

## Instructions for Colonel-AG Gluer 220/240 Volts, 60 Hz

Remove the packing materials and carefully remove the gluer from the wooden crate. It is strongly recommended that you apply some 30 weight oil to the two slots that hold the Top Feed Roller (#10) and the oil hole located in the Flywheel Collar (#38) which lubricates the Eccentric Shaft (#30). This will help keep the Flywheel (#29) from seizing up. This gluer was shipped to you assembled ready for operation, except for the Automatic Watering System. Photo 3 on page 6 shows the location for attaching the Watering System stand.

← Standard Pick-off Point (73AG)



Photo A



Photo B

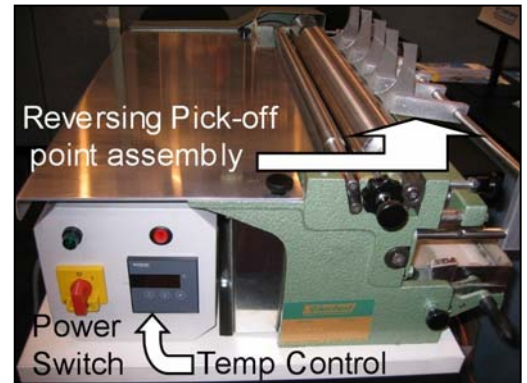


Photo C

The new standard pick-off points fit individually on a holder as shown in the Photo A. If you have the optional reversible pick-off point assembly you can see the assembly as shown in Photos B & C above. See the section below for Reversible Pick-off Point Assembly.

The Glue Tray (#39), in relationship to the roller, may be adjusted by loosening the Tray Knob (on the left-hand side as you face the rollers) and moving the handle that positions the glue tray. For your initial test, fill glue tray halfway with water based or animal glue (available from Gluefast) & leave the tray in the lowest position. Raise it as the amount of glue decreases to be sure that the bottom glue pick-up roller is always in contact with glue.

If using **cold water based glue**, raise the glue tray so that the glue comes in full contact with the Glue Pick-up Roller (the bottom roller, #13). Turn on the switch at the left side of the gluer (#35). You can now adjust the glue thickness by turning the Glue Control Knobs (#49, 50 & 51). There is one knob on each side of the gluer and they should be adjusted equally to provide an even film of adhesive across the glue roller.

If using **hot animal glue**, set the temperature to 10 degrees hotter than the recommended running temperature for the glue until the glue is completely liquefied (about 45 minutes). Follow the glue manufacturer's instructions regarding the addition of water to the glue. There is an automatic watering system to replenish the water from evaporation. It is similar to an intravenous system, allowing you to adjust the water flow. We recommend adding water at a rate of 1 to 3 drops per second. Remember to reduce the temperature once liquefied!



Photo D

**Note:** If you are using **AG-90** protein glue from Gluefast see the last page of this manual for instructions!

Before turning on the rollers when using hot animal glue, it is a good practice to take a hair dryer or professional heat gun to warm the rollers. After turning on the motor you may notice an uneven film and noise at first, but once the rollers warm up you should get a good even glue film across the rollers.

Adjustment of the Pressure Feed Rod (#5) should only be done after the Glue Application Roller (upper glue roller #10) has the correct amount of adhesive. The Pressure Feed Rod is adjusted by loosening the Locking Knob (#6) and turning the outer knob - the Pressure Feed Adjustment Knob (#8). The two grooves on either end of the Pressure Feed Rod should be facing towards the Glue Application Roller. If the Pressure Feed Rod is too close to the Glue Application roller adhesive will be transferred to the rod. If it is too far away the leading or trailing edge of the label/cover stock may not be adequately coated with glue.

Photo #3 shows a knob (below the motor) attached to the Motor Speed Control Mounting Plate (#24). By turning this knob so that the motor moves toward the front of the gluer (nearer to the glue rollers) the speed of the rollers will increase. To decrease the speed turn the knob so that the plate moves the motor to the back. However, if you bring it too far back the life of the Drive Belt (#27) will be greatly reduced.

