



**KLEIBERIT®**

ADHESIVES • COATINGS

# Operating Instructions Topmelter 2518



Please follow the safety instructions. Failure to follow these may result in injuries.

Competence **PUR**



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## **EC Declaration of Conformity as per the EC Machinery Directive (89/392 EWG)**

KLEBCHEMIE M. G. Becker GmbH & Co. KG  
Max-Becker-Str. 4  
76356 Weingarten  
Germany

hereby declares that the machine described below,

### **Topmelter 2518,**

**is in keeping with the provisions of the following EC directives:**

Machine Directive 89/392  
Low-Voltage Directive 72/23  
EMC Directive 89/336

### **Applicable standards and technical specifications:**

EN 292-1, EN 292-2	"Safety of machinery"
EN 294	"Safety distances to prevent danger zones being reached by the upper limbs"
EN 60950	"Safety of information technology equipment including electrical office equipment"
where applicable, EN 60204-1	"Electrical equipment of machines"
EN 60073	"Coding principles for indicators and actuators, using colors and other markings"



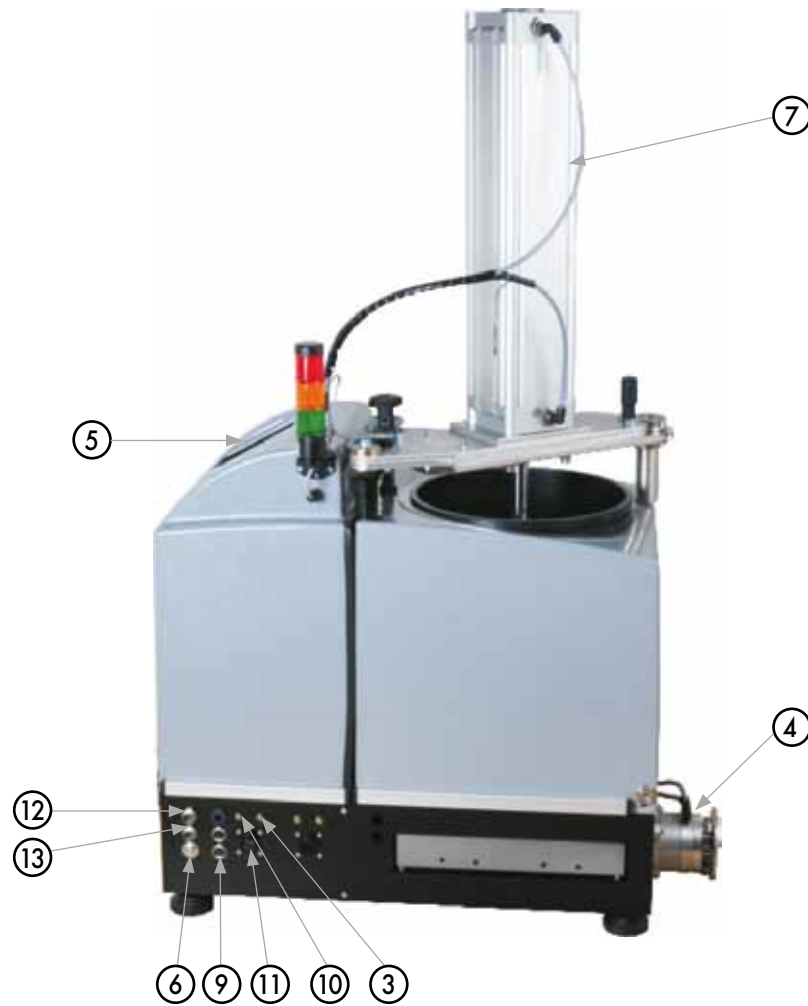
## 1. Information about the hotmelt adhesive machine

### 1.1 Machine structure

#### Topmelter 2518



⑧ ① ②



#### Components

- |                                      |                                       |
|--------------------------------------|---------------------------------------|
| ① Power switch                       | ⑦ Extrusion cylinder                  |
| ② Valve switch for adhesive release  | ⑧ Valve switch for extrusion cylinder |
| ③ Control light for head heater      | ⑨ Connector for fill level sensor     |
| ④ Rotary cylinder                    | ⑩ Control light for pipe heater       |
| ⑤ Keypad / temperature regulator     | ⑪ Connector for pipe heater           |
| ⑥ Manual button for adhesive release | ⑫ Connection to second unit           |
|                                      | ⑬ Connection to third unit            |



## 1. Information about the hotmelt adhesive machine

### 1.2 Machine functions

The hotmelt adhesive is melted inside the tank and pushed into the distributor system through the extrusion cylinder. When the fill level sensor is released, the nozzle valve is opened, allowing the adhesive to flow to the application site through a heated pipe. The adhesive volume can be set by adjusting the cylinder pressure. Four heating zones are monitored and regulated using the microprocessor-controlled temperature regulator.

Please read the operating instructions carefully!

The hotmelt adhesive machine can be hazardous if it is not used by trained personnel or used improperly.

### 1.3 Area of application/proper usage

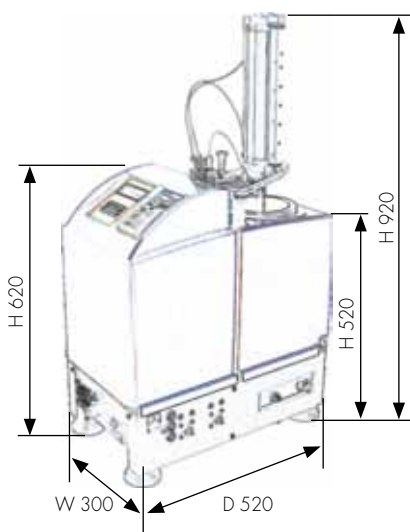


The **Topmelter 2518** is intended for fusing and conveying reactive, bonding **KLEIBERIT polyurethane hotmelt adhesives (PUR)** and **KLEIBERIT HotCoating®** from 18-kg aluminum-laminated pouches up to a diameter of 280 mm.

Thermosetting plastics and solvent-based adhesives cannot be processed in the hotmelt adhesive machine. Any other use is considered incorrect. The safety instructions must always be followed.

Please always follow our safety data sheets.

