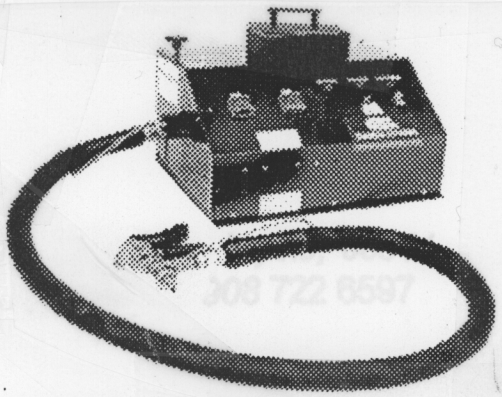
CRL AZTECH MINI HOT MELT BUTYL DISPENSING SYSTEM



CAUTION

It is not recommended that any AZ.TECH Hot Melt Equipment be left on overnight or for any extended period of time without someone in attendance. No matter how reliable this equipment is or has proven to be , over a period of time , any electrical or electronic controls can and will fail. Serious damage to the equipment and possibly to your plant can occur should the equipment overheat. Therefore, please take all necessary precautions to assure the safe operation of this equipment and have a qualified operator in attendance at all times it is in operation.

OVER-TEMPERATURE PROTECTION

All AZ.TECH extruders are equipped with over-temperature controls, both mechanical and electronic. These controls are set for approximately 410 deg.F.(210 deg.C.). The normal operating temperature range for most hot melt materials is between 300 and 375 deg.F.(150 to 190 deg.C.). Should your material require a higher or lower operating temperature, please consult with our service department before using the equipment.

CAUTION: DO NOT REMOVE OR REPLACE THE MACHINE COVER OR TOUCH ANY HEATING ELEMENT WITHOUT FIRST SHUTTING OFF THE MAIN POWER SUPPLY.

DIGITAL PYROMETER

The digital pyrometer, mounted on the control panel cover, provides an accurate direct reading of the temperature of the materials within both the pot and the extruder hose.

A three-position selector switch, located directly below the pyrometer, allows the operator to read either the hose or pot temperature.

PUMP AND DRIVE

The extruder pump is a positive displacement progressive cavity pump located on the left side of the pot. A screw auger is used within the pot to move the material into the mouth of the pump. Since the pump rotates on an eccentric, universal joints are used on both ends of the auger. The universals are coupled to the pump rotor and the drive shaft with shoulder screws. The drive shaft rotates in a factory sealed double ball bearing. A teflon seal protects the bearing from the material within the pot.

The extruder pump is belt driven by a 1/6 h.p. gear motor at 90 rpm when standard gearing is used. The pump is activated by a pump switch located on the top of the control panel.

HAND GUN

The extruder hand gun is made of cast aluminum with a brass stem tip and tip seat. Teflon packing is used to seal the trigger stem. Foamed silicone sleeving on the handle and trigger provides heat protection. The tip adaptor is machined to accept a clamp type heater which maintains the temperature at the gunning tip. The hand gun also has an adjustable trigger stop for more precise control of flow through the gun tip.

BY-PASS VALVE

The flow rate through the gun is maintained by an adjustable by-pass valve on the outlet end of the pump which feeds excess material back into the pot. The by-pass valve is located to the left of the pot. The pressure to the hose is increased by turning the adjusting screw to the right (clockwise) and decreased by turning the screw to the left (counterclockwise). The pump should be operated at the lowest pressure necessary for production requirements. If the flow rate at the lowest by-pass pressure is still too great for production needs, it can be decreased further by adjusting the trigger stop on the extruder hand gun.

OVERTEMPERATURE PROTECTION

The Mini-Max Extruder is equiped with an overtemperature thermostat connected in series with the power relay coil. Power to the heaters and controls will be interupted should the pot overheat.

