

BF 400V / 600V

Bliss-Matic[®]

Options



A  DOVER COMPANY

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Safety Practices

Injury or loss of limbs may result if this machine is improperly operated or maintained. Please note the following precautions:

-  Never adjust, repair, clean, or clear a jam without turning the power off. To shut down the power, turn the disconnect switch to the off position and lock it in the off position.
-  Do not operate this machine without the guards in place.
-  Turn off the power before removing or opening any guards. Turning off the power means locking the power disconnect switch in the off position.
-  Hot surfaces! Severe burns result from the improper handling of the hot melt glue system. Wear proper clothing and high temperature gloves when cleaning or repairing the hot melt glue system.
-  Replace all broken or worn parts immediately. Check and tighten all bolts and screws.
-  High voltage electrical equipment – authorized personnel only.
-  Turn off the power when the machine is not in use.
-  This machine starts automatically in the ‘auto’ position when the downstream control contact and/or time delay attachment is used.
-  Always wear proper clothing during operation of heavy-duty machinery.

SWF Machinery endeavors to comply with OSHA standards. You, however, are the most important part of safe equipment operation. In order to provide for your safety, you should be knowledgeable and put into practice the following:

-  Always know the purpose of the control buttons and selector switches before operating any equipment.
-  Always perform an emergency stop and a normal cycle stop before operating this machine.
-  Be familiar with the power off or disconnect procedure. This procedure includes turning off the power and locking the power disconnect switch in the off position.
-  Always be aware of all moving parts and of the danger in putting hands or limbs in or around these areas.
-  Note the high operating temperatures required in operating the glue system. Always wear gloves, goggles, and protective clothing when servicing the glue systems.

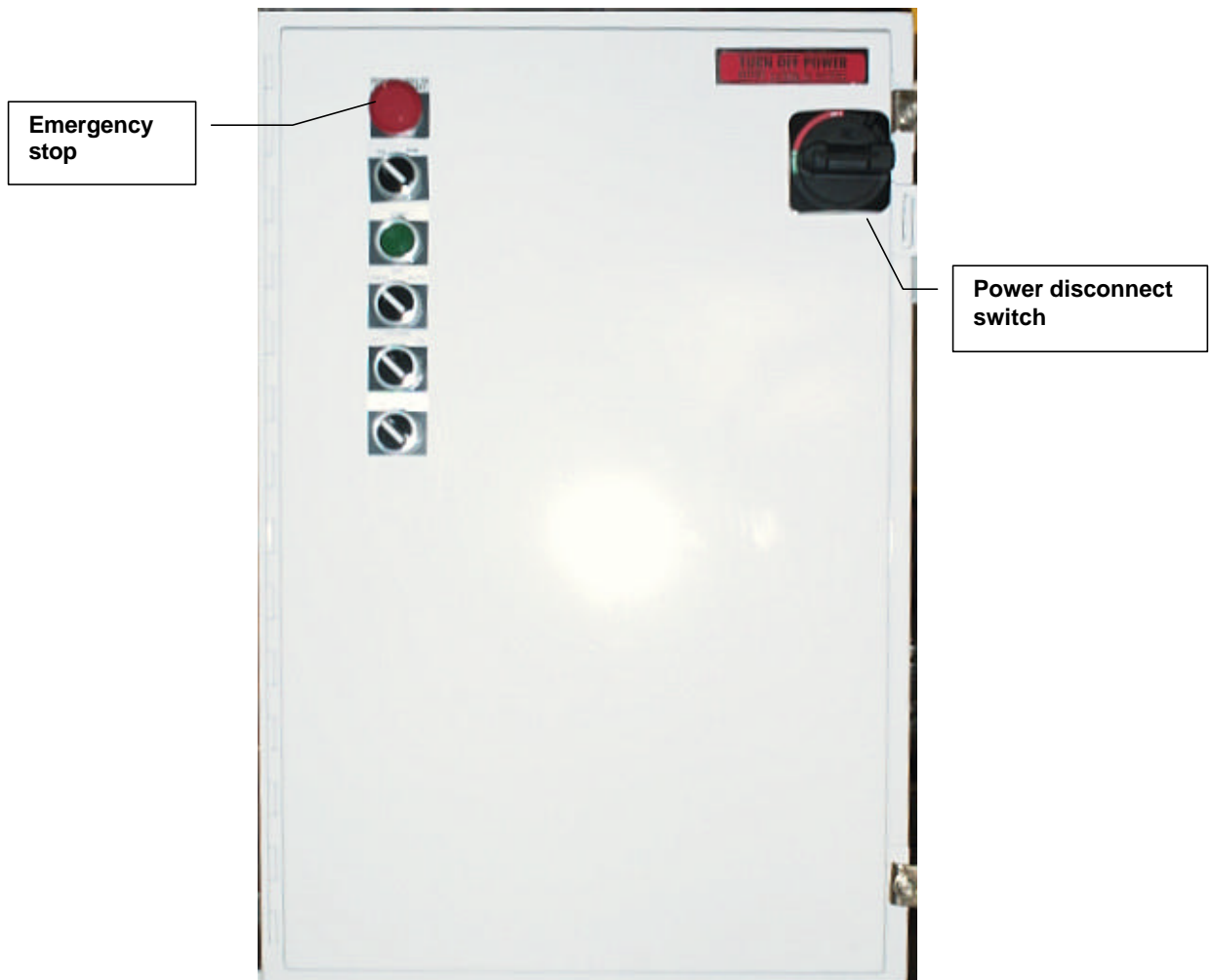
Lockout Information

Never attempt to adjust, repair, clean, or remove corrugated in a jam condition, without stopping, powering down, and locking the machine out.

Main Power Panel

To lock out the power:

1. Push the red emergency stop button.
2. Rotate the disconnect switch to the “Off-Lock” position.
3. Under the disconnect switch, locate and push up the lock slide.
4. Insert a lock into the exposed squared area.
5. Test all buttons and try moving the switch to make sure power cannot be applied.