### 1.4 Technical data



Hotmelt adhesive machine	Topmelter 2518
Tank capacity	max. 25 kg
Pouch containers	18 kg, 20 kg
Feed pump	
Feed volume*	18-22 kg/h
Operating pressure for cylinder	6 bar
Operating temperature**	120°C-150°C
Hose connections	max. 1
Operating voltage	400 VAC ~ 50 Hz
Total output	6300 W
Weight	approx. 90 kg
* Depends on the hotmelt adhesive product; determined at a viscosity of 15,000 mPaS / 140 °C	
** Standard setting	
Subject to technical changes	

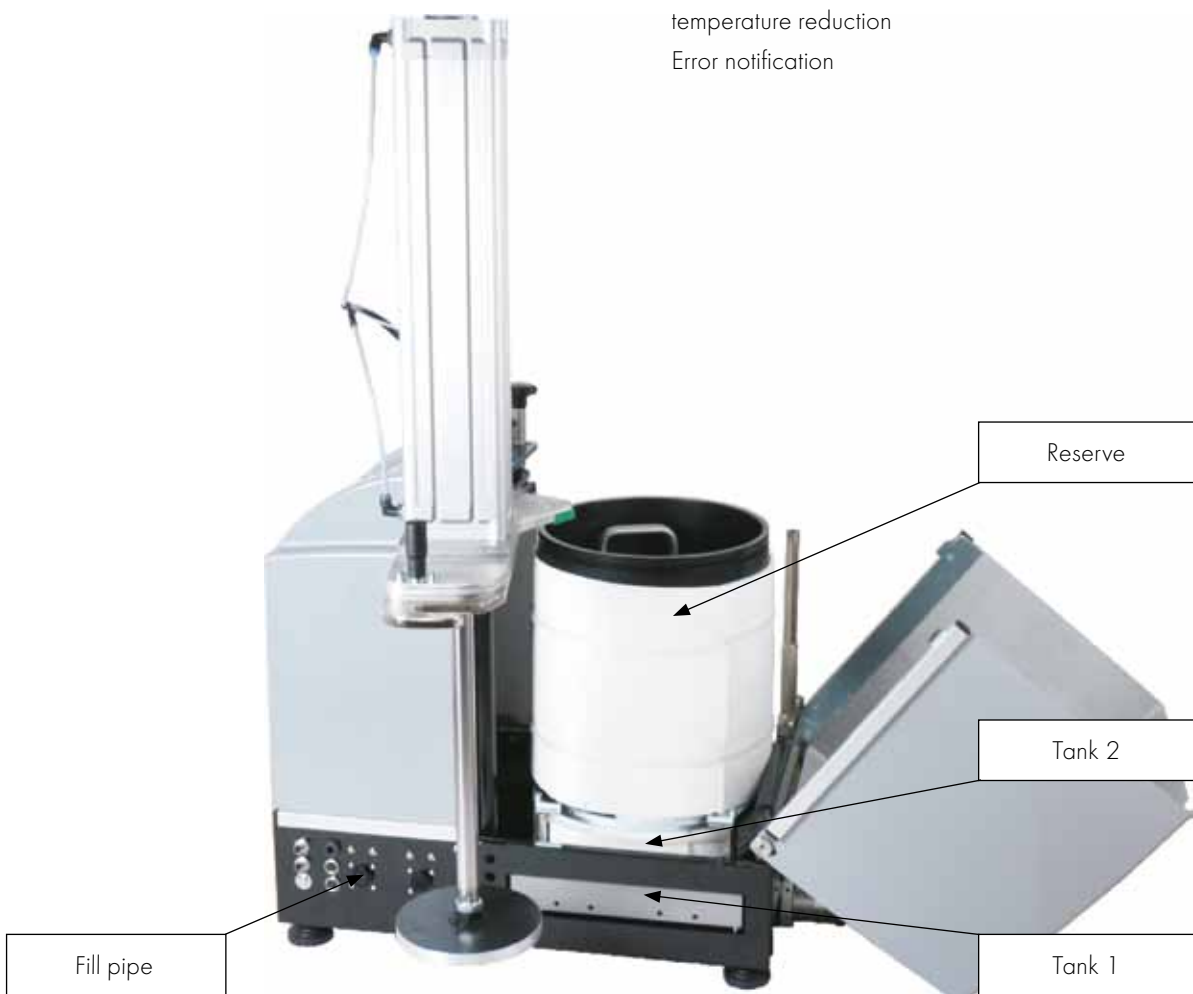


## 1. Information about the hotmelt adhesive machine

### 1.5 Basic machine equipment

#### Features

- Tank with nonstick coating
- Operating voltage 50 Hz ~ / 400 VAC
- Switch for adhesive release
- Tank is heated using replaceable heating cartridges
- Seven-channel temperature regulator
- Automatic temperature reduction
- Error notifications for overheating and sensor faults
- Weekly timer
- Pouch cutout plate and bearing ring
- Control displays for supply voltage,  
heating on,  
temperature display, actual value, target value  
temperature reduction  
Error notification



Optional: 'operation-ready' signal  
'empty' signal



## 2. Starting up the machine

### 2.1 Safety instructions

Please follow the operating instructions and safety instructions! Failure to follow these may result in severe injuries.

**The pin assignment and voltage must be checked before the machine is connected to the power grid!**

#### Protective clothing

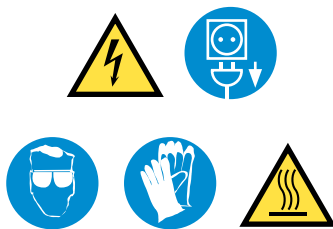
The machine must be started up by trained expert personnel. When working with the Topmelter, protective clothing must be worn to protect the body from hotmelt adhesive spraying. In addition, heat-insulating protective gloves and protective goggles must be worn. Hotmelt adhesive can burn the skin!

In the event that the skin is burned, cool the affected areas with cold, clean water. Do not use force to remove adhesive from the skin beforehand. For severe burns, please see a doctor.

The temperature limiter and material pressure limiter are installed as safety features and cannot be removed or manipulated. Do not modify the machine!

If damage or faults are found at the time of startup, these must be reported to the manufacturer immediately.

#### Warning signs



The Topmelter fulfills the applicable safety provisions. In order to alert operators to hazardous areas, additional warning symbols have been posted.

When opening the cover: CAUTION - electrical voltage!

Risk of electrical shock.

Remove power cord before beginning work!

Caution - risk of burns from hot adhesive and hot surfaces. Wear heat-protective clothing (long pants, closed shoes), protective goggles and heat-protective gloves!

#### Remaining residual risk

Risk of burns from hot adhesive

Risk of burns when filling and pumping out the adhesive

Risk of burns at the tank, after opening the tank lid

Risk of burns from all uncovered parts, such as hose connectors, drain screw, fill pipe.

Components are electrically charged after opening the cover and the electronics rack, even after the machine is switched off.