## Installation of Reversible Pick-off Point Assembly

The Reversible Pick-Off point assembly will not work well on paper and prints, causing tearing. It is designed for use with flexible cover materials for making hard-cover books and other items.

You must remove the standard pick-off point assembly before putting the reversible pick-off point assembly in place.

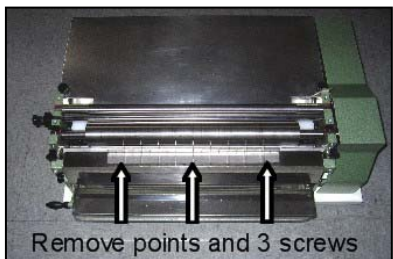


Photo E

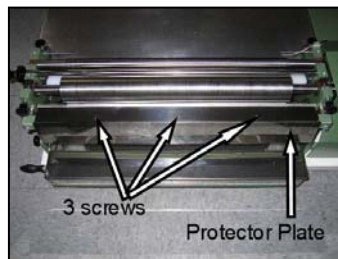


Photo F



Photo G

There are three screws that hold the assembly in place. Remove the screws with the point holder making certain that the Protector Plate is not removed. Remove the top bolts (53COL shown in Photo G above) on both sides of machine.

Assemble the Reversible Pick Off points onto the rod as shown in Photo H & I below.

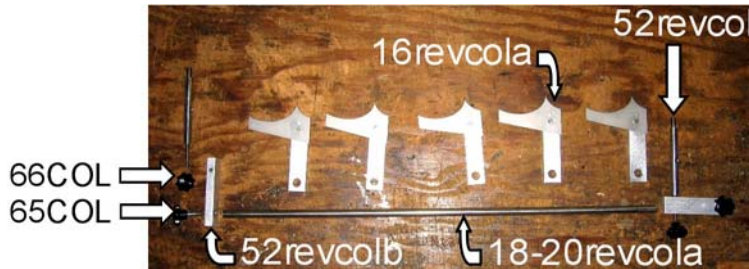


Photo H

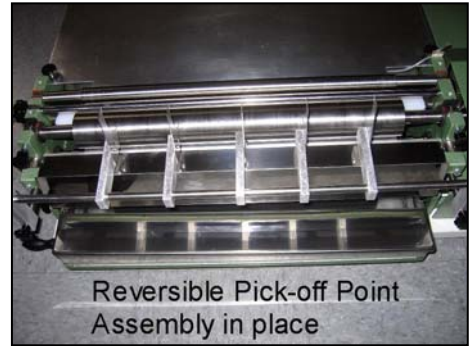


Photo I

The bottom of the stainless steel point should sit on the Glue Application Roller, forcing the cover material fed into the gluer to turn around and come back to the person doing the gluing as shown in Photo J. When feeding material into the gluer do not “pull” on the material as it exits the machine as this could result in too little or no glue on the end of the material.

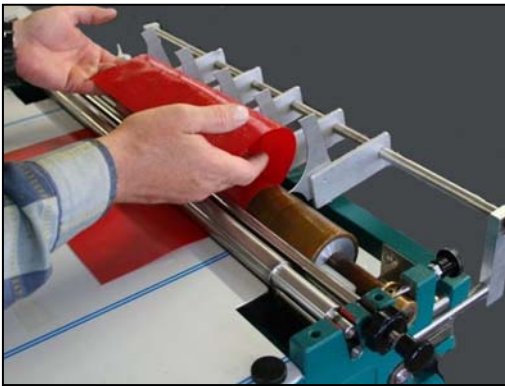


Photo J



## Cleaning and Maintenance

The gluer should be cleaned at the end of the work day. If you are using animal glue you may elect to keep the glue in the glue tray for a few days, but full cleanup is recommended weekly. The tray should be covered with a little water and stretch wrap or other item to keep it from drying out too much. An optional water tray is available to help clean the glue rollers should you decide not to clean the glue tray on a daily basis.

For hot animal glue & dextrin glues you only need hot water to clean the machine. For water based resin adhesives warm water is generally good enough but some glues might need a mild solvent such as alcohol or citrus solvent cleaners.

