

# 6" Opening Roller Coater Glue Spreader

## Installation & Operation Manual









# **6" Opening Roller Coater Glue Spreader**

**Installation & Operation Manual**



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# Introduction

Thank you for your purchase of a 6" Opening Quick Roller Coater Glue Spreader. Your machine has been designed for many years of trouble-free performance. Please read this installation & operation manual and follow its instructions to correctly install, operate and maintain your Glue Spreader. Doing so will help ensure optimum productivity and reliability of your machine.





# Installation

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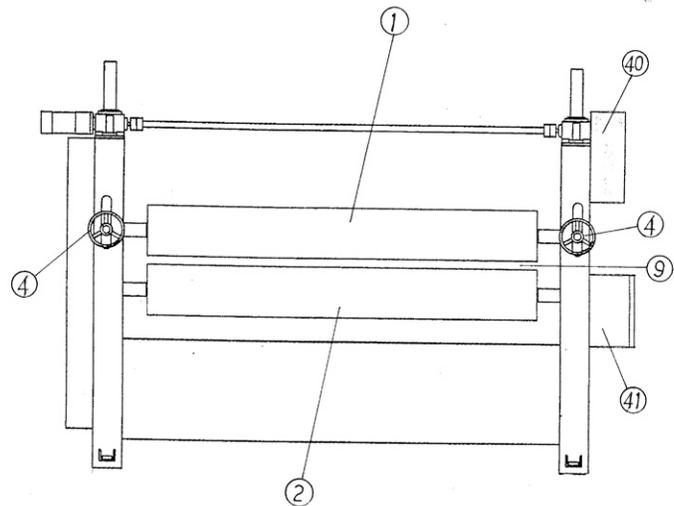
1. Remove the wooden shipping pallet from underneath the machine.
2. Place the machine on a flat concrete floor. Adjust the levelers on the Glue Spreader feet such that all of the feet touch the floor and the Applicator rolls are as level as possible.
3. Attach the proper-voltage (same as the Glue Spreader motor) 3-phase power source to the Glue Spreader's power connection box. Be sure to connect a proper ground connection to minimize the risk of electrical shock. Make sure to check that the motor turns in the proper direction. If not, reverse two of the three 3-phase power source leads.



# Operation

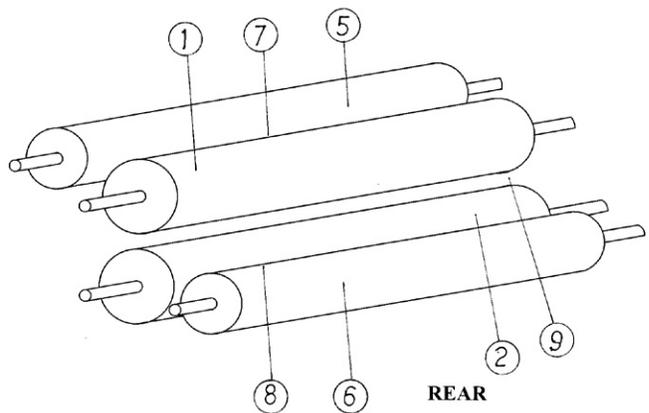
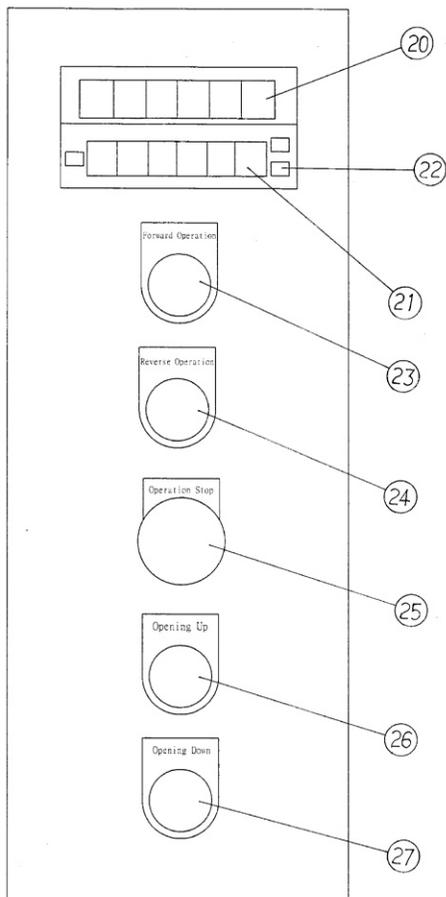
## Components & Controls

- (1) Upper coating roll
- (2) Lower coating roll
- (4) Glue spread thickness adjusters
- (5) Upper doctor roll
- (6) Lower doctor roll
- (7) Upper trough for glue
- (8) Lower trough for glue
- (9) Gap for stock feed-through

