Operating Instruction for the
GLUING MACHINE MODEL SENATOR
TOP SIDE GLUER

a) General
The machine will be shipped completely assembled. Once having unpacked the machine, any damage during shipping must be reported to the manufacturers without delay. Claims that are not reported immediately will be rejected.

b) Setting up the machine
The machine must be on a level surface. Leveling must be performed with a level that shall be put on the gluing cylinder and on the cast lateral parts.
The final leveling is achieved by regulating the foot screws (picture 1 -3).

IMPORTANT: Before turning the machine on, always be sure that the two glue rollers are not too close. Leave a small space (large enough to slip a piece of paper between the rollers) before turning the machine on! If the rollers are too close you may damage the rollers and/or gears.

c) Electric parts and speed control
The On/Off switch is on the back of the machine.
The speed adjustment is performed by pressing the up or down arrow on the Sieman's inverter (item 3 on picture 1).

d) Getting the machine ready for operation to glue paper or other thin materials
The filled glue box (picture 1 - 4) must be put into the frame over the gluing cylinders. (If this machine also includes the Recirculating Pump option, you can disregard this section and remove the frame that holds the glue box.) The pick off point assembly (picture 1 - 5) must be aligned on the system (picture 5-27), carefully placed against the gluing cylinder of 100 m/m. Any damage with the points must be avoided while cleaning the same, as such damage would cause problems with the glued sheet delivery.
A uniform clearance between the fingers and points over the whole width of the sheet to be glued is essential. Next, be sure that the lateral plates are in place at the end of the glue rollers and placed snugly against the rollers. The lateral glue plates (picture 6) limit the glue at the ends of the cylinders. Clean contact surfaces of the two glue plates are essential for good sealing. A *small* amount of petroleum jelly can help with the seal.

When gluing paper the eccentric rod (picture 5-24) must be placed so that the paper or material to be glued is pressed close to the large gluing cylinder (picture 5-26) by actuating the knob (picture 3-11) and the small lever on the eccentric rod to make sure that the leading and trailing ends of the sheet will be glued.

Important: ***The two glue rollers must not collide hard.***
This is of highest importance to avoid damage!

e) Getting the machine ready for operation to glue thick materials

This section is provided for gluing thicker materials. Assembly and disassembly are possible with few manipulations within shortest time. The adjustment must be performed without glue and when the machine is not running. When gluing paper, it is to be recommended, not to mount the contact pressure roller section (picture 8 -1). When gluing thicker materials like cardboard the feeding rollers (picture 5 22+23) must be taken out.

The contact pressure roller section (picture 8 -1) rests laterally on two adjustable knurled screws (picture 8 - 3) and is fixed from above by means of two counter knobs (picture 8 -4). On the driving side, there is a rocking lever with toothed wheel of 24 teeth (picture 8 - 5), which is engaged into the 52 teeth comprising toothed wheel of the conveying roller (picture 8 -8). In addition, the traction spring (picture 8 -6) on the rocking lever must be guided to the traction spring holder (picture 8 -7) for clamping firmly the rocking lever and engaging into the toothed wheel from the lower side.

For facilitating the assembly two slots (picture 8 -2) are provided laterally. These slots are arranged in such a manner that, when introducing the contact pressure roller section, the right is introduced between the knurled wheel (picture 8 -3) and the counter knob (picture 8 -4) in a inclined position. Thereafter, a turn is made forward around the spot of assembly and the contact pressure roller section is pushed in from the driving side as previously described. A round lip on the knurled wheel (picture 8 - 3) and a correspondingly round recess beneath the contact pressure roller section at the slots makes sure a good seating of the gluing roller.

Cardboard to be glued is then put between the gluing roller and the contact pressure roller section. The clearance can be set by means of the two knurled wheels. Thereafter, the contact pressure roller section must be fixed by means of the counter knobs. The adjustment must be performed carefully and thereafter corrected, if this becomes necessary.

