

TIP 0305-43

OLD TIP NO. 205-82
ISSUED – 1982
REVISED – 1988
REAFFIRMED – 1994
REVISED – 2000
WITHDRAWN – 2007
REVISED AND REINSTATED – 2007
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Extruded glue mechanism supplement

Scope

Trouble-shooting extruded glue mechanism systems.

Safety precautions

Follow all manufacturers safety precautions and directives. Insure that all lock-out and/or tag-out procedures are followed.

Content

<i>Problem</i>	<i>Cause</i>	<i>Remedy</i>
No glue	No power to control	Turn on circuit breaker; turn on glue unit. Find source of short circuit.
	Blown fuse; tripped circuit breaker	Replace fuse; reset breaker; use VOM to check for short.
	Defective pump	Repair or replace pump.
	Clogged filter	Clean filter.
	Clogged glue supply line	Clean line.
	No air pressure	Turn on air to recommended pressure.
	Low air pressure	Adjust to correct pressure.
	Low level or no glue	Add glue.
Insufficient glue	Flow rate too low	Adjust for more glue.
	Viscosity too high	Replace with proper viscosity glue.

TIP Category: Automatically Periodically Reviewed (Ten-year review)



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<i>Problem</i>	<i>Cause</i>	<i>Remedy</i>
	Glue too cold	Add warm glue or replace glue supply.
	Low glue supply	Add glue.
	Leak in air system	Find and correct.
	Obstruction in glue or air supply line	Clean lines.
	Clogged filter	Clean filter.
	Obstruction in glue applicator head	Remove and clean in warm water or hydraulic fluid.
	Flow rate too low	Adjust for more glue.
	Poor pump output	Check to see if pump is working properly
	Flow rate too high	Adjust for less glue.
	Viscosity too low	Replace with proper viscosity glue.
Excessive glue	Air pressure too high	Adjust air pressure setting.
Erratic glue pattern	Air in glue lines	Bleed or purge.
	Pulse generator	Check tension of drive belt and functioning of pulse generator.
	Clogged glue applicator	Clean in warm water; hydraulic fluid.
	Obstruction in glue supply lines	Clean and flush lines.
	Air pressure too high or low	Adjust to proper setting.
	Clogged glue filters	Clean filters.
	Dirty sensor light	Clean.
	Applicator pressure to sheet not correct	Adjust.
	Worn glue applicator	Replace.
	Air in glue system	Bleed or purge system.
Glue beads on lead and trail edge of sheet	Defective electric solenoid	Replace.