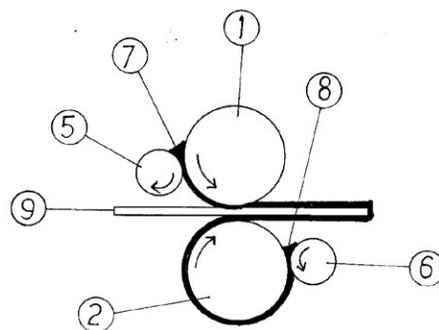


FRONT

- (40) Control box & push-buttons



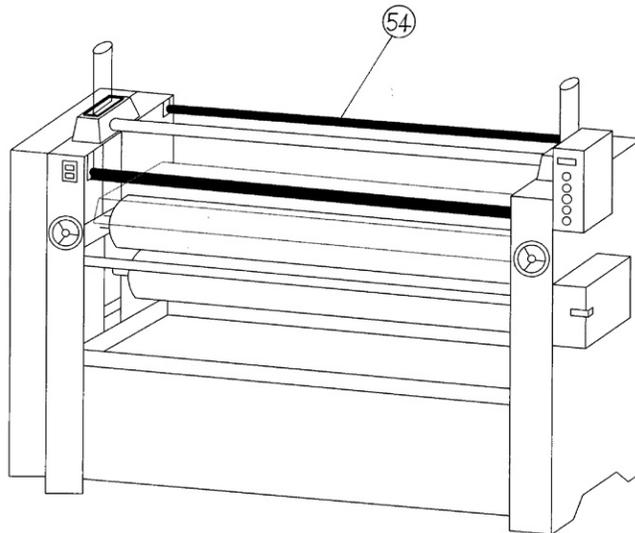
REAR



# Operation

## Operation Overview

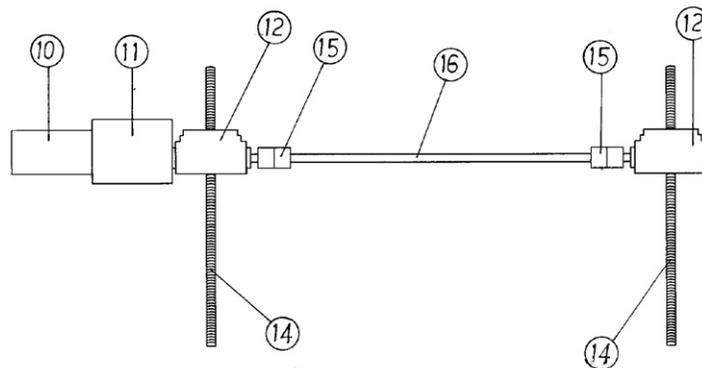
1. Adjust the gap between the two coating rolls (1 & 2) to accommodate the stock to be glued, with the pushbuttons (26) and (27) on the Control Box (40), or the hand wheel (31).
2. Adjust the glue spread thicknesses with the glue spread thickness adjusters (4), which control the distances between the coating rolls and the doctor rolls. (For one-sided gluing, leave a big gap between the two lower rolls.)
3. Fill the upper trough (7) and/or the lower trough (8) with glue. (For one-sided glue application, fill only the upper trough.)
4. Start the rolls turning by pressing the “Forward Operation” button on the Control Panel.
5. After the rolls are all well-coated, feed the stock through the gap (9).
6. In case of emergency during glue spreading or while advancing the rolls for cleaning, push either of the two emergency stop bars (54) to stop the machine.



# Operation

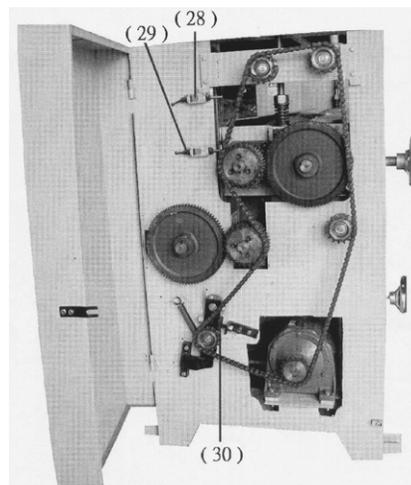
## Motorized Vertical Adjustment (optional equipment)

1. Adjust the gap between the two coating rolls (1 & 2) to accommodate the stock to be glued, with the pushbuttons (26) and (27) on the Control Box (40). Both ends of the rolls will raise and lower together. If one side is higher than the other, then one side of the coupling (15) should be adjusted to fix this.



## Digital Readout (optional equipment)

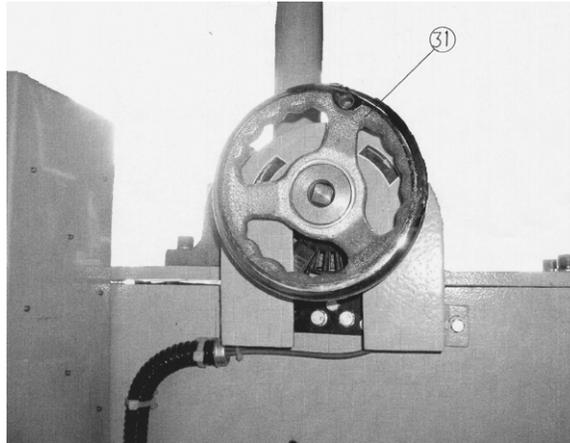
1. As the gap between the two coating rolls (1 & 2) is adjusted as described above, the upper display (20) on the Digital Readout will display the gap dimension.
2. Two limit switches (28) and (29) cause the vertical adjustment to automatically stop when it reaches the fully up and fully down position, respectively.