ATX MINI

Aztech Thermal Extruder

Part #	Description
E5514	Power Relay 240V Clear Plastic
E9118	By-Pass Valve with Knob
E9124	By-Pass Heater 240V
E9124A	By-Pass Heater 110V, 100W, 1x1
E9125	Gun Tip Heater Outlet 240V
E9127	Handgun Complete with Swivel & Adaptor for 5/8" hose
E9138	Hose Adaptor 5/8" Hose x 1/2 Pipe
E9150	Indicator Light red, 220-240V
E9150A	Indicator Light Green, 220-240V
E9150B	Indicator Light Green 110-120V
E9150C	Indicator Light Red, 110-120V
E9154	Pump Switch (same as E9975)
E9158	Hose Plug / Female
E9160	Pot Thermocouple Probe
E9180	Hose & Pot Temperature Control 110V (Dial Cal 3200)
E9180A	Temperature Control, 110-240V with Digital Read Out
E9181	Handle, Pot
E9182	Hose & Pot Temperature control 240V, Digital Or Dial
E9184	Main Fuse (20-AMP)
E9185	Power Relay Socket 220V, 11 Pins
E9186	Quick Connect Plug (11-Pins)
E9187	Hub Gasket
E9188	Bronze Bearing for Hub (2 each per Hub)
E9189	Teflon Seal for Hub
E9190	Thermostat Interlock
E9191	Thermostat Overload
E9192	Hose & Pot SS Relay 15 AMP
E9317	By-Pass Valve Stem With Knob
E9329	Hi Temperture Grease
E9330	Heat Shrink (End Caps), set of 2 each 9"
E9333	Heat Shrink (End Caps), set of 1
E9334	Hi-Temperature Ring Terminals (VACO)
E9335	Hi-Temperature Wire #12
E9503	Fuse Holder
E9544	Heated Hose, 5/8" x 8' 120V
E9544A	Heated hsoe, 5/8" x 8' 240V

ATX MINI

Part #	Description
E9820	High Temperature Electrical Tape (order by ft.)
E9832	Trigger
E9833	Trigger Pin with Nut
E9834	Gripping Plates / Set
E9835	Gripping Plate Spring
E9837	Recoil Spring
E9838	Recoil Plate Assembly
E9839	Power Cord with Switch
E9840	Gun Barrel Complete
E9842-E9847	Gun Nozzles #3(3/16), #4(1/4), #5(5/16), #6(3/8), #7(7/16), #8(1/2")
E9852	Heating Element 120V Pot Heater
E9852A	Heating Element 240V Pot Heater
E9901A	Gear Motor, Mini
E9902	Pump Rotor & Stator
E9903	Augur
E9904A	Universal Front
E9904B	Universal Rear
E9908A	Drive Shaft
E9914	Pump Heater 120V
E9914A	Pump Heater 240V
E9915	Gun Tip Heater 110V
E9935	Digital Pyrometer
E9937	Edge Connector (PC Broard)
E9938	Terminal Block 120V
E9941	Dial Face Plate
E9942	Pump "ON" lights (Red) 240V
E9947	Power Relay 115V
E9948	Power Relay 230V
E9949	Transformer (Triad)
E9950	Ir...
E9950A	[illegible]
E9955	Power Cord (120V)
E9956	Power Cord (220V)
E9557A	Hub with Teflon Seal & Bearings
E9958	Torque Limiter
E9959	Sprocket 1/2" Bore

ATX MINI

Aztech Thermal Extruder

Part #	Description
E9960	Sprocket for Pump (no keyway or screw set)
E9960A	Sprocket 5/8" Keyway
E9960B	Sprocket 1/2"
E9961	#35 Chain
E9961A	#35 Chain Master Links
E9662A	Gear Motor (Replaced E9962)
E9964	Motor Mounting Plate
E9965	Seals, Shaft Motor
E9966	Heater, Pot (Rod) 1/2" x 8"
E9667	Heater, Pot (Rod) 1/2" x 5"
E9968	Temperature Meter
E9969	Motor Circuit 2.5 AMP
E9969A	Motor Circuit Breaker (Motor Reset Fuse)
E9971	Power Relay before 1988
E9971A	Power Relay after 1988 (110V)
E9973	Fuse Holder
E9974	15 AMP Fuse
E9976	Reset Switch (Red)
E9983	Vibro Rubber Insulator (feet for machine)
E9987	Digital Display Temp.Controller (Cal 3200)
E9988	Power On-Off Switch
R2480	Crimps, Hi Temperature Connectors