Inhalation of adhesive vapors

#### Do not start machine

if parameters for the operation area are not met

if covers are open

if tank lids are open

if the machine is clearly damaged

if independent modifications have been made to the machine

if the environment is damp or poses a risk of explosion

if personnel have not been trained

- Trained personnel are those who have been instructed about possible risks, proper operation of the machine and the safety measures.

The reactive components in PUR are isocyanate groups. Therefore, when hotmelts are processed, isocyanate vapor is released. Isocyanates are substances that severely irritate the skin, eyes and breathing passages. Before processing PUR, the safety data sheets must always be observed. It is recommended that the resulting PUR hotmelt vapors be extracted using appropriate equipment.



## 2. Starting up the machine

### 2.2 Machine assembly

Please observe operating instructions and safety instructions. Failure to do so may result in severe injuries.

#### Setup location

The machine must be set up and operated exclusively by skilled personnel. Skilled personnel are qualified skilled workers who are in a position to install, operate, maintain and repair the machine due to their training and abilities.

The Topmelter must be free-standing; no heat may be accumulated. Damp rooms and splash water are to be avoided.

The illustration shows the necessary minimum distances.

The machine must be screwed onto the setup table.

No objects can fall into the tank or the adhesive container.

Do not use the machine in explosion-prone environments!

#### Electrical connections



**CAUTION** - electrical voltage!  
Risk of electrical shock.  
Remove power cord before beginning work.

The power cord must have a cross-section that corresponds to the total current consumption. Do not use a cable drum!

When setting up the machine, ensure that the connection cable is not pinched or damaged. Replace damaged cables immediately.

Always use the machine with the supply voltage specified on the rating plate.

Ground the machine according to the regulations, and provide surge protectors for the total current consumption.

<b>Type: Topmelter 2518</b>		
<b>P:</b>	<b>U:</b>	
<b>No.</b>	<b>Weight:</b>	<b>CE</b>

U: Supply voltage (nominal voltage),  
if necessary with neutral conductor,  
V = volts

P: Machine output (heat output)  
W = watts





## 2. Starting up the machine

### 2.2 Machine assembly

#### Installing the fill pipe



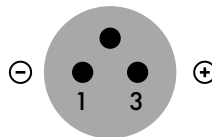
Attach the pipe under the exhaust valve.

Create an electrical connection by inserting the plug and screwing it into the hose connector (11). Temperature control station S1K1.

Set control station S1 to the target temperature on the display.

Control station K1 is set by the manufacturer at a constant 125°C and may not be changed.

Create an electrical connection for the fill-level sensor (9).



24-volt PNP sensor



**CAUTION** - risk of burns from all uncovered components.

Hotmelt adhesive may leak from the exhaust valve.

Wear protective clothing (long pants, closed shoes), heat-insulating gloves and protective goggles.



12

9

11



## 2. Starting up the machine

### 2.3 Connecting pressurized air to the cylinder

#### Installing the fill pipe

Create a pressurized-air connection (hose diameter 6 mm). The default on the machine's pressure controller is 4 bar. Do not exceed 6 bar!

Cylinder must be retracted into working position, and the adjusting pin must be engaged.

Valve switch (8) to On, cylinder moves downward to the tank floor

Valve switch can only be used when the cylinder is pivoted inward



#### Adjusting pin

**red** light flashing: - Cylinder in downward position  
- Pouch is empty

**yellow** fill paste rolls

**green** machine is heated up  
target temperatures achieved  
ready signal

**Sensor** to release the valve switch (8) must glow yellow when cylinder is in working position



## 2. Starting up the machine

### 2.4 Filling the tank

#### Hotmelt adhesive



Before inserting the HotCoating/hotmelt adhesive into the tank, the application area (Point 1.3) and safety instructions must be observed. The expiration date for the adhesive cannot be exceeded. The foil pouch cannot show any signs of damage. Do not combine different types of adhesive.

Clean any hotmelt adhesive residue from the tank before inserting a new pouch. Use a wooden spatula for cleaning.

Place pouch under protective gas; puncture before processing.

Use template to cut a circle in the bottom of the pouch.

Place the pouch into the tank with the cutout facing down, then place the top ring on the pouch.

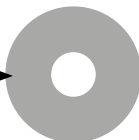
Close the swiveling arm and **set the switch (8) to On**. The cylinder will move downward and press the pouch against the seal. The pouch prevents moisture in the air from entering the tank. This is why there must always be a pouch in the tank, even after shutdown.

Once the pouch is empty, the light will flash red; readjust the sensor if necessary.

Only then can the pouch be changed.



Top ring



#### CAUTION – risk of burns!

When the machine is turned on and the lid is open, there is a risk of burns from the tank and the aluminum pouch when changing pouches, as well as from the hotmelt. Wear protective clothing (long pants, closed shoes), heat-insulating gloves and protective goggles.

Pouch Ø 280 mm    Cutout Ø 180 mm

#### Note:

Before delivery, the tank was filled with a rinsing agent to inspect the machine. Before initial startup, this residue must be removed by melting and conveying the hotmelt adhesive to be processed.

The temperature required by KLEIBERIT cannot be exceeded. No liability is assumed for damages caused by an incorrect temperature setting.





## 3. Operating the machine

### Buttons and switches



① ②

Set the **power switch** (1) to **position 1**,

Turn on the **temperature regulator** (5) using the **On/Off** and **Enter** buttons.

When the target temperature is reached, the **signal light glows green**.

When the **valve switch** (2) is set to **position 1**, the 5/2 magnet valve (14) is released for use by the rotating cylinder (see page 19).

Switch position 0 turns off the rotating cylinder.

Machine should be used only by trained personnel!



#### 3.1 Equipment features for temperature regulation

#### 3.2 Description of controls

#### 3.3 Initial startup

#### 3.4 The user menu

1. Individual activation ("K" head)

2. Temperatures

3. Limit values

4. Timed operation

5. Date/time

6. Control parameters

7. Optimization

8. Operation type

9. Wait times

10. Language

11. Factory settings

12. Sensor selection

#### 3.5 Technical data

1. Connection diagram for the circuit board

2. Description of connections

### 3.1 Equipment features: temperature controls

Self-optimizing temperature controls

Available for PT 100 and NI 120 sensor controls

Easy, intuitive use, with 8 buttons and a large display featuring 4 x 20 characters

Temperature can be lowered or turned off individually for each channel

Programmable overcooling and overheating alarm

Sequential or parallel heating of channels

Weekly timer with lithium back-up battery, including on/off function, parallel to the timer

Code lock for the basic parameters

Integrated fault diagnosis system with scanning function for fast, easy fault localization

A wide range of external connection options

Optional RS 485 Profibus interface for centrally controlling all functions through SPS



