

Operating Instructions for Hot-Melt Applicator

TR 70 LCD Cartridge Glue Applicator



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Dear customer,

The glue applicator you purchased will help you to glue parts together more easily and more rapidly. Before using the applicator please read these instructions thoroughly.

Product Description

Proper Use

The applicator works with hot glue which is dispensed under pressure. Therefore, the glue applicator should only be used by qualified people. Handling the applicator properly will save you unnecessary accident hazards and problems.

Personal injury or material damage caused by an improper use of the Hot-Melt Glue Applicator shall not be the manufacturer's but the user's responsibility.

Technical Data

Connection	230 V (110 V)
Heating capacity	400 W
Air control glue	0.15 - 7 bars
Air consumption max.	100 l/min
Temperature control	electronic
Temperature control range	approx. 50 - 210°C (infinitely variable)
Overheat protection	temperature controller
Heat-up time	approx. 3 - 10 min (depending on glue type)
Length cord to mains	approx. 8 m
Tank capacity	310 ml
(aluminium cartridge)	
Max. application of glue per min.	310 ml
Weight hand applicator	1400 g

Accessories

Foot switch art.no. 3518
Stationary equipment art.no. 3618
Balancer art.no. 3544
Stand for depositing applicator art. no. 3587

- **Special nozzles upon request.** Please ask for our accessory nozzle leaflet.

Trouble - Shooting

Survey on Possible Fault Signals and Assistance in Trouble-Shooting

In case of damage, send glue applicator to Reka, indicating type and serial no. of your applicator. We shall not be responsible for any repair made by the customer.

Problems	Possible Causes/ Faulty Operation	Trouble-Shooting
No or too little glue comes off though the heat-up time has been exactly observed	<ul style="list-style-type: none"> • clogged nozzle • pressure too low • temperature too low • defective valve • piston got stuck in cartridge 	<ul style="list-style-type: none"> • unscrew nozzle, clean or replace it • check controller • check temperature • replace valve • replace cartridge
Glue is too fluid or too consistent	<ul style="list-style-type: none"> • temperature too high or too low 	<ul style="list-style-type: none"> • check temperature
Glue leaks out of nozzle	<ul style="list-style-type: none"> • sound absorber got stuck • clogged nozzle • piston got stuck in cartridge 	<ul style="list-style-type: none"> • clean or exchange sound absorber • unscrew nozzle, clean it carefully or replace it. Unscrew nozzle at operating temperature; wear gloves (risk of burning) • replace cartridge
No temperature	<ul style="list-style-type: none"> • instrument unplugged • instrument switched off • defective electronics 	<ul style="list-style-type: none"> • is cable properly connected to socket? • is glue applicator switched on? • return applicator to supplier
Display shows: 999		<ul style="list-style-type: none"> • Unplug cord and plug it in again. Switch on glue applicator again. • If this problem shows up again, send in the glue applicator for checking.

General Safety Instructions

User's Care and Diligence

The Cartridge Glue Applicator has been designed and fabricated according to the applicable harmonized standards and further technical specifications. So, it is state of art and ensures a maximum of safety. This safety, however, can only be achieved in practice, if all necessary measures have been taken. The user of the device shall be obliged to plan these measures and to make sure that they are taken.

In particular, the user shall ensure that

- the applicator is in working order
- the required personal protective equipment (protective gloves) for the operating personnel is available and used
- the entire operating instructions are in legible condition and available to the operator
- only sufficiently qualified and authorized personnel operates and maintains the applicator
- this personnel is regularly instructed in the applicable aspects of operational safety and environmental protection, and knows the operating instructions and, in particular, the safety instructions.

Make the information available:

This operating manual shall be kept on the site of operation. It must be ensured that all persons operating the applicator can look into the manual at any time. In addition to the operating manual, the instructions pursuant to the Factory Act and the regulations as regards the use of equipment shall always be at the operator's disposal.

