H.B. Fuller

# advantra® Packaging Adhesives

# An Illustrated Guide to Adhesive Changeover

advantra®
HIGH PERFORMANCE
PACKAGING ADHESIVES

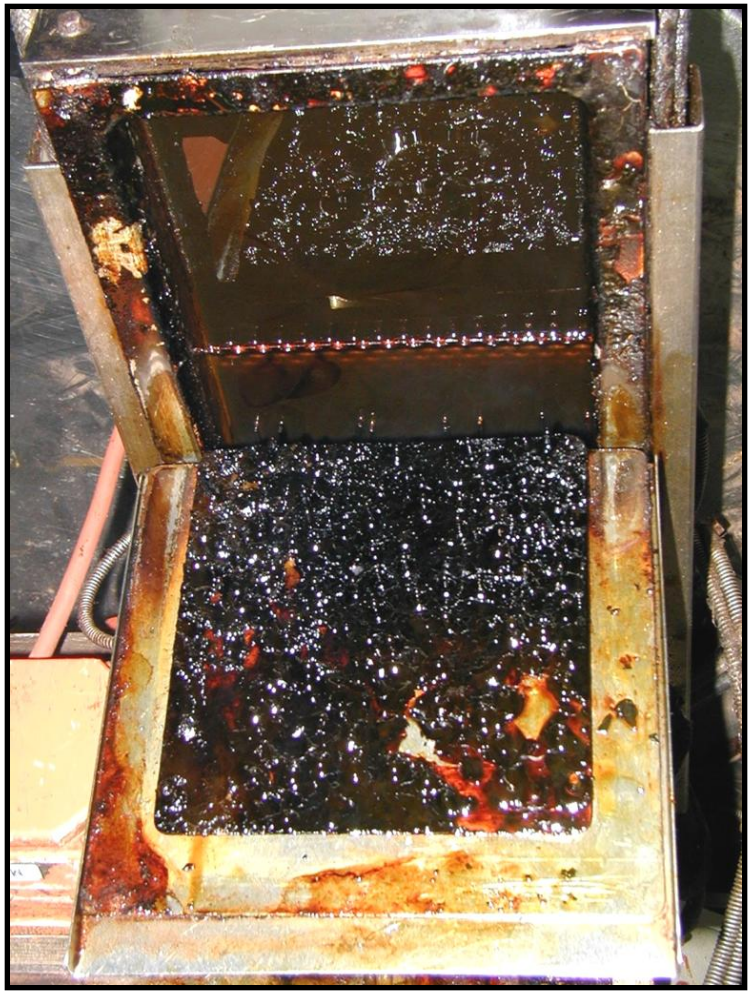
# Conversion Checklist

- Make sure the proper people involved with the demo are informed (production manager, machine operator, maintenance…)
- Confirm the sample product arrived at the customer's facility and that they have located it.
- Who will provide parts (filters, modules, nozzles…) for the changeover? Are the parts available?
- Is the customer prepared to take the line out of service for the necessary time to perform the changeover? What time will be agreed upon for the changeover to be completed?

advantra® HIGH PERFORMANCE PACKAGING ADHESIVES

H.B. Fuller

# How much time will be required for the changeover process?



**1-2 hours are usually required for a changeover, depending on the condition of the equipment.**

advantra®
HIGH PERFORMANCE
PACKAGING ADHESIVES

# Basic Tools Required


- Safety glasses
- Protective gloves
- Cleaner
- Wrench
- Screw-driver
- Allen wrench
- Rags