NOTES ** Orders that include Parts E9125-Gun Tip Heater (240) or E9915-Gun Tip Heater (110)
May also need: E9820-High Temp electric Tape (need 3ft)
E9333-Heat Shrink (end caps)
R2480-Crimps / Hi-Temp Connectors

** Nozzles Included with ATX MINI Equipment: #4 (1/4")
#5 (5/16")
#6 (3/8")

OPERATION

The Aztech Mini can be plugged into any 115 Volt electrical outlet. (It is also available in 220 Volt 50 Hz power supply.) Up to 20 pounds of material in chips or chunks can be placed into the hopper and refilled as required during operation. The desired gunning temperatures for both the gunning hose and the pot are then set on the temperature dials and the material is allowed to heat. Heat up time is approximately 45 minutes to an hour. Gunning is accomplished by activating the pump switch and triggering the extruder gun. Various gun tips and special extruding nozzles are available depending on the application.

STANDARD EQUIPMENT:

The Aztech Mini comes fully equipped and ready to operate. It needs only to be plugged into the specified electrical supply. The standard components included with each unit, unless otherwise requested, are an eight foot extension cord, an eight foot heated gunning hose, a trigger actuated hand gun with a stainless steel swivel coupling and rubber pads for table top placement. The temperature controls are solid state printed circuit boards. A digital temperature readout for the hose and the pot is standard. Special voltages or optional equipment such as gunning nozzles, special dispensing heads and hose requirements must be specified and quoted prior to ordering.

TECHNICAL DATA:

Machine Dimensions	19" Deep × 24" Wide ×16" High
Net Weight	90 lbs.
Shipping Weight	110 lbs.
Power requirements	16 Amps@ 115 Volts - 8 Amps @ 220 Volts.
Construction	Aluminum Pot Steel Base and Working Components.
Motor and Drive	1/6 hp. Gear Motor
Pump	Positive Displacement Pump with an adjustable Pressure Range to 600 psi.
Pot Opening Dimensions	4 1/2" × 9" x 11 1/2" Deep
Pot Capacity	2 Gallons (Approx. 20 lbs.)
Temperature Range	200 to 400 °F (95 to 205 °C)
Viscosity Range	To 500,000 Centipoise
Flow Capacity	Approx. 1 lb. per Minute at Above Viscosity. Can be Changed to suit application.
Start Up Time	Approx. 45 Min. to 1 Hour

PARTS LIST

MINI

PART NO.	DESCRIPTION
E5514	POWER RELAY 240V
E9118	BYPASS VALVE WITH KNOB
E9124	BYPASS HEATER 240V
E9124B	BYPASS HEATER 110V 100W 1X1
E9138	HOSE ADAPTOR 5/8" HOSE X 1/2" PIPE
E9150	INDICATOR LIGHT RED, 220-240V
E9150A	INDICATOR LIGHT GREEN, 220-240V
E9150B	INDICATOR LIGHT GREEN, 110-120V
E9150C	INDICATOR LIGHT RED, 110-120V
E9154	PUMP SWITCH
E9154A	POWER ON/OFF SWITCH
E9158	HOSE PLUG/FEMALE
E9160	POT THERMOCOUPLE PROBE
E9180	HOSE & POT TEMP CONTROL 110V, DIAL TYPE
E9181	HANDLE, POT
E9182	HOSE & POT TEMP CONTROL 240V, DIAL TYPE
E9184	MAIN FUSE 20 AMP
E9185	POWER RELAY SOCKET 220V, 11 PINS
E9186	QUICK CONNECT PLUG 11 PINS
E9190	THERMOSTAT INTERLOCK
E9191	THERMOSTAT OVERLOAD
E9192	HOSE & POT SS RELAY 15 AMP
E9317	BY-PASS VALVE STEM W/KNOB
E9544	HEATED HOSE, 5/8" X 8' 120V
E9544A	HEATED HOSE, 5/8" X 8' 240V
E9852A	POT HEATER 240V (FOUR PER MACHINE)
E9852C	POT HEATER 120V (ONE PER MACHINE)
E9901A	GEAR MOTOR, MINI
E9902	PUMP ROTOR AND STATOR
E9903	AUGER
E9904A	UNIVERSAL FRONT
E9904B	UNIVERSAL REAR
E9908A	DRIVE SHAFT
E9914	PUMP HEATER 120V
E9914A	PUMP HEATER 240V
E9938	TERMINAL BLOCK 120V

