

# InvisiPac<sup>®</sup> Advanced Feed System

334629H

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For feeding adhesives to the Invisipac<sup>™</sup> Hot Melt Delivery System.



## Important Safety Instructions

Read all warnings and instructions in this manual and in related manuals. Save these instructions.

Kit No. 17D749

See technical specifications for limitations.



# Warnings

The following warnings are for the setup, use, grounding, maintenance, and repair of this equipment. The exclamation point symbol alerts you to a general warning and the hazard symbols refer to procedure-specific risks. When these symbols appear in the body of this manual or on warning labels, refer back to these Warnings. Product-specific hazard symbols and warnings not covered in this section may appear throughout the body of this manual where applicable.

## **WARNING**



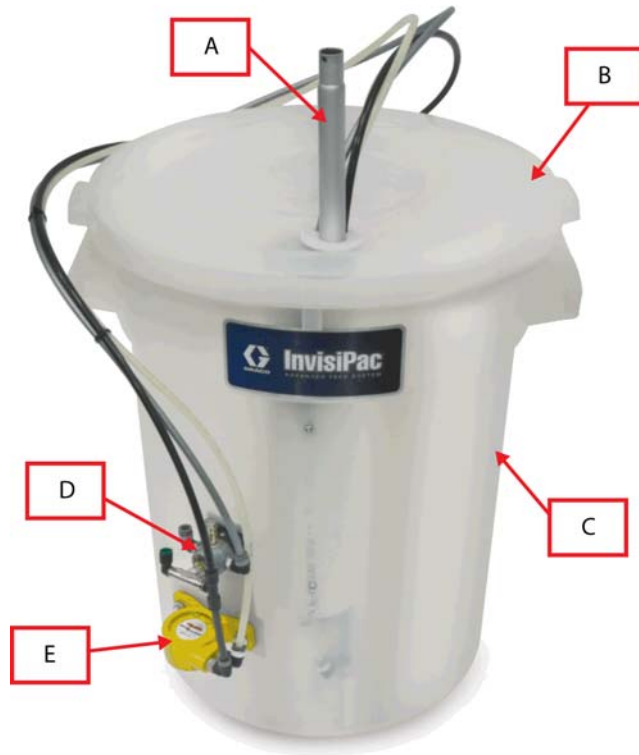
### **EQUIPMENT MISUSE HAZARD**

Misuse can cause death or serious injury.

- Do not operate the unit when fatigued or under the influence of drugs or alcohol.
- Do not exceed the maximum working pressure or temperature rating of the lowest rated system component. See **Technical Data** in all equipment manuals.
- Use fluids and solvents that are compatible with equipment wetted parts. See **Technical Data** in all equipment manuals. Read fluid and solvent manufacturer's warnings. For complete information about your material, request MSDS from distributor or retailer.
- Do not leave the work area while equipment is energized or under pressure.
- Turn off all equipment and follow the **Pressure Relief Procedure** when equipment is not in use.
- Check equipment daily. Repair or replace worn or damaged parts immediately with genuine manufacturer's replacement parts only.
- Do not alter or modify equipment. Alterations or modifications may void agency approvals and create safety hazards.
- Make sure all equipment is rated and approved for the environment in which you are using it.
- Use equipment only for its intended purpose. Call your distributor for information.
- Route hoses and cables away from traffic areas, sharp edges, moving parts, and hot surfaces.
- Do not kink or over bend hoses or use hoses to pull equipment.
- Keep children and animals away from work area.
- Comply with all applicable safety regulations.

