

InvisiPac™ Feed System

3A4937G

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*For feeding adhesives to the InvisiPac Hot Melt Delivery System.
For professional use only.*



Important Safety Instructions

Read all warnings and instructions in this manual and in the InvisiPac Hot Melt Delivery System manual. Save all instructions.

Feed Kit 25C193 Single feed system.

(Includes 10 feet of vacuum tube and 10 feet of 3/8 in. air tube)

Feed Kit 25F083 Dual feed system.

(Includes 10 feet of vacuum tube and 10 feet of 3/8 in. air tube)

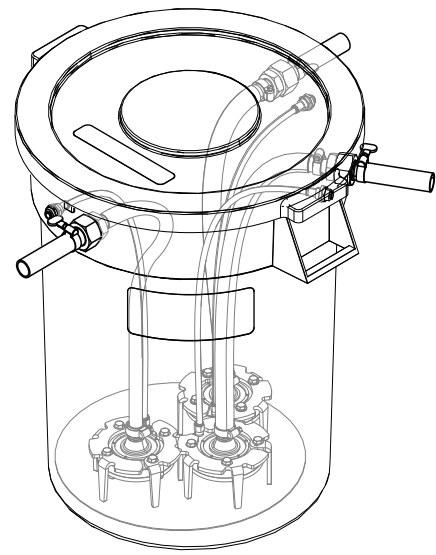
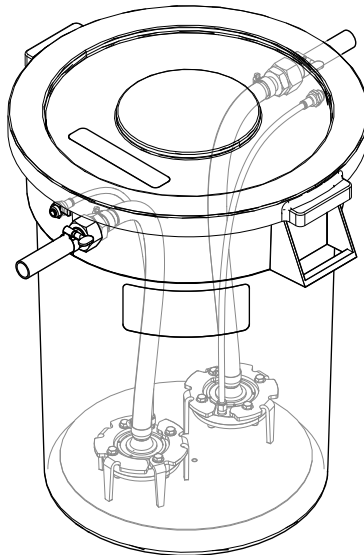
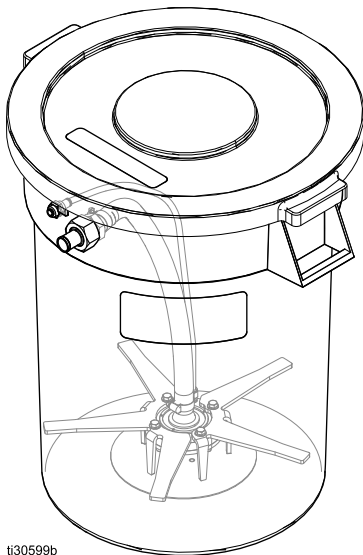
Feed Kit 25F281 Three feed system.

(Not shown) (Includes 10 feet of vacuum tube and 10 feet of 3/8 in. air tube)