It is advisable to place newspaper beneath the glue tray *before* removing the glue tray! Rinse the tray thoroughly and fill tray with warm water and replace in gluer. Raise the glue tray into position so that the water is in full contact with the Lower Glue Roller. Turn on the motor and let it run so that the rollers can help clean themselves.

Remove any hardened glue on the rollers. Never scrape or scratch the rollers with a knife or sharp object! Don't use a towel to clean the glue rollers if the machine is running! *If you get a towel stuck between the glue rollers you might ruin the rollers!* You can remove the Drive Gear Cover (#44 or Photo 4, part C), then remove the belt and turn the flywheel by hand to rotate the glue rollers while cleaning. Dry the rollers with a soft cloth. All moving parts should be lubricated with oil regularly, but do not apply too much which can result in the oil getting into the glue tray and decreasing the efficiency of the gluer.

The Drive Guard Cover (#44) must be removed before any of the geared rollers can be removed. Photo #4 shows the gluer completely disassembled. When cleaning remove the parts in the following order:

- Reversible Pick-Off Finger Rod
- Pressure Rod
- Gear Housing Cover
- Top Feed Roller
- Bottom Feed Roller
- Glue Tray
- Glue Application Roller (turn the Glue Control Knobs counterclockwise completely)
- Glue Pick-Up Roller (loosen knobs on shafts that support pick-off finger rod and swing bottom roller locks counterclockwise.
- When reassembling be sure that all of the units with oil holes have the oil holes facing up.