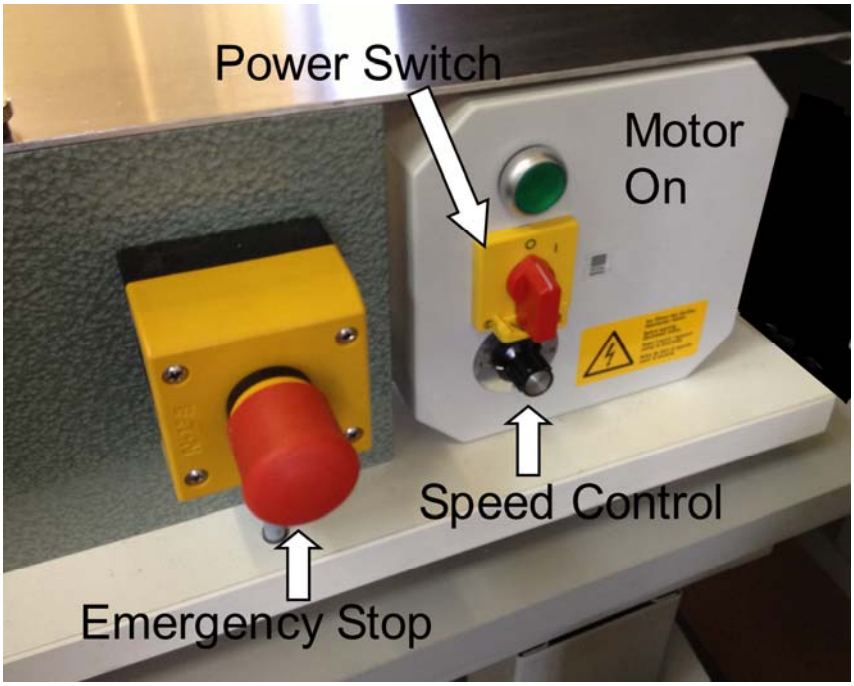
f) Powering On

At this point you can turn the machine on (see photo on page 4).and place adhesive between the glue rollers. Place adhesive between the two glue rollers so that it flows throughout the rollers. You can adjust the glue film by turning the glue control adjustment knob (pictures 2-10 and 7-10). If there is a leakage of adhesive at the lateral glue plates at the end of the rollers, increase the pressure on those plates by turning the adjustment knob against the lateral plates (#41). The speed of the motor can be changed by turning the speed control knob on the inverter.

SENATOR ELECTRIC GLUER PARTS LIST

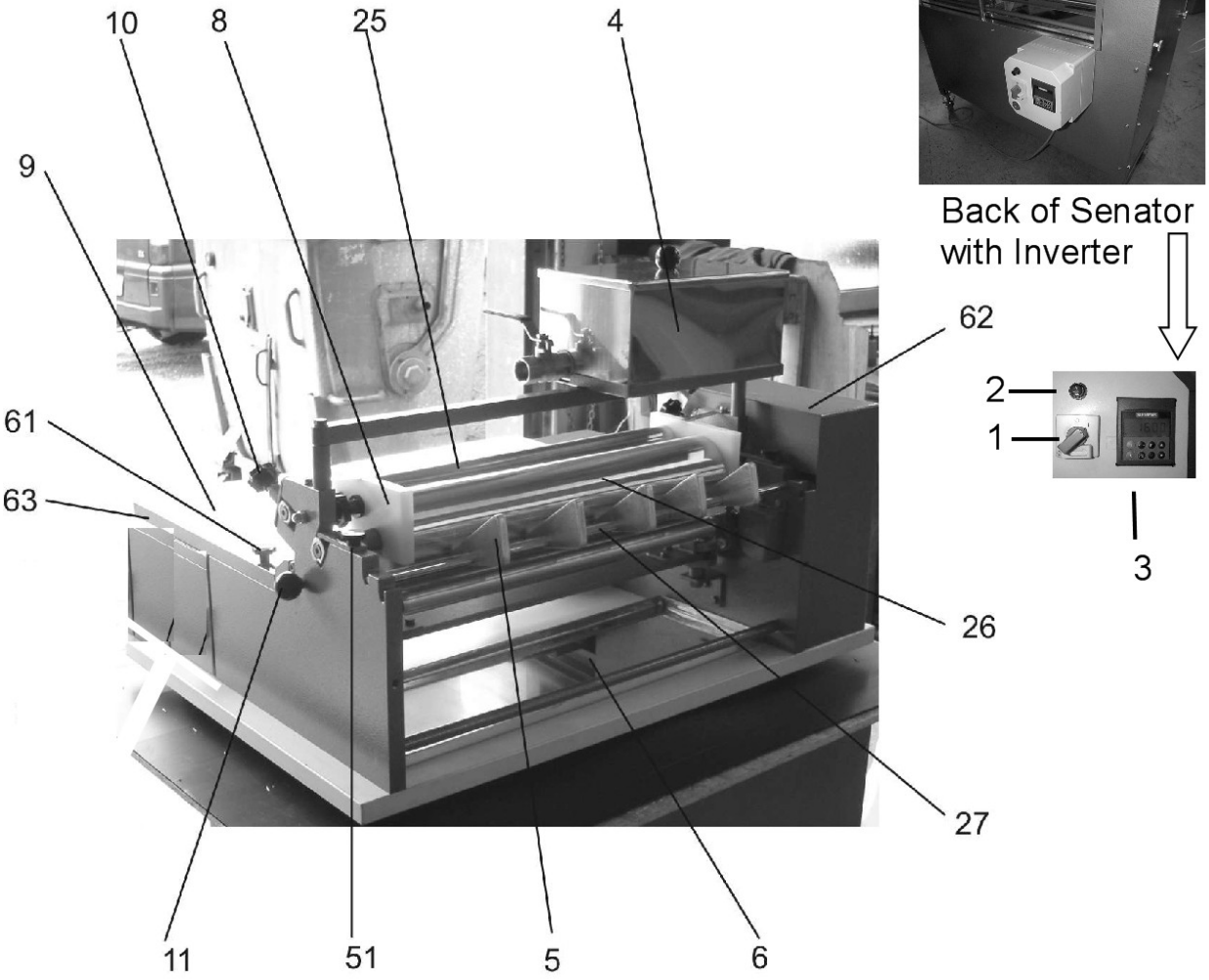
PART NO.	DESCRIPTION
1	On/Off Switch
2	Pilot Lamp
3	Speed Control / Inverter
4	Glue Pot
5	Finger & Point Assembly With Screw
6	Glue Tray
7	Pick Off Point
8	Lateral Glue Plates
9	Feed Table
10	Glue Control Adjustment Screw With Knob
11	Pressure Feed Adjustment Knob
12	Holding For The Bras Finger Rod
13	Bushing For The Glue Application Roller
14	Bushing For The Glue Dosing Roller
15	Holder For The Top/Bottom Feed Roller
17	Lock Nut For Fixing Glue Plates Knob
18	Tension Spring For Glue Dosing Roller
19	Motor Typ Sg71 0,25 kw, 380 V. 50 Hz
22	Bottom Feed Roller With Gear z-24
23	Top Feed Roller
24	Pressure Feed Rod
25	Glue Dosing Roller (50 mm)
26	Glue Application Roller (100 mm)
27	Brass Finger Rod
28	Traction Spring Mounting
29	Traction Spring On The Rocking Lever
30	Vertical Adjustment With Knurled Disks
31	Counter Knobs Over The Knurled Disks
32	Pressure Roller
33	Pressure Roller
34	Frame Pressure Roller
35	Gear z-52
36	Gear z-24
37	Clutch-Clutch Lever Housing
38	Holder Pressure Bar Left
39	Holder Pressure Bar Right
40	Locking Knob behind the pressure Knob
41	Pressure Knob for Lateral Glue Plates
42	Gear z-75
43	Double Drive Gear
44	Gear z-24
45	Gear z-52
46	Gear Collar (Only)
47	Drive Belt
48	Drive Guard Cover Supports Posts