Meaning of the Various Safety Symbols

This operating manual shall give concrete advice as to safety to draw the user's attention to remaining unavoidable hazards. These hazards imply dangers to

- persons
- product and equipment

The symbols used in the operation manual shall, in particular, call attention to the safety instructions!



This symbol indicates that there is, above all, danger to persons, but also to equipment and material.



Caution: Hot surface!

Accident Prevention Regulation VBG 125 - W26

Hot surfaces such as machine parts, tanks or materials, but also hot liquids cannot always be perceived. The utmost caution is advised when this symbol is attached to a component.

Always wear protective gloves when you have to touch hot surfaces.



Wear protective gloves!



Wear safety goggles.



To avoid risk of stumbling lay cable so that it does not cause any risk of stumbling.

Safety Measures in Case of Normal Operation

The instrument must only be used by authorized persons trained and instructed in its use. They have to know the operating instructions and be able to work accordingly.

Prior to each use, check the applicator for visible damage and make sure that it is in perfect condition! Advise detected defects to your superior at once!



Safety Instructions for the Use of Holt-Melt Glue Applicator TR 70 LCD

- Never exceed operating temperature of hot melt. Overheating may lead to decomposition which may affect health.
- Compressed air pressure max. 6 bars.
- Once the applicator has warmed up, nozzle and cover are extremely hot!
- Never start working without having mounted a nozzle.
- **Do not direct glue jet towards people.**
- Prior to any nozzle replacement, unplug connecting cable.
- When replacing a nozzle, liquid glue might leak out. **Warning: Risk of burning!**
- Never bring the hot nozzle into contact with the cable.
- **When your skin got into contact with hot glue, immediately cool it with cold water. Do not try to remove hot melt from the skin first. If necessary consult your doctor.**
- **When hot adhesive got into your eyes, immediately cool them under running water for about 15 minutes and consult your doctor at once.**
- If the vent valve does not audibly de-aerate, hot glue might flow off the sound absorber after the trigger has been operated.
- **Always wear protective gloves!**
- **Always wear safety goggles!**

Note:

- Do not lay applicator on its side
- Applicator must de-aerate audibly
- Do not direct glue jet towards people
- Do not hold nozzle top upwards
- Never work without having mounted a nozzle
- Do not carry out overhead work
- Stop using the instrument, if casing is damaged due to shock, breakage or heavy wear

- Even if the applicator has been switched off, it may be under pressure and glue may flow off.
- **When using the stand, remove wire strap**
- When the applicator is fixed to a balancer (tension spring), we recommend to use suspension no. 10436. Thereby it is prevented that, with wrong positioning, glue will get into the vent valve. This applies to TR 55, TR 50.30.33, TR 70.3/LCD, TR 80.3/LCD glue applicators.

Start-up and Operation



To avoid risk of stumbling:

Lay all instrument connections (cables, hoses, and lines) so that they do not cause any risk of stumbling (cable conduits, bridges)!

Make supply connections and settings

Connect the TR 70 LCD Glue Applicator to the electric mains of 230 V and a compressed air line of max. 6 bars.

- Plug connecting cable into socket with earthing contact.
- **Adjust working temperature for hot melt.**



1 = raise temperature 2 = reduce temperature 3 = on / off / confirmation

To switch on: Press the **key 3** to switch the glue applicator on.

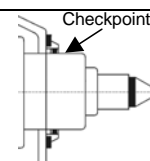
To raise temperature: Press **key 1** until the desired temperature is displayed. For confirmation press **key 3 once**.

To reduce temperature: Press **key 2** until the desired temperature is displayed. For confirmation press **key 3 once**.

If the chosen temperature is not confirmed within a few seconds by pressing key 3, the device will use the last chosen temperature. While the device is heating up to the chosen temperature, the numbers on the display are blinking.

Minor leaking during the heat-up phase is due to the hot melt expanding in the nozzle/heating chamber. As soon as the working temperature is reached, the hot melt will not leak out anymore.