# Operation

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3. For precise manual gap adjustment, use the hand wheel (31). The gap can be adjusted all the way down to 0.0 inches with the hand wheel, if desired.



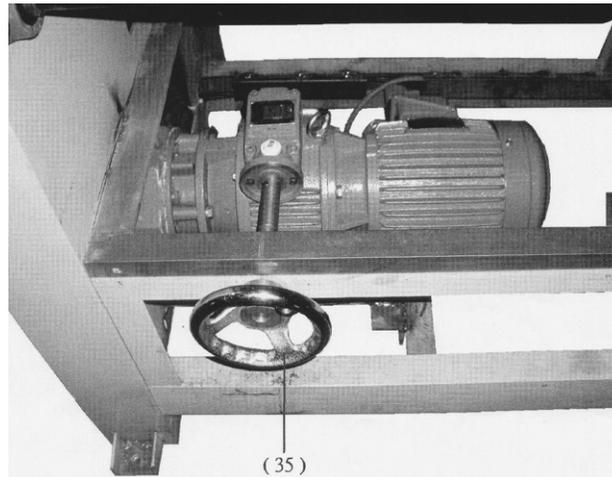
## Calibration

1. To calibrate the digital readout, turn the machine off, then on. Then, press the “Opening Down” button (27) until the rolls stop moving (limit switch 29 has been tripped). As pre-set from the factory, the rolls will stop moving when the gap is 0.028 inches. Press the “Reset” button on the Digital Readout. This will reset the upper display (20) to 0.028 inches, or to whatever has been keyed into the lower display (21).
2. To calibrate the upper display (20) to a certain wood panel thickness, adjust the rolls to the desired gap. Then key the desired dimension into the lower display (21). Press the “Reset” button on the Digital Readout. This will reset the upper display (20) to the dimension keyed into the lower display (21).

# Operation

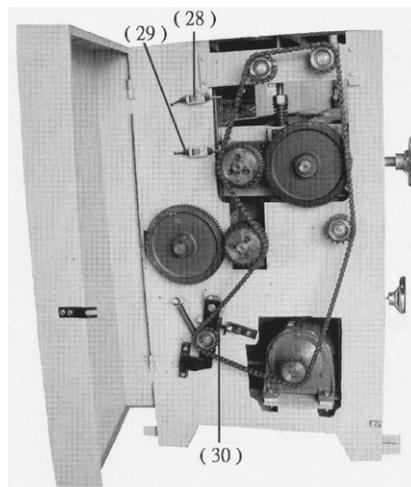
## Variable Speed Control (optional equipment)

1. Adjust the feed rate of the machine with the hand wheel (35).



## Reversible Roll Rotation (optional equipment)

1. To operate the machine in the forward direction, press the “Forward Operation” button.  
To operate the machine in the reverse direction, press the “Reverse Operation” button.
2. The machine is designed to run primarily in the forward direction. If the drive chain “chatters” during reverse operation, adjust the idler arm stop (30) to reduce or eliminate the chatter.





# Maintenance

## Daily

### Remove excess glue from the machine:

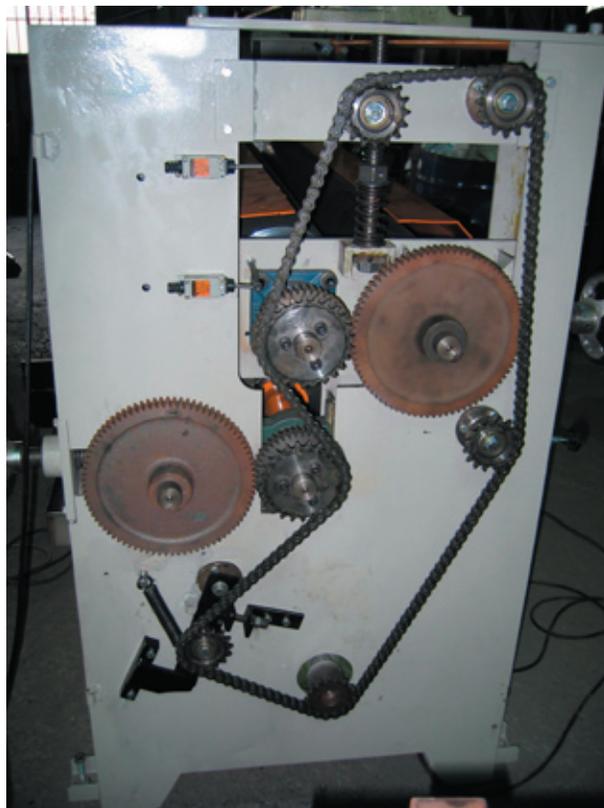
1. Turn off the electrical switch to stop the machine.
2. Lift the copper end plates out from both ends of each set of rolls.
3. Adjust the glue spread thickness adjusters (4) to create a large gap between the coating rolls and doctor rolls. Let the excess glue drip down into the aluminum drip pan.

