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Purpose: To start up the hot melt unit and make it ready for production.

Required PPE:



Safety Glasses



Hearing Protection



Steel Toe Shoes



Cotton Gloves



Potential Hazards:



In the automatic mode the packing equipment may start without warning. Keep hands clear unless the unit is off and locked out and tagged out.






The hot melt unit has very hot surfaces, which could cause severe burns. Avoid contact with glue guns and tubing and with the components on the rear and inside of the unit.


Reference Documents: Nordson VersaBlue Adhesive Melters Models VA and VT Technical Manual

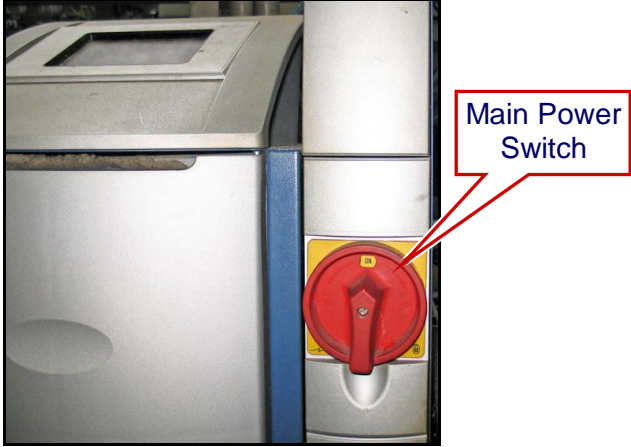
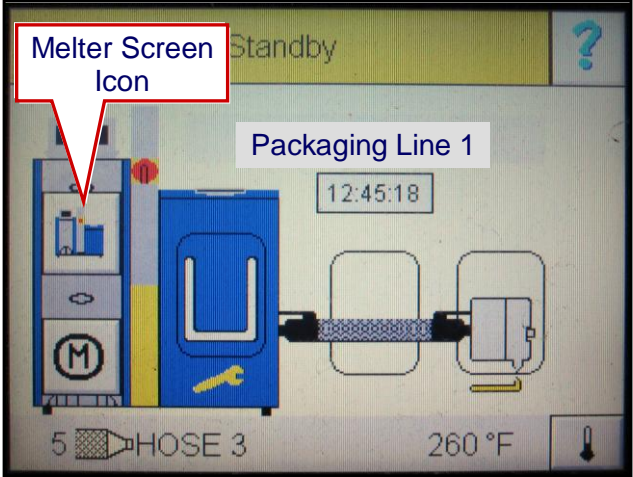
Required Equipment & Materials: Hot Melt Glue Pellets S/N #54237383006


SAMPLE PROCEDURE ONLY – DO NOT USE FOR EQUIPMENT OPERATION		
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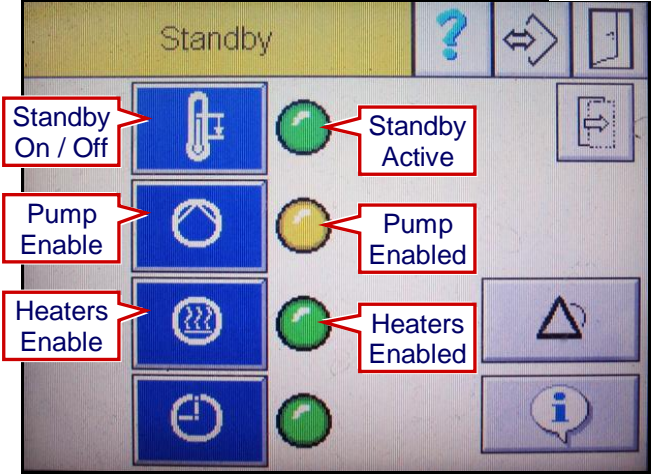
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Steps	Key Points
Prepare the Hot Melt Unit for Operation	
1. Open the top of the glue hopper.	
2. Fill the glue hopper until it is ¾ full.	
3. Check the glue level probe for clumps of unmelted glue	
4. If clumps of glue are found, scrape the probe clean with a putty knife.	
5. Check the level in the glue tote.	
6. If the tote is empty, refill or replace the glue tote.	