25C193 Single Feed System

25F083 Dual Feed System

25F281 Three Feed System



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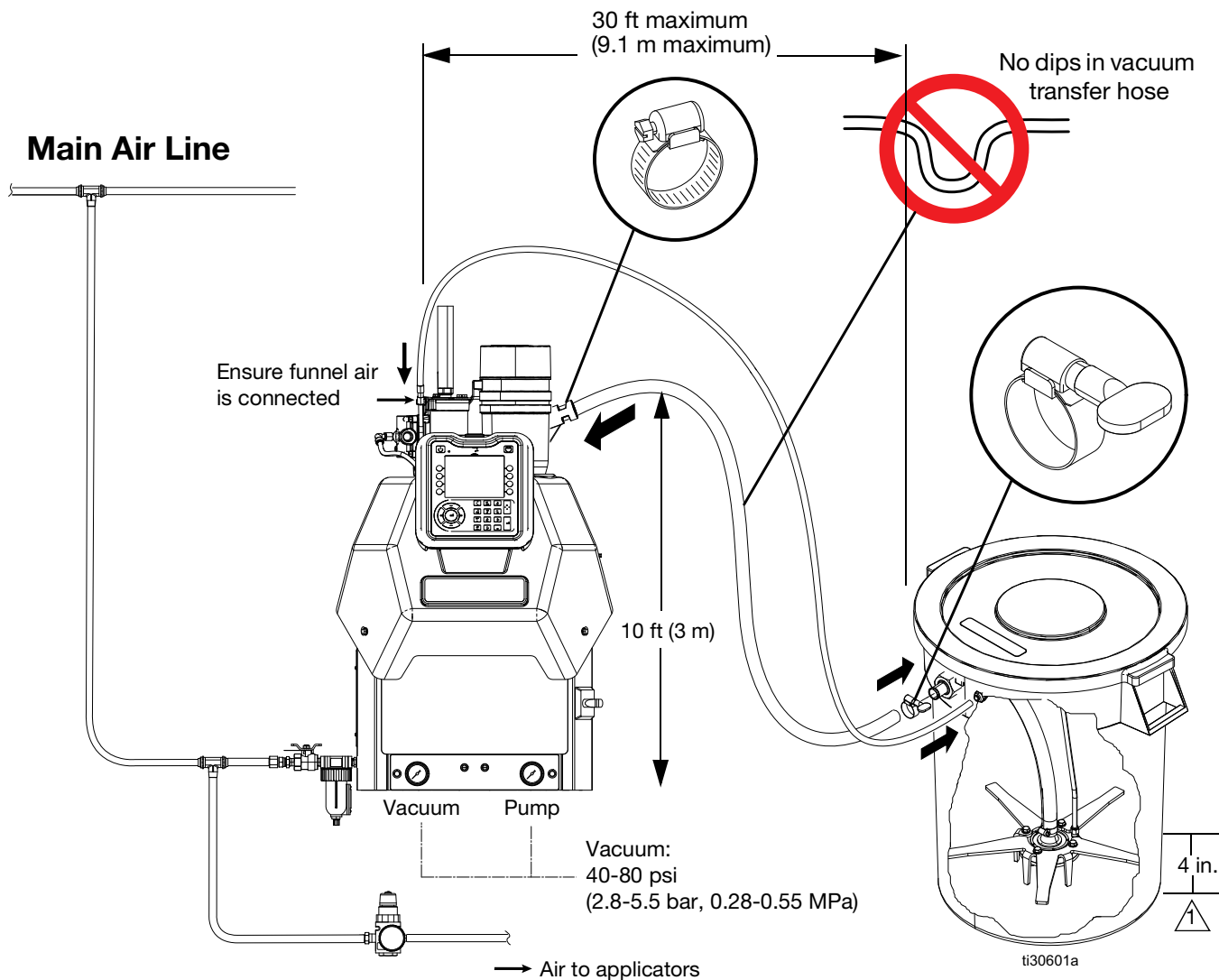
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
Related Manuals

Manual	Description
3A4938	InvisiPac HM25c Hot Melt Delivery System, Instructions - Parts
3A7259	InvisiPac HM10 Hot Melt Delivery System, Instructions
333347	InvisiPac HM25 and HM50 Tank-Free Hot Melt Delivery System, Instructions