### Clean the machine:

1. Clean the rollers, doctor rollers, and the copper end plates with a brush and hot water. When cleaning the rollers and doctor rollers, make sure the machine is turned OFF. After cleaning one side of the rollers, turn on the machine briefly to advance the rollers, turn OFF the machine, and clean the other side of the rollers.

## Weekly

1. Lubricate the drive chain, drive gears and large vertical gap-adjusting screws with oil or grease.
2. While lubricating the chain and gears, check for loose bolts; tighten if needed.

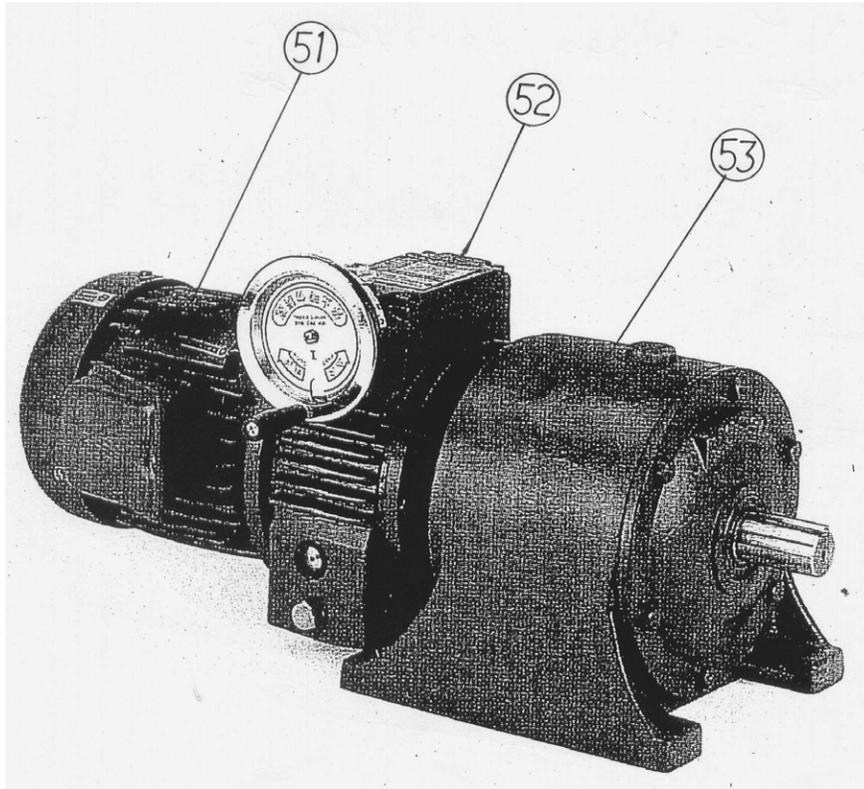


# Maintenance

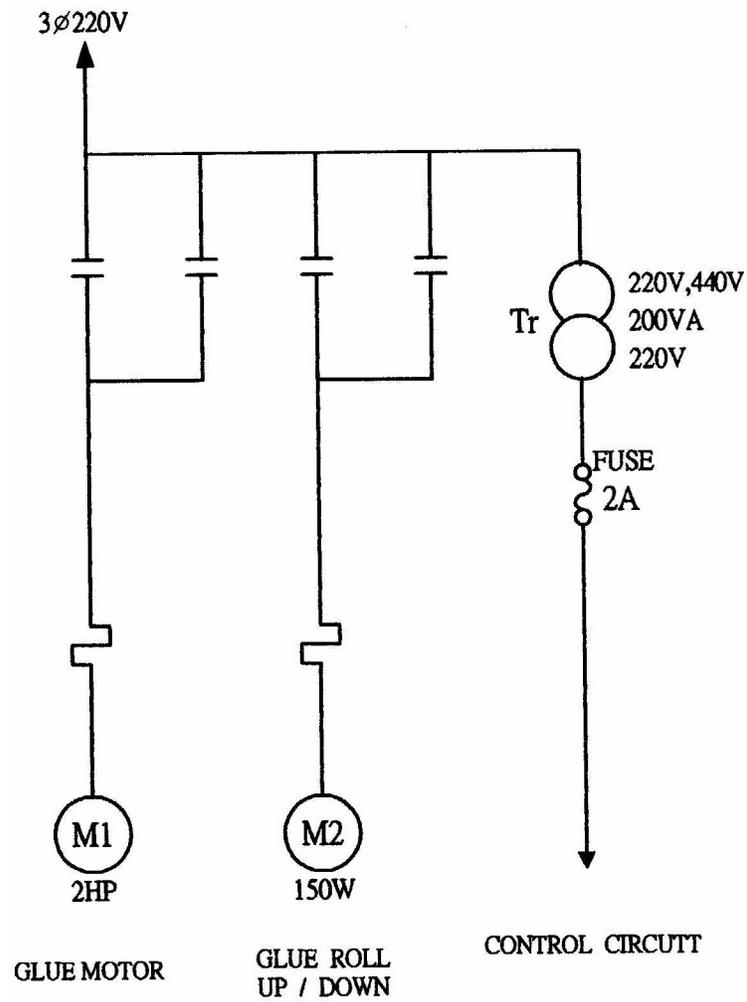
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## Monthly

