



# OPERATIONS MANUAL

ISSUED: JANUARY 2011



**IMPORTANT:** Read and understand the Operations Manual before operating the EconoDot®.

Part No.: ED1



**GlueDots**<sup>®</sup>  
Adhesive Products

5515 S. WESTRIDGE DR. • NEW BERLIN, WI 53151  
888.688.7131 • [WWW.GLUEDOTS.COM](http://WWW.GLUEDOTS.COM)

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**INTRODUCTION**

The EconoDot® is an economical bench-top machine exclusively designed to dispense Glue Dots® Adhesive Products in rolls of up to 8,000 adhesive patterns. This manual shows the basic operation of the EconoDot including set up, loading and operation.

**SAFETY**

For your safety it is important to read and understand this Operations Manual before using the EconoDot. It is important to keep hands, hair, clothing, jewelry and other loose objects away from any moving parts during operation of this machine.

The EconoDot is designed to exclusively dispense patented Glue Dots® Adhesive Products on registered liner. Operating this machine outside of its intended nature will result in poor results, damage to the machine or compromised operator safety. Glue Dots International will not be held liable for any damage to products or persons resulting from improper use of the EconoDot.

**If you have any safety related questions, please call 888-688-7131.**

**IMPORTANT:** Only persons who have read this Operations Manual and who are familiar with the proper use of the EconoDot should operate this machine.

**IMPORTANT:** All electrical work performed on the EconoDot should be performed by a licensed electrician or trained person supervised by a licensed electrician.

**IMPORTANT:** Draw-in or squeezing can occur between the motor-driven and clamp rollers. Reference the associated label shown here and on the shroud. (See the components diagram Fig 1 on page 3)



**SPECIFICATIONS**

<b>Materials:</b>	Steel, Aluminum	<b>Cycles:</b>	1 adhesive pattern per second
<b>Dimensions:</b>	18.5" L x 10.5" H x 7.0" D	<b>Capacity:</b>	Up to an 8,000-count roll on registered liner; Maximum 9" roll diameter
<b>Weight:</b>	10 lbs	<b>Temp:</b>	Min 50 ° F; Max 122 ° F
<b>Noise:</b>	45db		
<b>Power:</b>	100-240VAC		
	50-60Hz		
	0.5A		
	24VDC		



