

Glue Pressure Control Guide



Setting the glue pressure (Pafra Systems)

1. Set the Standoff parameter to 10.
2. Set the Slope parameter to 10.
3. Program a 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 monitor the glue volume.
5. If the glue volume is good go to step 8.
6. If the glue volume is insufficient increase the Standoff parameter by 5 and go back to step 4.
7. If the glue volume is too great please contact Leary Support for more detailed information.
8. Run the production line (with product) at high speed and monitor the glue volume.
9. If the glue volume is good you are finished.
10. If the glue volume is insufficient increase the Slope parameter by 10 and go back to step 8.
11. If the glue volume is too great reduce the Slope parameter by 10 and go back to step 8.

Setting the glue pressure (Leary Systems – Basic Setup)

1. Go to Station Setup>GRU1 and choose Regulation Unit.
2. In the first row set the speed to 10 and the pressure to 5.0.
3. In the second row set the speed to 400 and the pressure to 20.0.
4. Ensure all other settings are set to 0.0.
5. Program a glue pattern to apply a line of glue 100mm in length and centered on the product.
6. Run the production line (with product) at low speed and monitor the glue volume.
7. If the glue volume is good go to step 10.
8. If the glue volume is insufficient increase the pressure setting in the first row. Go back to step 6.
9. If the glue volume is too great decrease the pressure setting in the first row. Go back to step 6.
10. Run the production line (with product) at high speed and monitor the glue volume.
11. If the glue volume is good you are finished.
12. If the glue volume is insufficient increase the pressure setting in the second row. Go back to step 10.
13. If the glue volume is too great decrease the pressure setting in the second row. Go back to step 10.

Setting the glue pressure (Leary Systems – When using continuous dot mode)

1. Go to Station Setup>GRU1 and choose Regulation Unit.
2. In the first row set the speed to 10 and the pressure to 20.0
3. In the second row set the speed to 400 and the pressure to 20.0.
4. Ensure all other settings are set to 0.0.
5. Adjust the dot size using the valve & spot size adjustments.

Setting the glue pressure (Leary Systems – When using auto dot-line mode)

1. Go to Station Setup>GRU1 and choose Regulation Unit.
2. In the first row set the speed to 10 and the pressure to 20.0.
3. In the second row set the speed to 1m/min more than the dot/line change-over speed and the pressure to 5.0.
4. In the third row set the speed to 400 and the pressure to 20.0.
5. Ensure all other settings are set to 0.0.
6. Program a glue pattern to apply a line of glue 100mm in length and cantered on the product.
7. Run the production line (with product) just above the dot/line change-over speed (so that the line of dots changes to a solid line) and monitor the glue volume.
8. If the glue volume is good go to step 11.
9. If the glue volume is insufficient increase the pressure setting in the second row. Go back to step 7.
10. If the glue volume is too great decrease the pressure setting in the second row. Go back to step 7.
11. Run the production line (with product) at high speed and monitor the glue volume.
12. If the glue volume is good you are finished.
13. If the glue volume is insufficient increase the pressure setting in the third row. Go back to step 11.
14. If the glue volume is too great decrease the pressure setting in the third row. Go back to step 11.