49	Flywheel Collar (Only)
50	Screw For Fixing Bushing Retention Plate
51	Knob For Bushing Retention Plate
52	Gear Collar (Only)
53	Gear z-52
54	Bushing Retention Plate For Dosing Roller
55	Gear Cover
56	Flywheel With Pinion Gear z-35
57	Spring For Lateral Glue Plates
61	Knob For Fixing Feed Table
62	Drive Guard Cover
63	Frame For Feed Table
64	Holder For Pressure Bar Attachment (Left)



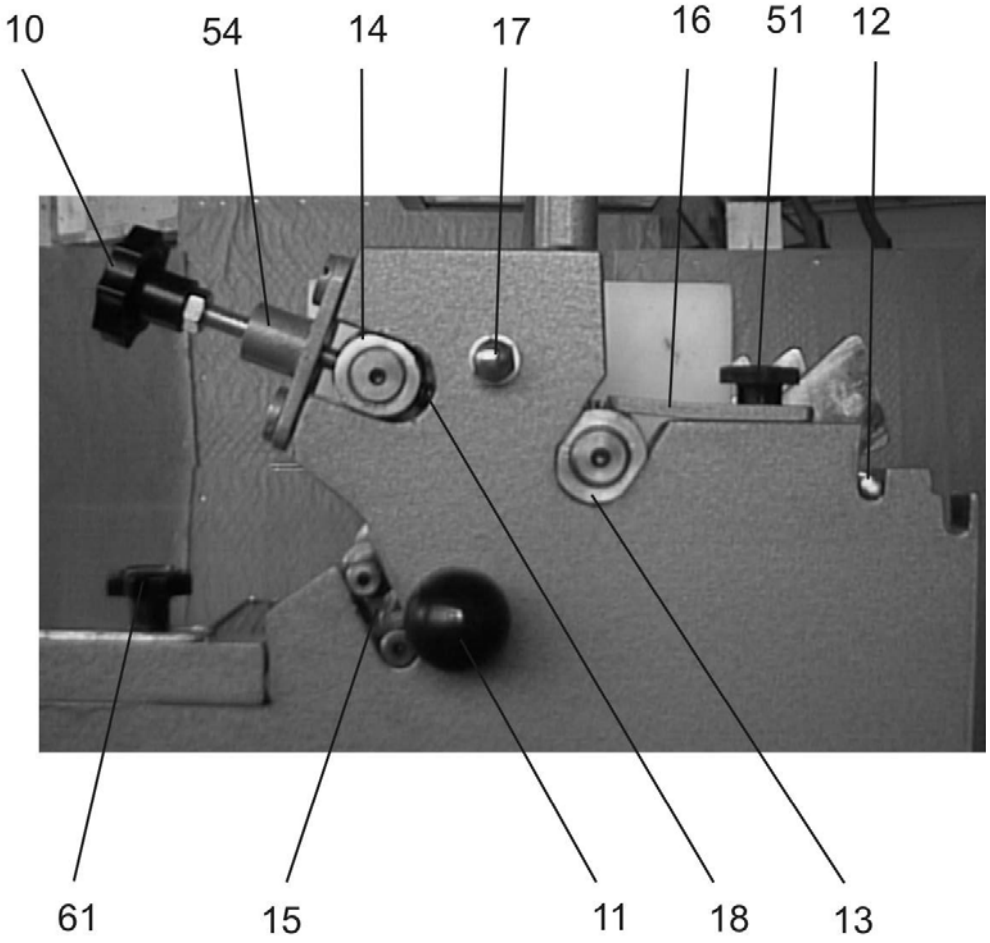
Note: Pushing in the Emergency Stop button will immediately stop the motor.
To restart pull out the Emergency Stop button.