Installation

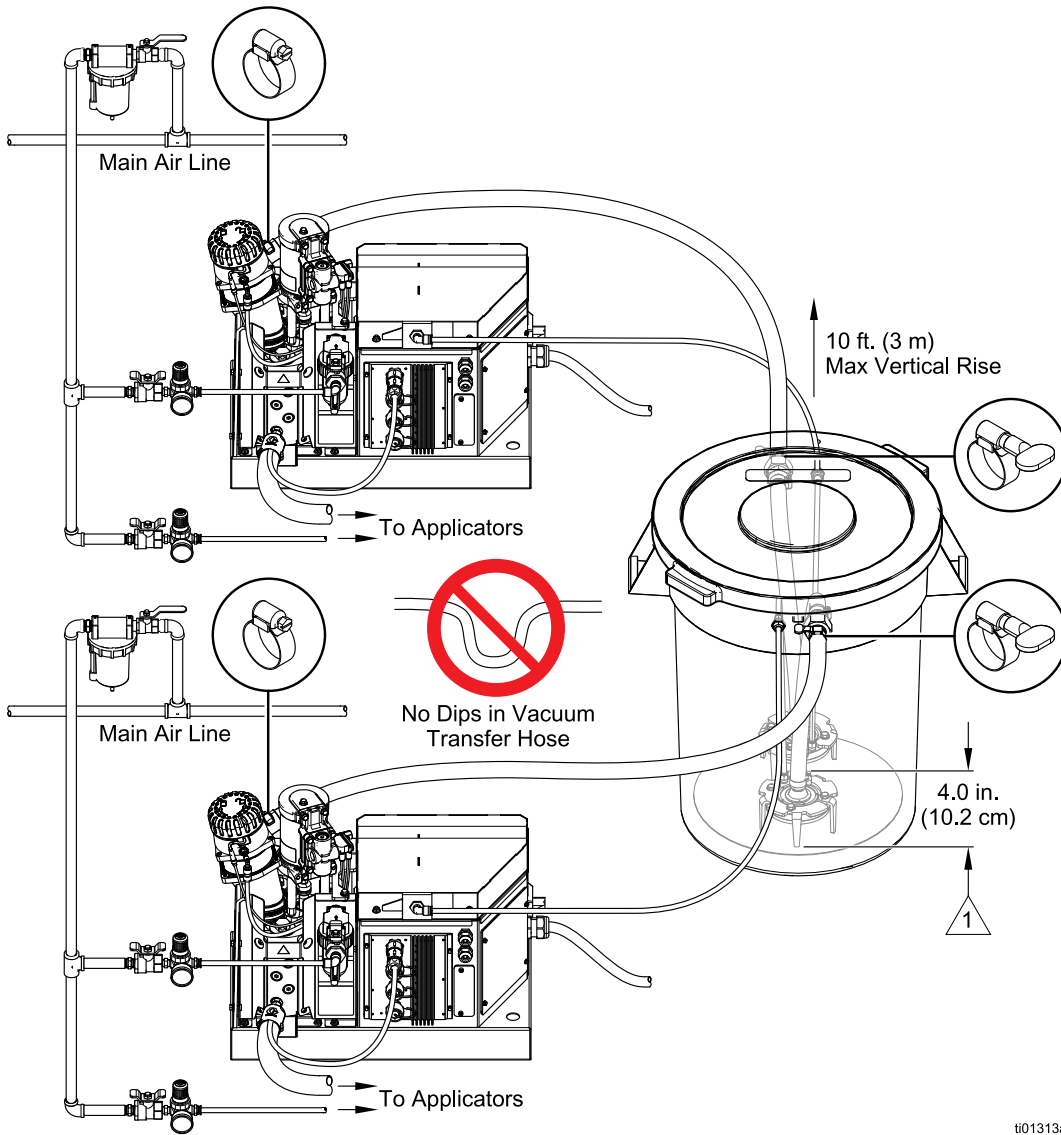
Feed Kit 25C193



 For optimum performance, always keep shaker arms covered with glue pellets (approximately 4 in.).

NOTE: See system manual for required system installation settings.