Warning: The temperature regulation is not calibrated!
If an exact temperature is needed, it must be checked with a calibrated temperature sensor.



Warning: Once the applicator has warmed up, nozzle and cap are extremely hot!
Never work without wearing protective gloves!



Stand incl. pressure controller and manometer

When the stand is used as a deposit, do not fit the wire strap to the applicator!

The precise adjustment of the compressed air ensures an exact regulation of the glue quantity to be applied. The adjusted pressure may be read from the manometer indication.

- Mount compressed air hose between glue applicator and stand
- Connect compressed air hose for main connection to the rear side of the stand.

Preparation of the Cartridge



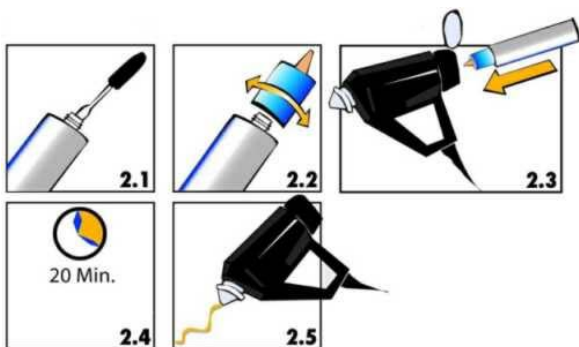
Prick cartridge outlet open (fig. 2.1)



Screw nozzle/nozzle adapter on the cartridge (fig. 2.2)

Loading of Glue Cartridge

- As soon as the applicator has warmed up, open the lid (no. 13) by turning the star grip (no. 14) to the left.
- **Before loading the cartridge (310 ml), mount the enclosed adapter incl. nozzle, making sure that the cartridge has been opened.**
- To close the lid turn the grip to the right.



- 2.1 Use a pointed tool (screw driver, knife or the like) to prick cartridge outlet open
- 2.2 Screw nozzle adapter incl. nozzle on the screw thread. 2.3 Insert cartridge in cartridge applicator.
- 2.4 Allow 20 minutes (depending on type of glue) for the applicator to warm up
- 2.5 Press hotmelt glue off the applicator.

- Allow approx. 3 - 10 minutes, depending on quantity and type of glue, for the applicator to melt the glue. The quantity to be applied can be determined by pressing the trigger (no. 27); the longer you press, the more glue comes out.

Only fill clean cartridges into the premelting tank. Contaminated glue, nails, clamps, sand, etc. cause malfunctions.

Replacement of Cartridges

Cartridges may be exchanged when the apparatus is warm or cold.



Warning – Risk of burning!



Wear protective gloves and safety goggles.

If, when exchanging a cartridge, a different type of glue is to be used, the nozzle must be flushed (see chapter "Cleaning of the Nozzle/Nozzle Adapter").

If an empty cartridge shall be replaced by a full cartridge containing the same type of glue, proceed as follows:

- Open the cartridge outlet (see chapter "Preparation of the Cartridge").
- Remove the empty cartridge. Caution - risk of burning!
- Unscrew the nozzle/adapter of the empty cartridge and screw it onto the full cartridge.

- Insert the full cartridge (nozzle/adapter being screwed on) in the glue applicator.

Preheating of Cartridge

To ensure optimum working it is recommended to preheat the closed cartridge in the switched-on glue applicator. After approx. 10 minutes (depending on glue type), take off the warmed-up cartridge, open it at the front, and screw on the enclosed adapter incl. nozzle. Alternatively, you may preheat the cartridge using our cartridge preheater.

Caution: Risk of burning! Wear protective gloves or the like!



protective gloves and safety goggles!

Application of Hot Melts

Make yourself familiar with the instrument first. Apply a little glue in varying forms (small, large dots) on a piece of paper or cardboard. This is very easy. Try to find out the correct quantity and the ideal pattern by adjusting the pressure controllers at the stand to different pressures. Observe the correct working temperatures of the individual hot melt.