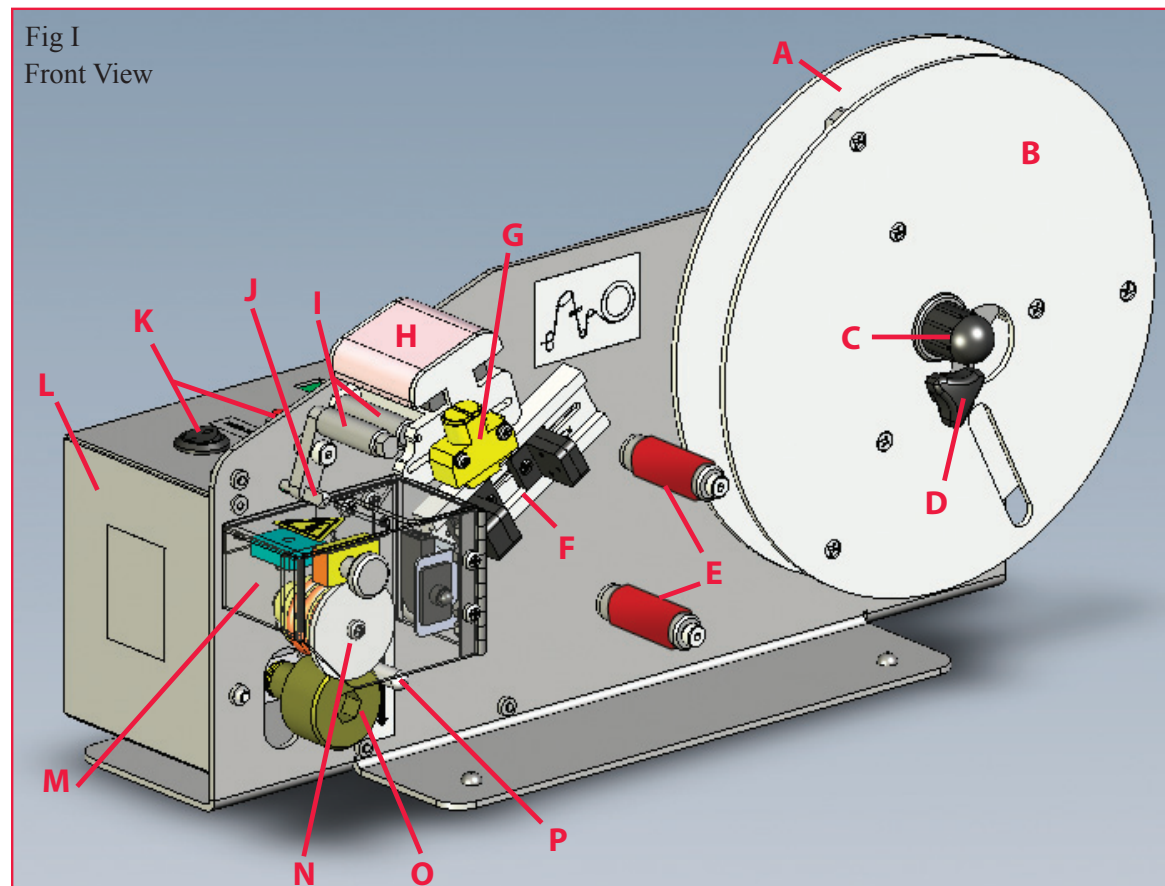
## COMPONENTS

The EconoDot comes equipped with:

- The main unit
- Photo sensing eye
- Supply reel plate and fastener
- Electrical cord
- International plug package
- Operations manual

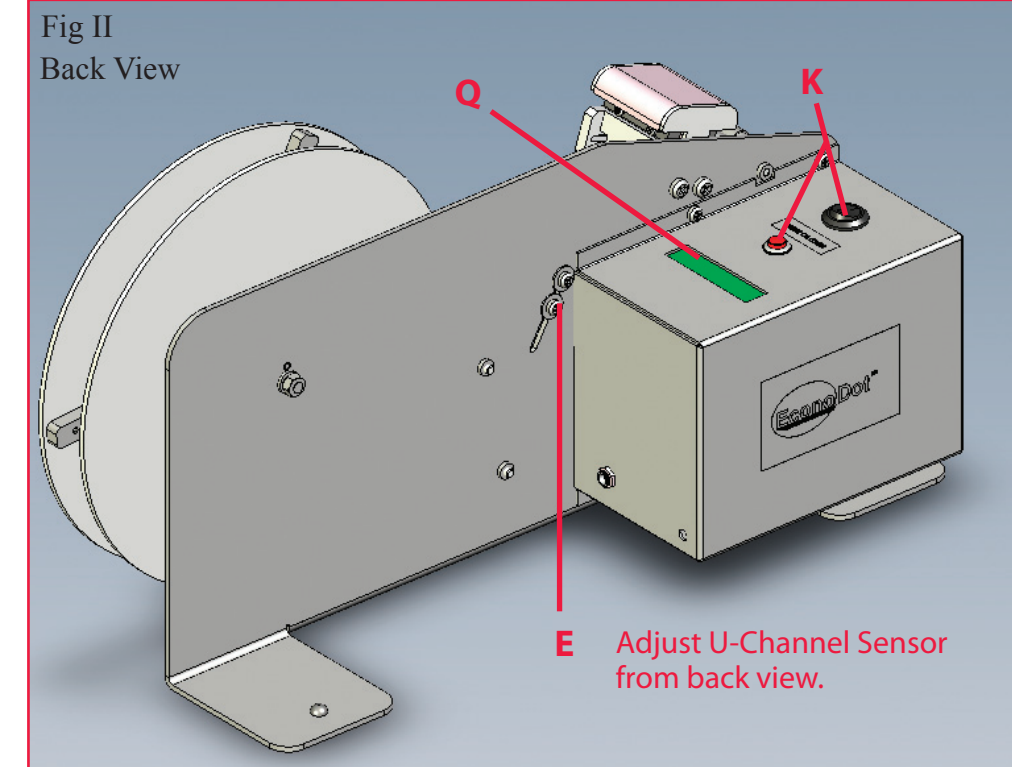
In the event of missing or damaged parts, please contact a Glue Dots International Account Specialist at 888-688-7131.