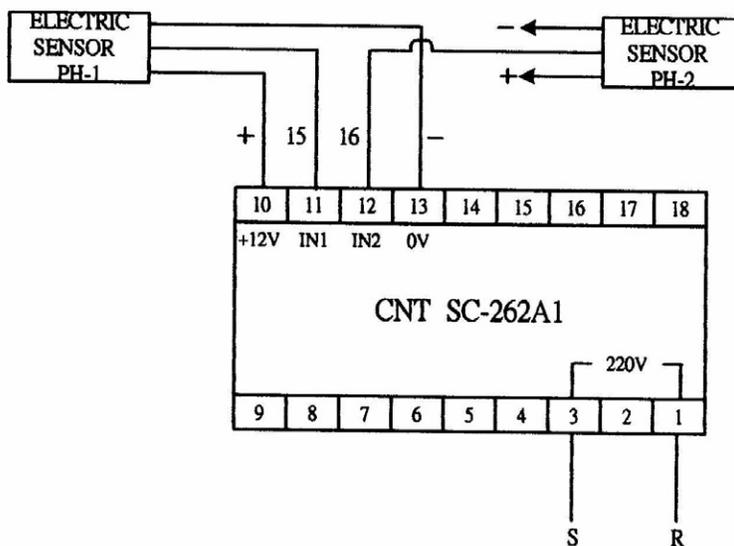
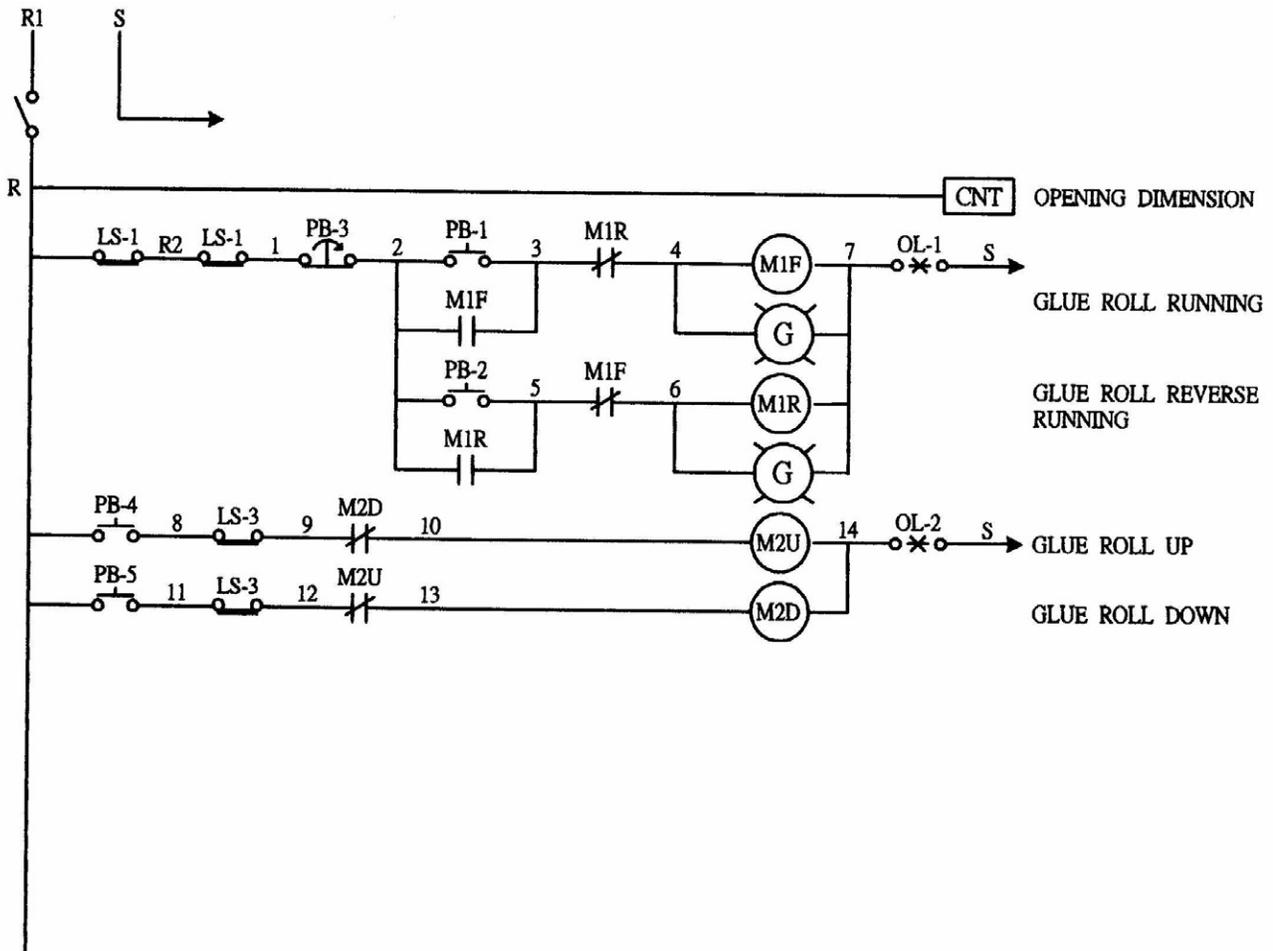
1. If the machine has the DISCO style variable speed control, check the oil level in the variable speed drive (52)/gear reducer (53) via the sight glass on the variable speed drive (52). If needed, add Mobil DTE Light Oil or Shell Tenus Oil 32, so the oil level is 1/2 way up the sight glass.
2. After 100 hours of machine operation, change the oil in the variable speed drive (52)/gear reducer (53).
3. Thereafter, replace the oil in the variable speed drive (52)/gear reducer (53) after every 500 hours of machine operation.