advantra® HIGH PERFORMANCE PACKAGING ADHESIVES

**Safety first! Use protective gear.**

# Additional Useful Tools


- 1,2,3,4,5 Cleaning tools
- 6 Screw Driver
- 7 Digital Thermometer
- 8 Heat Gun

# Prior to Changeover

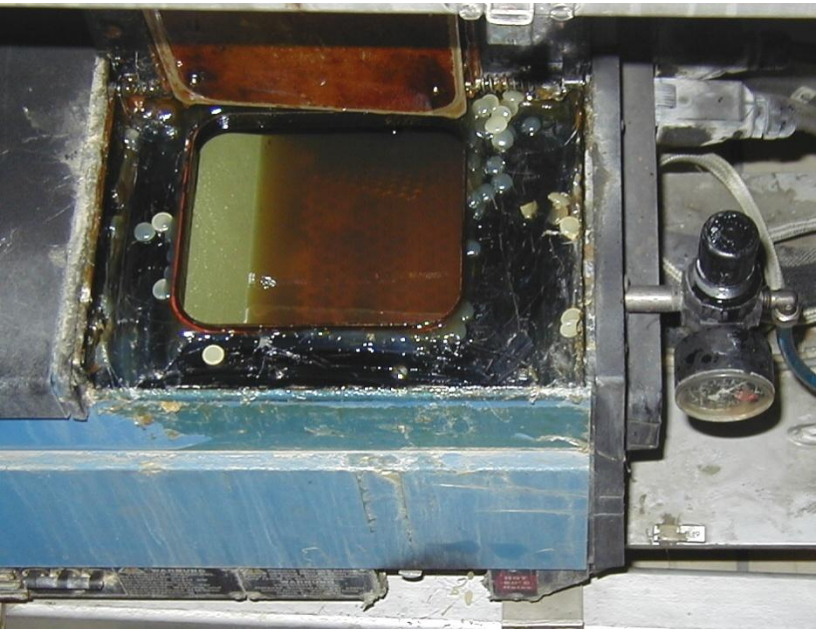
**Record the actual settings and parameters of the hot-melt equipment.**

| | |
|---|---|
| TANK: | _____ºC |
| HOSES: | _____ºC |
| NOZZLES: | _____ºC |
| PRESSURE: | _____ psi |
| NOZZLE SIZE: | _____ in. |

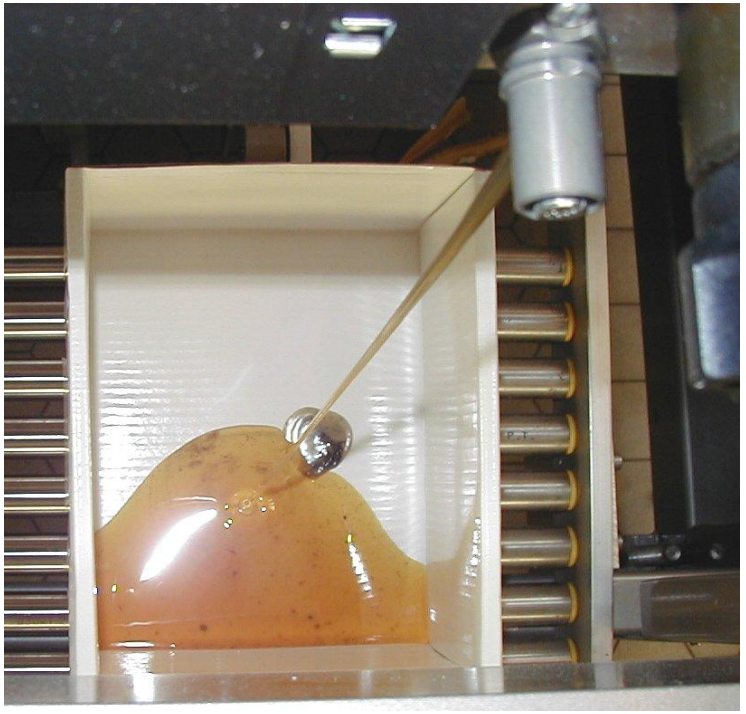

advantra®
HIGH PERFORMANCE
PACKAGING ADHESIVES

# Tank Flushing Procedure

## Empty the tank of previous adhesive used.



- Reduce System Pressure
- Open the drain valve
- Slowly increase system pressure and drain the tank