- A: Supply Reel: Holds up to 9" diameter roll of Glue Dots® products.  
 B: Supply Reel Plate with pads: Secures the Glue Dots® roll onto the supply reel.  
*For 3/4" wide rolls, place the supply reel with pads facing inward. For 1" wide rolls, place the supply reel with pads facing outward.*  
 C: Supply Reel Spindle: Loosens and tightens supply reel tension.  
 D: Supply Reel Clamp Knob: Holds the supply reel plate in place after threading.  
 E: Liner Threading Rollers: Guides the liner from the supply reel to the nose plate.  
 F: Adjustable U-Channel Sensor: Detects the registration marks on the liner. Adjustable for various spaced adhesive patterns. Adjust from the back. (See Fig II on page 4.)



## COMPONENTS, CONT.

- G: Adjustable Photo Sensing Eye: When your hand or the product to which you're applying the Glue Dots® covers then uncovers the photo sensing eye's beam, it signals the advancement of the next adhesive pattern. **IMPORTANT:** The photo sensing eye's beam must be covered then uncovered to ensure the advancement of the adhesive patterns.
- H: Nose Plate: Adhesive application point.
- I: Peeler Rollers: Catch and remove missed adhesive patterns so they don't get caught up in the motor-driven and clamp rollers. **IMPORTANT:** Remove missed adhesive patterns from the peeler rollers regularly so motor continues to turn with ease.
- J: Peeler Roller Separation Lever: Pushing down on the lever separates the two peeler rollers.
- K: Power and Reset Buttons: Power button powers the machine on and off. The reset button resets the pattern counter (Pattern counter resets automatically after 2.5 million patterns used).
- L: Control Box: Houses the electrical and motor components.
- M: Shroud with hinged door: Protective guard for pinch points between the motor driven roller and clamp roller. Accessible for threading liner and for cleaning purposes. (Shroud door must be closed to operate machine)
- N: Motor-Driven Roller: Pulls the spent liner through.
- O: Clamp Roller: Keeps the liner against the motor-driven roller.
- P: Spring-Loaded Lever: Creates space between the motor-driven and clamp rollers when depressed for threading purposes.
- Q: Pattern-Counter Window: Displays the number of adhesive patterns used. (See Fig II below.)



## OPERATION

The EconoDot is designed to automatically dispense Glue Dots® or Glue Lines®, one at a time. The EconoDot can dispense stock 1/4", 3/8" and 1/2" diameter Glue Dots® in all standard tack levels and profiles. It can also dispense 1" Glue Lines® and other custom products which fall within the registration marks. No programming is required with the EconoDot.

**The EconoDot is not intended to apply other adhesive types and should be operated indoors.**

**IMPORTANT:** Altering the EconoDot and its controls from its original manufactured state, nullifies its CE standards compatibility.

**IMPORTANT:** Before starting any job, it is important you test various Glue Dots® to determine the proper adhesive pattern, size, tack level and profile. Product samples for testing can be obtained by calling a Glue Dots International Account Specialist at 888-688-7131.

**TO OPERATE THE ECONODOT:**

- 1) Plug the electrical cord into the back of the machine and then into a wall outlet.
- 2) Load a roll of Glue Dots® products and thread the liner so a single adhesive pattern comes to rest on the nose plate. (See loading illustration Fig IV on page 6.)
- 3) Turn on the power using the power button located on the top of the control box.
- 4) Press the item to be adhered firmly against the adhesive pattern resting on the nose plate, peeling the item off the liner towards the supply reel. (See Fig III below.)

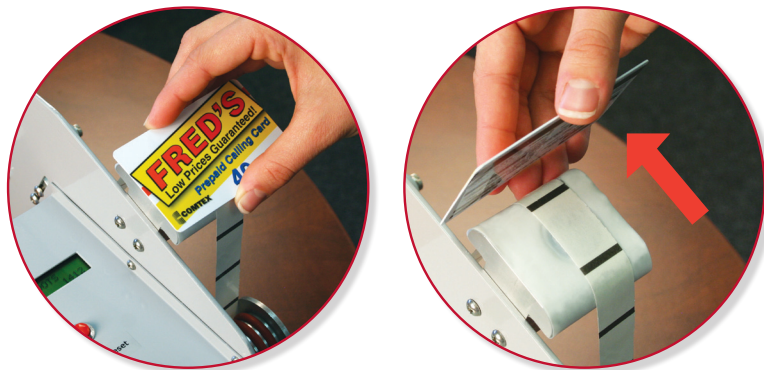
**IMPORTANT:** Lifting an adhesive pattern directly up off the liner or in a direction away from the supply reel may result in pulling excess liner from the supply reel or tearing of the liner. (See Proper Application Figure III below.) Avoid touching Glue Dots® Adhesives as dust and oils will compromise the bond.