Never start working without having mounted a nozzle!



Wear protective gloves and safety goggles!

Nozzle Replacement

Only replace nozzles when the glue applicator is warm (instrument temperature 60 - 80°C / approx. 140 - 170 °F) and empty. You are advised to wear gloves.



Prior to exchanging nozzles, unplug connecting cable!

Replacing a cold nozzle may damage the applicator. If the nozzle is replaced when it is too hot, liquid adhesive may leak out.



Warning: Risk of burning!

- When your skin got into contact with hot glue, immediately cool it with cold water. Do not try to remove hot melt from the skin first. If necessary consult your doctor.
- When hot adhesive got in your eyes, immediately cool them under running water for about 15 minutes. **Consult your doctor at once!**

Never start working without having mounted a nozzle!

Do not direct glue jet towards people!

Working with Stationary Equipment

(in connection with pneumatic foot switch)

To work with stationary equipment, glue applicator and foot switch, mount these parts.

The corresponding drawings will be supplied with the respective accessories.

Afterwards, proceed as follows:

- Press trigger (no.27) down to stop and hold it
- Plug enclosed bolt into the borehole provided for this purpose at one side of the casing handle
- Let trigger loose
- Trigger is locked



Warning: Risk of burning!

When, in the stationary mode of operation, workpieces are passed below the glue applicator by hand, there is a risk of burning; so, it is absolutely necessary to wear protective gloves.

Working with a balancer (tension spring)

When the applicator is fixed to a balancer (tension spring), we recommend to use suspension no. 10436. Thereby it is prevented that, with wrong positioning, glue will get into the vent valve. This applies to TR 55, TR 50.30.33, TR 70.3/LCD, TR 80.3/LCD glue applicators.

Operation

The glue applicator shall only be used/applied according to its intended use. Please see Section "General Safety Instructions".

Improper use of the applicator may cause personal injury or material damage. Non-observance of the safety instructions when working with the applicator may lead to serious burns. Make a functional test acc. to the following list, before you switch on the glue applicator:

Check List

- Did you make sure that compressed air is supplied to the glue applicator?
- Is pressure max. 6 bars and min. 2 bars?
- Is the glue applicator connected to 230 or 110 volts?
- Do the control lamps light?
- Is the nozzle clean and free of any foreign matters?
- Is hot melt in the cartridge?
- Has the heat-up time of approx. 10 minutes (depending on the glue type) been observed?

While you are working...

...the glue applicator always has to be deposited on its stand (unless it is fitted to a balancer).

Never lay applicator on its side!

- Open premelting tank only if required.
- Keep hot melt free of dirt and humidity.

When using the stand, remove wire strap!

General Hints

Should the sound absorber (no. 6) got stuck, the adhesive tank may be under pressure. **The vent valve (sound absorber) must audibly de-aerate each time you operate the trigger (no. 27).**



Warning: With this, hot glue might come off the sound absorber!



If the vent valve does not de-aerate audibly, the adhesive tank must be de-aerated by unscrewing the sound absorber (no. 6), the DT - SEV (no. 7) and the swivelling screw (no. 26).

For this, you are advised to wear gloves.

No liquid glue should get into the sound absorber, when the applicator is ready for operation.

Always deposit the applicator on its stand or use the wire strap or a balancer. **When using the stand, remove wire strap!**

If nevertheless, glue should have got into the vent valve, either clean that valve or replace sound absorber, DT - SEV and swivelling screw.

- Note:**
- Do not lay applicator on its side
 - Instrument must de-aerate audibly
 - Do not direct glue jet towards people
 - Do not hold nozzle top upwards
 - Never work without having mounted a nozzle
 - Do not carry out overhead work
 - Never exceed glue operating temperature
 - Stop using the instrument, if casing is damaged due to shock, breakage or heavy wear.

Even if the applicator has been switched off, it may be under pressure and glue might flow out!