# Electrical Diagrams



# Electrical Diagrams



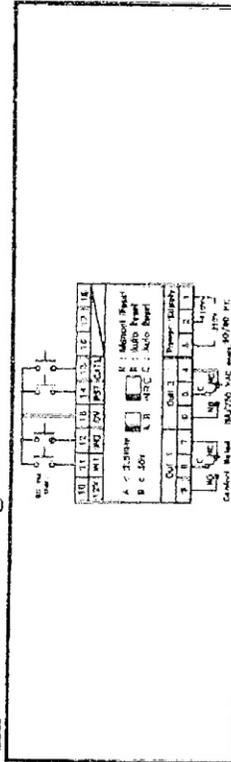
# Electrical Diagrams

## SC-26X series INSTRUCTION MANUAL

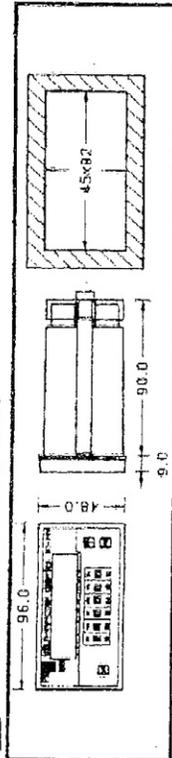
### General Data

Type	Total Counter	Single Preset Counter	Dual Preset Counter
Model	SC-260	SC-261	SC-262
Power Supply	110V / 220V AC $\pm$ 20% , 50/60 Hz		
DC Power Output	12V / 60mA max.		
Input Method	Single or Two Phase Input    Selectable		
Counting Method	Increment or Decrement Counting    Selectable		
Response Frequency	High Speed <A> > 2.5K CPS , Low Speed <B> < 60 CPS		
Output Method	One Relay	Two Relay	
Output Control	N / R / C    Selectable		
Contact Rated	5A / 250 V AC Max.		
Output Delay Timer	0.01S ~ 99.99S		
Divider	Range : 1 ~ 9999		
Multiplier	EEPROM		
Memory Method	Over 8 KV		
ESD Strength	Over 2.5 KV / 1min , Between Power And Each Terminal		
Dielectric Strength	Over 100MQ/500VDC , Between Power And Each Terminal		
Operating Temp./Humi	-20°C ~ +80°C ; 35% ~ 85% RH		

### Connection Diagram



### Dimension & Fixed Hole



### Inner DIP Switch

Nr.	Function
1	ON : Two Phase Input OFF : Single Phase Input
2	ON : Decrement Counter OFF : Increment Counter
3	ON : Multiplier OFF : Divisor
4	ON : Setting of Divisor or Multiplier OFF : Counting Status

### A/B Slide Switch

Counting	Hi → Lo, L < 2V, 6V < Hi < 30V
A	2.5K CPS Max.
B	60 CPS Max.

### Selecting of Decimal Point

Push The & Key  
To Select The Decimal Point

### Setting of Delay Time (t)

Pushing The Key 2 Sec.  
Push The Key To Increase The Delay Time  
Push The Key To Decrease The Delay Time

### Selecting of Divisor or Multiplier

Divisor : The Inner DIP Switch #3 Set At "OFF" Position < Range : 1~9999 >  
Multiplier : The Inner DIP Switch #3 Set At "ON" Position < Range : 0.001~9.999 >

Set The Inner DIP Switch #4 To "ON" Position.

Push The Key To Increase The Value of Divisor or Multiplier.

Push The Key To Decrease The Value of Divisor or Multiplier.

After Finishing Setting, Please Set The Inner DIP Switch #4 To "OFF" Position.