PARTS LIST

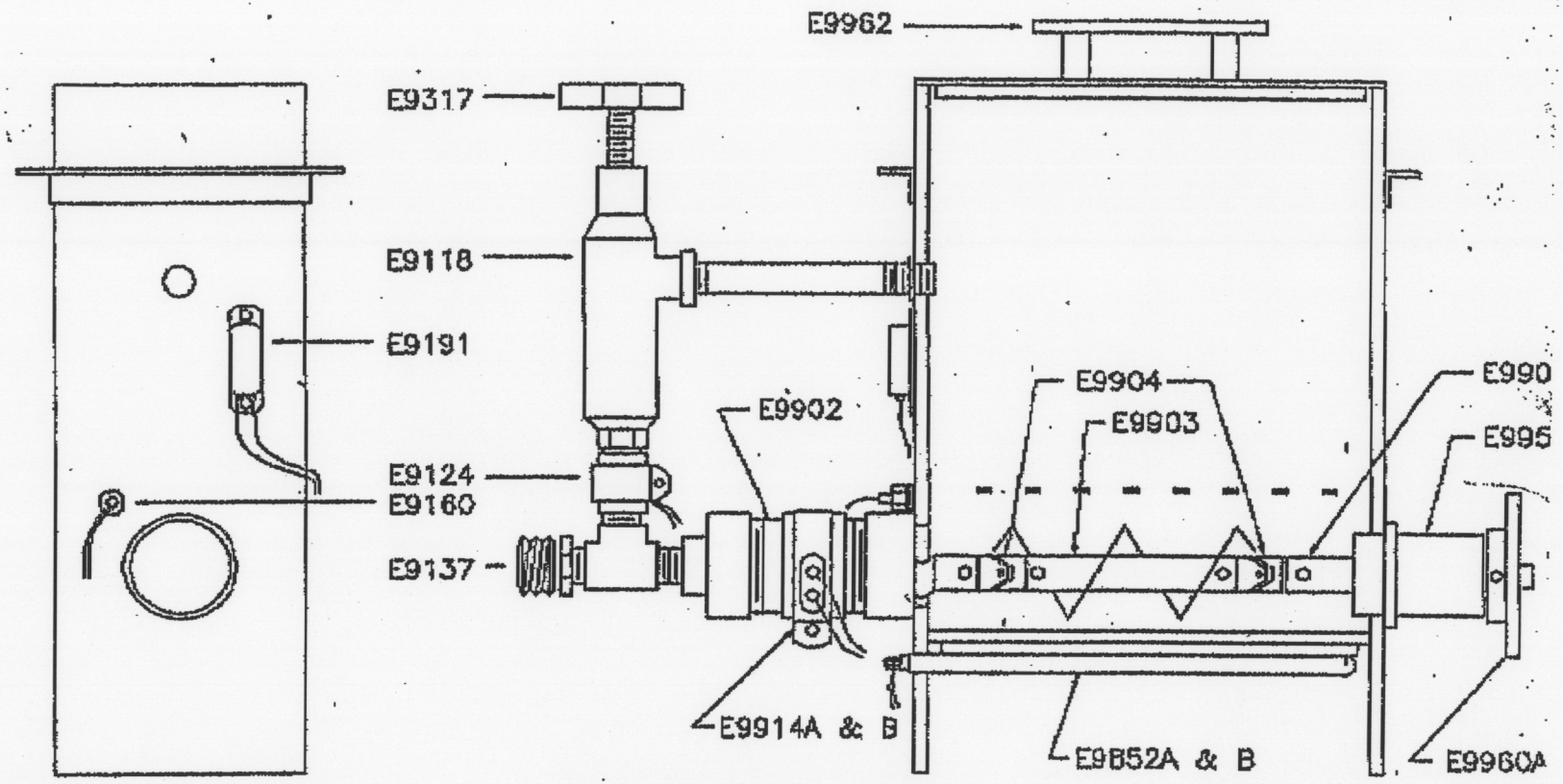
MINI

PART NO.	DESCRIPTION
E9125	* GUN TIP HEATER OUTLET 240V
E9127	HANDGUN COMPL. W/SWIVEL & ADAPTOR FOR 5/8" HOSE
E9180A	TEMP CONTROL , 110-240V WITH DIDITAL READOUT
E9187	HUB GASKET
E9188	BRONZE BEARING FOR HUB (2 EACH PER HUB)
E9189	TEFLON SEAL FOR HUB
E9329	HI TEMP GREASE
E9330	HEAT SHRINK (END CAPS) - SET OF 2
E9333	HEAT SHRINK (END CAP) - SET OF ONE
E9334	HI TEMP RING TERMINALS (VACO)
E9335	HI TEMP WIRE #12
E9503	FUSE HOLDER
E9820	HIGH TEMP ELECTRICAL TAPE - ORDER BY THE FOOT
E9833	HEAT SHRINK (END CAPS) - *SEE BOOK NOTES*
E9915	* GUN TIP HEATER/MINI 110V-* SEE BOOK NOTES *