## 3. Operating the machine

### 3.2 Description of controls

LCD display, choice of 5 languages



"Menu" button	Menu selection on/off
"Arrow" button	Select a menu item/channel or change a setting (value from 0-230)
"Enter" button	Activate a menu item or confirm and apply the new value
"ESC" button	Undo (if value has not yet been saved by pressing "Enter") Jump back one level within the menu
"Standby" button	Activate the chosen temperature reduction (only for timed and manual operation) The relay K4 is switched off, and the display flashes "Standby operation" at the bottom. The target standby temperature is also displayed. Display: Confirm machine standby by pressing "Enter."
"Info" button	Pressing the "Info" button several times will show the following, one after the other: All actual temperature values, individual display in scanning mode Display: Actual value: Tank 1: temperature is displayed Tank 2 (heating collar): temp. is displayed S1: shows temperature on or off K1: shows temp. on or off S2: shows temperature on or off K2: shows temp. on or off R1: shows temperature on or off
"On/Off" button	Turns the machine on/off when weekly timer is activated Button only available when weekly timer is activated On = deactivates timer when machine is off Off = activates timer when machine is on (System will restart at the next programmed startup time)

CAUTION! This makes it easy to accidentally turn off the machine.



## 3. Operating the machine

### 3.3 Initial startup

Turn on the 230 V AC / 50 Hz power supply.

The following text will appear: **7 channel temperature controller V21 190905**  
after about 2 sec

Display: Manually controlled  
To start the preheating phase, please press **On/Off**.  
The controller is now ready.

Next, check all of the settings to ensure that they are correct, and adjust them if necessary.

"Menu" button	Menu selection on/off
"Arrow" button	Select a menu item
"Enter" button	Activate a menu item
"Arrow" button	Choose a sub-menu item / change the setting
"Enter" button	Confirm and apply the new value
"ESC" button	Undo

Once all of the settings are correct, exit the menu function by pressing the "**Menu**" button.  
Activate the controller by pressing the **On/Off** button.

Display: Machine is starting up - confirm by pressing "**Enter**"

Display:	Description
Tank	12:45 Channel and time appear
T=140°C 140°C	Channel temperature Actual and target values
Prewarming phase	Operating conditions: prewarming phase / normal mode / standby
Ready for manual control	Operation type: menu item 8 (manual control / timed / SPS) "Ready" signals readiness for operation

Once 75% of the set target temperature is reached, the preheating phase is started for the other channels.

Once all of the temperatures are reached, the delay time set in menu item 9 is activated.

Once this time has passed, the display automatically switches to scanning mode.

### 3.4 The user menu

After you press the Menu button, the following menu list will appear:

- 1. Individual activation**
- 2. Temperatures**
- 3. Limit values**
- 4. Timed operation**
- 5. Date/time**
- 6. Control parameters**
- 7. Optimization**
- 8. Operation type**
- 9. Wait times**
- 10. Language**
- 11. Factory settings (code required)**
- 12. Sensor selection (code required)**

Use the arrow buttons and confirm by pressing **Enter** to select the corresponding menu item and to jump to the next menu, where you can adjust additional settings.



## 3. Operating the machine

The following are the factory settings for the individual menus. In some cases, these have been simplified.

### 1. Individual activation

(T2=heating collar), (S=hose), (K=head), (R=reserve) e.g. activating the necessary control channels

Default display	Explanation
S1, K1=ON	On= hose/head group is turned on
S2, K2=ON	Off= hose/head group is turned off
	Standby= hose/head group is in standby mode (as per the setting under Point 2)

NOTE:

The tank temperature channel (T1) is always activated, so it must always be connected; otherwise, a fault notification will be activated (flashing display). This fault notification will also appear if a channel switched to ON is not in use.

### 2. Temperatures

Preselect the necessary temperatures (see information from the materials manufacturer)

Default display	Explanation
Tank	Temperature zone (Tank 1 / Tank 2 / Hose 1+ Head 1 / Hose 2 + Head 2 / Reserve)
Normal mode: 130°C	Operating temperature
Standby: 80°C	Standby temperature

In order to set the individual temperature values, please press **Enter**. Use the arrow buttons (**up/down**) to set the temperature to the desired value, and confirm by pressing **Enter**. To jump back to the menu, press the Enter button again.

### 3. Limit values

Set the tolerance range to activate the alarm output

Default display	Explanation
Tank	Temperature zone
High 10°C	Activates the alarm output at 10°C above the target temperature
Low 10°C	Activates the alarm output at 10 °C below the target temperature
Max 5°C	When the upper limit is exceeded by 5 °C, the power supply to the corresponding channel is automatically shut off.

Use the **Enter** button to choose the item on the display. Use the arrow buttons (**up/down**) to change the displayed values. To go back to the menu, press **Enter** again.

### 4. Timed operation (weekly timer)

Here you can enter a standby time for every day of the week, for instance during the lunch break.

Default display	Explanation
Mon(-Fri)	Day of the week
On: 7 am. Off: 5 pm	On: start of operation Off: end of operation
Standby On: 12 pm	Between 12 and 1 pm, all temperatures are lowered to
Standby Off: 1 am	protect the adhesive

NOTE: In the default settings, the weekly timer is activated from Mon-Fri according to the display.

### 5. Date/time

Shows the current date (day, month, year) and the precise time (24-hour clock)

Display Date: Tu. 16 Dec. 13  
Time: 15:26



## 3. Operating the machine

### 6. Control parameters

Automatically set by the optimization function - menu item 7

Proportional / differential / integral value setting

P:100            D:10            I:80

### 7. Optimization

This function is used to determine the control temperature for connected heating elements. The controller is preset with standard parameters, which are sufficient for precise regulation in most cases. However, it is possible that parameters for certain heating units may need to be corrected slightly in order to ensure precise regulation.

To optimize the controls, switch to the Optimization menu when the heater is turned off and the heating elements are cold. Use an arrow to mark the objects on the list for which you want to determine the control parameters, by pressing the Enter button. Scroll down until you reach the Start option.

Press the Enter key to begin optimization of the selected objects. All of the activated channels will be set to 95% of the target temperature; after that, the channels will be switched off again.

Please note that the corresponding heating elements need to be cool before optimization is started. Optimization can be interrupted by pressing the On/Off button and Enter. Use the up/down arrow buttons to select the controls. To confirm, press the Enter button.

### 8. Operation type

1. Timed (default)

Control the controller using the programmed weekly timer

2. > Manual

Control the controller using the on/off button

3. SPS-controlled

Control the controller using the 24 VDC inputs

### 9. Wait time

Default display	Explanation
Lower limit: 100°C	Tank temperature above which the wait time is activated.
Wait time: 0 min	The release signal is delayed for 0-30 minutes (adjustable) once all temperatures are reached.
> Sequential:	Channels are heated one after the other to avoid expansion pressure
> Parallel:	Heating is simultaneous if expansion pressure is not an issue.