Options

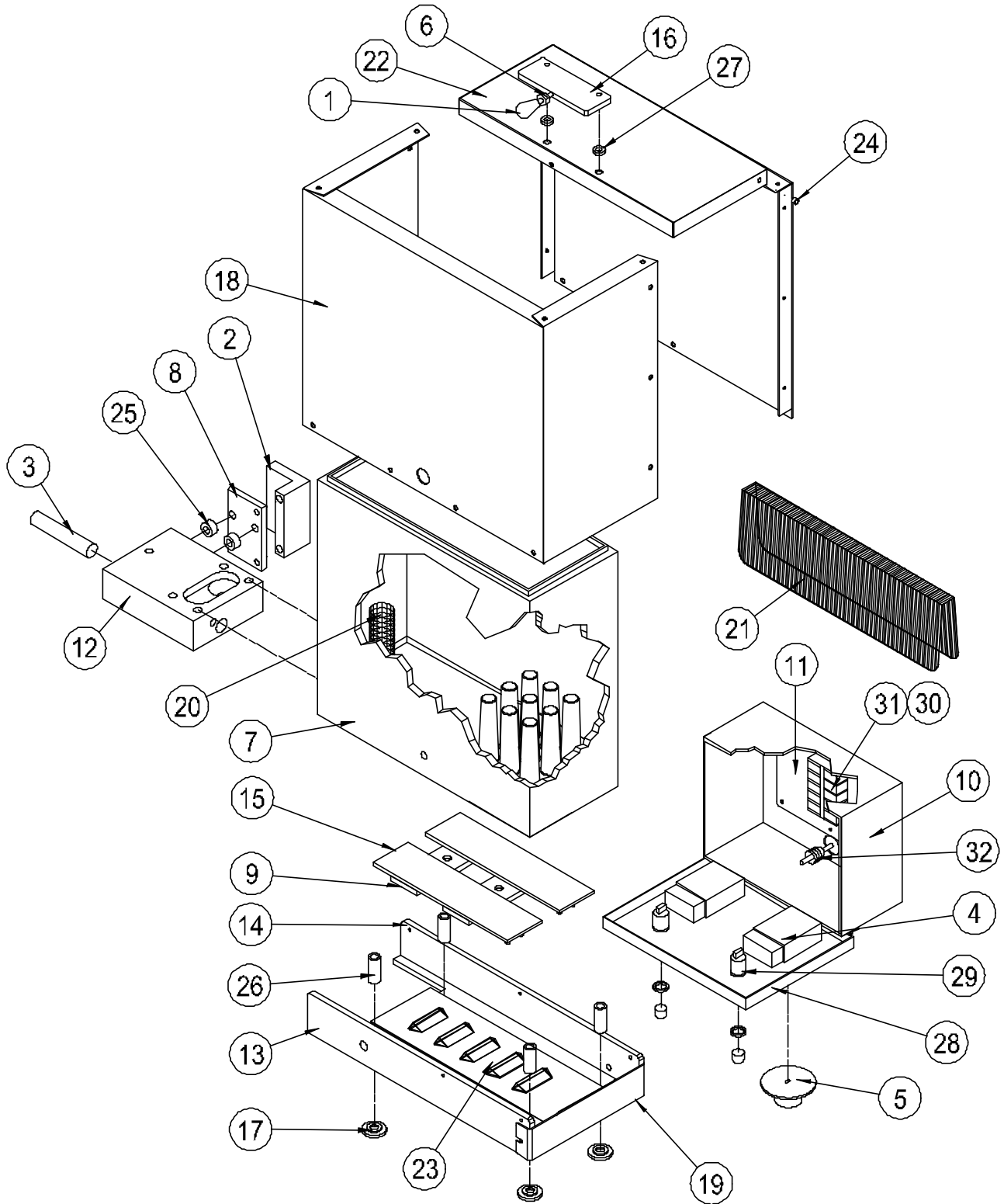
The following are available options for the SWF 1D5AK/1D6AK BLISSMATICS. Contact SWF Machinery for information.

- Large capacity glue pots
- Time delay
- Down stream control systems
- Color coded wiring
- Customized paint
- Left hand control box
- NEMA 4 power cabinet enclosures
- Hoppers, various capacities
- Hopper, horizontal powered
- Hopper , low level indicator
- Hopper, empty cycle stop
- Bottom stop jam detector
- Pressurized hot melt systems
- Cold glue systems
- Code daters / Bar counters
- Adjustable legs
- Special guarding
- Additional manuals
- Pressurized lubrication system
- Lidding attachment

