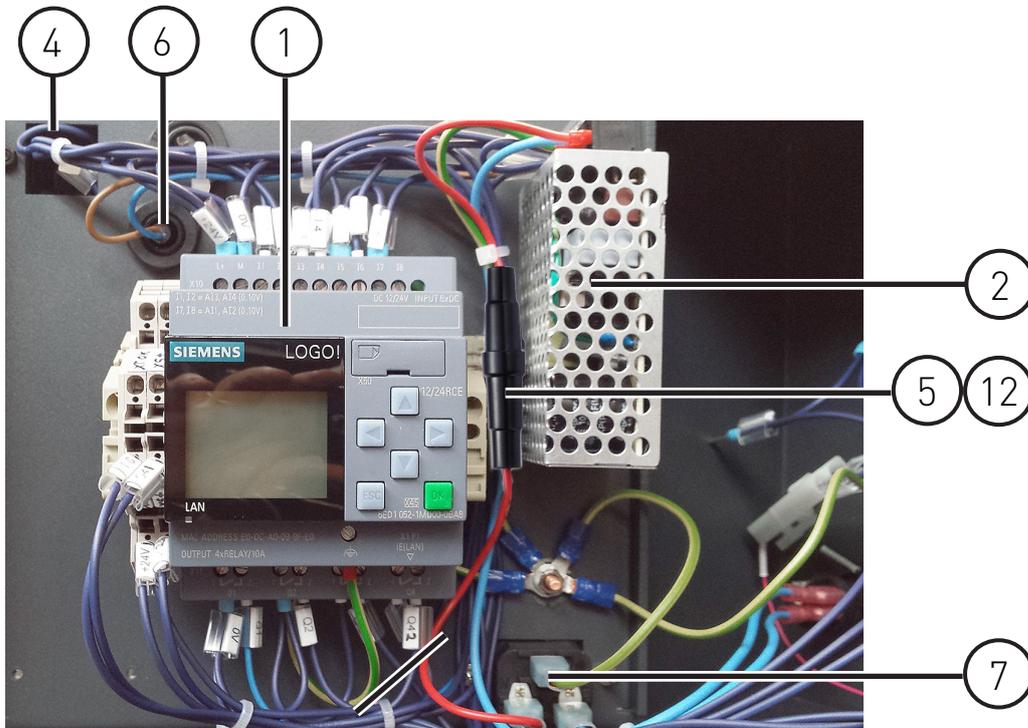
The spare parts are naturally assembled in several groups, located in the equipment.

As a visual aid it includes general images of the pieces, numbered to facilitate location within the drawing.

The lists provide the name of the reference and parts.