### 10. Language

German  
 English  
 French  
 Italian  
 Spanish

To choose a language, select the corresponding language using the arrow buttons (**up/down**). Confirm by pressing **Enter**. To go back to the menu, press **Enter** again.

### 11. Factory settings

Code ####

(default 1 2 3 4)

Enter code using up/down arrow buttons; once a digit has been entered, confirm by pressing **Enter**. Repeat this process for each digit. To go back to the menu, press **Enter** again.

Display:

**Warning** - all settings will be reset. Confirm with **Enter**.

Note:

The existing sensor selection will not be reset.





## 3. Operating the machine

### 12. Sensor selection

Code ####	(default 1 2 3 4)
	Here, each channel can be assigned its own sensor type. The options are NI 120 and Pt 100 sensors.
Default display	Tank 1: Pt100      Tank 2: Pt100
	S1: Pt100      K1: Pt100
	S2: Pt100      K2: Pt100
	R: Pt100

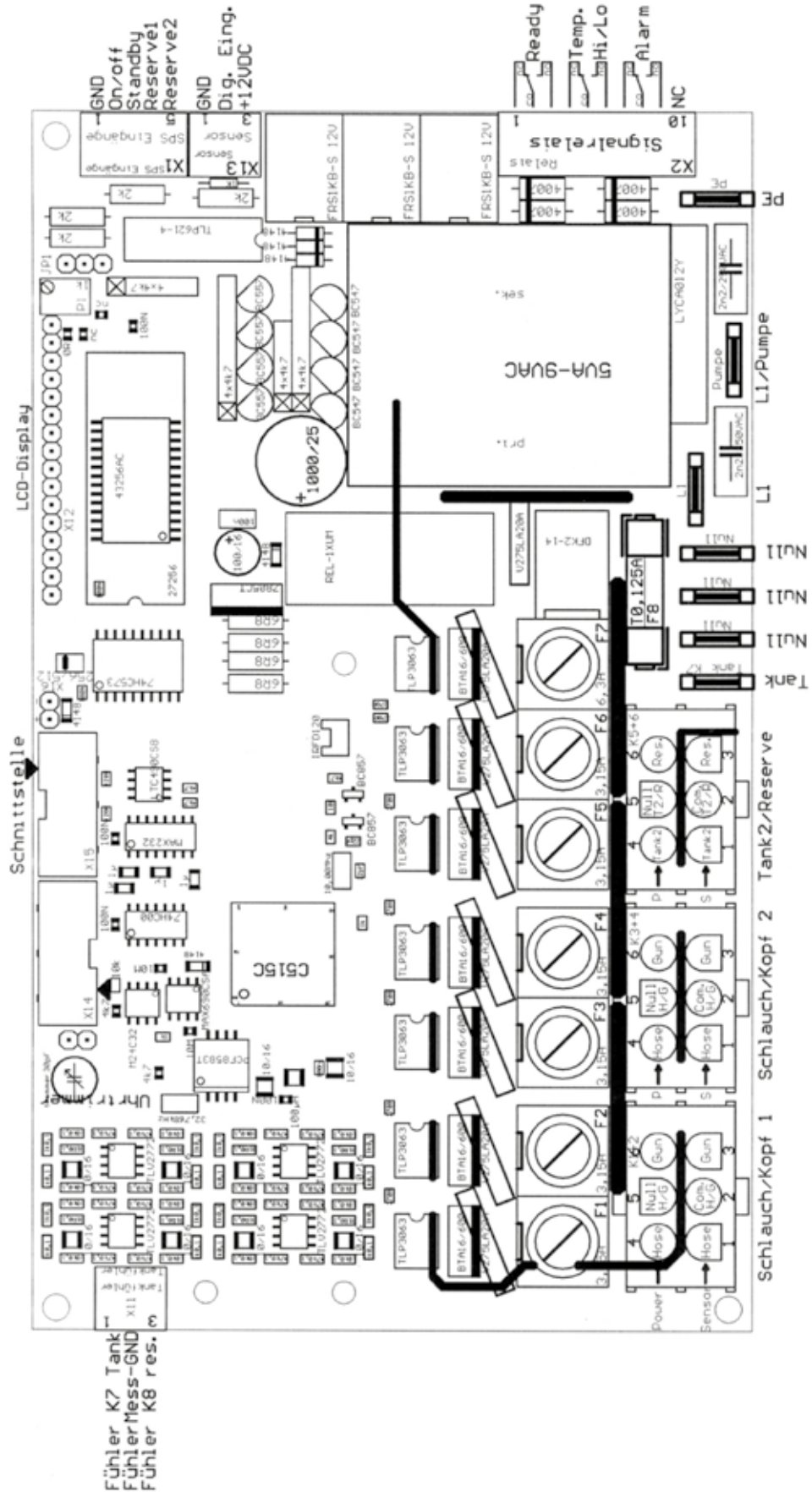
### 3.5 Technical data

Electrical parameters:	Inputs:	- sensor Pt100 / NI120 - controller On/Off - controller on standby - fill level sensor (optional)
	Voltage range	230 VAC / 60Hz (1L-N-SL)
	Connected load per channel	1000 W
	Total output max.	3500 W
Optional:	400 VAC / 60HZ (3L-N-SL) 120 / 240 VAC / 60Hz (3L without neutral connection, with transformer)	
General parameters:	- Ambient temperature:	0-70°C
	- Relative humidity:	10-95%
Outputs:	- Ready signal NO/NC (with adjustable 3 to 30-minute delay in minute increments) - Alarm temp. NO/NC - Alarm sensor breakdown or sensor short circuit (NO/NC) - Acoustic signal (optional)	
Measurement parameters:	- Temperature range:	0-160°C
	- Controllable sensors:	NI120 (RTD) / Pt100
	- Controlling precision:	+/- 0.5%
	- Temperature resolution:	1 °C