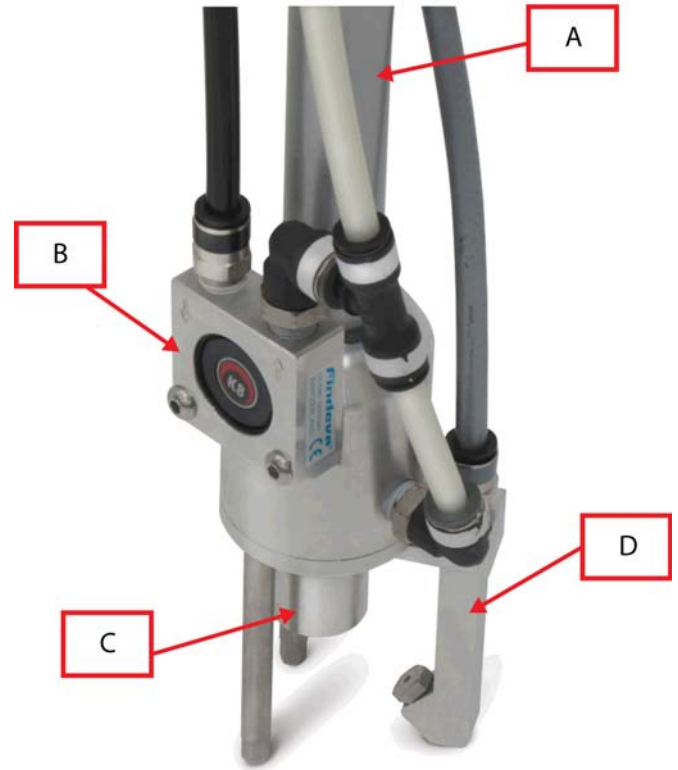
# Component Identification

## Hopper



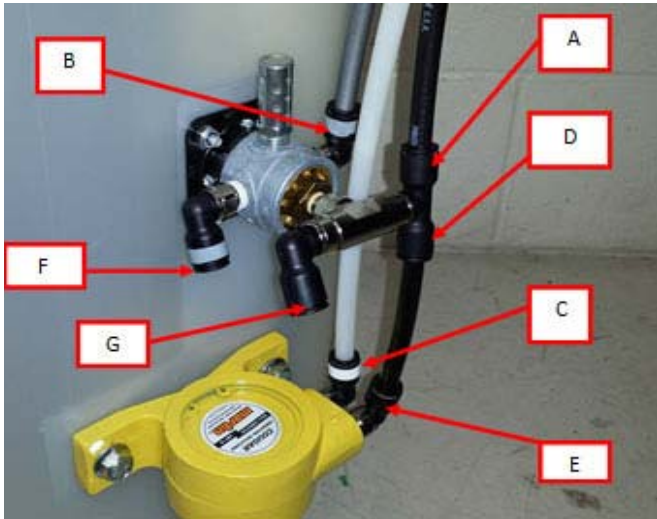
- A Wand
- B Hopper Cover
- C Hopper
- D Pilot Valve
- E Hopper Shaker

## Wand



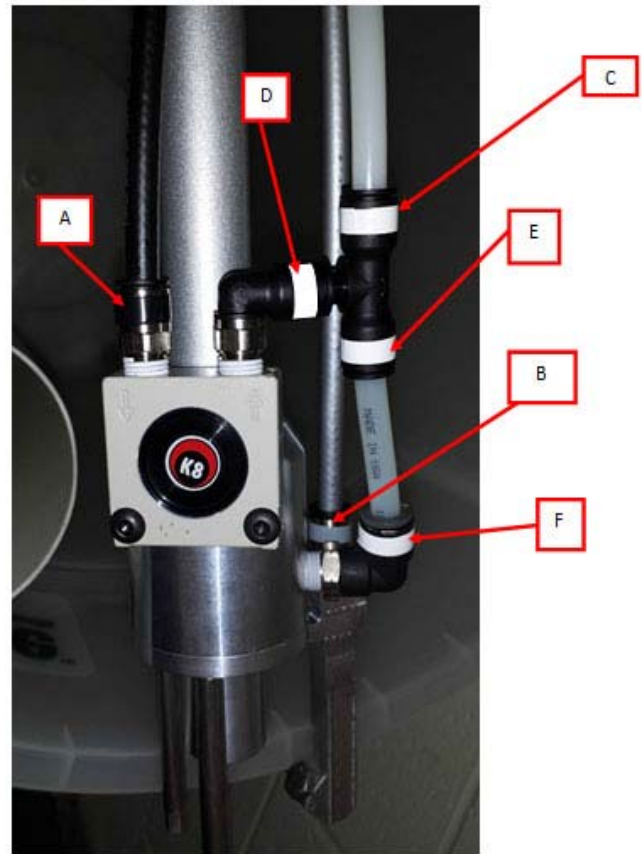
- A Wand
- B Wand Shaker
- C Vacuum Inlet
- D Air Assist Injector