Cleaning and Maintenance

If you observe the operating instructions, the applicator does normally not need cleaning. When PUR hot melts are used, the adapter and nozzles have to be cleaned. We advise to use special cleaning material in 310 ml cartridges.

Cleaning of the Nozzle/Nozzle Adapter

Prior to any longer work interruptions (max. 24 hours), the nozzle of the glue applicator must be cleaned.

- Only unscrew the nozzle/nozzle adapter when the glue cartridge is warm (see chapter "Replacement of Cartridges").



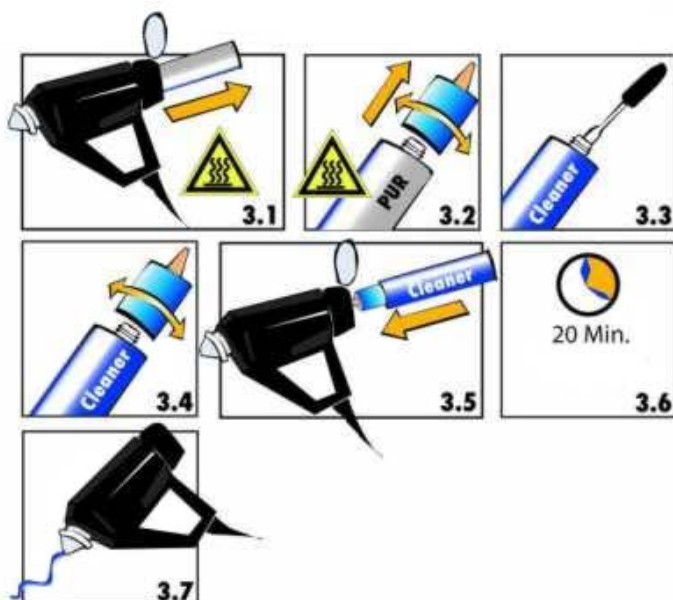
Caution – risk of burning!



Wear protective gloves and safety goggles!

- Allow approx. 20 minutes for the cleaning agent to melt.
- Press cleaning agent off until you can see it coming off the outlet.
- Remove the cleaner cartridge while the nozzle/nozzle adapter is screwed on (see chapter "Replacement of Cartridges").
- Unscrew the nozzle/nozzle adapter from the warm cleaner cartridge.
- Let the cleaner cartridge cool down and keep it for the next cleaning.

If the applicator is used very often, it has to be maintained regularly. To set a date, please call our service department.



Cleaning

Caution - risk of burning!

Please wear protective gloves

- 3.1 Remove PUR cartridge from the applicator
- 3.2 Unscrew nozzle adapter.
- 3.3 Use a pointed tool (screw driver, knife or the like) to open the outlet of the PUR cartridge.
- 3.4 Screw nozzle adapter on the screw thread of cleaner cartridge.
- 3.5 Insert cleaner cartridge in the applicator.
- 3.6 Allow about 20 minutes for the applicator to warm
- 3.7 Flush nozzle adapter with cleaner until you see cleaning agent come off steadily.

Caution – risk of burning!

Please wear protective gloves.

Remove cleaner cartridge from the applicator and unscrew nozzle adapter.

Disposal



Separate disposal of electric and electronic equipment.

Additional Information

Do you have any more questions or requests? We should be glad to help you.