Feed Kit 25F083

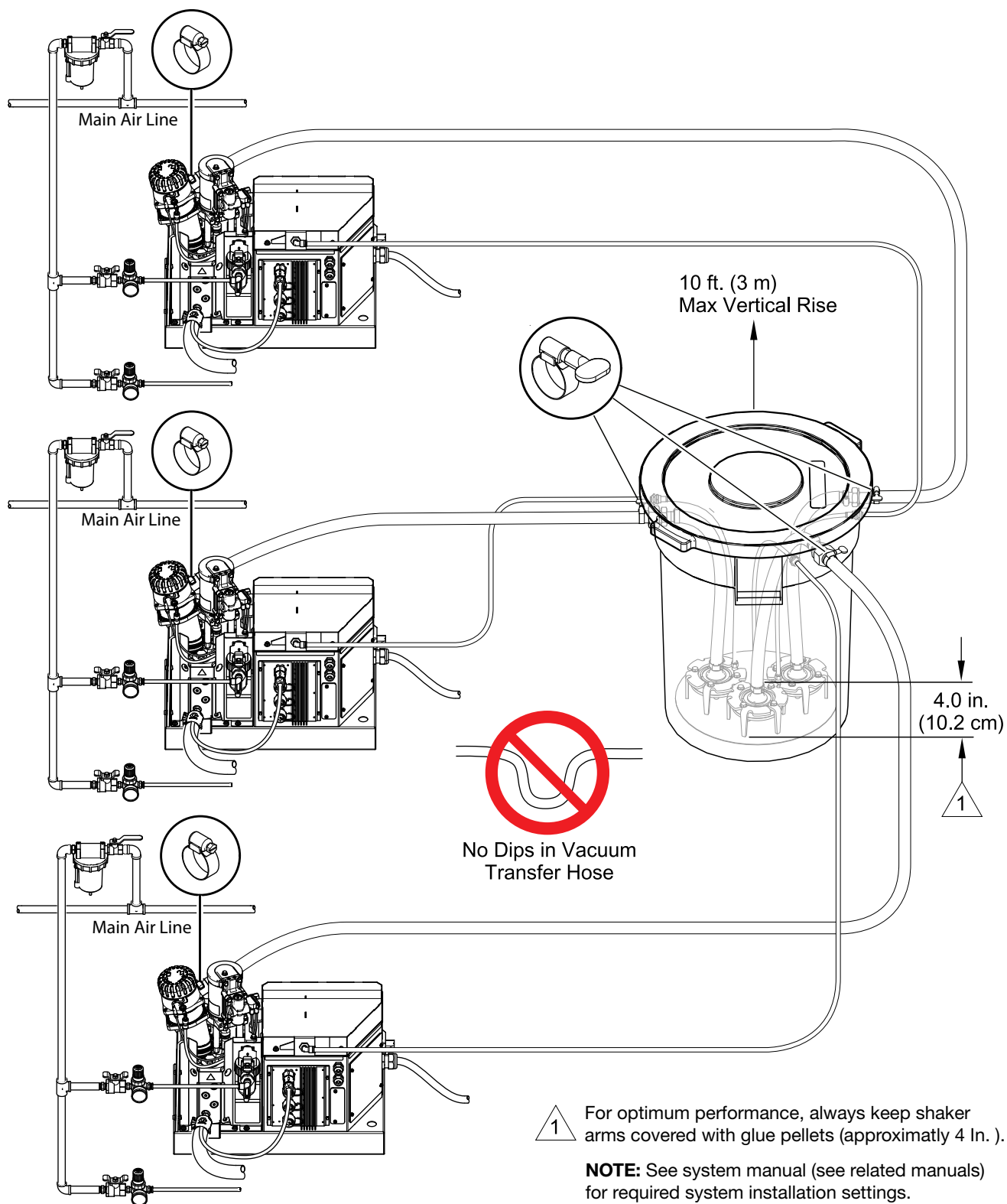


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△ 1 For optimum performance, always keep shaker arms covered with glue pellets (approximately 4 in.).

NOTE: See system manual for required system installation settings.