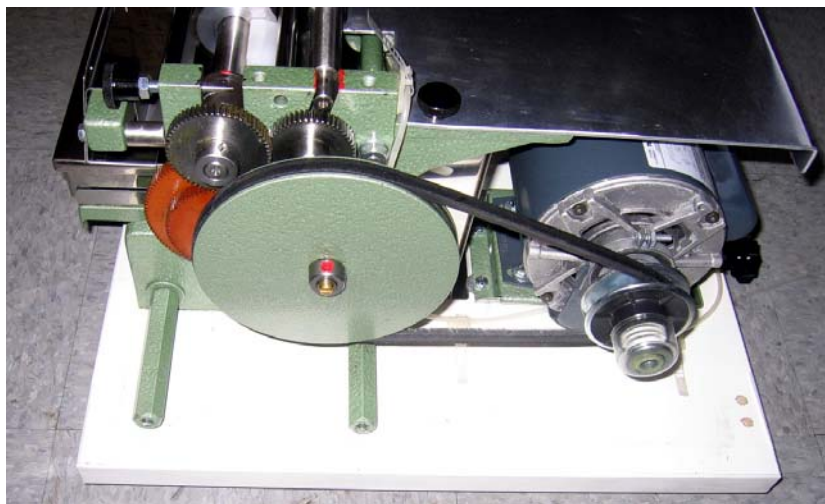


## COLONEL ELECTRIC LABEL GLUER

Photo #1



Photo #2



**COLONEL ELECTRIC LABEL GLUER**

Photo #3

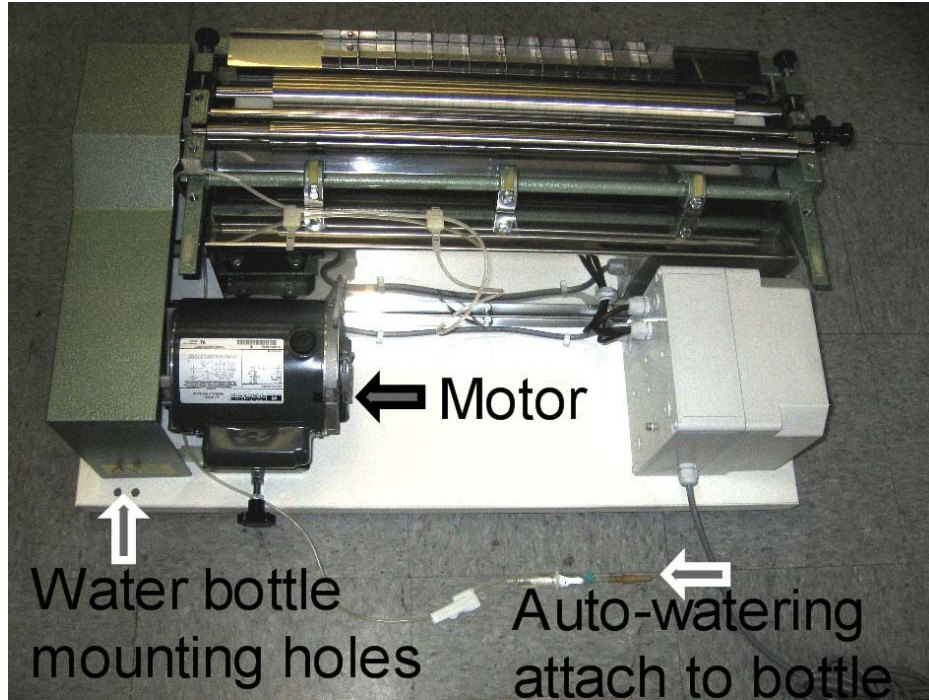
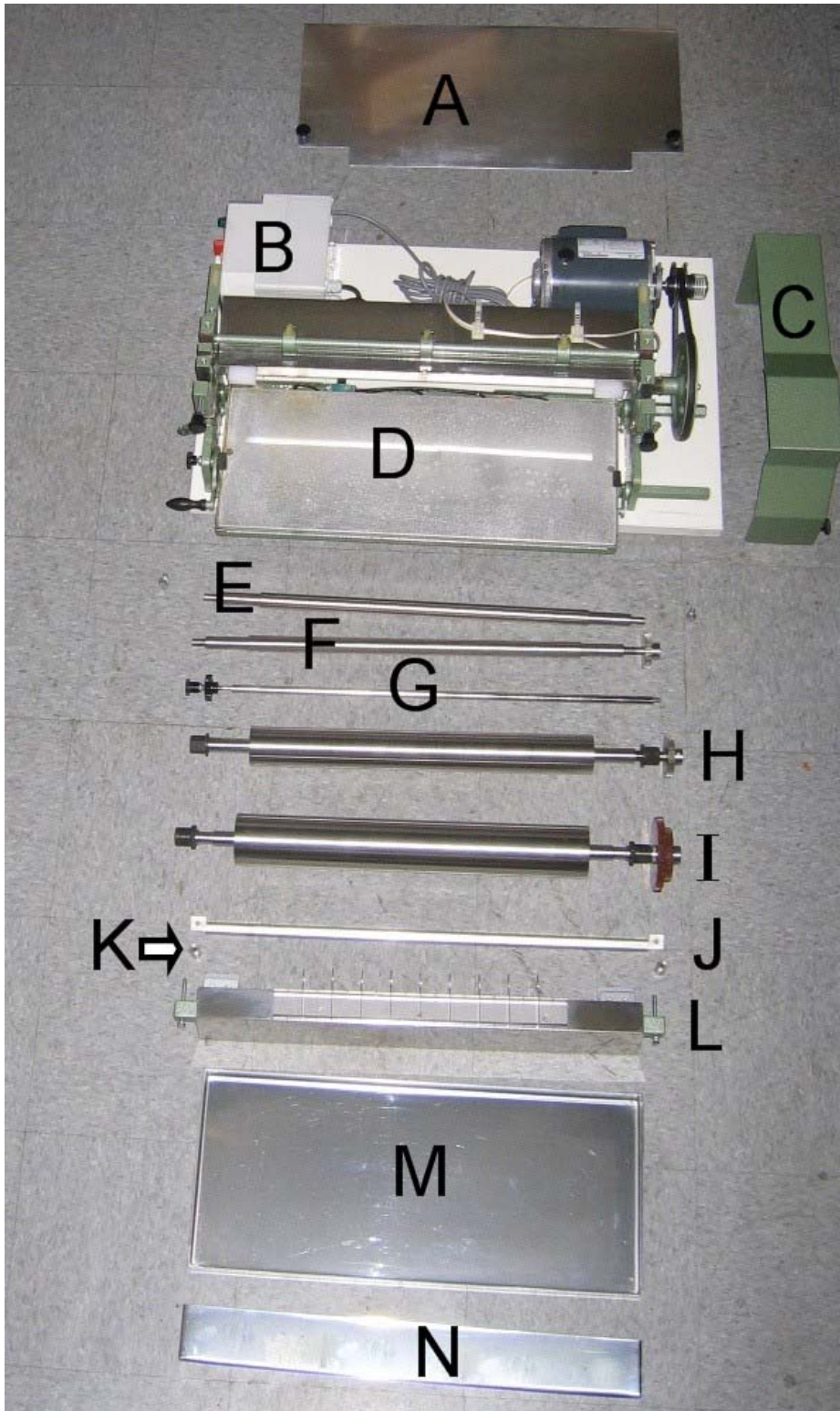


