

Valve Setup Guide

Setting a LearyJet Glue Valve

1. Ensure valve is clean inside and out.
2. Ensure the adhesive used is within valve specifications and in good condition.
3. Using your finger and thumb turn the stroke adjust (knurled knob on top of gun) clockwise until resistance is felt.
4. Now turn the stroke adjust counter-clockwise $\frac{1}{4}$ of a turn (90 degrees).
5. Use the purge controls to test valve in line and spotting modes.
6. If glue jets from the valve cleanly (in a straight line) the valve setting is complete.
7. If glue does not jet from the valve cleanly (in a straight line), turn the stroke adjust counter-clockwise a further $\frac{1}{8}$ of a turn (45 degrees) and go back to step 5.

Setting a PafraJet Glue Valve

1. Ensure valve is clean inside and out.
2. Ensure the adhesive used is within valve specifications and in good condition.
3. Using a spanner, carefully turn the stroke adjust (nut) clockwise until resistance is felt (be very careful here as damage will occur if the nut is turned against the resistance felt).
4. Now turn the stroke adjust counter-clockwise $\frac{1}{4}$ of a turn (90 degrees).
5. Use the purge controls to test valve in line and spotting modes.
6. If glue jets from the valve cleanly (in a straight line) the valve setting is complete.
7. If glue does not jet from the valve cleanly (in a straight line), turn the stroke adjust counter-clockwise a further $\frac{1}{8}$ of a turn (45 degrees) and go back to step 5.

Recommended settings for nozzle height

In general the glue nozzle should be positioned as close as possible to the product without it wiping itself in the applied glue bead. However, if the nozzle is positioned too close it will accumulate glue build up and require more frequent cleaning. Therefore care should be taken in setting the valve height to ensure a) gluing accuracy and b) robust valve performance.

Glue viscosity, pressure and the use of either dotting or line application modes may also impact on the absolute ideal nozzle height.

Setting the nozzle too high will result in a slight reduction in pattern placement accuracy.

The benchmark setting for valve nozzle height (from product) is 5-6mm.