- 5) When the item to be adhered is pressed to the nose plate and covers the beam on the photo sensing eye a signal is sent to the machine that the adhesive pattern is being removed. Once the item is removed from the nose plate, uncovering the beam, the motor automatically advances the next adhesive pattern.

**IMPORTANT:** The photo sensing eye's beam must be covered then uncovered to ensure the advancement of the Glue Dots® Adhesives.

- 6) Repeat application instructions.
- 7) The EconoDot has a built-in counter that displays the number of adhesive patterns used. To reset the counter push the reset button located on top of the control box and hold for 2 seconds.

Fig III  
Proper Application



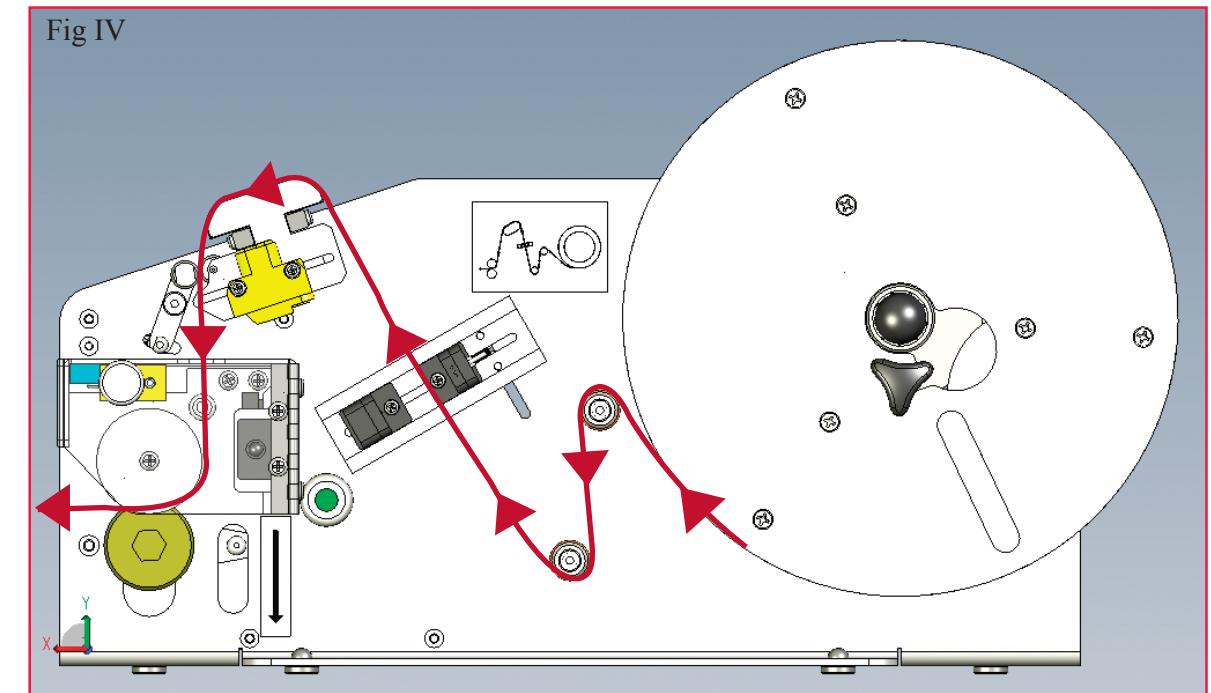
For more information about Glue Dots® Brand Adhesive Products, visit [www.gluedots.com](http://www.gluedots.com) or call 888-688-7131

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U.S. Patent No.'s 5,935,670; 6,319,442; 6,640,864; 6,686,016. Other U.S. and Foreign Patents Pending. © 2011 Glue Dots® International.