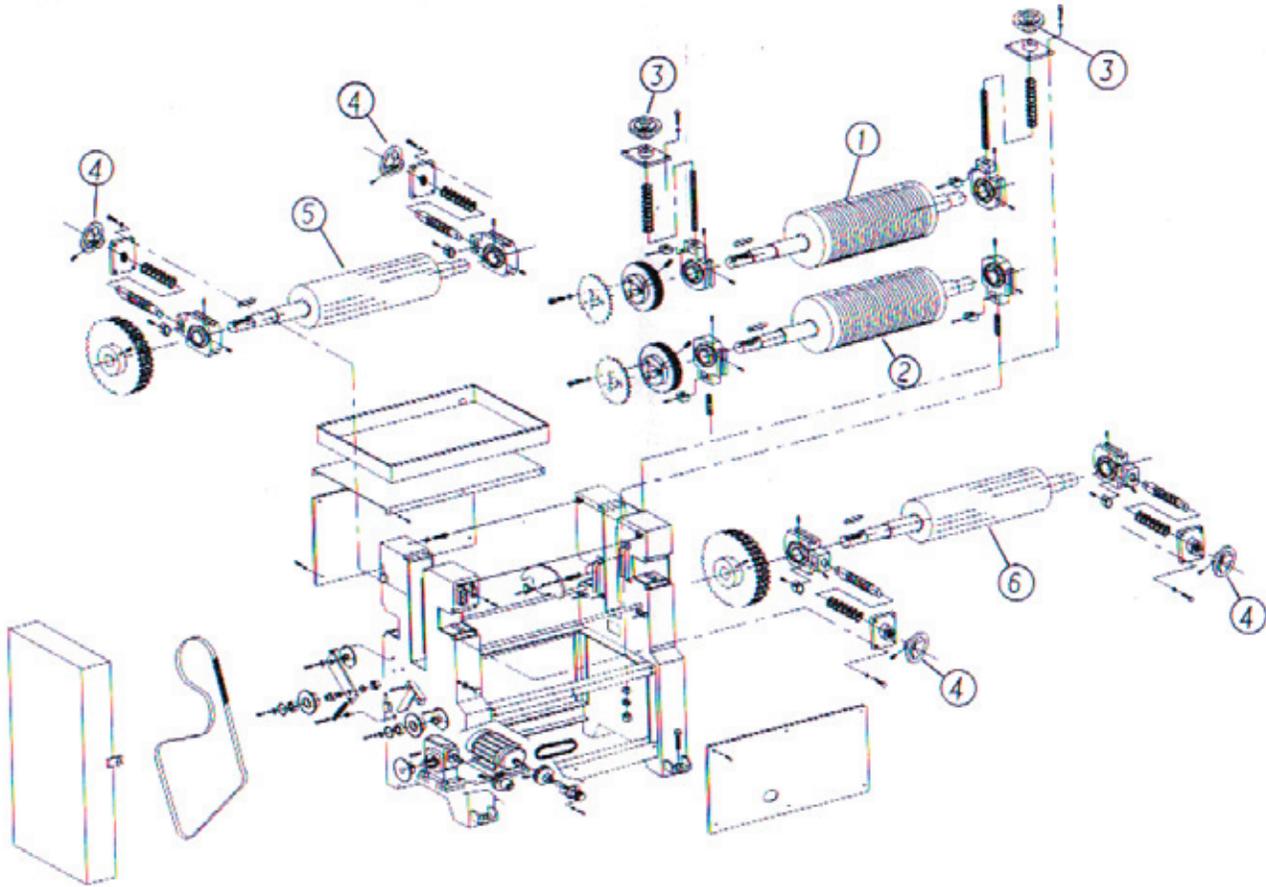
### Setting of The Preset Value (SV<sub>1</sub>)

Push The Key To Set The SV<sub>1</sub>.