advantra®
HIGH PERFORMANCE
PACKAGING ADHESIVES

# Tank Cleaning Procedure

**Using precaution: Remove any loose char from the tank.**

**- Always wear protective gear when working with molten material**

**- You may use a non-abrasive scraper to loosen char from the edges and bottom**

advantra®
HIGH PERFORMANCE
PACKAGING ADHESIVES

# Tank Cleaning Procedure

**Example of a clean tank**

**Clean the lid assembly if required**

advantra®
HIGH PERFORMANCE
PACKAGING ADHESIVES

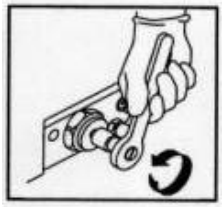
# Tank Filter Maintenance

## Remove and Clean (or change) the filter assembly

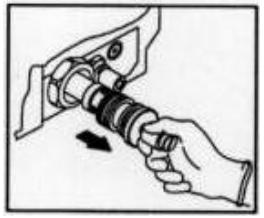


**Be sure to minimize system pressure before removing filter**

**Reduce system pressure to 0 psi**



**Loosen the filter assembly**



**Remove the filter**

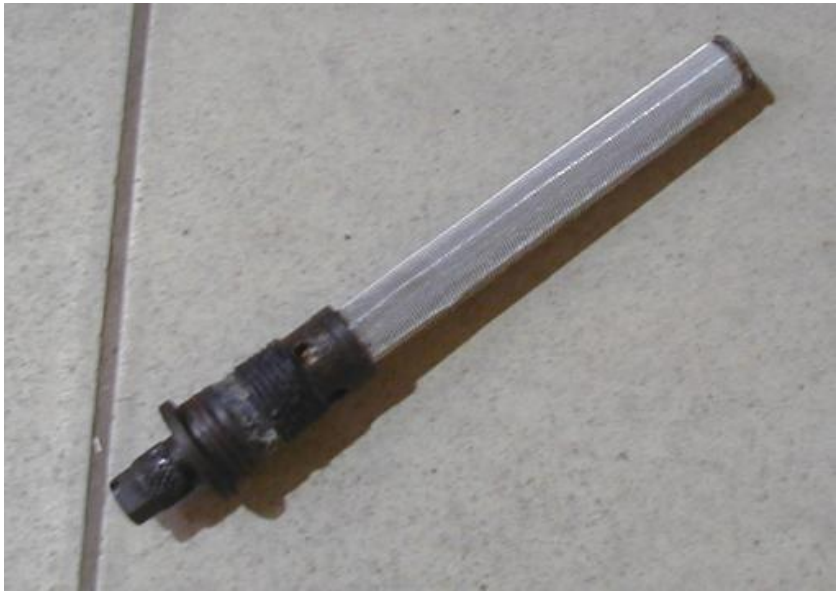
advantra®
HIGH PERFORMANCE
PACKAGING ADHESIVES

# Tank Filter Maintenance

**The filter assembly should be changed if it cannot be cleaned with a lint-free cloth.**

**Example of filter char**

**New Filter**



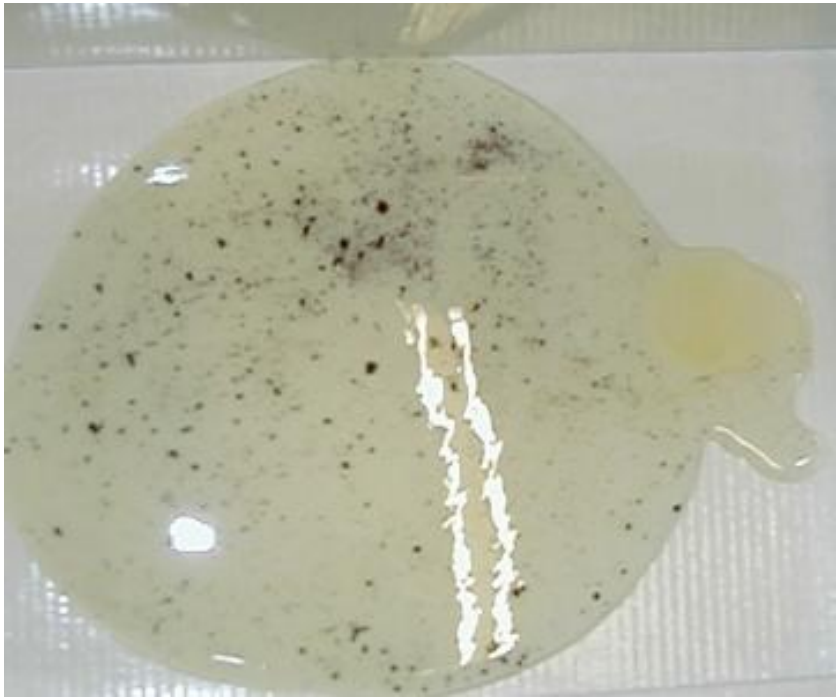
advantra®
HIGH PERFORMANCE
PACKAGING ADHESIVES