Picture 1



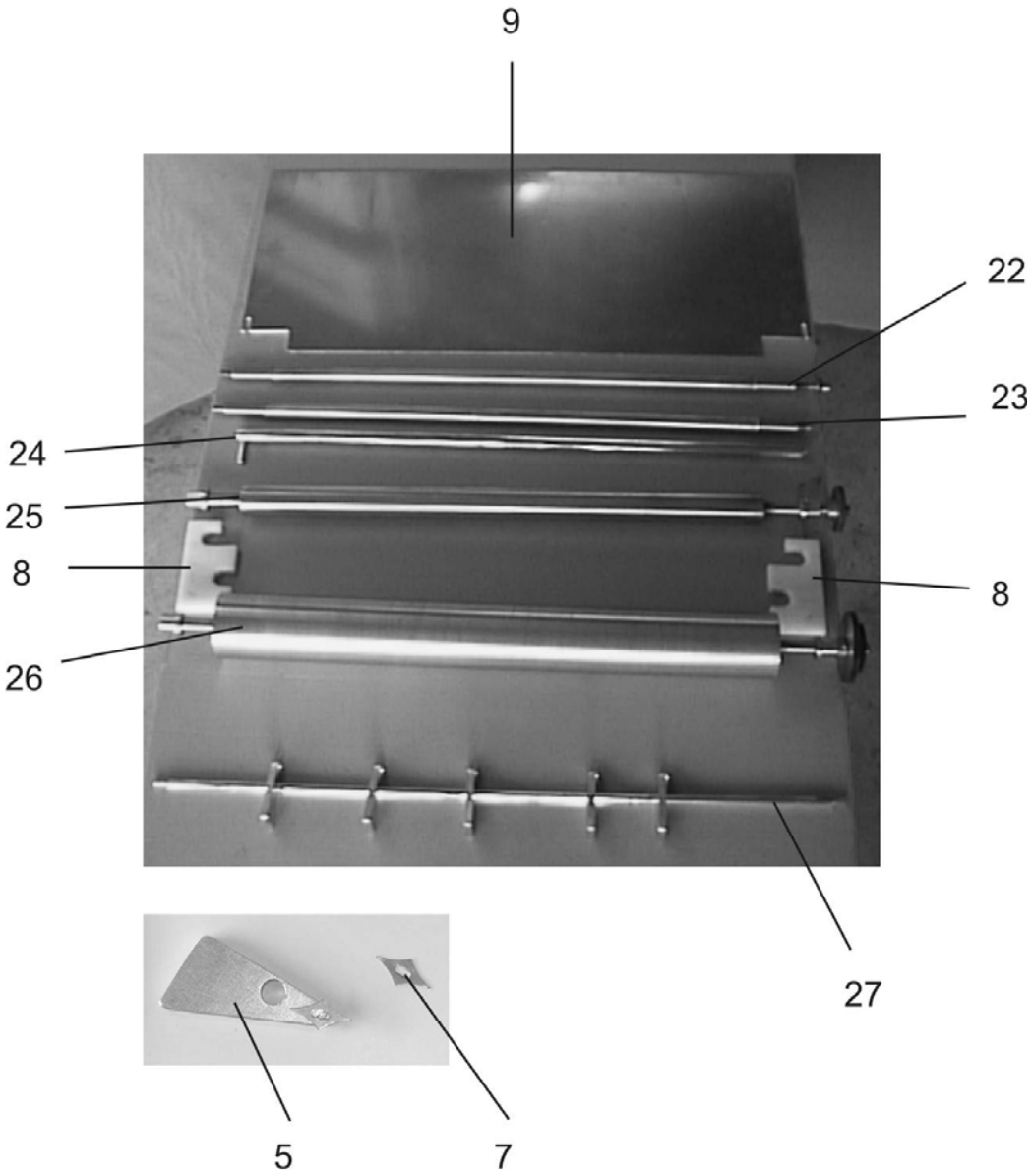
1) On/Off Switch
2) Pilot lamp
3) Speed Control / Inverter
4) Glue pot
5 + 7) Finger & Point Assembly With Screw
6) Glue tray
8) Lateral Glue Plates
9) Feed Table
10) Glue Control Adjustment Screw With Knop
11) Pressure Feed Adjustment Knob For The Excentric Rod
25) Glue Dosing Roller, 60 mm
26) Glue Application Roller, 100 mm
27) Brass Finger Rod
51) Knob for Bushing Retention Plate
61) Knob for fixing feed table
62) Drive Guard Cover
63) Frame for Feed Table