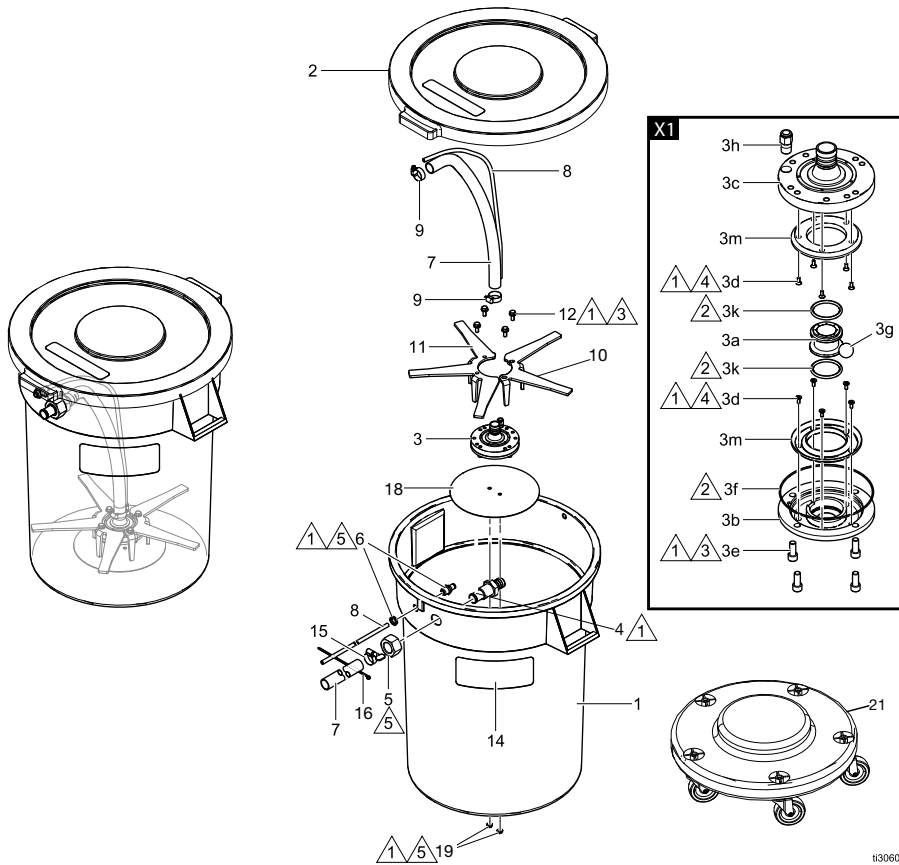
Feed Kit 25F281



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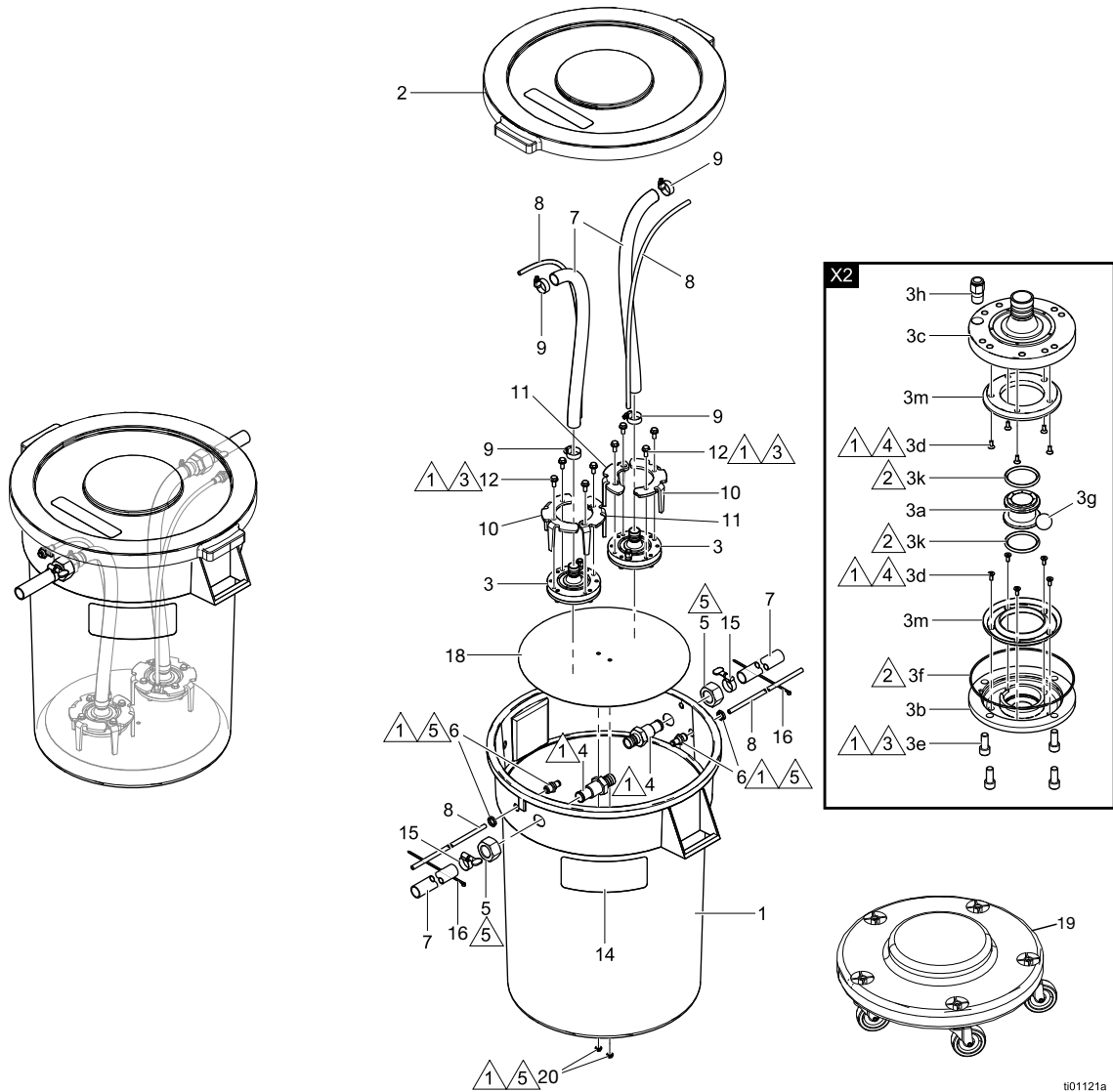
Parts

