

# Glue Pattern Control Guide



## Setting a glue pattern

1. Measure the distance from the leading edge of the product to the point on the product that you would like the glue pattern to start.
2. Input this distance (in millimetres) into the start parameter on the pattern controller.
3. Measure the distance from the leading edge of the product to the point on the product that you would like the glue pattern to end.
4. Input this distance (in millimetres) into the end parameter on the pattern controller.

If the glue pattern is not applied as programmed please re-calibrate the controller setting as per the instructions found below.

## Setting a MSD/Encoder ratio setup (for systems with fine ratio adjustment including Leary Equipment)

1. Program the glue pattern to apply a line of glue 100mm in length and centered on the product.
2. Run the production line (with product) at minimum machine speed (low speed) and measure glue line.
3. If the applied glue line is equal to the programmed length you are finished.
4. If the applied glue line is longer than the programmed length (100mm) reduce the ratio setting by .1. Go back to step 2.
5. If the applied glue line is shorter than the programmed length (100mm) increase the ratio setting by .1. Go back to step 2.

## Setting a MSD/Encoder ratio setup (for systems with 2-point adjustment including Pafra Equipment)

1. Program the glue pattern to apply a line of glue 100mm in length and centered on the product.
2. Run the production line (with product) at minimum machine speed (low speed) and measure glue line.
3. If the applied glue line is equal to the programmed length you are finished.
4. If the applied glue line is longer than the programmed length (100mm) adjust the setting to 2. Go back to step 2.
5. If the applied glue line is shorter than the programmed length (100mm) adjust the setting to 1. Go back to step 2.

## Setting a lead distance

1. Measure the distance from the leading edge of the trigger sensor light spot to the valve nozzle tip.
2. Input this distance (in millimetres) into the lead distance parameter on the pattern controller.

3. Run the production line (with product) at low speed and assure the leading edge of the glue line is accurately placed.
4. If the glue line is accurately placed go to step 7.
5. If the front edge has started too early increase the lead parameter by as much as the glue line started early (in millimetres). Go back to step 3.
6. If the front edge has started too late reduce the lead parameter by as much as the glue line started late (in millimetres). Go back to step 3.
7. Repeat this procedure for every control channel.

### **Setting valve compensation times**

1. Ensure MSD/Encoder setup has been completed.
2. Ensure lead distance setup has been completed.
3. Program the glue pattern to apply a line of glue 100mm in length and centered on the product.
4. Run the production line (with product) at low speed and assure glue line is accurately placed both front and back edge.
5. Run the production line (with product) at high speed and assure glue line is accurately placed front edge only.
6. If front edge of the glue line is correctly positioned go to step 9.
7. If front edge has started too early reduce the on-comp parameter by 0.5ms. Go back to step 5.
8. If front edge has started too late increase the on-comp parameter by 0.5ms. Go back to step 5.
9. If the back edge of the glue line is correctly positioned you are finished and the compensation times are correct. If not continue to step 10.
10. If the back edge has finished too early (line has become shorter) reduce the off-comp parameter by 0.5ms. Go back to step 5.
11. If the back edge has finished too late (line has become longer) increase the off-comp parameter by 0.5ms. Go back to step 5.
12. Check the glue line stability at low and high speed. The glue line should remain in good placement at all times. If it does not repeat this procedure or call W H Leary service department for further assistance.