## Pilot Valve (Pneumatic Connections)



- A To Wand Shaker Inlet (Black)
- B To Air Assist Injector Inlet (Gray)
- C To Wand Exhaust Tee Inlet (White)
- D To Hopper Shaker Inlet (Black)
- E Hopper Shaker Inlet (Black)
- F AFS Assist Air Line Air IN (Gray)
- G InvisiPac Feed Air IN (Black)

## Wand (Pneumatic Connections)

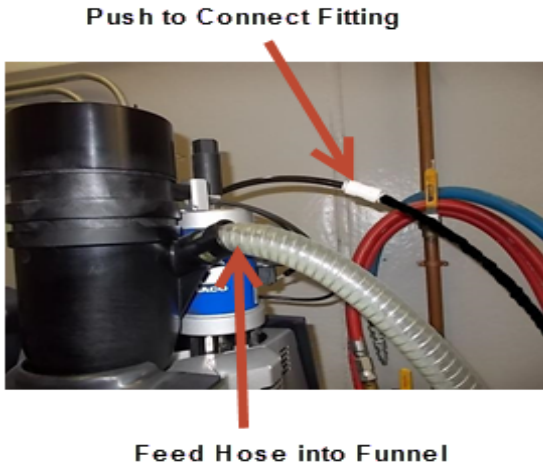


- A Wand Shaker Inlet (Black)
- B Air Assist Injector Inlet (Gray)
- C Wand Exhaust Tee Inlet (White)
- D Wand Shaker Outlet to Exhaust Tee Stem (White)
- E To Vacuum Inlet (White)
- F Vacuum Inlet (White)

# Installation

**NOTE:** In the following steps, when routing the vacuum transfer hose, ensure there are no tight coils, turns, or dips in the vacuum hose. These will inhibit optimal functioning of the vacuum transfer system.

1. Remove vacuum transfer hose and air supply line out of the accessory box that came with InvisiPac.



**FIG. 1**

2. Adjust funnel inlet direction as necessary, see system manual for instructions.
3. Connect clear feed hose to InvisiPac funnel and to the top of the feed wand. secure feed hose on each end with the hose clamp supplied. Connect black airline to the push to connect fitting (FIG. 1) on top of the InvisiPac. Connect the other end of black airline to the outside of the feed container fitting (G) See FIG. 2.



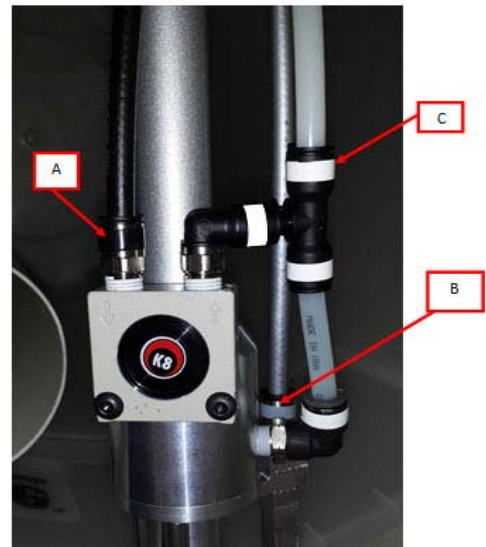
**FIG. 2**

4. Remove packing material from new container and feed wand inside the container.
5. Slide feed wand through the opening in the white insert on the top cover.



**FIG. 3**

6. Connect the white, black and gray air hose to the end of the feed wand. Connect corresponding colors to fitting labeled with that color.



**FIG. 4**

**NOTE:** If using the tank option continue with step 7, if not using the tank jump to step 9.



Installation

- Air tank is supplied with a 3/8 NPT female adaptor on the incoming air on the side of the tank. Use fittings supplied to attach your compressed air source to the tank. Place air tank either near the InvisiPac or by the feed container. Run a section of 3/8 in tubing from the air tank to the air inlet of the InvisiPac.

**NOTE:** All air tubing used on feed container and tank is 3/8 inch OD (1/4 ID) tubing.

Install air tube from tank.



FIG. 5

- Install regulator (24H420 provided) between the tank and feed container fitting F. Use 3/8" tubing to connect to inlet of regulator and from the outlet of the regulator to the fitting F. See FIG. 6.