Photo 4



- A – Cover Plate (38SS)
- B – Control Box Complete (74AG)
- C – Drive Gear Cover (44)
- D – Heater Plate (40AG)
- E – Top Feed Roller (1-20SS)
- F – Bottom Feed Roller with gear (2-20SS)
- G – Pressure Feed Rod assembly (5 & 6)
- H – Glue Application Roller Assembly
- I – Glue Pick-up Roller Assembly
- J – Roller Guard (10A-20)
- K – Spacer (2 pieces, 71AG)
- L – Complete Pick-off point Assembly
- M – Glue Tray (39AG)
- N – Glue Tray Cover (39AGC)



## COLONEL-AG ELECTRIC GLUER PARTS LIST

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<u>PART NO.</u>	<u>DESCRIPTION</u>
1-20SS	Top Feed Roller - 20" Gluer (Gearless)
1-32SS	Top Feed Roller - 32" Gluer (Gearless)
2-20SS	Bottom Feed Roller - 20" Gluer
2-32SS	Bottom Feed Roller - 32" Gluer
3	Bottom Feed Roller Gear (Approx. 2")
4	Gear Set Screw
5-20SS	Pressure Feed Rod - 20" Gluer
5-32SS	Pressure Feed Rod - 32" Gluer
6	Pressure Feed Rod Lock Knob
7	Stop Nut
8	Pressure Feed Adjustment Knob
9	Bushing (Double Faced)
10-20SS	Glue Application Roller - 20" Gluer
10-32SS	Glue Application Roller - 32" Gluer
11	Glue Control Roller Gear (Approx. 2.25")
12R	Right Bushing (Single Faced)
12L	Left Bushing (Single Faced)
13-20SS	Glue Pickup Roller - 20" Gluer
13-32SS	Glue Pickup Roller - 32" Gluer
14	Double Drive Gear (Single Unit)
16REVCOLA	Reversing Pick Off Finger & Point Assembly
16AG	Standard Pick Off Point for Colonel-AG
17	Screw for Finger
18-20REVCOLA	Rod for Reversible Pick-off points - 20" Gluer
18-32REVCOLA	Rod for Reversible Pick-off points - 32" Gluer
19	Calrod Heater Ceramic Plug
19PC	Heater Cord
19A	Calrod Heater White Plastic Plug (Gluer w/serial # starting "590" & up)
20	Power Plug
20PC	Power Cord
21	Motor - 1/3 HP 115 volts AC
22	Variable Speed Pulley
22A	Fixed Pulley - 3"
22B	Fixed Pulley - 3.5"
23	Allen Screw
24	Motor Speed Control Mounting Plate with Knob
25&26	Motor Mounting Bolt & Washer
27-AG	Drive Belt (3L300)
28	Flywheel Collar (Only)
28 & 29	Flywheel with Pinion Gear & Collar
30	Eccentric Shaft & Adjusting Nut
31 & 32	Eccentric Shaft Washer & Locknut
37	Cover Knob