Picture 2



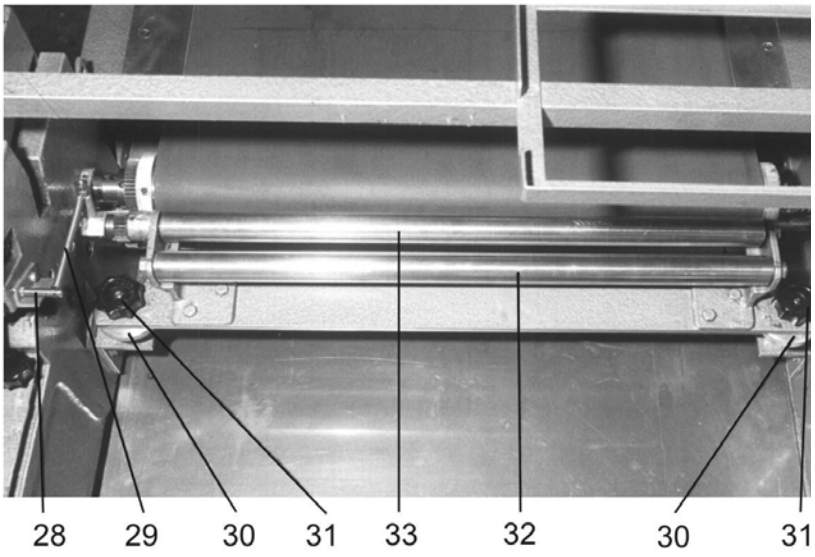
10) Glue controle screw
11) Operating knob for the eccentric rod
12) Holding fixture for the Bras Finger Rod
13) Bushing for the glueing roller 100 m/m
14) Bushing for the glue dosing roller 60 m/m
15) Holder for the feed roller
16) Bushing Retention Plate For Dosing Roller
17) Nut for Fixing Glue plates knob
18) Tension Spring For Glue Dosing Roller
51) Knob For Bushing Retention Plate

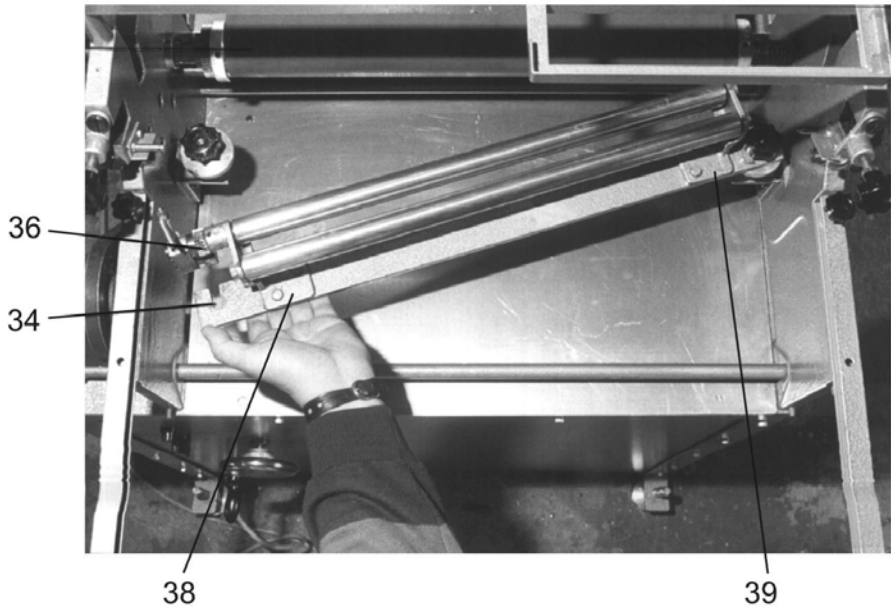
Picture 3



5) Finger & Point Assembly with Screw
7) Pick Off Point
8) Lateral glue plates
9) Feed table
22) Bottom feed roller with gear z-24
23) Top feed roller
24) Pressure Feed Rod
25) Glue dosing roller, 60 m/m
26) Glue Application Roller, 100 m/m
27) Brass Finger Rod