Feed Kit 25C193



Ref.	Part	Description	Qty.	UOM	Ref.	Part	Description	Qty.	UOM
1▲	17C460	HOPPER, chicklet feed	1	EA	9	125370‡	CLAMP, hose, dia. 11/16-1-1/2 in.	2	EA
2	17C470	COVER, hopper	1	EA	10	17N572	ARM, shaker (3 arm)	1	EA
3	26A287	SHAKER, ball/vac	1	EA	11	17P233	ARM, shaker (2 arm)	1	EA
3a	-----	INSERT, vac	1	EA	12	110963	SCREW, cap, flange head	4	EA
3b	-----	HOUSING, vac, top	1	EA	14	17P382	LABEL	1	EA
3c	-----	HOUSING, vac, bottom	1	EA	15	129621‡	CLAMP, hose, turn-key	1	EA
3d	-----	SCREW, fhsc, 6-32 x 0.375, sst	10	EA	16	125871	CABLE TIE	4	EA
3e	-----	SCREW, 5/16-18 x .75	4	EA	18▲	-----	PLATE, bottom	1	EA
3f	-----	O-RING, seal	1	EA	19▲	-----	NUT, flange	2	EA
3g	-----	BALL, tungsten carbide, .750	1	EA	21	129745	DOLLY, feed system	1	EA
3h	-----	FITTING, air	2	EA		▲	Apply removable thread locker		
3k	-----	PACKING, o-ring	2	EA		▲	Apply grease to seals		
3m	-----	RACE, feed shaker	2	EA		▲	Torque to 15 ft-lb (20.3 N•m)		
3n	-----	LUBRICANT, grease	AR	EA		▲	Torque to 7 in-lb (9.4 N•m)		
3p	-----	SEALANT, anaerobic	AR	EA		▲	Torque to 5 ft -lb (6.7 N•m)		
4 †	-----	FITTING, bulkhead	1	EA		†	Included in Kit 17R717		
5 †	-----	NUT, 1 1/4-12	1	EA		‡	Included in Kit 17R718		
6	598449	BULKHEAD, union	1	EA		▲	Included in kit 26A368		
7 ‡	-----	TUBE, clear pvc	10	FT					
8 ‡	-----	HOSE, nylon, wpr 250 psi	12	FT					

Feed Kit 25F083 Dual Feed System



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FIG. 1: Feed Kit 25F083 Dual feed system

Ref.	Part	Description	Qty.	UOM
1	17C460	HOPPER, chicklet feed	1	EA
2	17C470	COVER, hopper	1	EA
3	26A287	SHAKER, ball/vac	2	EA
3a	-----	INSERT, vac	1	EA
3b	-----	HOUSING, vac, top	1	EA
3c	-----	HOUSING, vac, bottom	1	EA
3d	-----	SCREW, fhsc, 6-32 x 0.375, sst	10	EA
3e	-----	SCREW, 5/16-18 x .75	4	EA
3f	-----	O-RING, seal	1	EA
3g	-----	BALL, tungsten carbide, .750	1	EA
3h	-----	FITTING, air	2	EA

Parts

Ref.	Part	Description	Qty.	UOM
3k	-----	PACKING, o-ring	2	EA
3m	-----	RACE, feed shaker	2	EA
3n	-----	LUBRICANT, grease	AR	EA
3p	-----	SEALANT, anaerobic	AR	EA
4	†	FITTING, bulkhead	1	EA
5	†	NUT, 1 1/4-12	1	EA
6	598449	BULKHEAD, union	2	EA
7	‡	TUBE, clear pvc	10	FT
8	‡	HOSE, nylon, wpr 250 psi	12	FT
9	125370‡	CLAMP, hose, dia. 11/16-1-1/2 in.	2	EA
10	18E214	ARM, shaker, 3 blade, short	2	
11	18E213	ARM, shaker, 2 blade short	2	EA
12	110963	SCREW, cap, flange head	8	EA
14	17P382	LABEL	2	EA
15	129621‡	CLAMP, hose, turn-key	1	EA
16	125871	CABLE TIE	8	EA
18	-----	PLATE, bottom	1	EA
19	-----	NUT, flange	2	EA
21	129745	DOLLY, feed system	1	EA

① Apply removable thread locker to threads

② Apply grease to seals

③ Torque to 15 ft-lb (20.3 N•m)

④ Torque to 7 in-lb (9.4 N•m)

⑤ Torque to 5 ft -lb (6.7 N•m)