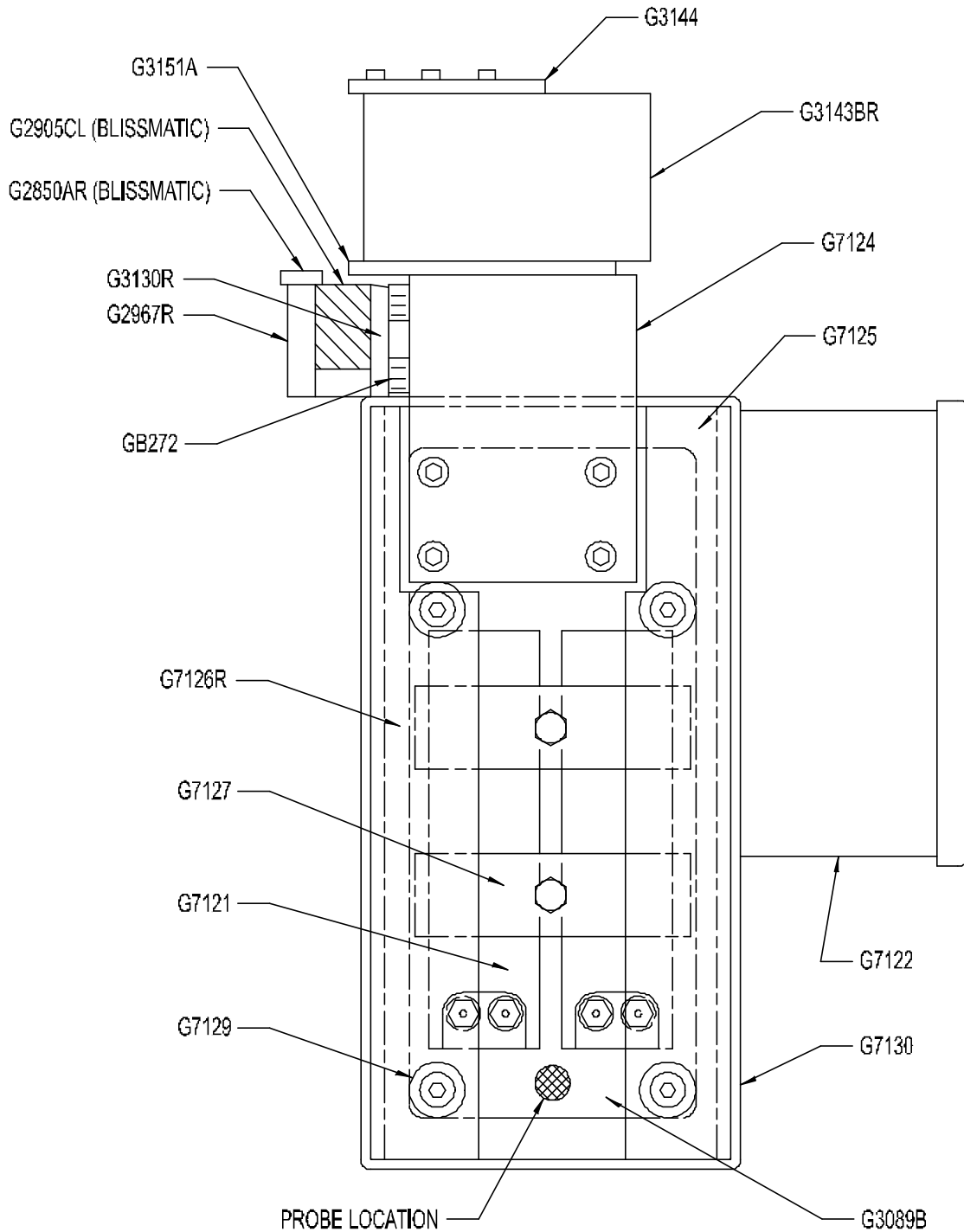
Double Capacity Adhesive Melt Pot

Item	Qty.	Part No.	Description
1	1	00-02758-00	KNOB, MELT POT COVER
2	1R/1L	00-02967-00	CLAMP, GLUE POT MOUNTING
3	1	00-02997-00	HEATER, GLUE MELTING
4	2	00-02998-02	THERMOSTAT
5	2	40-02998-02	KNOB ,THERMOSTAT
6	1	00-03067-00	STUD, GLUE POT COVER KNOB W/ LOCKNUT 10-32
7	1R/1L	00-03089-02	CASTING, GLUE POT
8	1R/1L	00-03130-00	PLATE, GLUE POT MOUNTING
9	2	00-07121-00	HEATER, GLUE POT STRIP
10	1	00-07122-00	ENCLOSURE, GLUE POT CONTROL
11	1	00-07123-00	PANEL, GLUE ENCLOSURE
12	1R/1L	00-07124-00	MANIFOLD, GLUE POT
13	1R/1L	00-07125-00	BASE, GLUE POT FRONT
14	1R/1L	00-07126-00	BASE, GLUE POT REAR
15	2	00-07127-00	PLATE, STRIP HEATER CLAMP
16	1	00-07128-00	HANDLE, LARGE GLUE POT
17	4	00-07129-00	WASHER, GLUE POT MOUNTING
18	1	00-07130-00	SHROUD, GLUE POT
19	1	00-07131-00	END CAP, GLUE POT FIXED
20	1	00-07132-00	SCREEN, GLUE POT FIXED
21	1	00-07133-00	SCREEN, GLUE POT
22	1	00-07134-00	COVER, GLUE POT
23	1	00-07135-00	PLATE, BOTTOM ENCLOSURE SHROUD
24	2	02-00040-00	BUSHING, GLUE POT COVER AXLE
25	2	02-00272-00	BUSHING, GLUE POT MOUNTING
26	4	02-00396-00	SPACER, GLUE POT CASTING MOUNTING
27	2	02-00499-00	SPACER, HANDLE MOUNTING
28	2	22-00006-01	LIGHT, HEATER INDICATING
29	2	22-00006-02	LAMP, HEATER INDICATING
30	2	41-00008-04	TERMINAL BLOCK SECTION END 230
31	6	50-00008-01	TERMINAL SECTION 514

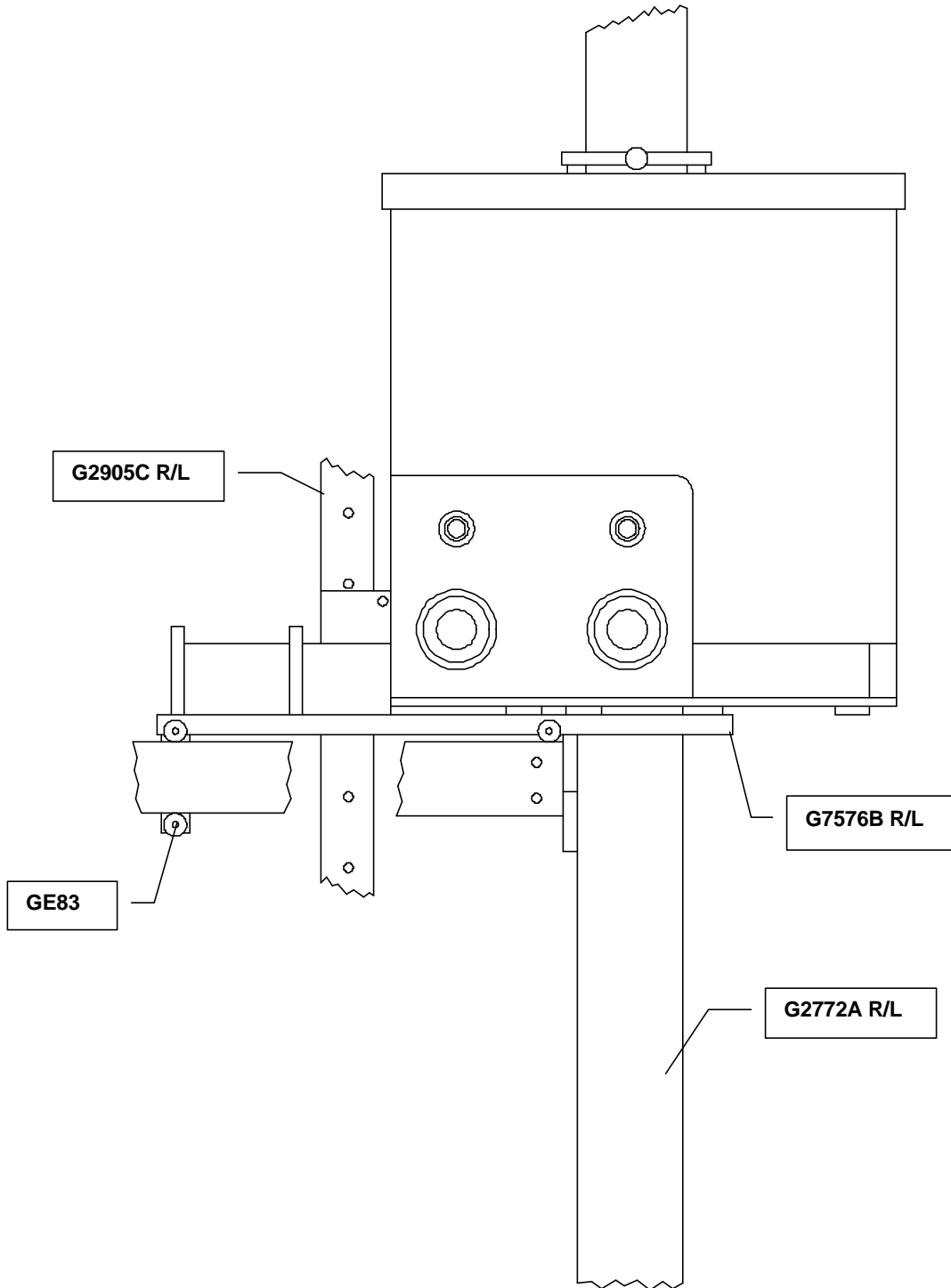
Double Capacity Adhesive Melt Pot



Double Capacity Glue Pot (Bottom)