## LOADING INSTRUCTIONS

**To load a roll of Glue Dots®**

- 1) Loosen supply reel clamp knob located in front of the supply reel plate. Remove the plate by turning it clockwise and pulling it straight off the spindle.
- 2) Load the Glue Dots® roll onto the supply reel, ensuring the liner runs in a clockwise direction. For 3/4" wide rolls, place the supply reel with pads facing inward. For 1" wide rolls, place the supply reel with pads facing outward.
- 3) Replace the supply reel plate. Tighten the supply reel clamp knob.
- 4) Pull the liner over the first roller, under the second roller, up through the U-channel sensor and over the nose plate.
- 5) Press down on the peeler roller separation lever located to the left and beneath the peeler rollers in order to create space between the two rollers. Thread the liner between the separated rollers.
- 6) Open the hinged door located on the side of the shroud and continue to thread the liner downward through the slit on the top of the shroud.
- 7) Press down on the spring-loaded lever located to the right of the motor-driven and clamp rollers in order to create space between the two rollers. Thread the liner between the two rollers. Release the spring-loaded lever so the motor-driven and clamp rollers sandwich the liner. Close the door on the shroud. (Shroud door must be closed to operate the machine.)
- 8) Pull on the liner until a single adhesive pattern comes to rest on the nose plate.
- 9) Spent liner should trail into a trash receptacle.

**EconoDot Loading Diagram:**

For more information about Glue Dots® Brand Adhesive Products, visit [www.gluedots.com](http://www.gluedots.com) or call 888-688-7131

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**MAINTENANCE / REPAIRS**

All maintenance and repairs should be performed by a technical staff member such as a technician, electrician, maintenance personnel or equivalent. Maintenance performed by unqualified persons nullifies the EconoDot warranty. It is important to keep the sensors free from debris. Malfunctions not addressed in the troubleshooting section of this manual can be directed to the Industrial Engineering staff at Glue Dots International.

**TROUBLESHOOTING**

The following chart outlines problems that could arise while using the EconoDot. Malfunctions experienced outside of the issues outlined below will need to be addressed by an experienced, professional technician or electrician.

<b>Problem</b>	<b>Cause</b>	<b>Solution</b>
Motor doesn't turn.	Too much tension on the Supply Reel Spindle; Adhesive patterns built up on Peeler Rollers.	Adjust tension accordingly.  Peel adhesive patterns off the Peeler Rollers.
Liner advances more than one adhesive pattern at a time.	Dirty registration sensor.	Clean.
When the liner advances, the adhesive pattern is not centered on the nose plate.	Improper registration.	Loosen the screws behind the sensor and adjust accordingly.



**LIMITED WARRANTY**

**Limited Warranty:** Glue Dots International ("Glue Dots") warrants the EconoDot™ (the "Product"), when shipped in its original container and used in accordance with the Product specifications and documentation, will be free from material defects in material and workmanship for a period of 90 days from the date of purchase by the original customer. Glue Dots agrees that within this time period, it will, at its option and sole discretion, either repair the defect or replace the defective Product or part thereof with a new or remanufactured equivalent at no charge to the buyer for parts and/or labor.

**Warranty Exclusion:** This warranty does not apply in cases of damage in transit, negligence, abuse, abnormal usage, accidents, normal wear and tear, damage due to natural or environmental elements, mishandling, failure to follow Glue Dots' instructions, improper installation, unauthorized repair, modification or maintenance. This warranty does not apply to defects or variations in the appearance of the Product or portion thereof or to any Product the exterior of which has been damaged or defaced, which has been subjected to improper voltage or other misuse, abnormal service or handling, or which has been altered or modified in design or construction.

**Remedy:** Glue Dots International's sole and exclusive obligation under this warranty (and Buyer's sole and exclusive remedy) shall be, upon prompt written notice by Buyer during the Warranty period of any warranty breach, to either, at Glue Dots' option, repair or replace without charge, F.O.B. Buyer's Location, any defective Product or part thereof expressly warranted herein by Glue Dots against defects and found by Glue Dots to be defective and covered by this warranty, or credit Buyer for the purchase price paid for such Product. Glue Dots shall not be liable to Buyer, or to anyone claiming under Buyer, for any other obligations or liabilities including, but not limited to, obligations or liabilities arising out of breach of contract or warranty, negligence or other tort or any theory of strict liability, with respect to the Products or Glue Dots' acts or omissions or otherwise. This warranty covers only replacement or repair of defective Product or parts thereof at Glue Dots' main facility.