FIG. 6

- Install regulator (24H420 provided) between the second air source and feed container fitting F. Use 3/8" tubing to connect from the outlet of the regulator to the fitting F. Inlet of regulator can be mounted directly to source, or plumbed in line with 3/8" tubing. See FIG. 6.
- Lift and rotate the lid to fill container with hot melt adhesive.



FIG. 7

- Turn on InvisiPac and open air supply ball valve to unit. Check all fittings to ensure there are no air leaks around air tubing. Adjust the Advanced Feed System (AFS) Assist Air Regulator (regulator from second source and installed in step 9) according to the table below.

**NOTE:** Use the lowest pressure first and increase pressure as required to achieve error-free feeding.

Recommended Air Pressure Ranges psi (kPa, bar)		
	Spherical Pellet	Round or Rectangular Tablet
InvisiPac Feed Air	60-80 (420-550, 4.2-5.5)	60-100 (420-690, 4.2-7)
AFS Assist Air Pressure	15-100 (103-690, 1-7)	80-100 psi (550-690, 5.5-7)

- Allow InvisiPac to warm up and then resume production. Refer to operation manual for InvisiPac for further instructions.

## Change Air Filter

Only for systems with optional filter hopper cover kit (17D747).

1. Unscrew the knurled knob on top of the air filter unit. Pull cover off the filter, remove filter and replace with new filter.
2. Place cover back on top of the air filter and screw down the knurled knob.



**FIG. 8**

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## Parts

### **Wand Kit, 24X322**

Replacement wand for the AFS.

### **Hopper Kit, 24X321**

Replacement hopper kit for the AFS.

### **Hopper Cover Kit, 17D748**

Replacement hopper cover for the AFS.

### **Pilot Valve Kit, 126929**

Repair kit for replacing the pilot valve on the AFS hopper.

### **Hopper Shaker Kit, 24X329**

Repair kit for replacing the shaker on the AFS hopper.

### **Wand Shaker Kit, 24X327**

Repair kit for replacing the shaker on the AFS wand.

### **AFS Replacement Air Assist Injector Kit, 24X330**

Repair kit for replacing the air assist on the AFS wand.

## Accessories

### **AFS Filtered Hopper Cover Kit, 17D747**

Hopper upgrade for dirty environments. The filtered hopper cover seals and filters the replacement air entering the hopper during an InvisiPac melter refill. The filtered cover further reduces contamination, a major cause of char within all hot melt systems.

### **AFS Chicklet Hopper Grate, 17D597**

Hopper grate for the AFS system to sift chicklet material through 1.25 in (31.75 mm) holes.

### **AGFS Pellet Hopper Grate 17D598**

Hopper grate for the AFS system to sift pelletized material through 0.75 in (19 mm) holes.



# Technical Specifications

InvisiPac Advanced Feed System		
	US	Metric
<b>General</b>		
System Dimensions (without feed hose attached)	26 x 38 in	660 x 965 mm
Weight	20 lbs	9 kg
<b>Maximum Dimensions per Adhesive Specimen</b>		
Round Tablet	0.5 in dia. x 0.25 in thick	12.7 mm dia. x 6.4 mm thick
Rectangular Tablet	0.5 x 0.50 x 0.25 in	12 x 12 x 6 mm
Spherical Pellet	0.35 in dia.	8.9 mm dia.
Maximum Weight per Adhesive Specimen	0.3 g	
<b>Pressure and Temperature Ranges</b>		
Air Inlet Requirements	80-100 psi	550-690 kPa (5.5 - 5.9 bar)
Ambient Temperature Range	32-120° F	0-49° C
<b>Vacuum Transfer Specifications - Complete AFS System</b>		
Maximum Vacuum Transfer Hose Length	30 ft	9.1 m
Maximum Vacuum Transfer Hose Vertical Rise	10 ft	3 m
Vacuum Transfer Operating Pneumatic Pressure Range	60-100 psi	420-690 kPa (4.2-6.9 bar)
Vacuum Transfer Air Consumption at 60 psi Feed Regulator, 80 psi Air Inlet (420 kPa, 4.2 bar Feed Regulator, 550 kPa, 5.5 bar Air Inlet)	25 scfm (intermittent duty; 4% at 25 lb/hr)	43 scmh (intermittent duty; 4% at 25 lb/hr)
Vacuum Transfer Air consumption at 80 psi Feed Regulator, 80 psi Air Inlet (420 kPa, 4.2 bar Feed Regulator, 550 kPa, 5.5 bar Air Inlet)	25 scfm (intermittent duty; 4% at 25 lb/hr)	43 scmh (intermittent duty; 4% at 25 lb/hr)
Vacuum Transfer Air Consumption at 60 psi Feed Regulator, 100 psi Air Inlet (420 kPa, 4.2 bar Feed Regulator, 690 kPa, 6.9 bar Air Inlet)	27 scfm (intermittent duty; 4% at 25 lb/hr)	46 scmh (intermittent duty; 4% at 25 lb/hr)
Vacuum Transfer Air consumption at 80 psi Feed Regulator, 100 psi Air Inlet (550 kPa, 5.5 bar Feed Regulator, 690 kPa, 6.9 bar Air Inlet)	30 scfm (intermittent duty; 4% at 25 lb/hr)	51 scmh (intermittent duty; 4% at 25 lb/hr)