E9955	POWER CORD 120V
E9956	POWER CORD 220V EXPORT
E9957A	HUB WITH TEFLON SEAL & BEARINGS
E9960	SPROCKET (35B30 X 1/2" FOR PUMP)
E9960A	SPROCKET (35B30 X 5/8" FOR MOTOR)
E9960B	SPROCKET (35B24 X 1/2" FOR 50 HZ MACHINE)
E9961	CHAIN #35
E9969	MOTOR RESET SWITCH 2.5 AMP
E9971A	POWER RELAY 110V (AFTER 880476)
E9976	RESET SWITCH
R2480	CRIMPS/HI-TEM CONNECTORS

*E9125/E9915 WHEN ORDERING SEE IF THE FOLLOWING IS NEED:
E9820-HIGH TEMP ELECTRIC TAPE (NEED 3 FEET)
E9333-HEAT SHIRNK (END CAP)
R2480-CRIMPS/HI-TEMP CONNECTORS

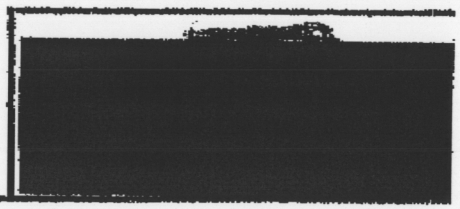
*NOTE: PRICES SUBJECT TO CHANGE WITHOUT NOTICE