Double Glue Pot Mounting Detail

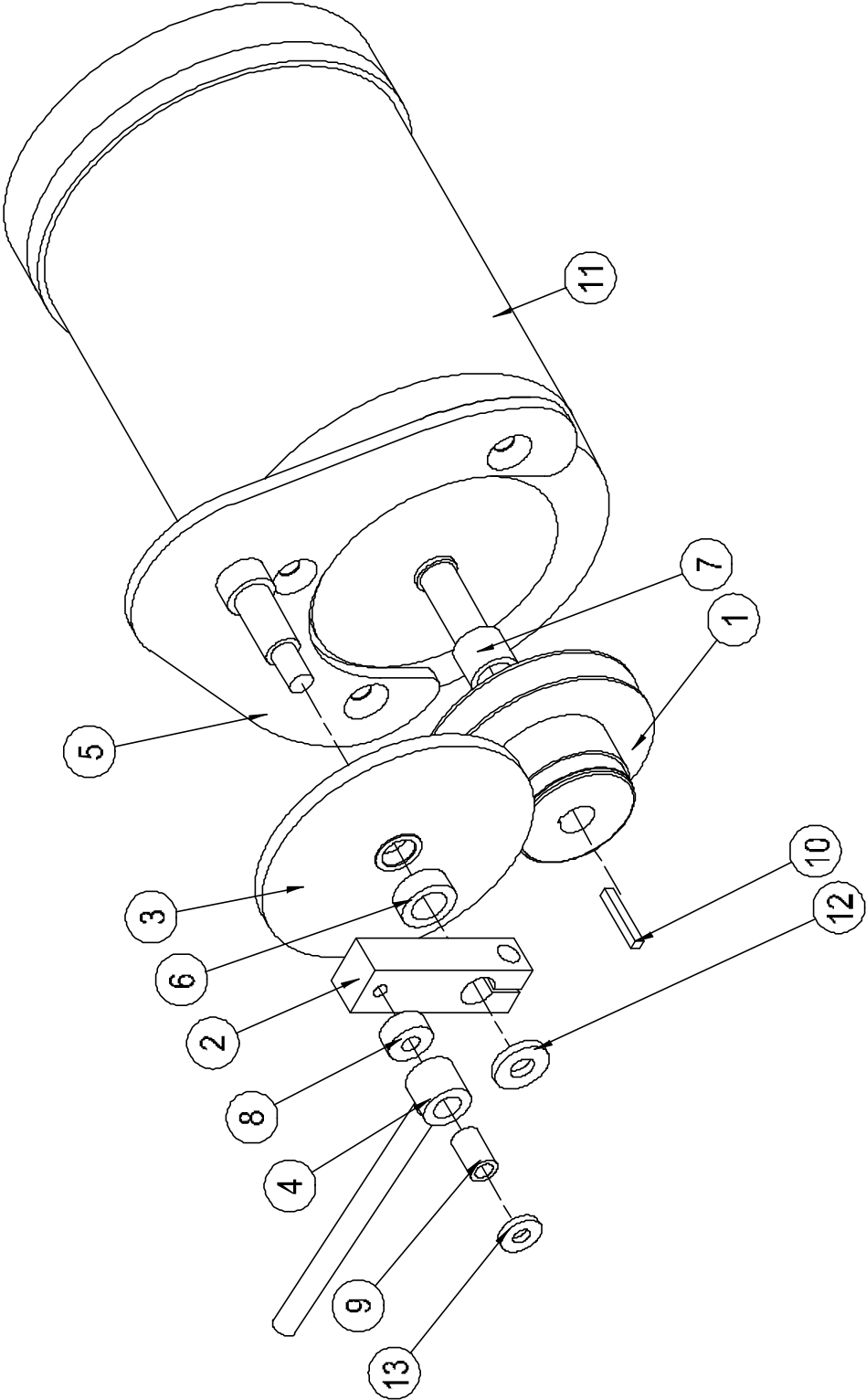


V-Belt Vari-Drive

Item	Qty.	Part No.	Description
1	1	00-03231-00*	PULLEY, VARI-DRIVE MOTOR..12-35 OR 21-58 SPEED
		00-03231-00*	PULLEY, VARI-DRIVE MOTOR..29-70 SPEED
2	1	00-03232-00	ARM, MOTOR DRIVE SPEED CONTROL
3	1	00-03233-00	WASHER, MOTOR DRIVE BASE
4	1	00-03235-00	ROD, SPEED CONTROL OPERATING
5	1	00-03236-00	BASE, MOTOR DRIVE
6	1	02-00145-00	BUSHING, SPEED CONTROL ARM SPACER
			1 OD x 41/64 ID x 3/8 LONG
7	1	00-00198-00	BUSHING, MOTOR PULLEY SPACER
			7/8 OD 5/8 ID x 3/4 LONG
8	1	00-00267-00	BUSHING, SPEED CONTROL OPERATING SPACER
			13/16 OD x 21/64 ID x 3/8 LONG
9	1	00-00271-00	BUSHING, SPEED CONTROL OPERATING ROD
			1/2 OD x 21/64 ID x 25/32 LONG
10	1	10-00009-04	KEY, VARI-DRIVE PULLEY
11	1	13-00004-02*	MOTOR, 3/4 H.P., 3 PHASE, 240/460V, 50/60HZ 1800 RPM
		13-00004-04*	MOTOR, 3/4 H.P., 3 PHASE, 115/230V, 50/60HZ 1200 RPM
		13-00005-04*	MOTOR, 1 H.P., 3 PHASE, 230/460V, 50/60HZ 1140 RPM
12	1	23-00001-00	WASHER, 1 OD x 7/16 ID x 5/32 THICK
13	1	23-00056-00	WASHER, 3/4 OD x 5/16 ID x 1/8 THICK