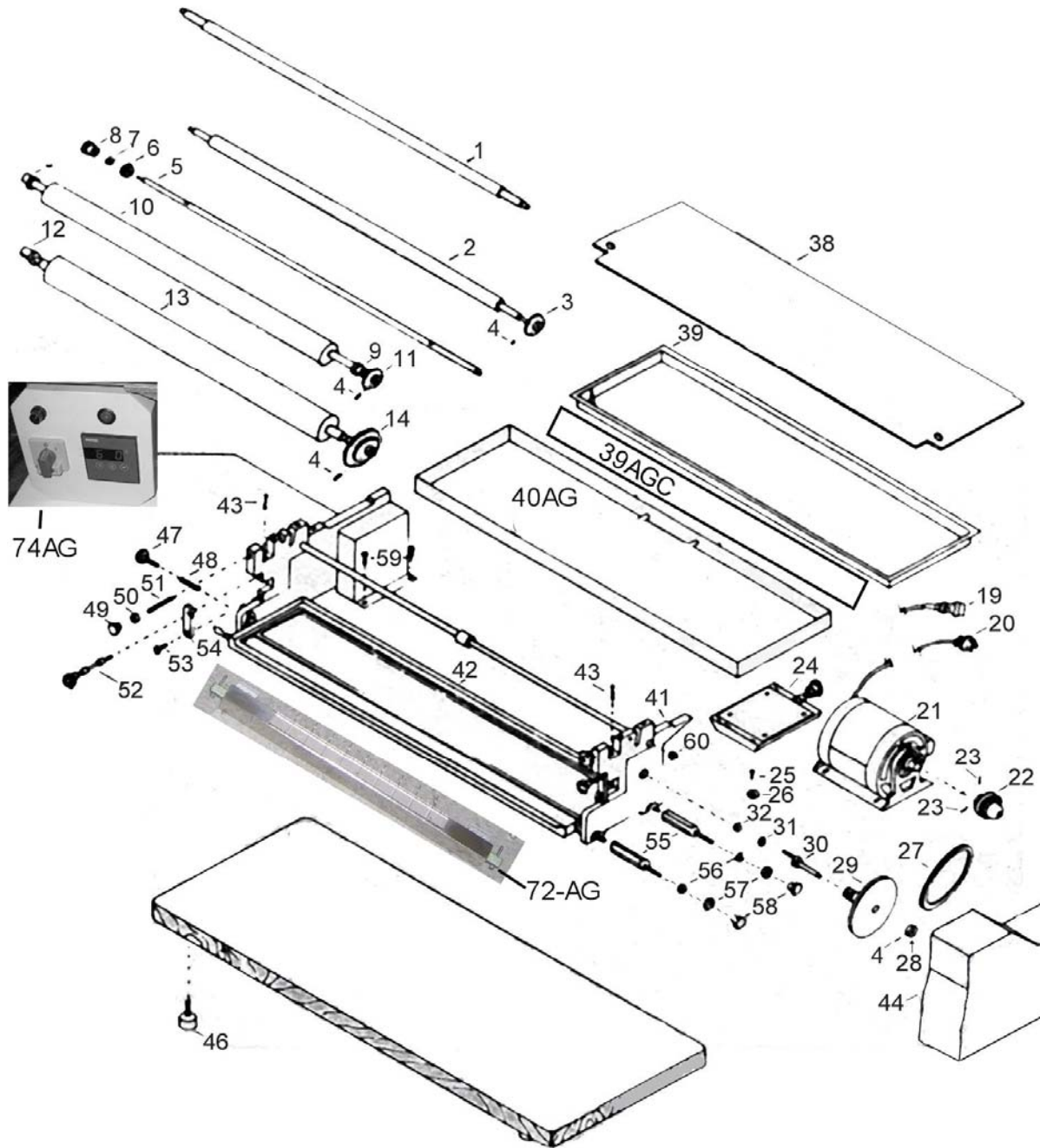


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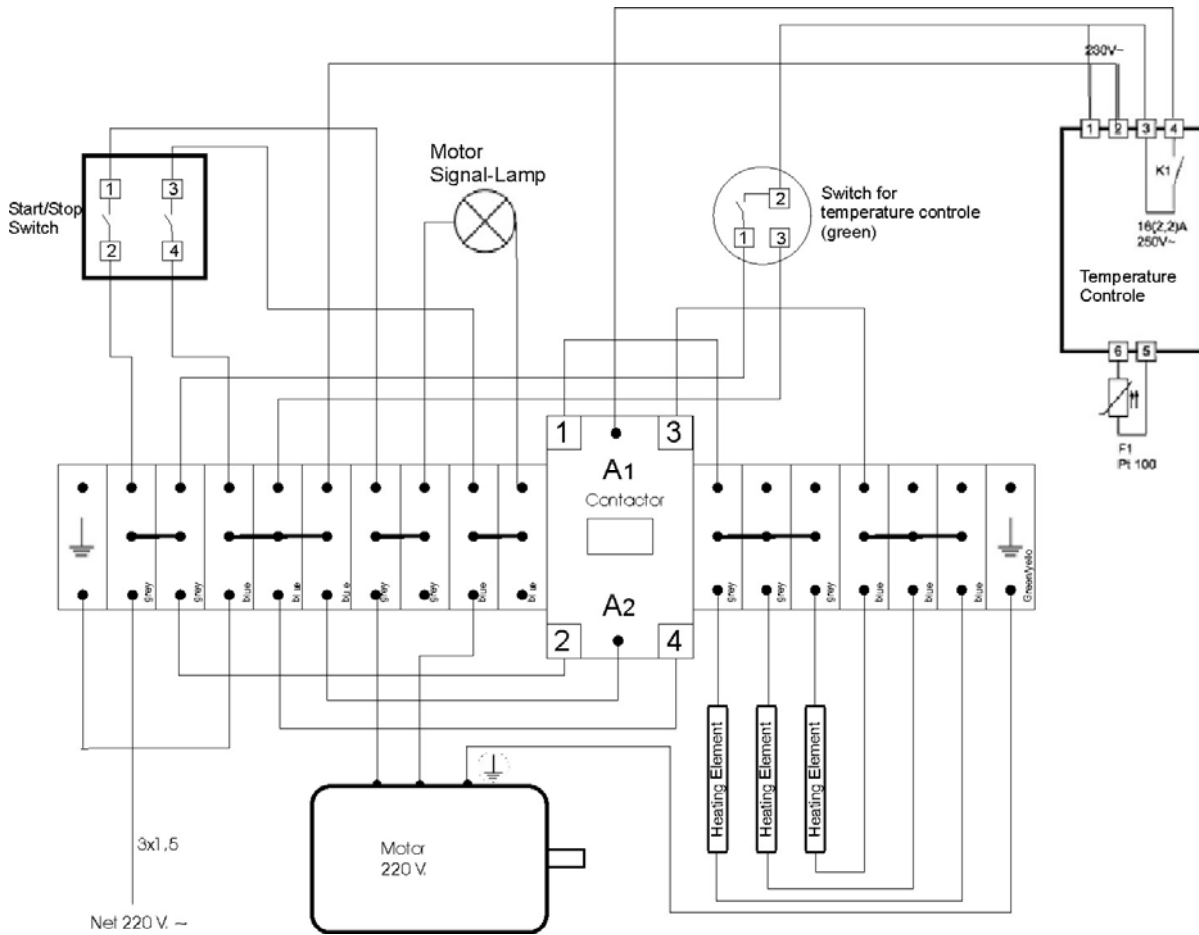
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<u>PART NO.</u>	<u>DESCRIPTION</u>
38AG-20	Cover Plate - 20" Gluer (12" Depth)
38AG-32	Cover Plate - 32" Gluer (12" Depth)
39AG-20	Glue Tray for 20" AG Gluer
39AG-32	Glue Tray for 32" AG Gluer
39AGC-20	Glue Tray Cover for 20" AG Gluer
39AGC-32	Glue Tray Cover for 32" AG Gluer
40AG-20	Heater Assembly for 20" AG Gluer
40AG-32	Heater Assembly for 32" AG Gluer
41AG-20	Main Frame with Support Crossbar & Hub - 20" Gluer
41AG-32	Main Frame with Support Crossbar & Hub - 32" Gluer
42-20	Glue Tray Platform with handle - 20" Gluer
42-32	Glue Tray Platform with handle - 32" Gluer
43	Tension Spring for Glue Application Roller
44	Drive Guard Cover
45-20	Wood Platform Base for 20" Gluer
45-32	Wood Platform Base for 32" Gluer
46	Platform Foot Support
47	Glue Tray Positioning Knob
48	Pressure Spring & Ball Bearing
49,50, & 51	Glue Control Knob, Locknut & Tapered Shaft