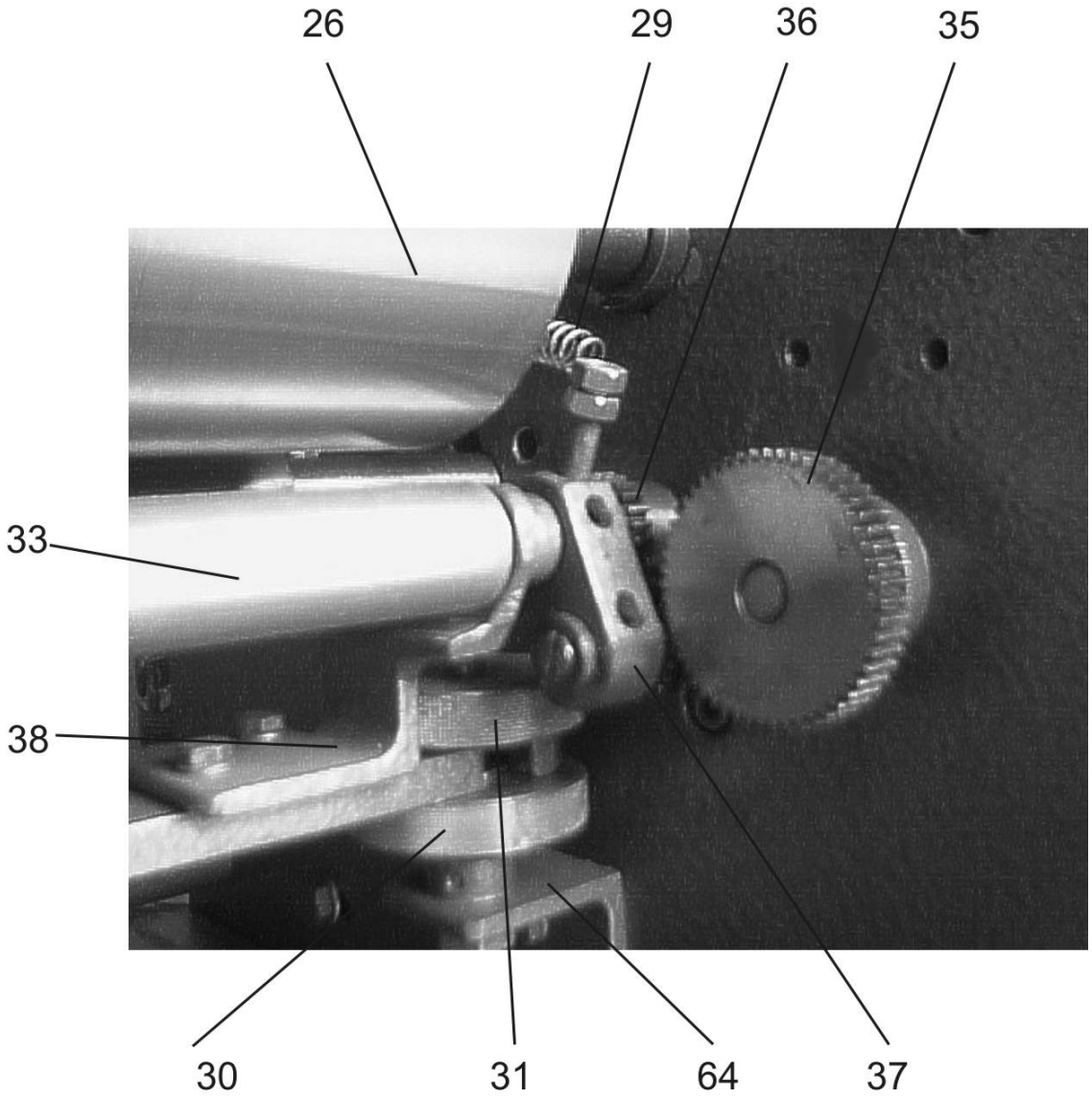
Picture 4





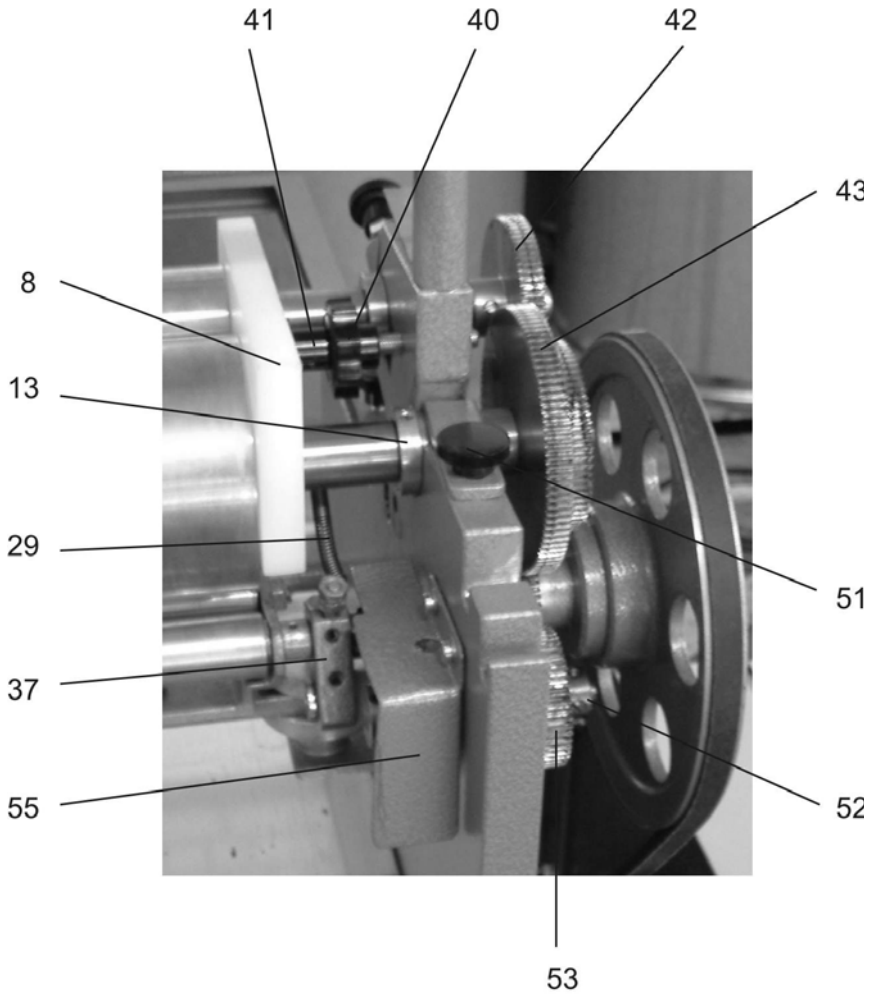
28) Traction Spring Mounting
29) Traction Spring on the Clutch-Clutch Lever Housing
30) Vertical Adjustment With Knurled Disks
31) Conter Knobs Over The Knurled Disks
32) Pressure Roller
33) Pressure Roller
34) Frame Pressure Bar
36) Gear z-24
38) Holder Pressure Roller left