### A. ELECTRICAL COMPONENTS OF THE CONTROL BOARD

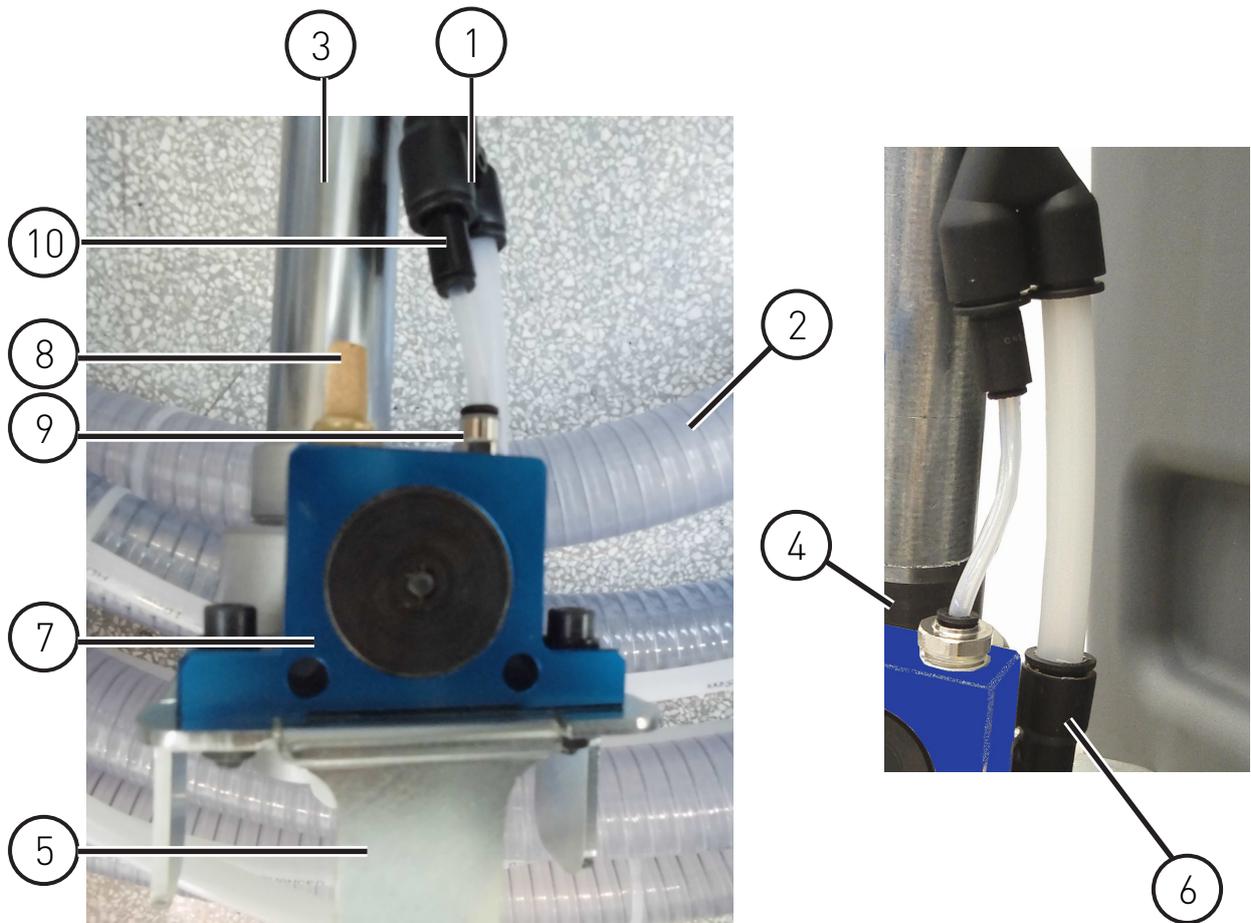


## A. ELECTRICAL COMPONENTS OF THE CONTROL BOARD

N°	Ref.	Description
1	150117130	Programmable relay LOGO
2	10110070	DC power supply 230VAC/24VDC
3	150114470	Main switch
4	150023760	Elbow connector socket
5	150133010	Fuse holder 5x20 10A 250V
6	150025630	Buzzer 24VDC
7	16020000	Power supply connection assembly
8	150115830	Yellow button with light
9	150115840	Black button
10	150022490	Yellow LED
11	150115870	Contact holder and contact N/O
12	10010002	Fuse 5x20 2A fast

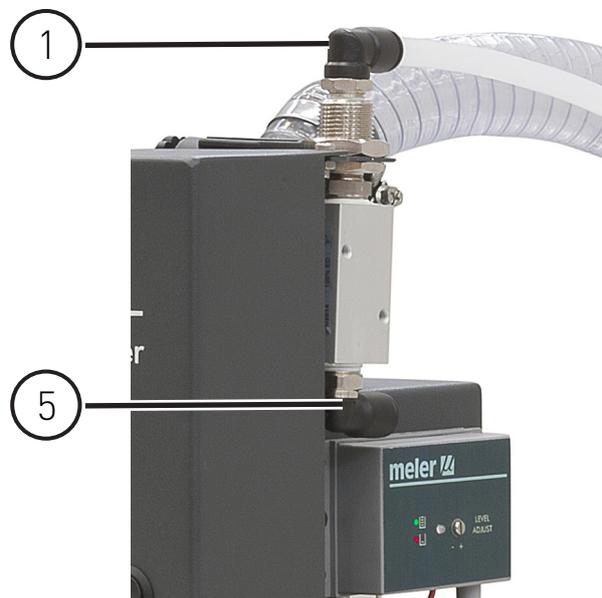
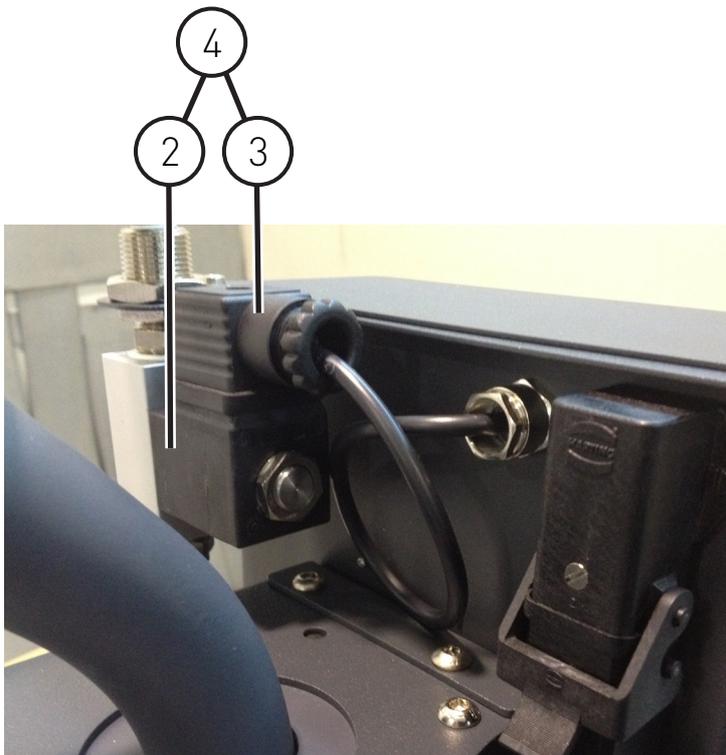
### B. SUCTION TUBE

N°	Ref.	Description
1	150025650	Fitting Y Ø10 quick plug
2	150025660	Hose vacuum feeder Ø30 (meter)
3	150025670	Metal suction tube
4	150025680	Venturi suction tube
5	150025690	Support for suction tube
6	150025700	Fitting 90° 3/8 Ø10 quick plug
7	150025710	Pneumatic vibrator vacuum feeder
8	21300000	Silencer
9	150110180	Straight fitting 1/8 Ø4 quick plug
10	150025740	Reduction Ø10-Ø4 quick plug
	150025810	Complete suction tube vacuum feeder



### C. VALVE ASSEMBLY

Nº	Ref.	Denominación
1	150025750	Fitting 90° 1/4 Ø10
2	150060080	Coil for solenoid valve 24 VDC (10W)
3	150060050	Solenoid valve connector
4	150060070	Complete solenoid valve 2/2 24VDC 5W
5	150025790	Fitting 90° 3/8 Ø10 quick plug



### D. FILTER- SENSOR ASSEMBLY

N°	Ref.	Description
1	150091730	Complete straight male connector
2	150025800	Capacitive level sensor (amplifier and probe)
3	150119170	Cable gland PG9
4	150025770	Grid filter 20 mesh
5	150025870	Capacitive level sensor o-rings