**Notice of any warranty claim or request for warranty service should be sent to:**  
**Glue Dots International**  
**5515 South Westridge Drive**  
**New Berlin, WI 53151**

**Limitation on Damages:** IN NO EVENT SHALL GLUE DOTS INTERNATIONAL BE LIABLE FOR INCIDENTAL, COMPENSATORY, PUNITIVE, CONSEQUENTIAL, INDIRECT, SPECIAL OR OTHER DAMAGES. GLUE DOTS' AGGREGATE LIABILITY WITH RESPECT TO A DEFECTIVE PRODUCT SHALL BE LIMITED TO MONIES PAID TO GLUE DOTS FOR THAT DEFECTIVE PRODUCT. GLUE DOTS WILL NOT REIMBURSE BUYER FOR ANY EXPENSES INCURRED BY BUYER IN REPAIRING, CORRECTING OR REPLACING ANY DEFECTIVE PRODUCTS, EXCEPT FOR THOSE INCURRED WITH GLUE DOTS' PRIOR WRITTEN PERMISSION. ANY ASSISTANCE GLUE DOTS PROVIDES TO OR PROCURES FOR BUYER OUTSIDE THE TERMS, LIMITATIONS OR EXCLUSIONS OF THIS WARRANTY WILL NOT CONSTITUTE A WAIVER OF TERMS, LIMITATIONS OR EXCLUSIONS OF THIS LIMITED WARRANTY, NOR WILL SUCH ASSISTANCE EXTEND OR REVIVE THE WARRANTY.



**Disclaimer of Other Warranties:** GLUE DOTS AND BUYER AGREE THAT, TO THE EXTENT PERMITTED BY LAW, THE EXPRESS WARRANTIES ABOVE ARE EXCLUSIVE AND IN LIEU OF ALL OTHER WARRANTIES. GLUE DOTS HEREBY DISCLAIMS AND EXCLUDES ALL OTHER WARRANTIES (INCLUDING WITHOUT LIMITATION ANY IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE). ANY ORAL OR WRITTEN DESCRIPTION OF THE PRODUCT IS FOR THE SOLE PURPOSE OF IDENTIFYING THE PRODUCT AND SHALL NOT BE CONSTRUED AS AN EXPRESS WARRANTY. PRIOR TO USING OR PERMITTING THE USE OF THE PRODUCT, BUYER SHALL DETERMINE THE SUITABILITY AND FITNESS OF THE PRODUCT FOR THE INTENDED USE AND BUYER SHALL ASSUME ALL RISK AND LIABILITY WHATSOEVER IN CONNECTION THEREWITH. BUYER AGREES THAT GLUE DOTS HAS NO POST-SALE DUTY TO WARN BUYER OR ANY OTHER PARTY ABOUT ANY MATTER.

**Miscellaneous:** This Warranty shall not create a joint venture, partnership or principal and agent relationship between the parties. This Warranty may not be modified, amended or supplemented except by mutual written agreement by Glue Dots International. Either party may waive in writing any term or condition contained in this Warranty and intended to be for its benefit; provided, however, that no waiver by a party, whether by conduct or otherwise, in any one or more instances, shall be deemed or construed as a further or continuing waiver of any such term or condition. This Warranty represents the entire agreement of the parties with respect to the subject matter hereof and no provision or document of any kind shall be included in or form a part of this Warranty except by mutual, written consent of Glue Dots. The provisions contained in this Warranty are severable. If any provision of this Warranty is determined for any reason to be invalid, illegal or unenforceable, such determination shall not affect the validity, legality or enforceability of the remaining provisions, and the rights and obligations of the parties shall be construed and enforced as though this Warranty did not contain such invalid, illegal or unenforceable provision. This Warranty shall be governed by and construed in accordance with the internal laws of the State of Wisconsin without reference to any rule or provision thereof which would cause the application of the law of any other jurisdiction. Buyer agrees that any lawsuit, mediation, arbitration or other legal action taken against Glue Dots International to enforce this Warranty must be brought in a competent court located in Wisconsin.

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