Note: * Refer to machine order part number

V-Belt Vari-Drive

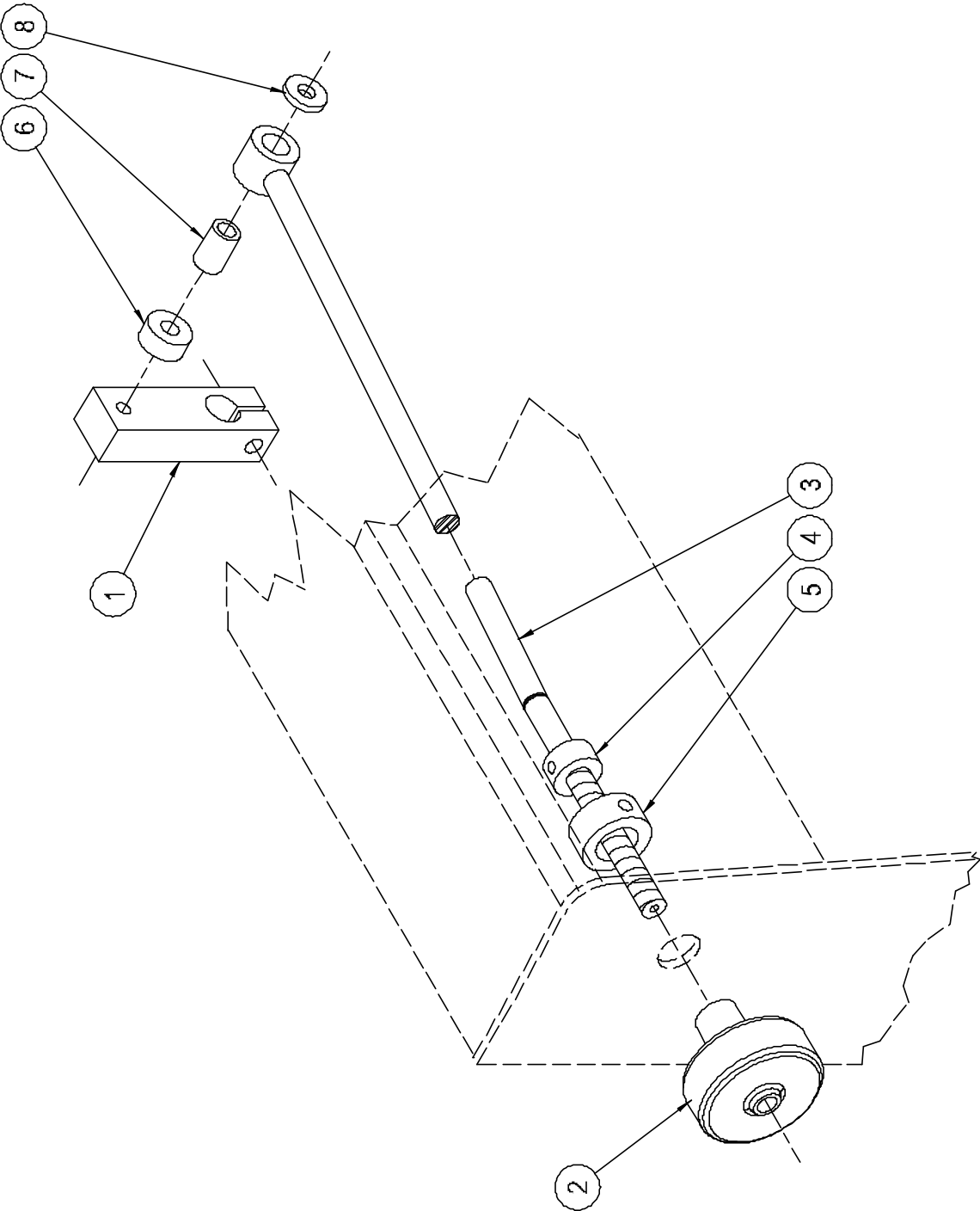


Vari-Speed Control

Item	Qty.	Part No.	Description
1	1	00-03232-00	ARM, MOTOR DRIVE SPEED CONTROL
2	1	00-03234-00	KNOB, SPEED CONTROL
3	1	00-03235-00	ROD, SPEED CONTROL OPERATING
4	1	01-00005-00	SET COLLAR, SPEED CONTROL ROD STOP
5	1	01-00009-00	SET COLLAR, SPEED CONTROL KNOB RETAINING
6	1	00-00267-00	SPACER, CONTROL OPERATING ROD
7	1	00-00271-00	BUSHING, SPEED CONTROL OPERATING ROD
8	1	23-00056-00	WASHER, 3/4" OD x 5/16" ID x 1/8" THICK

Note: These parts may be purchased as a preassembled package. To order, specify BU176.