### 3. Operating the machine

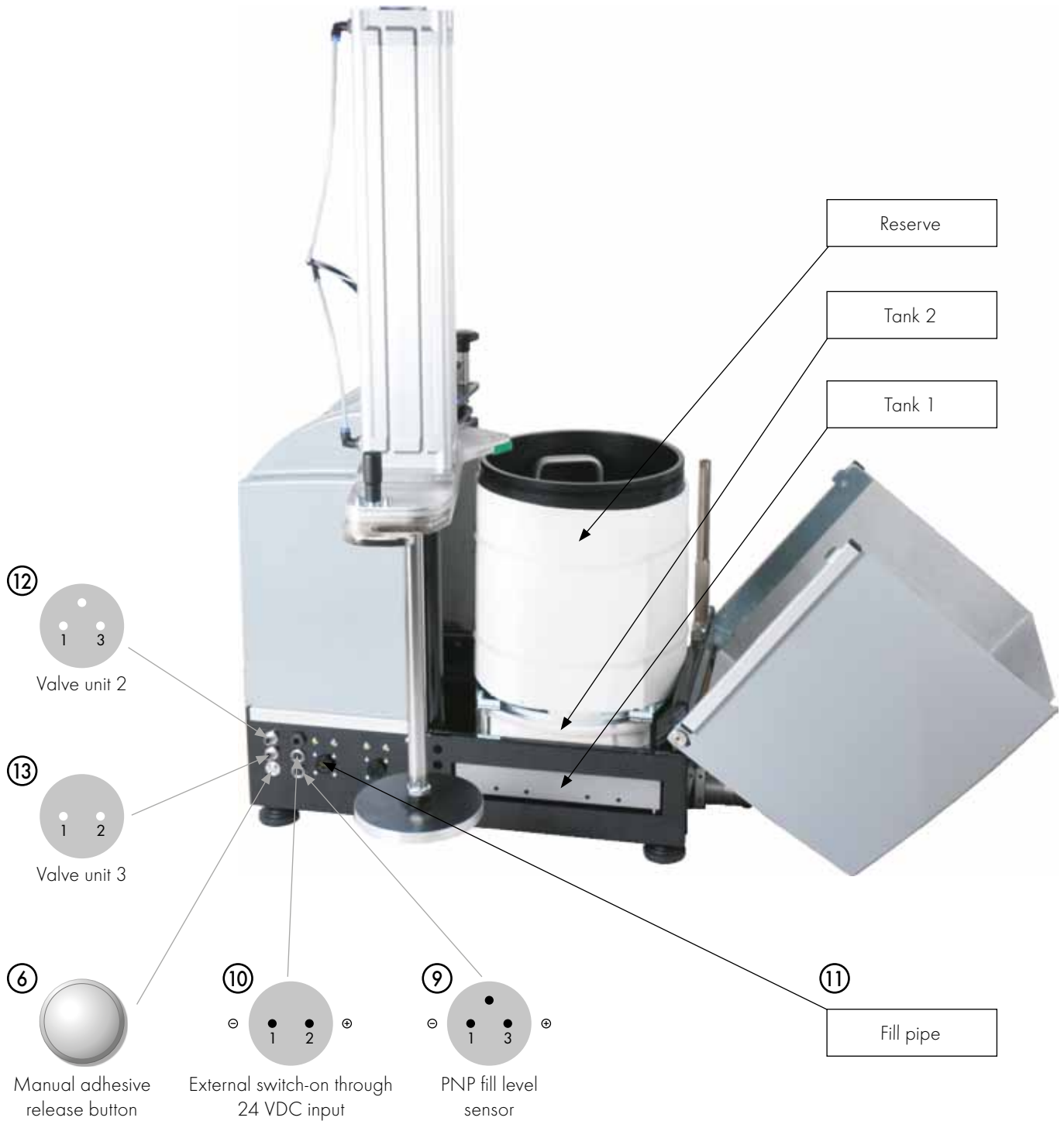
#### 3.6 Connection diagram for circuit board





## 3. Operating the machine

### 3.7 Connection diagram for output connector





## 3. Operating the machine

### 3.8 Regulating the adhesive volume

#### Material pressure



The flow-through volume can be increased to a maximum of 6 bar by changing the cylinder pressure at the manometer.

Adjusting the adhesive temperature T1 and T2 as well as preheating temperature R



#### **CAUTION - risk of burns!**

Wear protective clothing (long pants, closed shoes), heat-insulating gloves and protective goggles.

Magnet valve for rotating cylinder (14)





## 4. Maintenance

### 4.1 Maintenance work



#### OBSERVE SAFETY CONDITIONS

Daily maintenance is limited to cleaning the outside of the machine and removing adhesive residue from the tank.

Regularly check tank pipe and functionality of outlet valve to make sure they are firmly in place.

Clean the tank using KLEIBERIT 761.7 at least three times a year. Once the cleaner has been pumped out, the machine must be cleaned according to Point 4.3 (open the tank).

For production breaks of more than one hour, press the **"Standby"** button. For downtimes of more than seven days, rinse the machine with KLEIBERIT 761.7.



KLEIBERIT offers cleaning products to remove deposits in the tank. Solvent-based cleaners are highly flammable. Only use cleaners with combustion points above 280 °C. Maintenance must be performed by trained personnel.



**Only perform maintenance work when the machine is depressurized and disconnected from the power source.**

Note! Even after the power switch (10) is turned off, the power supply in the machine's switching box is still on. Disconnect the plug before beginning work.

### 4.2 Turning off the machine

Press the **On/Off** button and press **Enter** to confirm  
Set **power switch** (10) to **"Off"**

**CAUTION!** When **power switch** (10) is **off** and **valve switch** (22) is **on**, keep lid closed. Pouch must remain in the tank.

After shutdown, seal the injection pipe with a suitable wax or cleaning compound, or dip pipe in oil. If machine is shut down daily, do not completely empty the pouch; otherwise, the PUR hotmelt residue could harden.

For shutdowns lasting more than seven days, rinse the machine with KLEIBERIT 761.7.



## 4. Maintenance

### 4.3 Disassembling adhesive-conveying parts Open tank for cleaning

Adhesive-conveying parts can only be disassembled when they are warm.

Repairs must be performed by trained personnel.



**CAUTION!** Risk of burns!

- from all uncovered parts

During disassembly, hotmelt adhesive may leak. Wear protective clothing (long pants, closed shoes), heat-insulating gloves and protective goggles.

When opening the cover - CAUTION - electrical voltage!

There is a risk of electrical shock.

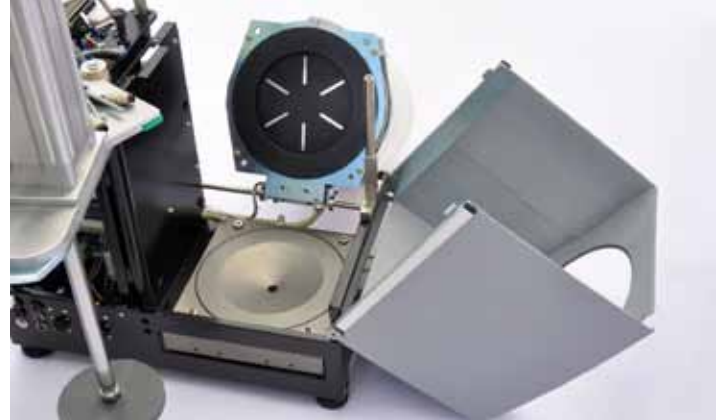
Disconnect the power plug before beginning work!