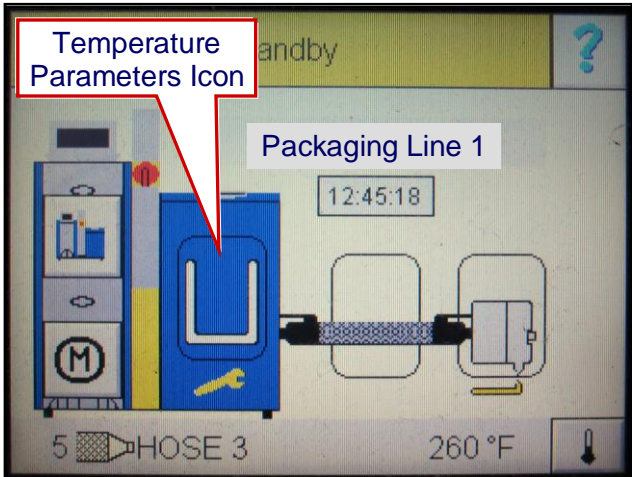
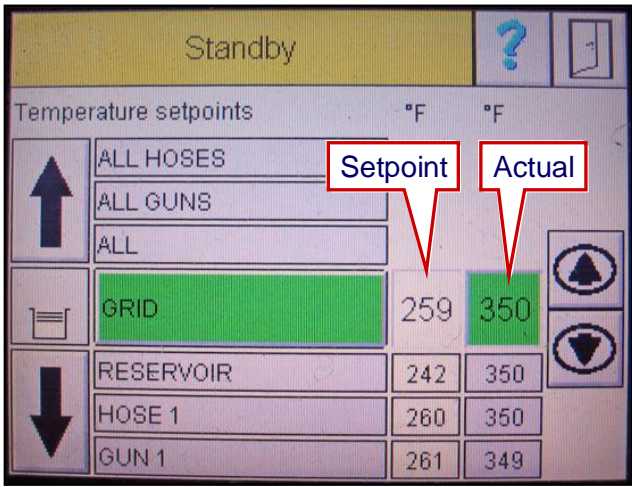
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Steps	Key Points
Start the Hot Melt Unit	
7. Turn the red Main Power Switch to the ON position.	
8. Allow time for the processor to run self-diagnostic checks, then the touch screen should be active	
9. At the Melter Starting Screen, touch the Melter Screens icon.	<p>The Melter Overview screen will be displayed</p>  <p style="text-align: center;">Melter Starting Screen</p>

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Steps	Key Points
<p>10. At the Melter Overview Screen, touch the Standby Mode On/Off button so the Standby Active indicator is yellow.</p>	<p>The yellow indicator shows the Standby Mode is OFF.</p> <div style="text-align: right;">Return</div>  <p style="text-align: center;">Melter Overview Screen</p>
<p>11. Verify the heaters enable indicator is green. If not, touch the Heaters Enable button so the indicator is green.</p>	<p>When the indicator is green, the heaters will be enabled and begin heating the hot melt.</p>
<p>12. Verify the pump enable indicator is green If not, touch the Pump Enable button so the indicator is green.</p>	<p>When the indicator is green, the pump will be enabled to run when the packer starts.</p>
<p>13. Touch the Return button.</p>	<p>The display will return to the Melter Starting Screen.</p>

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Steps	Key Points																								
<p>14. Touch the Temperature Parameters icon.</p>	<p>The Temperature Parameters screen will be displayed.</p>  <p style="text-align: center;">Melter Starting Screen</p>																								
<p>15. At the Temperature Parameters screen, verify that the Grid, Reservoir, Hose and Gun temperatures are increasing.</p> <p>If not, call maintenance to check heaters.</p>	 <p style="text-align: center;">Temperature Parameters Screen</p> <table border="1" style="margin-left: auto; margin-right: auto;"> <thead> <tr> <th></th> <th>°F</th> <th>°F</th> </tr> </thead> <tbody> <tr> <td>ALL HOSES</td> <td></td> <td></td> </tr> <tr> <td>ALL GUNS</td> <td></td> <td></td> </tr> <tr> <td>ALL</td> <td></td> <td></td> </tr> <tr> <td>GRID</td> <td>259</td> <td>350</td> </tr> <tr> <td>RESERVOIR</td> <td>242</td> <td>350</td> </tr> <tr> <td>HOSE 1</td> <td>260</td> <td>350</td> </tr> <tr> <td>GUN 1</td> <td>261</td> <td>349</td> </tr> </tbody> </table>		°F	°F	ALL HOSES			ALL GUNS			ALL			GRID	259	350	RESERVOIR	242	350	HOSE 1	260	350	GUN 1	261	349
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History of Revisions			
Revision Number	Revision Date	Revised By	Reason for Revision
V1	6 Mar 14	G. Pancerev	Included review comments.