Push The Key To Increase The Preset Value of SV<sub>1</sub>

Push The Key To Decrease The Preset Value of SV<sub>1</sub>

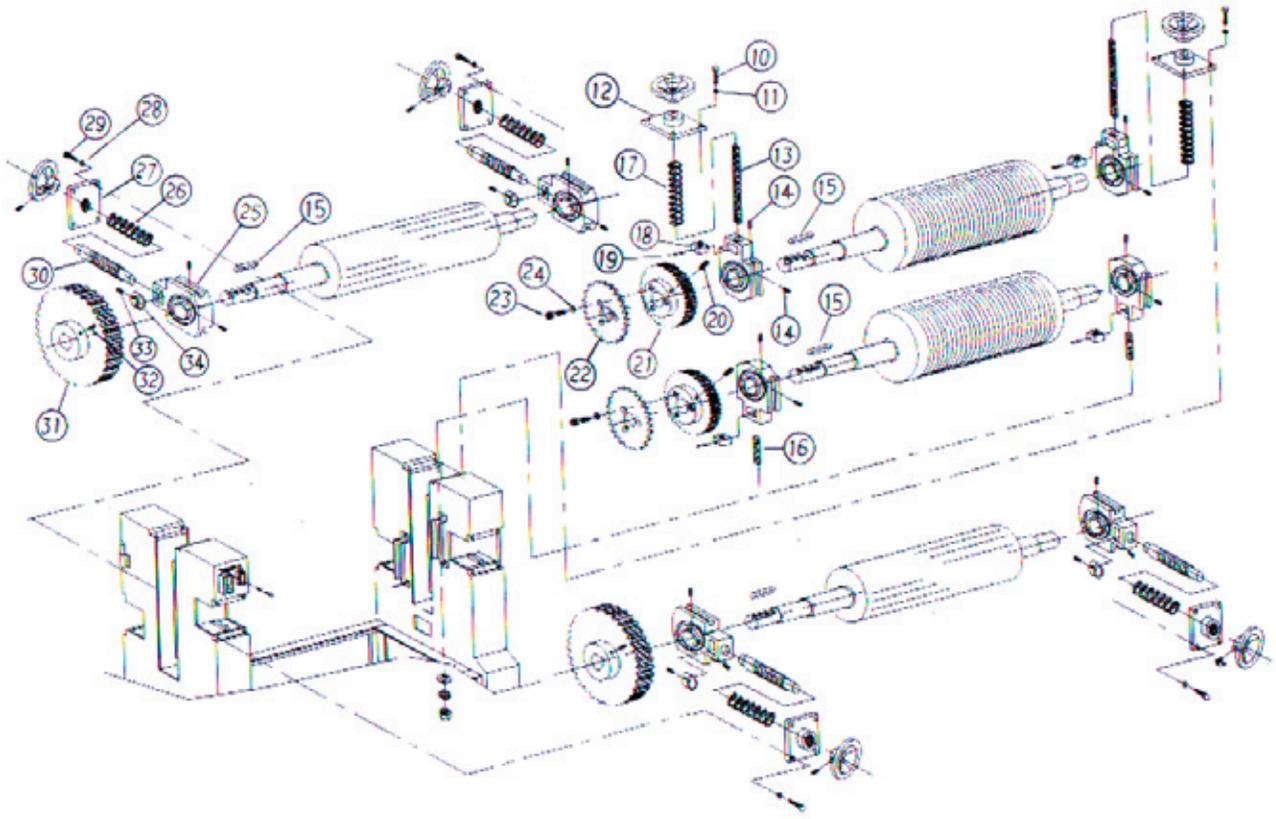
# Parts



This parts diagram is for an older model QUICK Roller Coater, and is included only for reference.

Please contact us for the correct diagram.

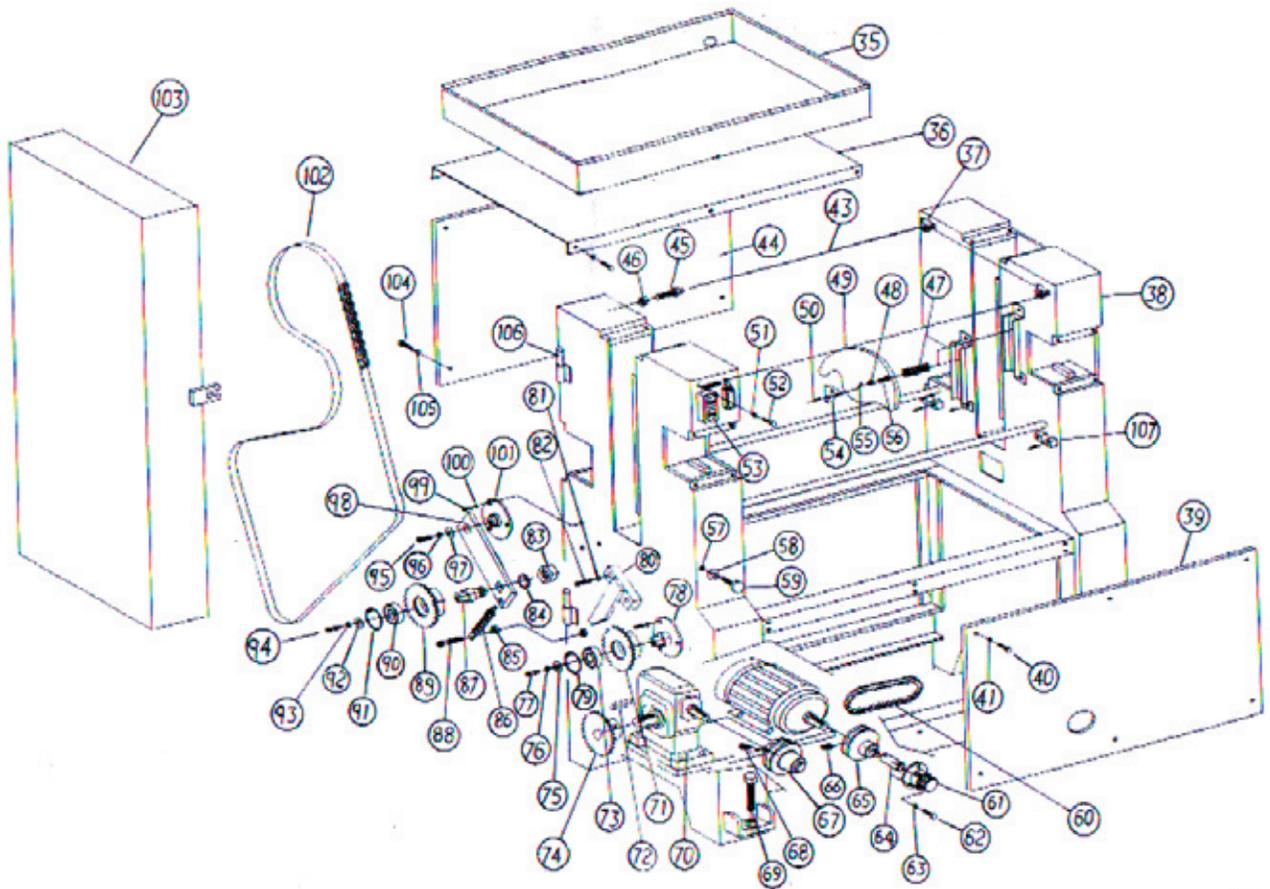
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