† Included in Kit 17R717

‡ Included in Kit 17R718

Feed Kit 25F281 Three Feed System

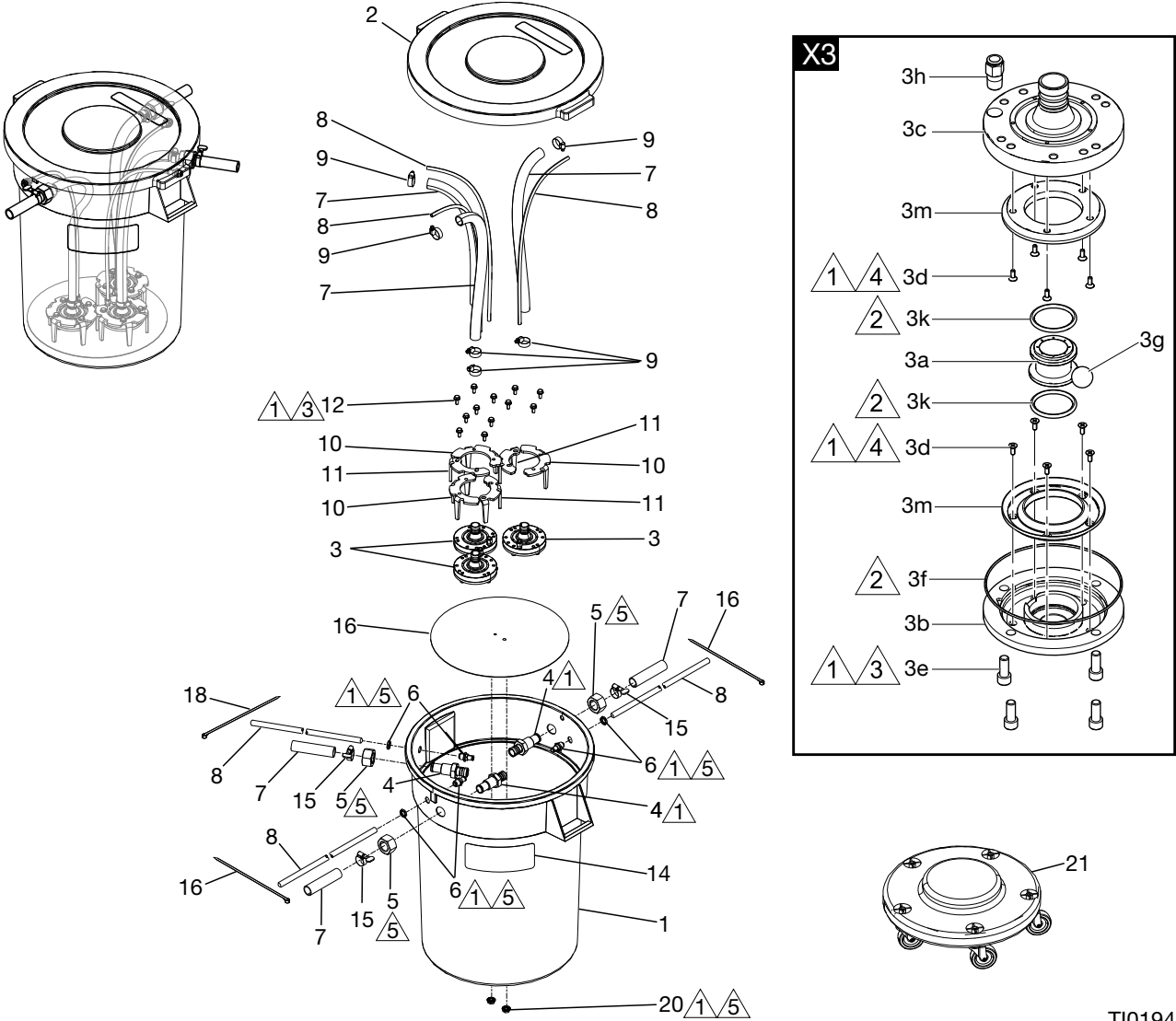


FIG. 2: Feed Kit 25F281 Triple feed system

Ref.	Part	Description	Qty.	UOM
1	17C460	HOPPER, chicklet feed	1	EA
2	17C470	COVER, hopper	1	EA
3	26A287	SHAKER, ball/vac	3	EA
3a	-----	INSERT, vac	1	EA
3b	-----	HOUSING, vac, top	1	EA
3c	-----	HOUSING, vac, bottom	1	EA
3d	-----	SCREW, mach, flat head	10	EA
3e	-----	SCREW, 5/16-18 x .75	4	EA
3f	-----	O-RING, seal	1	EA
3g	-----	BALL, tungsten carbide, .750	1	EA
3h	-----	FITTING, air	1	EA