## California Proposition 65

### CALIFORNIA RESIDENTS

 **WARNING:** Cancer and reproductive harm – [www.P65warnings.ca.gov](http://www.P65warnings.ca.gov).

# Graco Extended Warranty

Graco warrants all equipment referenced in this document which is manufactured by Graco and bearing its name to be free from defects in material and workmanship on the date of sale to the original purchaser for use. With the exception of any special, extended, or limited warranty published by Graco, Graco will, for a period of eighteen months from the date of sale, repair or replace any part of the equipment determined by Graco to be defective. This warranty applies only when the equipment is installed, operated and maintained in accordance with Graco's written recommendations.

This warranty does not cover, and Graco shall not be liable for general wear and tear, or any malfunction, damage or wear caused by faulty installation, misapplication, abrasion, corrosion, inadequate or improper maintenance, negligence, accident, tampering, or substitution of non-Graco component parts. Nor shall Graco be liable for malfunction, damage or wear caused by the incompatibility of Graco equipment with structures, accessories, equipment or materials not supplied by Graco, or the improper design, manufacture, installation, operation or maintenance of structures, accessories, equipment or materials not supplied by Graco.

This warranty is conditioned upon the prepaid return of the equipment claimed to be defective to an authorized Graco distributor for verification of the claimed defect. If the claimed defect is verified, Graco will repair or replace free of charge any defective parts. The equipment will be returned to the original purchaser transportation prepaid. If inspection of the equipment does not disclose any defect in material or workmanship, repairs will be made at a reasonable charge, which charges may include the costs of parts, labor, and transportation.

**THIS WARRANTY IS EXCLUSIVE, AND IS IN LIEU OF ANY OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING BUT NOT LIMITED TO WARRANTY OF MERCHANTABILITY OR WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE.**

Graco's sole obligation and buyer's sole remedy for any breach of warranty shall be as set forth above. The buyer agrees that no other remedy (including, but not limited to, incidental or consequential damages for lost profits, lost sales, injury to person or property, or any other incidental or consequential loss) shall be available. Any action for breach of warranty must be brought within two (2) years of the date of sale.

**GRACO MAKES NO WARRANTY, AND DISCLAIMS ALL IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, IN CONNECTION WITH ACCESSORIES, EQUIPMENT, MATERIALS OR COMPONENTS SOLD BUT NOT MANUFACTURED BY GRACO.** These items sold, but not manufactured by Graco (such as electric motors, switches, hose, etc.), are subject to the warranty, if any, of their manufacturer. Graco will provide purchaser with reasonable assistance in making any claim for breach of these warranties.

In no event will Graco be liable for indirect, incidental, special or consequential damages resulting from Graco supplying equipment hereunder, or the furnishing, performance, or use of any products or other goods sold hereto, whether due to a breach of contract, breach of warranty, the negligence of Graco, or otherwise.

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## Graco Information

For more information about InvisiPac, visit [www.InvisiPac.com](http://www.InvisiPac.com) or email [InvisiPac@graco.com](mailto:InvisiPac@graco.com).

**TO PLACE AN ORDER**, contact your Graco distributor or call to identify the nearest distributor.

For technical assistance or customer service, call toll free: 1-800-458-2133.

*All written and visual data contained in this document reflects the latest product information available at the time of publication.  
Graco reserves the right to make changes at any time without notice.*

Original instructions. This manual contains English. MM 334629

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