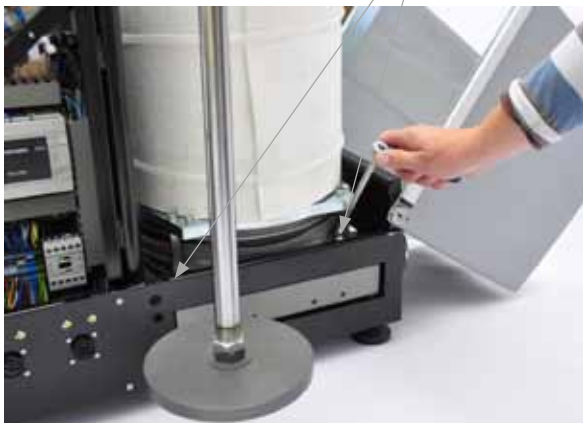


## 4. Maintenance

### 4.3 Disassembling adhesive-conveying parts Open tank for cleaning



Remove 4 screws



NOTE: Place O ring completely inside the groove  
O ring will expand when heated

**CAUTION!** Risk of burns!

- from all uncovered parts

Hotmelt adhesive may leak during disassembly.  
Wear protective clothing (long pants, closed shoes), heat-insulating gloves and protective goggles.



## 5. Repair instructions

### 5.1 Changing the temperature sensor

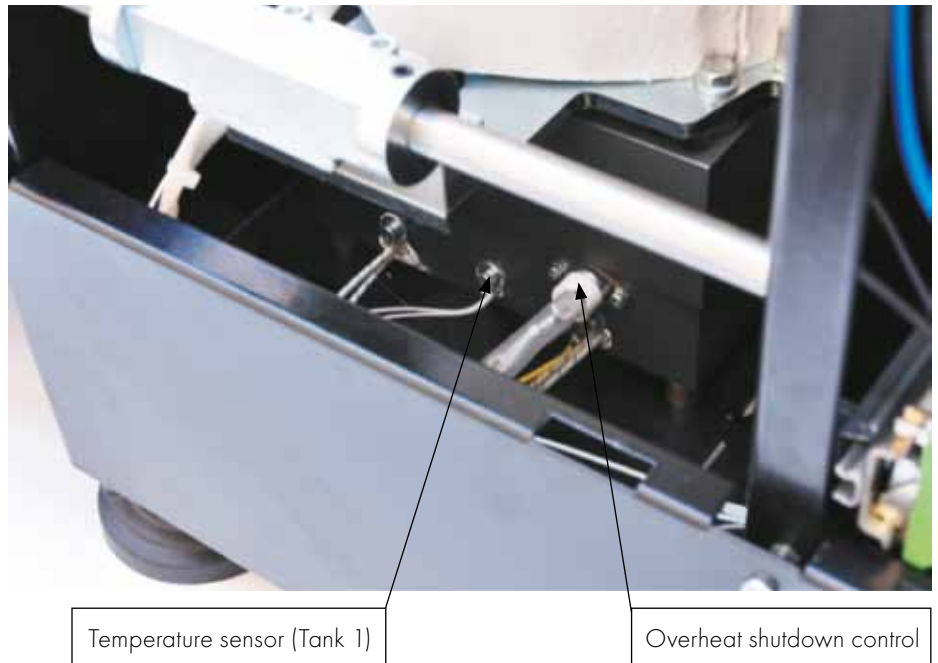


**CAUTION** - electrical voltage!  
Risk of electrical shock.  
Disconnect the power plug before beginning work.

Unscrew cover and open tank cover

Unscrew M4 screw using six-sided screwdriver with a width of 2.5.

Pull out temperature sensor (Tank 1).



Temperature sensor T2 and R are located under the heating cuff on the tank.

### 5.2 Changing the overheat shutdown control



**CAUTION** - electrical voltage!  
Risk of electrical shock.  
Disconnect the power plug before beginning work.

Unscrew cover

Disconnect connection wires

Unscrew M3 connection wires with six-sided screwdriver (SW 2 mm)





## 6. Customer service conditions

### 6.1 Packaging and transport

Transport the Topmelter when the machine is cold. The machine must be secured on a pallet for transport, using the screw-on brackets provided by the manufacturer to prevent slippage. The packaging should be sturdy enough to prevent transport damages.

### 6.2 Warranty

We provide a 12-month warranty (when machine is used in single-shift operations) according to the following conditions and as long as the startup requirements are followed. This excludes wear parts. The warranty period shall begin on the date of delivery, which must be proven by way of the purchase receipt and the invoice, delivery slip or copies thereof.

During the warranty period, we reserve the right to repair defective parts free of charge or to replace them with new parts as long as the damage is due to a faulty design or material flaw. Replaced parts become our property, and any shipping costs or assembly costs as well as travel expenses will be invoiced. The performance of any warranty services will not extend the warranty period.