# Hose Purging Procedure

## Purging the hot melt hoses

**Example of hose flushed with advantra® adhesive**

**If you utilize the existing hoses they should be flushed with new advantra® adhesive.**



advantra®
HIGH PERFORMANCE
PACKAGING ADHESIVES

# In-line Filter Maintenance

**Replace In-line filters (filters between hose and gun).**

**Filters should be replaced if any char is evident. Filter mesh size should always be smaller or the same as nozzle orifice size.**

advantra®
HIGH PERFORMANCE
PACKAGING ADHESIVES

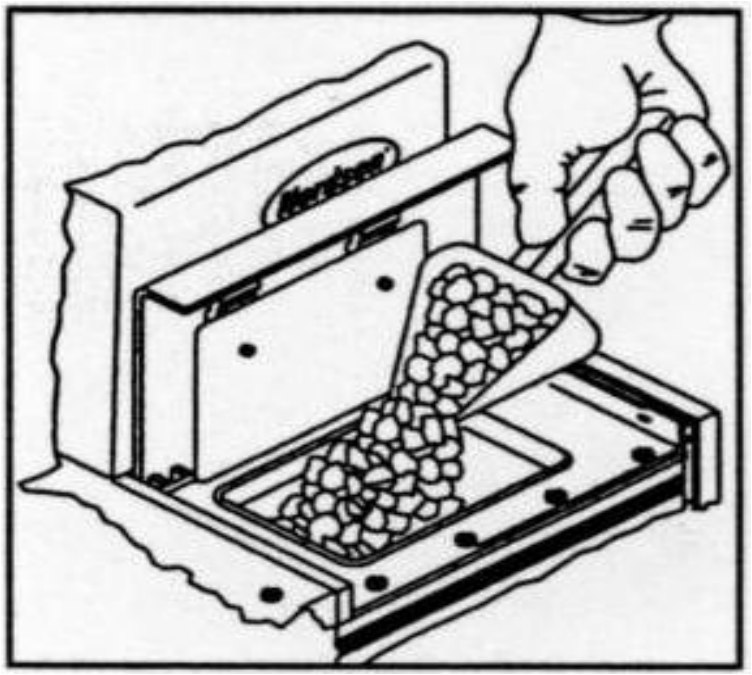
# Module Purging Procedure

## Purging the automatic gun with module


**Remove nozzles and flush new advantra® adhesive through the hose, gun and module.**

advantra®
HIGH PERFORMANCE
PACKAGING ADHESIVES

# Start Up



- Fill the tank with advantra® and heat to the recommended working temperature.

- Make sure the adhesive is completely molten before pump is engaged.

advantra®
HIGH PERFORMANCE
PACKAGING ADHESIVES

# Start Up

- Make sure pressures and temperatures are properly set.

- Start to run the machine and check that the nozzles are positioned correctly and bead size is suitable.

- If the bead is too large, decrease pressure slightly. Make sure you have the correct nozzle orifice size.

- If bead is not a clear straight line with clean cut off this may mean you have too little air pressure; increase accordingly.

- Make sure the pattern controller is programmed to accommodate any other adjustments.

advantra® HIGH PERFORMANCE PACKAGING ADHESIVES

# A Word About Char

- advantra® Packaging Adhesives will dissolve pre-existing char in hot melt dispensing equipment.

- With dirty, charred hoses, there may a period after the advantra® conversion where char breaks loose and accumulates on the in-line filter. Check filters weekly for a month.

- For extra heavily charred systems, hose replacement may be worth considering.