

## Leary Tips: Working with dot applications.

### General overview

Spot mode and working with spot applications is increasingly common. Spot mode is particularly useful when wishing to control (limit) the volume of adhesive being applied at lower machine speeds – were applying a glue line at low speeds can often result in excessive glue being applied. Single spot applications are useful when you have a very small target area where glue is required.

### A range of variable parameters to adjust the shape and size of applied spots

1. Spot size (adjusted on the touch screen).
2. Valve stroke (adjusted on the glue valve).
3. Glue pressure (adjusted on the touch screen).

Using these three parameters you are able to apply almost ANY spot size using your Leary system. Follow these general rules to achieve best results.

- a) When gluing in spot mode you should have a consistent high glue pressure (6-15 BAR).
- b) Ensure the glue valve stroke adjustment is set to the 'standard' set point before you start.

**The 'standard' set point is achieved by following this easy guide:**

1. *Using your finger and thumb turn the stroke adjust (knurled knob on top of gun) clockwise until resistance is felt.*
2. *Now turn the stroke adjust counter-clockwise ¼ of a turn (90 degrees).*
3. *Use the purge controls to test valve in line and spotting modes.*
4. *If glue jets from the valve cleanly (in a straight line) the valve setting is complete.*
5. *If glue does not jet from the valve cleanly (in a straight line), turn the stroke adjust counter-clockwise a further 1/8 of a turn (45 degrees) and go back to step 5.*

- c) Use the 'spot size' setting on the touch screen to achieve the desired spot size. Do not exceed 1.3ms (min) and 4.0ms (max).
- d) If a setting of 1.3ms is set and the spot size applied remains too large, adjust the valve stroke clockwise very slowly during running and observe the applied spot size shrink on the run until it reaches the desired size. **DO NOT REDUCE THE GLUE PRESSURE!**
- e) If a setting of 4.0ms is set and the spot size applied remains too small, adjust the valve stroke counter-clockwise very slowly during running and observe the applied spot size grow on the run until it reaches the desired size.
- f) In many (if not all) cases a higher glue pressure will provide improved results.

For further help with spot application control and best practice please contact Leary.

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