

LANGGUTH E62 lap glue system troubleshooting

General function of the lap glue system:

The container passes through the photo eye by the pick-up glue system and a sequence is started. The pick-up glue is fired first. When the container is at the label pick up point in the label magazine and the pick-up glue is touching the label, at exactly this moment the lap glue is fired and applied directly on to the overlap part of the label.

Before you start going deep into the system check the following:

- **Is the air pressure staying above 90 PSI when the machine is running**
- **Is the contact of the lap bar (the pressure onto the label stack) right? The lap bar is supposed to touch the labels in the magazine but not to put any pressure onto the stack in the magazine.**
- **Check the glue gun inspection hole to make sure it is in good working order and not leaking.**
- **Also check the solenoid valve that it is OK and working. Hold one finger onto the exhaust - you should feel air every time it is energized.**

- Make sure that the glue flow is unrestricted and the in line filter in the Nordson hose is clean.

If all this is set up properly and you still lose the lap glue while the machine is running, go to the lap glue bar timer at the control panel.

Whatever the number is the timer is set on, increase the number by 50 units.

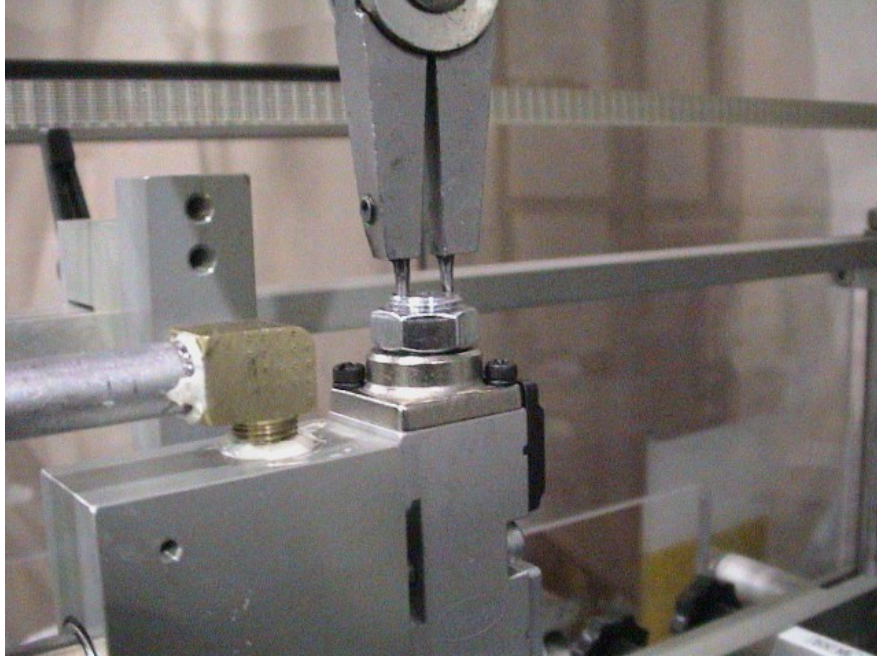
For example the timer is set to 90 increases the number to 140.



Set the machine to “Jog Mode” and check in jog mode that every time you push the button glue is pushed out of the nozzles at the lap bar.

The amount of glue is a little blub like the top of a needle head. If it is more than that or less you need to adjust the glue gun on top of the lap glue bar.

- Open the lock nut.
 - Turn the top screw 1/8 of a turn.
 - Check each time you move the screw if glue is coming out of the nozzles.
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- Please also check the solenoid valve that it is OK and working.



If a small amount of glue is coming out of the nozzles every time you push the “lap glue bar manual button” the setting should be right.

At this point I recommend trying this setting in a production run.

If the glue still fades away during production, check the incoming air pressure while the machine is running. The pressure has to stay above 90 PSI at all times.

Your pressure controller might be defective or just not set right.

If the air pressure stays above 90 PSI at all times change the Lap glue bar timer setting at the control panel again.

Set the number up by another 50 units and regulate the glue flow at the glue gun on top of the lap glue bar - same way as mentioned above. This time you have to reduce the glue flow. Turn the screw clockwise until you just get a little bit of glue coming out of the nozzles. Turn the glue gun top screw 1/8 of a revolution at a time until the glue flow is right.

If this solves the problem the BCD (electronic parts below the number switch) is worn out and has to be replaced ASAP.

If the problem is not going away please call our service department at:

519-888-0099 ext. 304/ 303

LANGGUTH AMERICA Ltd.
105 Randall Dr. #7
Waterloo, ON Canada
N2V 1C5