39) Holder Pressure Roller right

Picture 5



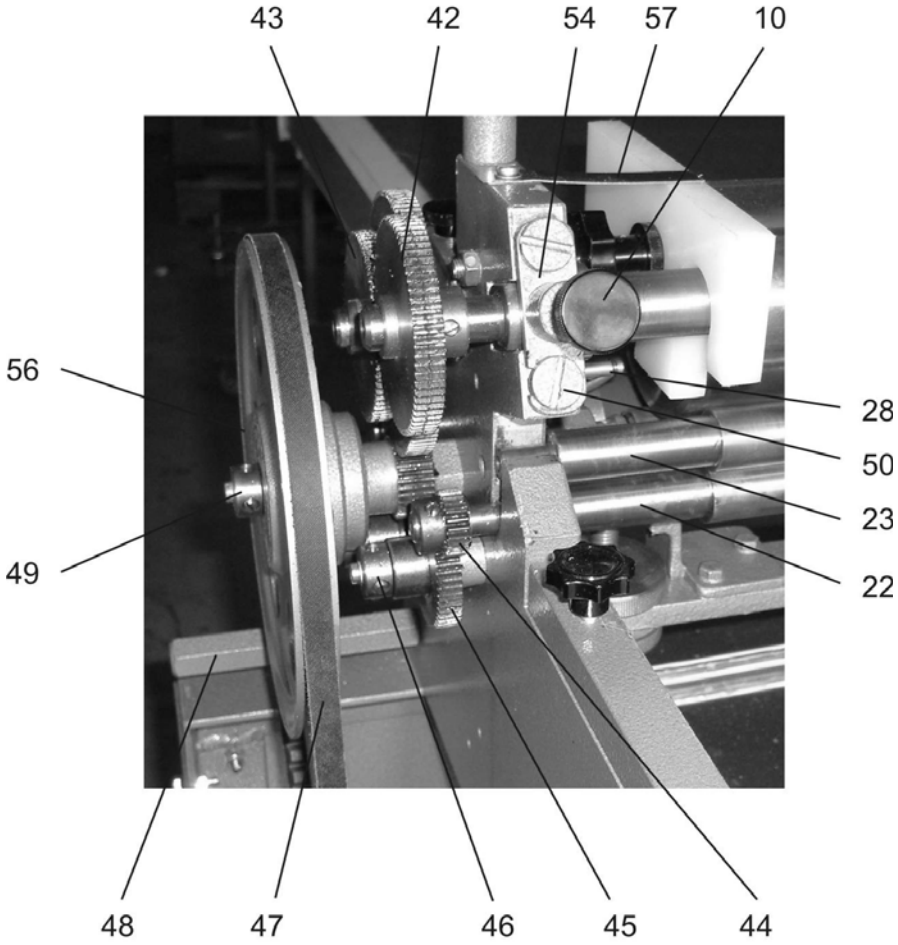
26) Glue Application Roller, 100 mm
29) Traction Spring on the Clutch-Clutch Lever Housing
30) Vertical Adjustment With Knurled Disks
31) Counter Knob Over The Knurled Disks
33) Pressure Roller
35) Gear z-52
37) Clutch-Clutch Lever Housing
38) Holder Pressure Roller left
64) Holder For The Pressure Bar Attachment