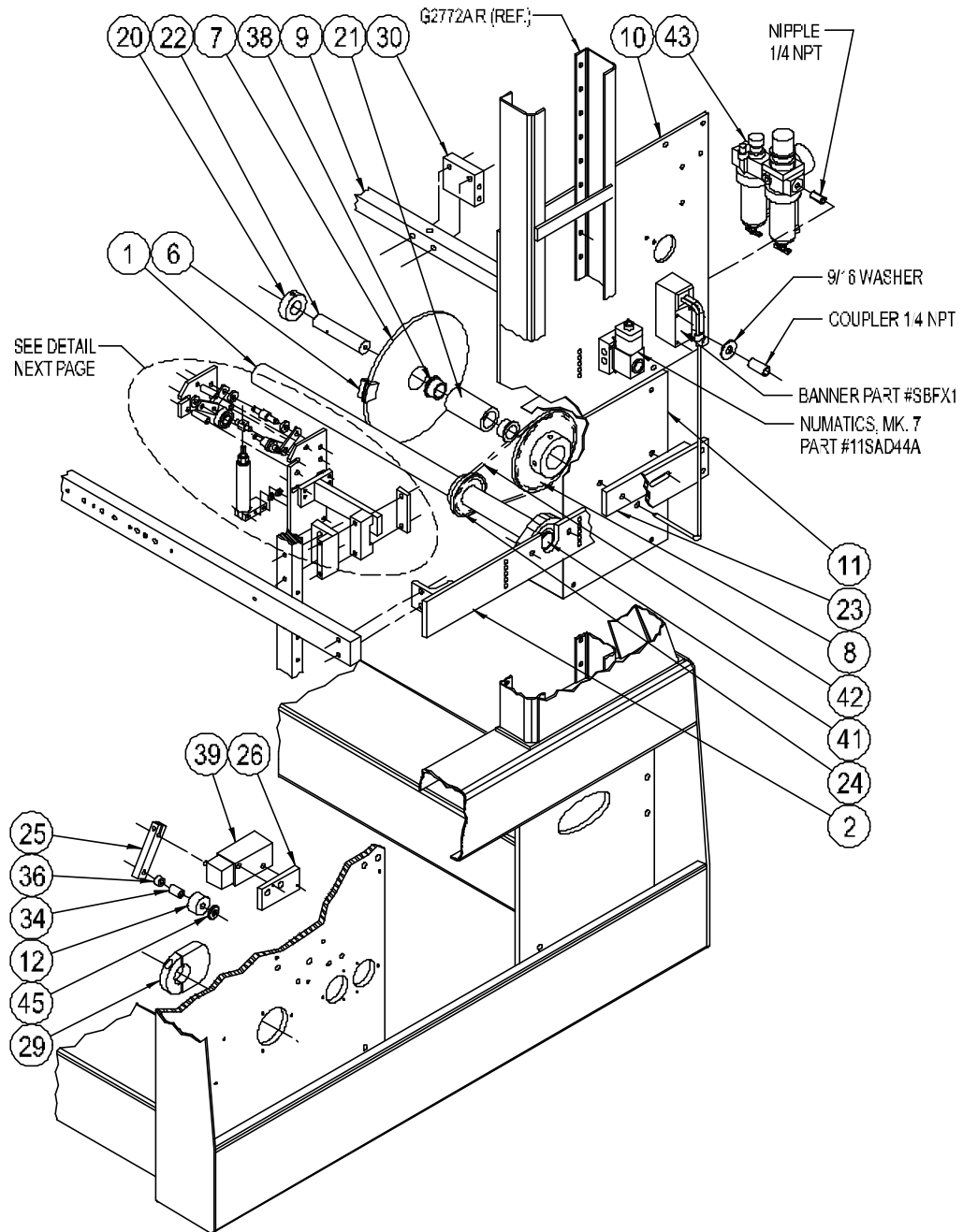
Vari-Speed Control

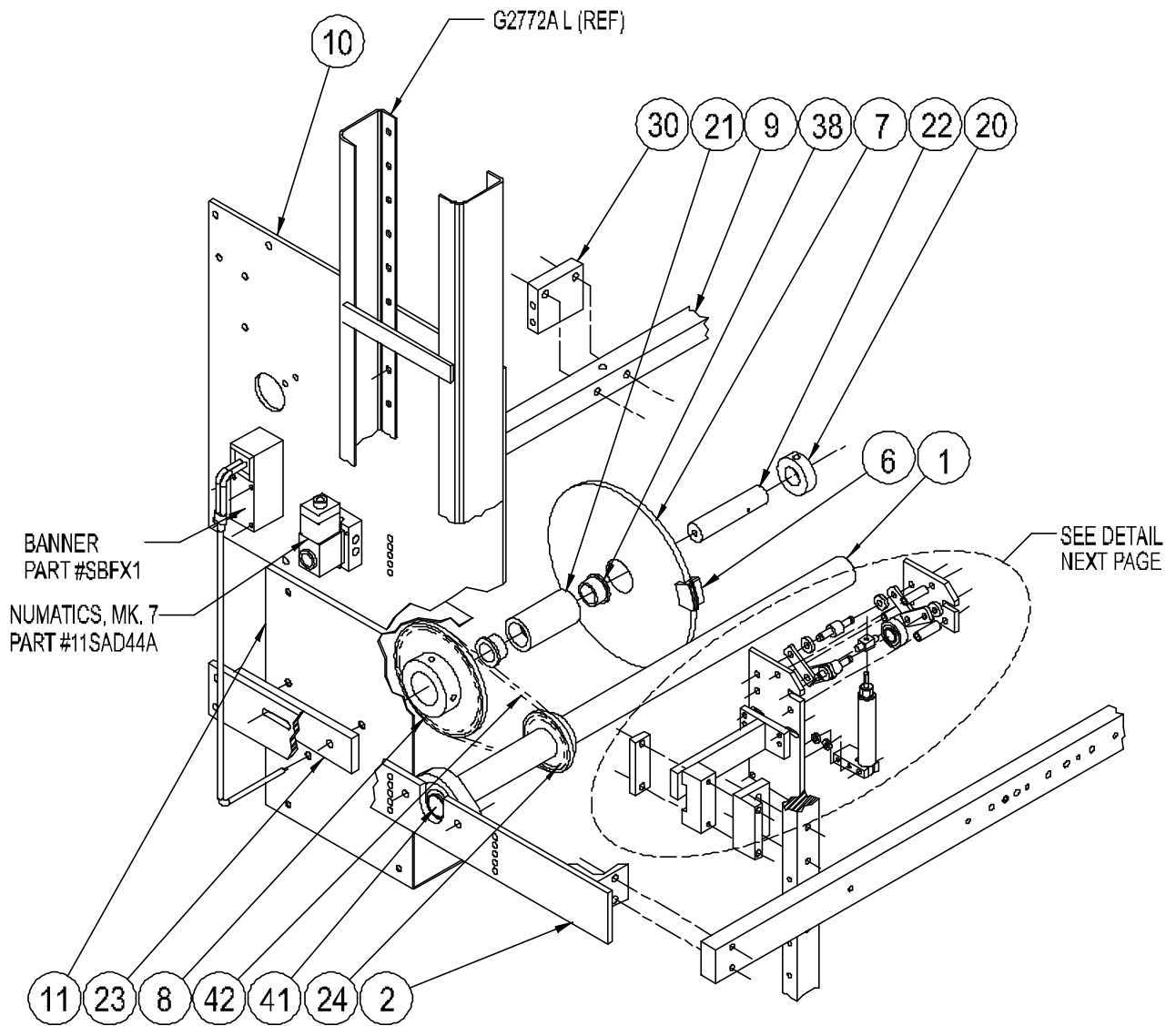


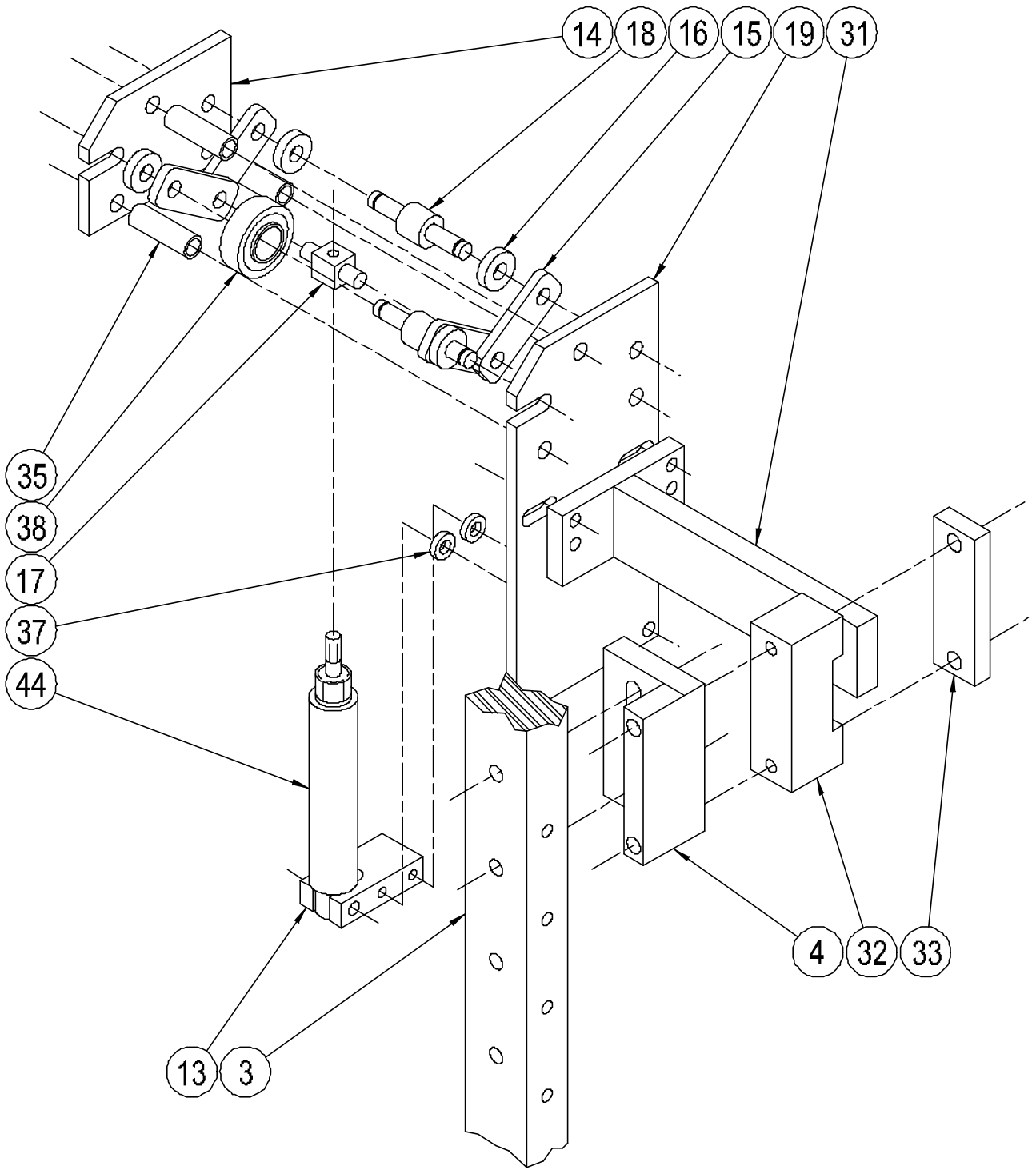
Bliss Back-up Roller Programmer (Right, Left Side & Air Programmer)