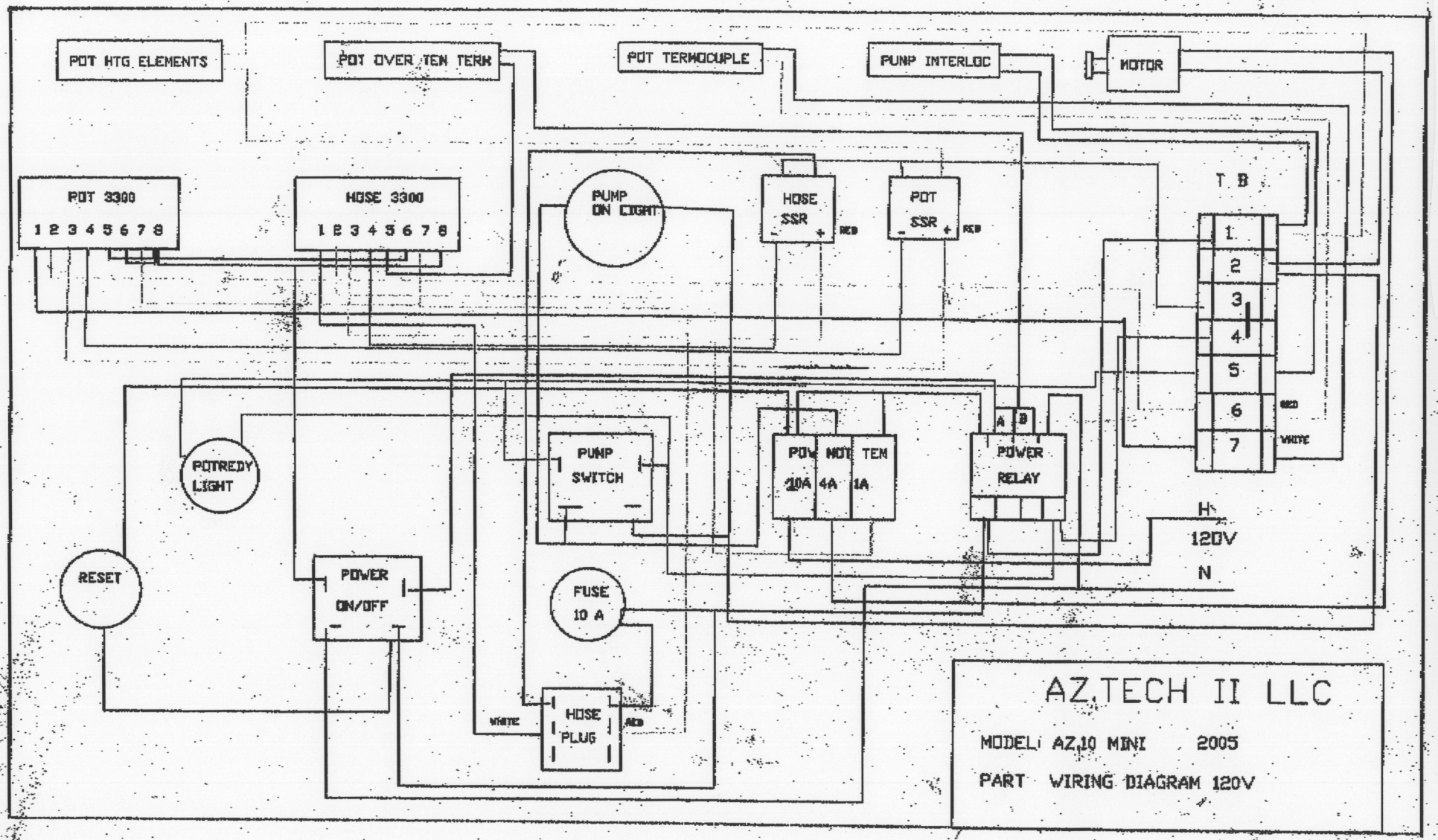
REVISED:



E9118 By—Pass Valve
E9124 By—Pass Heater
E9137 Hose Adaptor
E9160 Thermocouple Probe
E9191 Over Temp. Thermostat
E9317 By—Pass Handle & Stem
E9902 Pump Rotor/Stator (Set)
E9903 Auger
E9904 Universal (Mini)

E9914A Pump Heater 120V
E9914B Pump Heater 220V
E9852A Pot Heater 120V
E9852B Pot Heater 220V
E9908A Drive Shaft (Mini)
E9957A Hub (Mini)
E9960A Sprocket (35B30 for 60Hz)
E9960B Sprocket (35B24 for 50Hz)
E9962 Pot Cover Handle




POT HTG ELEMENTS
POT OVER TEN TERM
POT THERMOCUPLE
PUMP INTERLOC
MOTOR
POT 3300
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HOSE 3300
1 2 3 4 5 6 7 8
PUMP ON LIGHT
HOSE SSR
POT SSR
RED
T. B
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7
RED
WHITE
POTREDY LIGHT
PUMP SWITCH
POW 20A
HOT 4A
TEM 1A
A
B
POWER RELAY
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120V
N
RESET
POWER ON/OFF
FUSE 10 A
WHITE
HOSE PLUG
RED
AZ TECH II LLC
MODEL: AZ 10 MINI 2005
PART WIRING DIAGRAM 120V