Picture 6

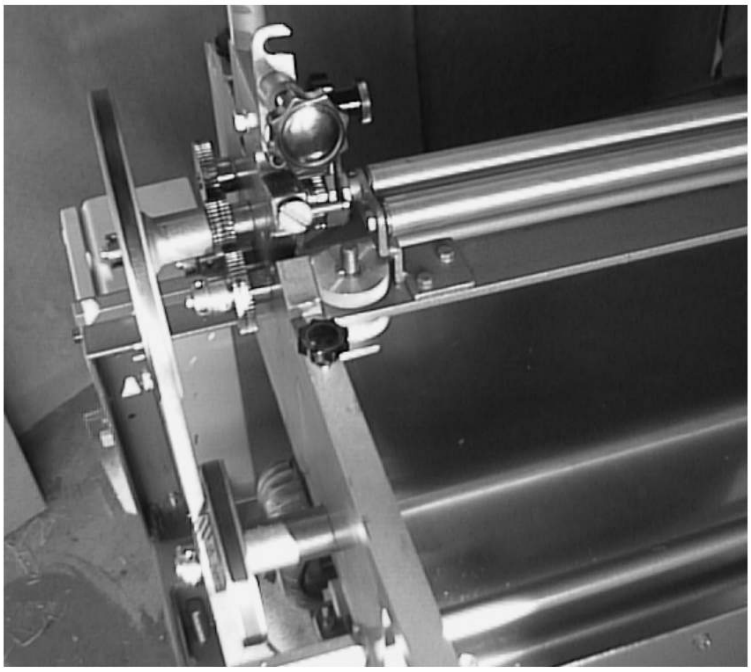
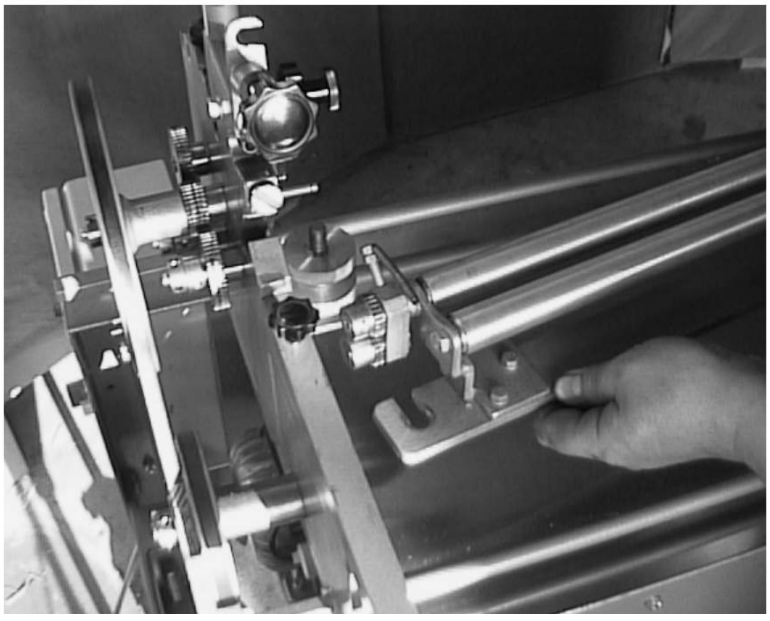


8) Lateral Glue Plates
13) Bushing For The Glue Application Roller
29) Traction Spring on the rockhing lever
37) Clutch-Clutch Lever Housing
40) Fixing Knob Behind The Pressure Knob
41) Pressure Knob for Lateral Glue Plates
42) Gear z-75 for the Glue Dosing Roller
43) Double Drive Gear
51) Knob for Bushing Retention Plate
52) Cear Collar (Only)
53) Gear z-52
55) Gear Cover

Picture 7



10) Glue Control Adjustment Knob
22) Bottom Feed Roller
23) Top Feed Roller
28) Traction Spring Mounting
42) Gear z-75 for the Glue Dosing Roller
43) Double Drive Gear
44) Gear z-24
45) Gear z-52
46) Gear Collar (Only)
47) Drive Belt
48) Drive Guard Cover Supports Posts
49) Flywheel Collar (Only)
50) Screw For Fixing Bushing Retention Plate
54) Bushing Retention Plate For Dosing Roller
56) Flywheel With Pinion Gear z-35
57) Spring For Lateral Glue Plates

The contact pressure roller section

Picture 8