Item	Qty.	Part No.	Description
1	1	00-02832-05	SHAFT, MATT FEED ROLLER
2	1	00-02900-09	PLATE, MATT FEED WHEEL SHAFT MOUNTING
3	1	00-02905-03	BAR, MATT GUIDE VERTICAL R & L
4	1	00-02967-01	CLAMP, ADHESIVE MELT POT
5	1	00-02999-04	BAR, MATT FEED IDLE ROLLER
6	1	00-03028-02	SEGMENT, AHESIVE APPLICATOR PROGRAM
7	1	00-03029-01	DISC, INTERMITTENT ADHESIVE APPLICATOR PROG.
8	1	00-07806-03	SPROCKET, PROGRAM BACK-UP ROLLER
9	1	00-07820-00	BAR, VACUUM FEED MOUNTING RIGHT
10	1	00-07829-00	PLATE, VACUUM FEED MOUNTING RIGHT
11	1	00-07832-02	GUARD, PROGRAM DISC
12	1	00-08458-01	ROLLER, MICROSWITCH OPERATING
13	1	00-08628-00	BRACKET, CYLINDER PIVOT MOUNTING
14	1	00-08629-00	PLATE, PROGRAM BACK-UP ROLLER SIDE
15	4	00-08630-00	LINK, PROGRAM OPERATING
16	4	00-08631-00	SPACE, GLUE BACK-UP ROLLER
17	1	00-08632-00	AXLE, ROLLER ACTUATOR LINK
18	2	00-08633-00	PIN, BLISS BACK-UP ROLLER AXLE
19	1	00-08634-00	PLATE, PROGRAM BACK-UP ROLLER MOUNTING
20	1	00-08635-01	SET COLLAR, PROGRAM DISC
21	1	00-08636-00	BEARING, DISC PROGRAM
22	1	00-08637-00	AXLE, PROGRAM DISC MOUNTING
23	1	00-08638-00	PLATE, PROGRAM DISC MOUNTING
24	1	00-08639-00	SPROCKET, PROGRAM BACK-UP ROLLER
25	1	00-08640-01	LEVER, MICROSWITCH OPERATING
26	1	00-08641-01	PLATE, MICROSWITCH MOUNTING
27	1	00-08643-01	COVER, LEAD FIBER OPTIC EYE
28	2	00-08643-02	PLATE, BANNER EYE MOUNTING
29	1	00-08644-02	CAM, BLISS PROGRAMMER REVOLUTION OPERATING
30	1	00-08646-00	MANIFOLD, BLISS PROGRAM AIR
31	1	00-08647-00	BRACKET, PROGRAM BACK-UP ROLLER MOUNTING
32	1	00-08648-00	BLOCK, PROGRAM BLISS BACK-UP ROLLER MOUNTING
33	1	00-08649-00	CLAMP, BLISS BACK-UP ROLLER PROGRAM MOUNTING
34	1	02-00045-00	BUSHING, 9/16 OD x 3/8 ID x 51/64 LONG
35	3	02-00331-00	BUSHING, 7/16 OD x 21/64 ID x 1 3/8 LONG
36	1	02-00372-00	BUSHING, 3/4 OD x 3/8 ID x 25/64 LONG
37	2	00-00499-00	BUSHING, 1/2 OD x 17/64 ID x 1/8 LONG
38	2	02-00512-00	BUSHING, 1 1/4 OD x 1 ID x 3/4 L w/ 1 1/2 OD x 1/8 T FLANGE
39	1	04-00068-00	MICROSWITCH, SPOT SIDE ROTARY (HDLs)

Bliss Back-up Roller Programmer (Right, Left Side & Air Programmer)







Flange End Attachment 1 RH / 1 LH

Item	Qty.	Part No.	Description
1	1R/1L	00-02692-01	STRIP, FORM PLUNGER GUIDE
		00-03185-00	SPACER, COMPRESSION CHAMBER MOUNTING BRKT. (FOR 1 1/2" FLANGE, 7/16" MATERIAL THICKNESS)
		00-03185-01	SPACER, COMPRESSION CHAMBER MOUNTING BRKT. (FOR 3" FLANGE, 1 15/16" MATERIAL THICKNESS)
		00-03185-02	SPACER, COMPRESSION CHAMBER MOUNTING BRKT. (FOR 1 3/4" FLANGE, 11/16" MATERIAL THICKNESS)
2	4	00-03185-03	SPACER, COMPRESSION CHAMBER MOUNTING BRKT. (FOR 2" FLANGE, 15/16" MATERIAL THICKNESS)
		00-03185-04	SPACER, COMPRESSION CHAMBER MOUNTING BRKT. (FOR 2 1/2" FLANGE, 1 3/16" MATERIAL THICKNESS)
		00-03185-06	SPACER, COMPRESSION CHAMBER MOUNTING BRKT. (FOR 2 3/4" FLANGE, 1 11/16" MATERIAL THICKNESS)
3	1R/1L	00-03189-00	BASE, FORM PLUNGER GUIDE
4	2	00-03190-00	SPACER, FORM PLUNGER GUIDE BASE (FOR 3" FLANGE, 1 1/2" MATERIAL THICKNESS)
		00-03191-00	SPACER, FORM PLUNGER GUIDE BASE (FOR 1 1/2", 2 1/4", 3" FLANGES, 1 1/8" MATERIAL THICKNESS)
5	1	00-03191-01	SPACER, FORM PLUNGER GUIDE BASE (FOR DBL WALL ENDS, 3/32" MATERIAL THICKNESS)
		00-03191-02	SPACER, FORM PLUNGER GUIDE BASE (FOR 2 1/4" FLANGE, 3/4" MATERIAL THICKNESS)
		00-03191-03	SPACER, FORM PLUNGER GUIDE BASE (FOR 1 3/4" FLANGE, 1/4" MATERIAL THICKNESS)
		00-03191-04	SPACER, FORM PLUNGER GUIDE BASE (FOR 2" FLANGE, 1/2" MATERIAL THICKNESS)
		00-03191-05	SPACER, FORM PLUNGER GUIDE BASE (FOR 2 1/2" FLANGE, 1" MATERIAL THICKNESS)
6	2R/2L	00-03192-01	PLOW, BOX END FLANGE (WITH SIDE BLISS FLANGE)
		00-03192-02	PLOW, BOX END FLANGE (WITH SIDE BLISS FLANGE 2" OR GREATER)
7*	1R/1L	00-03193-01	RAIL, AUXILARY BOX END HOPPER REAR FLANGES AND LID FLAPS)
		00-03193-02	RAIL, AUXILARY BOX END HOPPER BLISS ENDS)
8*	1	00-07120-01	FEED POST, BLISS INTERNAL FLANGE END
9	1	00-07215-01	DEFLECTOR, MATT (STANDARD TO 1 3/4" INTERNAL)
		00-07215-02	DEFLECTOR, MATT (2" INTERNAL FLANGE OR LONGER)
10	1	00-07217-02	PLATE, DEFLECTOR EXTENSION STD.
		00-07217-03	PLATE, DEFLECTOR EXT. (FOR 2" & OVER I.F.)
11*	4	23-00058-00	WASHER, 1 1/8" OD x 29/64" x 1/16" THICK
		23-00059-00	1 1/8" OD x 29/64" x 1/8" THICK