### 6.3 Manufacturer's address

**KLEBCHEMIE**

M. G. Becker GmbH & Co. KG

Max-Becker-Str. 4

76356 Weingarten

Germany

Phone: +49 7244 62-0

Fax: +49 7244 700-0

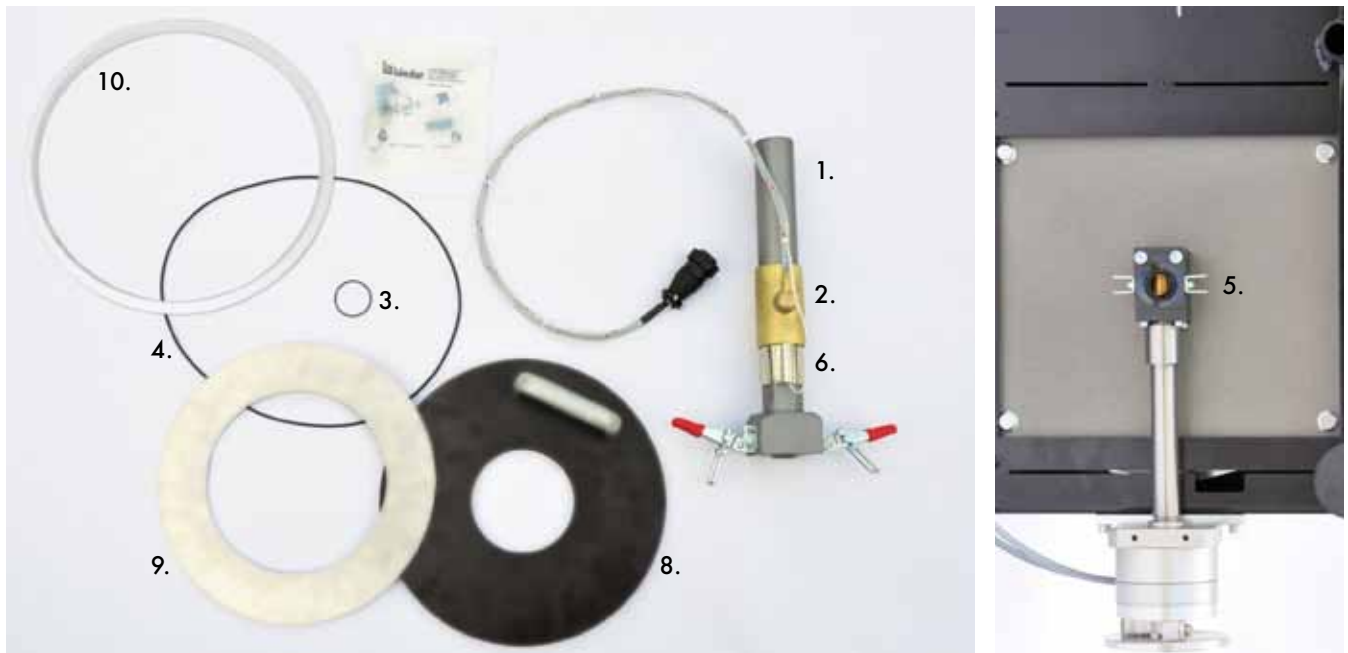
Email: [info@kleiberit.com](mailto:info@kleiberit.com)

**[www.kleiberit.com](http://www.kleiberit.com)**



## 7. Replacement parts/circuit diagram

### 7.1 Replacement parts



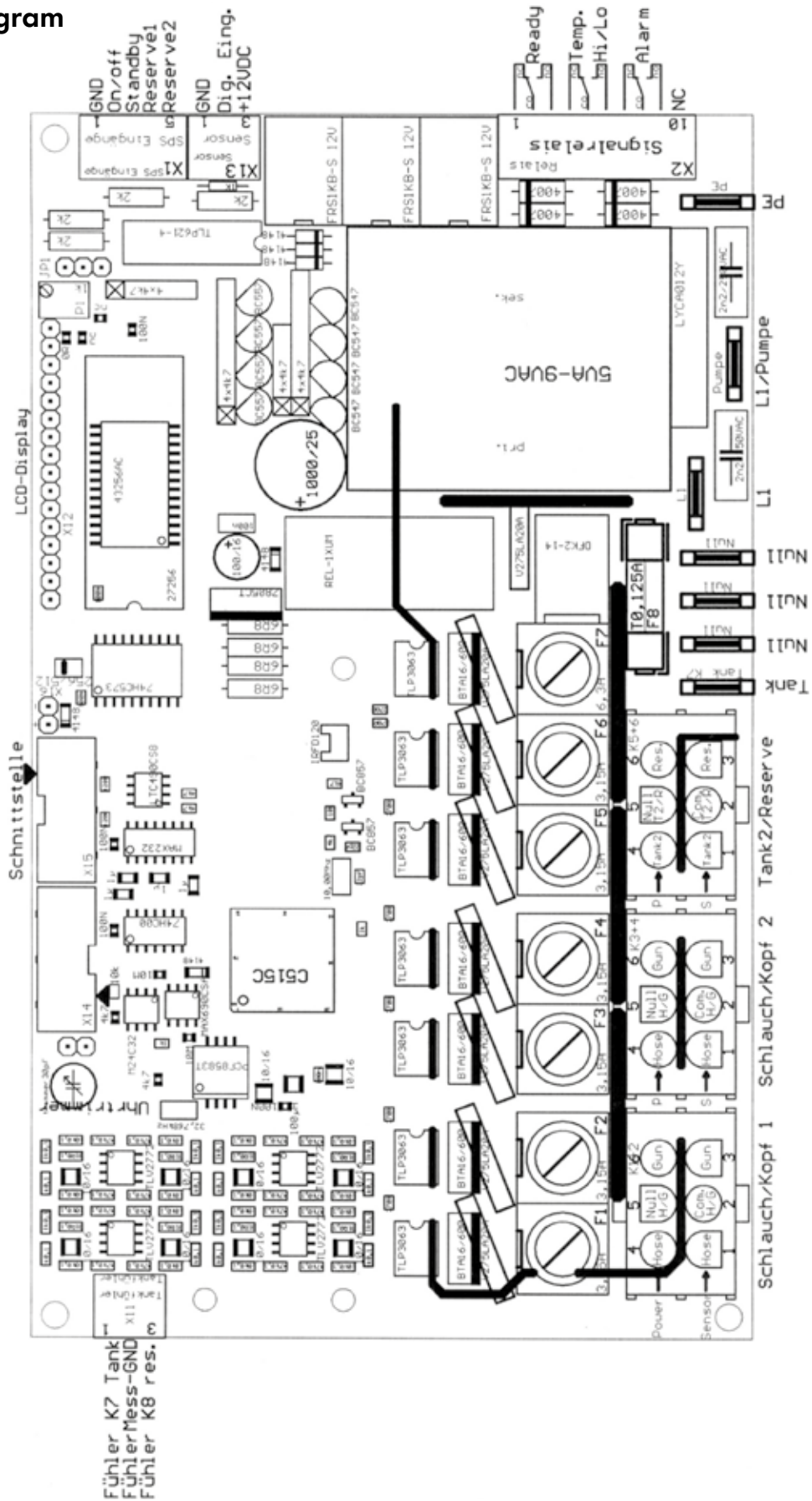
1. Fill pipe teflon coated fill pipe dia. 40 x 300 with mount
2. D 40 x 80-400W/230V heating band for fill pipe with connector
3. O-Ring FPM 24 x 2 (5 per package)
4. O-Ring FPM 80 280, P3000239 280x3
5. Glue dispensing valve Topmelter  
Glue dispensing valve teflon coated complete with spindle dia. 12
6. Sensor Pt 100  
Plug-in resistance thermometer D5  
Tank/fill pipe
7. 7 channel controller
8. Top platen dia. 280
9. Template for cutting pouches dia. 280
10. PTFE ring 280, spacer tank dia. 280





# 7. Replacement parts/circuit diagramm

## 7.2 Circuit diagram



Fühler K7 Tank  
 Fühler Mess-GND  
 Fühler K8 res.