Parts

Ref.	Part	Description	Qty.	UOM
3k	-----	PACKING, o-ring	2	EA
3m	-----	RACE, feed shaker	2	EA
3n	-----	LUBRICANT, grease	AR	EA
3p	-----	SEALANT, anaerobic	AR	EA
4	†	FITTING, bulkhead	1	EA
5	†	NUT, 1 1/4-12	1	EA
6	598449	BULKHEAD, union	3	EA
7	‡	TUBE, clear pvc	10	FT
8	‡	HOSE, nylon, wpr 250 psi	12	FT
9	125370‡	CLAMP, hose, dia. 11/16-1-1/2 in.	2	EA
10	18E214	ARM, shaker, 3 blade, short	3	EA
11	18E213	ARM, shaker, 2 blade short	3	EA
12	110963	SCREW, cap, flange head	12	EA
14	17P382	LABEL	2	EA
15	129621‡	CLAMP, hose, turn-key	1	EA
16	125871	CABLE TIE	12	EA
18	-----	PLATE, bottom	1	EA
19	-----	NUT, flange	2	EA
21	129745	DOLLY, feed system	1	EA

① Apply removable thread locker to threads

② Apply grease to seals

③ Torque to 15 ft-lb (20.3 N•m)

④ Torque to 7 in-lb (9.4 N•m)

⑤ Torque to 5 ft -lb (6.7 N•m)

† Included in Kit 17R717

‡ Included in Kit 17R718

Accessories

Part	Description
24R043	30 ft feed hose kit, includes hose clamp (2) clear PVC tube (30 ft), 3/8 in. nylon hose (34 ft), cable tie (10)
129745	Feed Bin Dolly
17D747	Filtered Cover

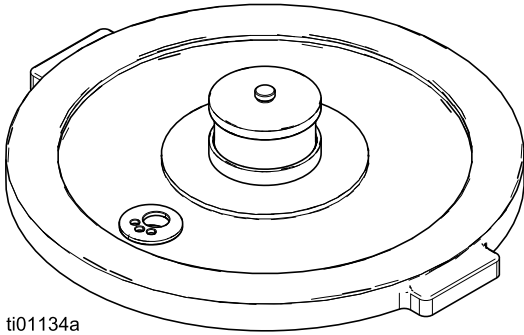


FIG. 1: Filtered Cover

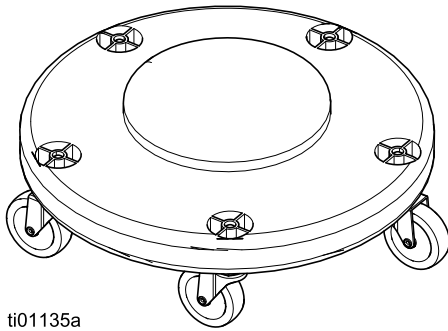


FIG. 2: Feed Bin Dolly

Technical Specifications

Vacuum Transfer Specifications		
	US	Metric
Maximum Vacuum Transfer Hose Length	30 ft	9.1 m
Maximum Vacuum Transfer Hose Maximum Vertical Rise	10 ft	3.0 m
Vacuum Transfer Operating Pneumatic Pressure Range (set with regulator on front of system)	40-100 psi	280-690 kPa (2.8-6.9 bar)
Vacuum Transfer Air Consumption at 40 psi (280 kPa, 2.8 bar)	9.5 scfm (intermittent duty; 4% at 25 lb/hr)	16.1 scmh (intermittent duty; 4% at 11.3 kg/hr)
Vacuum Transfer Air consumption at 80 psi (550 kPa, 5.5 bar)	17.2 scfm (intermittent duty; 4% at 25 lb/hr)	29.2 scmh (intermittent duty; 4% at 11.3 kg/hr)

Graco Standard 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.

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Graco Information

For more information about InvisiPac, visit www.InvisiPac.com or email 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.

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Graco Headquarters: Minneapolis
International Offices: Belgium, China, Japan, Korea

GRACO INC. P.O. BOX 1441 MINNEAPOLIS, MN 55440-1441

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