Electrical Time Delay Attachment

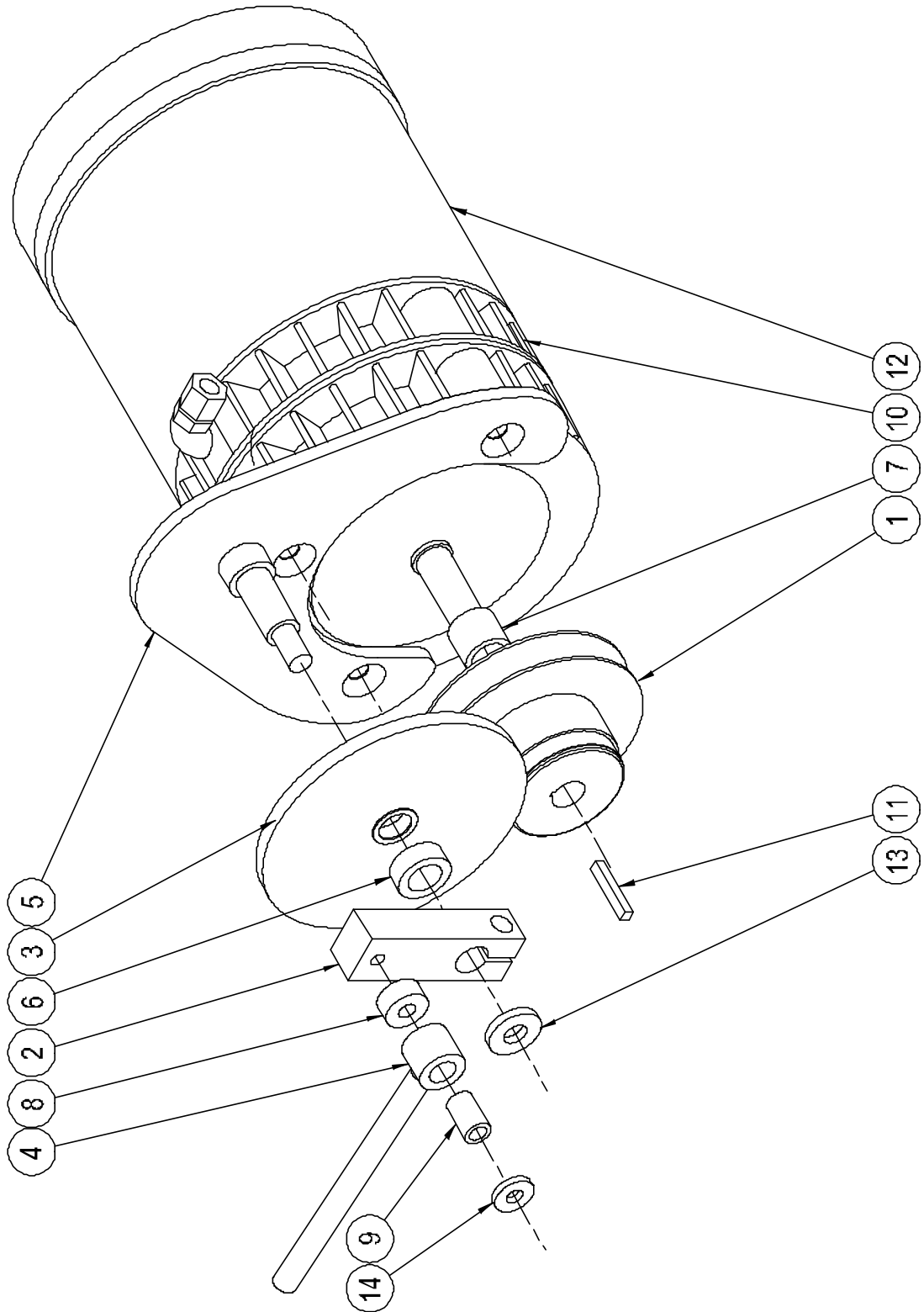
Item	Qty.	Part No.	Description
1	1	00-03231-00*	PULLEY, VARI DRIVE MOTOR...12-35 OR 21-56 SPEED
	1	00-03231-00*	PULLEY, VARI DRIVE MOTOR...29-70 SPEED
2	1	00-03232-00	ARM, MOTOR DRIVE SPEED CONTROL
3	1	00-03233-00	WASHER, MOTOR DRIVE BASE
4	1	00-03235-00	ROD, SPEED CONTROL OPERATING
5	1	00-03236-00	BASE, MOTOR DRIVE
6	1	02-00145-00	BUSHING, SPEED CONTROL ARM
7	1	02-00198-00	BUSHING, MOTOR PULLEY SPACER
8	1	00-00267-00	BUSHING, CONTROL OPERATING ROD SPACER
9	1	00-00271-00	BUSHING, SPEED CONTROL OPERATING ROD
10	1	04-00052-03	CLUTCH / BRAKE, TIME DELAY
11	1	10-00009-04	KEY, VARI DRIVE PULLEY
12	1	13-00004-04	MOTOR, 3/4 HP, 3 PH 115/230 V, 50/60 HZ, 1200 RPM
13	1	23-00001-00	WASHER, 1" OD x 7/16 ID x 5/32 THICK
14	1	23-00056-00	WASHER, 3/4" OD x 5/16 ID x 1/8 THICK

COMPONENTS NOT SHOWN

- 1 G4723 JUNCTION BOX, ELECTRIC TIME DELAY
- 1 GD18A RELAY, TIME DELAY
- 1 GV10A SOCKET, POWER SUPPLY
- 1 GV11 POWER SUPPLY

*** REFER TO MACHINE ORDER FOR PART NUMBER**

Electrical Time Delay Attachment



Glue System Large Capacity Melt Pots

TEMPERATURE CHECK AND CALIBRATION PROCEDURES

- Turn the machine power on and allow 60 minutes for the glue to reach operating temperature.
 - Measure the temperature of the melt pot with a Pyrometer at the probe location.
 - **If** the Pyrometer measurement and control dial setting are the same, the thermostat is calibrated. If the temperatures are not the same: Note the location of control dials when facing the melt pots.
 - The inner Thermostat dial controls the glue pump temperature.
 - The outer Thermostat dial controls the Melt pot temperature.
1. Set the **outer** control dial (melt pot), to the same temperature measured by the Pyrometer.
 2. Remove the **outer** control dial and note the slot in the dial shaft.
 3. Using a small screwdriver, adjust this slot until the heater light **extinguishes** (goes out.)
 4. Turn the same shaft in the **opposite** direction until the light comes back **on**.
 5. Repeat step # 3 until the light **just goes out**.
 6. Replace the **outer** control dial removed in step # 1 and set to the operating temperature.
 7. When complete, the glue pumps should be calibrated.
 8. Refer to Maintenance & Lubrication section of this manual for cleaning, purging and changing adhesive in the system.



Maintenance on any part of the adhesive section requires you wear safety goggles, heat resistant gloves, and protective clothing to prevent serious burns.

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