Please contact us by

Phone ++39 0362 / 543041

Fax ++39 0362 / 576460

e-mail: info@idealttech.it

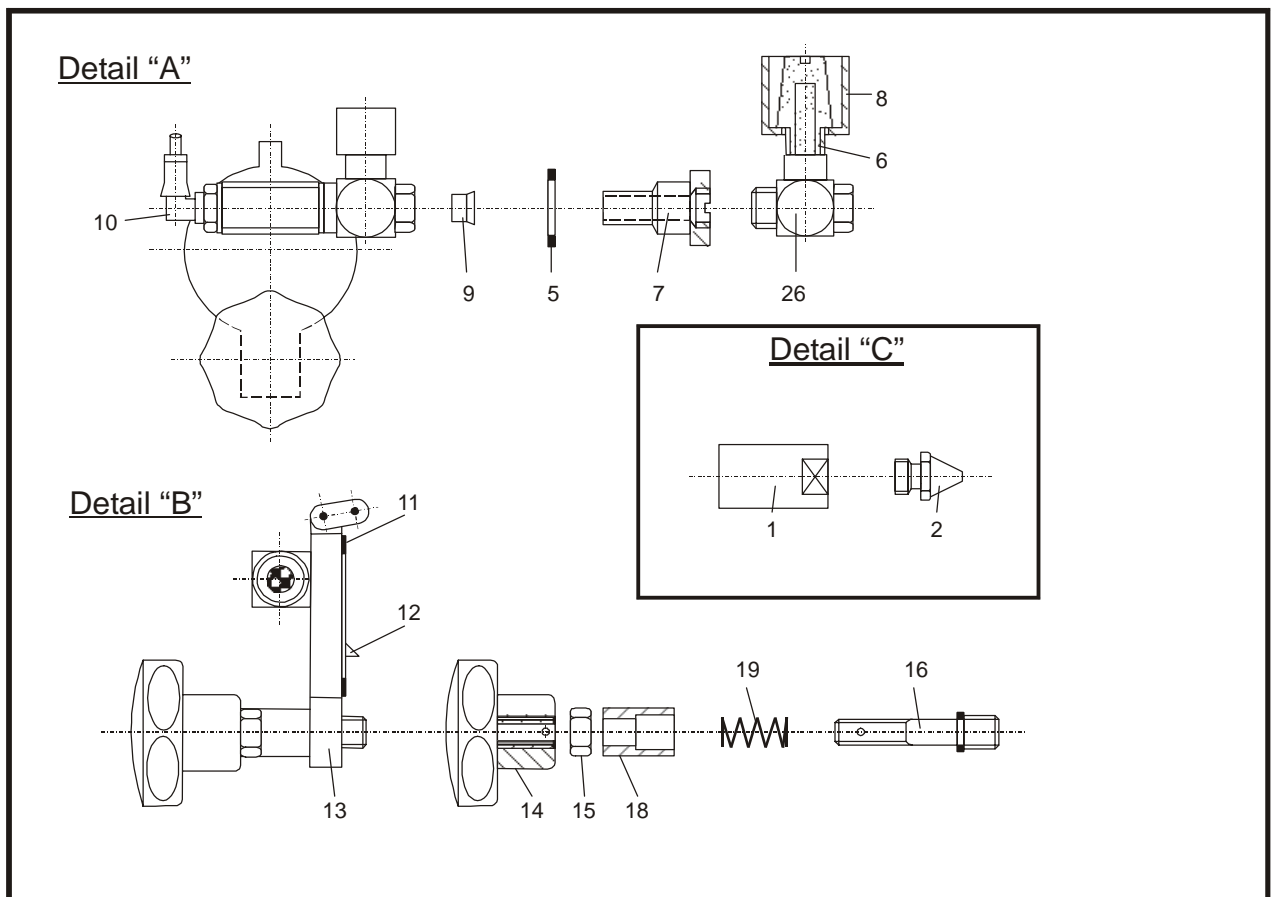
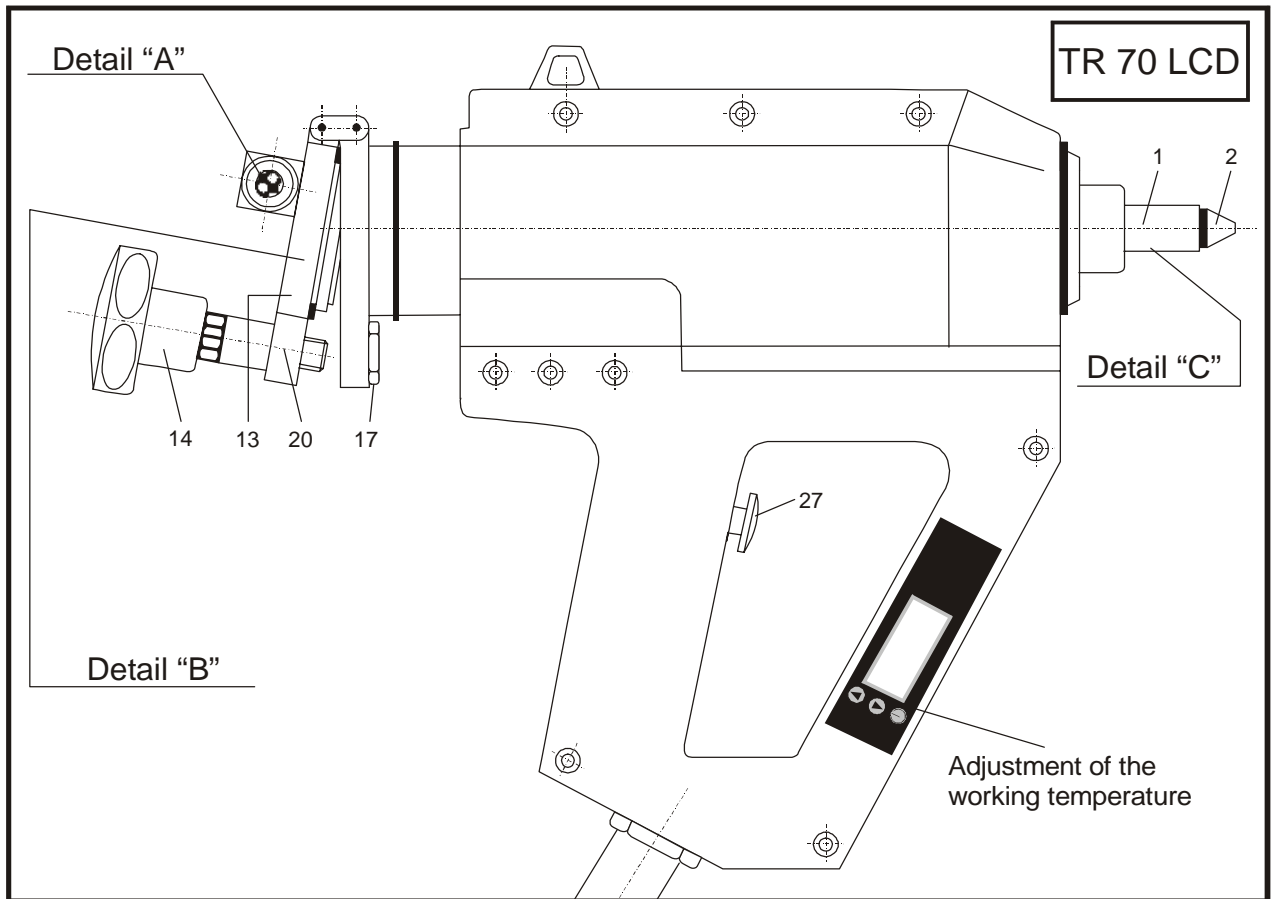
Our mailing address is:

Idealttech srl

Via Sondrio, n. 11

20814 Varedo (MB)

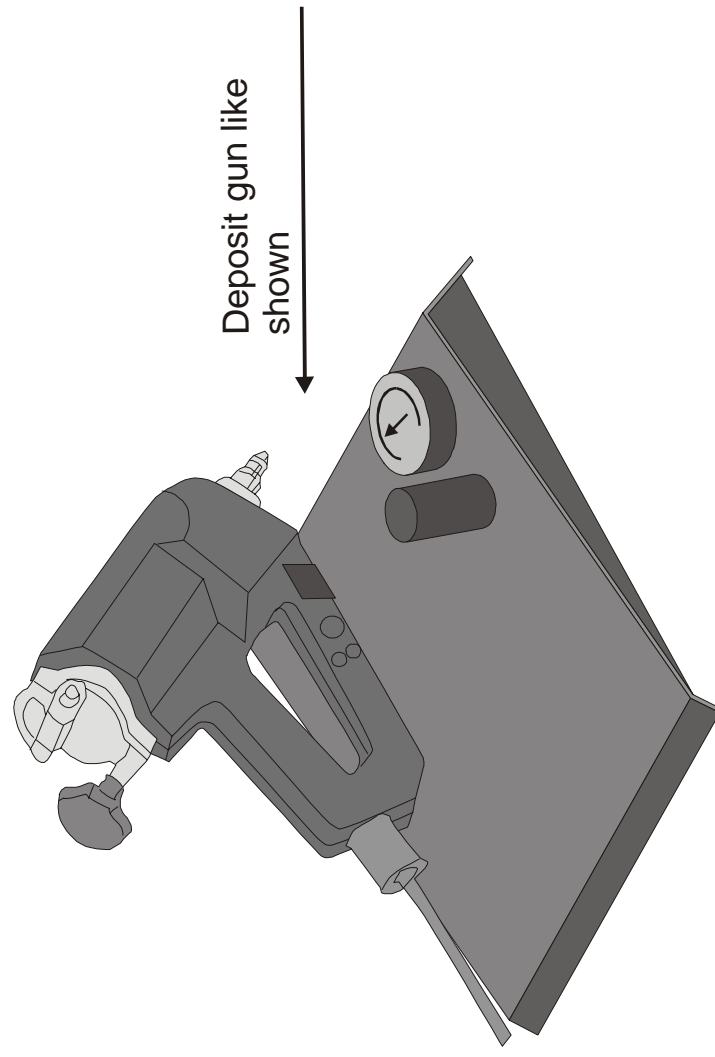
Internet: www.idealtech.it



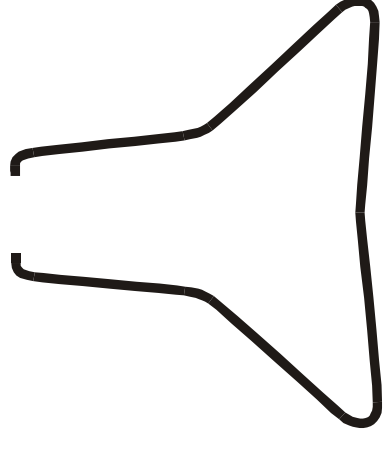
Spare Parts - Cartridge Glue Applicator TR 70 LCD**No. 5355 – 220 V****No. 5360 – 110V**

- 1 = 2958 Adapter
- 2 = 2505 Nozzle M 10 cpl.
- 5 = 2692 O-Ring SEV
- 6 = 2683 Sound absorber
- 7 = 2693 DT SEV D 16
- 8 = 2694 Cap SEV D 18
- 9 = 2696 Membrane SEV
- 10 = 2697 90° fitting SEV
- 11 = 2955 Flat seal
- 12 = 2953 Cartridge opener
- 13 = 3660 Lid without SEV
- 14 = 2613 Star grip
- 15 = 3665 Lock nut
- 16 = 2883 Lid release shaft
- 17 = 2884 Lock nut for lid release
- 18 = 2885 Spacer bush D 14/20
- 19 = 2718 Spring
- 20 = 2911 Safety screw
- 26 = 3016 L-Screwing
- 27 = 2711 Trigger

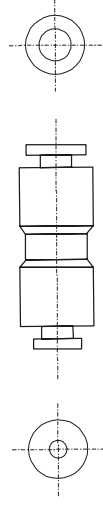
Stand Nr. 3587



Clamp Nr. 2866



Straight Union 3165



When using the stand no. 3587
remove clamp no. 2866.

Use this straight union only when you
work without stand no. 3587.