52REVCOL	Mounting Rod Reversible Pick-Off Point Assembly
52REVCOLA	Finger Rod Mounting Knob & Support for Reversible Pick-Off Point Assemb
52REVCOLB	Aluminum Support Bracket for Finger Rod
53	Bushing Cover Bolt
54	Bushing Retention Plate
55	Drive Guard Cover Support Posts
56 & 57	Guard Limit Locknut & Support Plate
58	Drive Guard Cover Knob
59	Switch Cover Mounting Screw
60	Cross Bar Mounting Nut
61	Calrod Heater Element (without Male Connector)
62	Male Connector for Calrod Heater Plug (Ceramic - Part #19)
62A	Male Connector for Calrod Heater Plug (White Plastic - Part #19A)
65COL	Knob for Reversible Pick-Off Rod
65COL	Knob for Aluminum Support bracket
Not Shown	Roller Guard for 20" Gluer (part no. 10A-20COL)
Not Shown	Roller Guard for 32" Gluer (part no. 10A-32COL)
Not Shown	Screw & Washer for Roller Guard for 32" Gluer (part no. 10AS-COL)
71AG	Spacer for standard Pick-off point assembly
72AG-20	Standard Pick-off point holder for 20" AG Gluer
72AG-32	Standard Pick-off point holder for 32" AG Gluer
73AG	Standard Pick-off Point
74AG	Control Box Complete

## COLONEL-AG GLUER SCHEMATIC DIAGRAM (April 09)



## COLONEL-AG ELECTRICAL SCHEMATIC





## USING HOT PROTEIN GLUE AG-90 IN THE COLONEL-AG GLUER (DIRECT HEATING OF GLUE TRAY)

1. With glue tray in lower position place about:
  - a. 6 pounds (2.7KG) of AG-90 in the glue tray for a 20" model
  - b. 9 pounds (4 kg) for the 32" model
  - c. 12 pounds (5.5 kg) for the 42" model.



2. Turn on heater to 65 degrees °C and add hot water. It will take 45 minutes or more to heat completely. Bring the glue tray up until the glue is at least past the bottom ¼" (6 mm) of the bottom glue roller (part 13 on the schematic diagram). Add the amount of hot water shown below for the machine size you have:
  - a. 9 oz. (250 ml) for the 20" gluer
  - b. 13.5 oz (375 ml) for the 32" gluer
  - c. 18 oz (500 ml) for the 42" gluer
3. Make certain the Pressure Feed Rod (part number 5) is moved far from the roller at startup (after the glue film is adjusted you will want to bring this closer to the roller). The purpose of this rod is to insure that the leading and trailing edge of the item to be glued is pressed up against the glue roller. However, since the initial turning on of the glue roller could result in too much glue on the roller, it would get glue on this rod.
4. If you have a hair dryer you can briefly use it to heat the rollers.
5. Turn on the power for the motor. For the first several seconds the machine may be noisy and the glue film will appear very inconsistent. However, once the glue rollers have warmed up the glue film will become controllable and consistent. The Glue Control Knobs (part 49,50 & 51) on the left and right of the machine controls the spacing between the glue rollers which determines the thickness of the glued film.
6. Adjust the Automatic Watering System to apply 2-3 drops of water per second. If the glue is too tacky at any point pour more hot water over the turning glue roller. Wait 10 seconds before using to allow the glue to mix before using. Make sure the temperature is maintained at 65 degrees C.

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