

MK1

electropneumatic valve



Zator
gluing solutions

**USER AND
MAINTENANCE
MANUAL**





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UE Declaration of Conformity

Manufacturer:

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DECLARES

Under its responsibility that the electropneumatic valve:

Model	MK1	Year of manufacture	
-------	-----	---------------------	--

Is in compliance with UE directives, with relation to the following ones and/or parts of them applicable to this product:

- Directive 2006/42/CE of European Parliament and Council of the 17th of May 2006 regarding to machines and that modify directive 95/16/CE (recasting)
- Directive 2014/35/UE of European Parliament and Council of the 26th of February 2014 regarding the harmonization of the UE Countries laws about the the making available on the market of electrical equipment intended to be used within certain voltage limits (recasting)
- Directive 2014/30/UE of European Parliament and Council of the 26th February 2014 regarding the harmonization of the UE Countries laws about the electromagnetic compatibility (recasting)

Cusano Milanino

Legal Representative

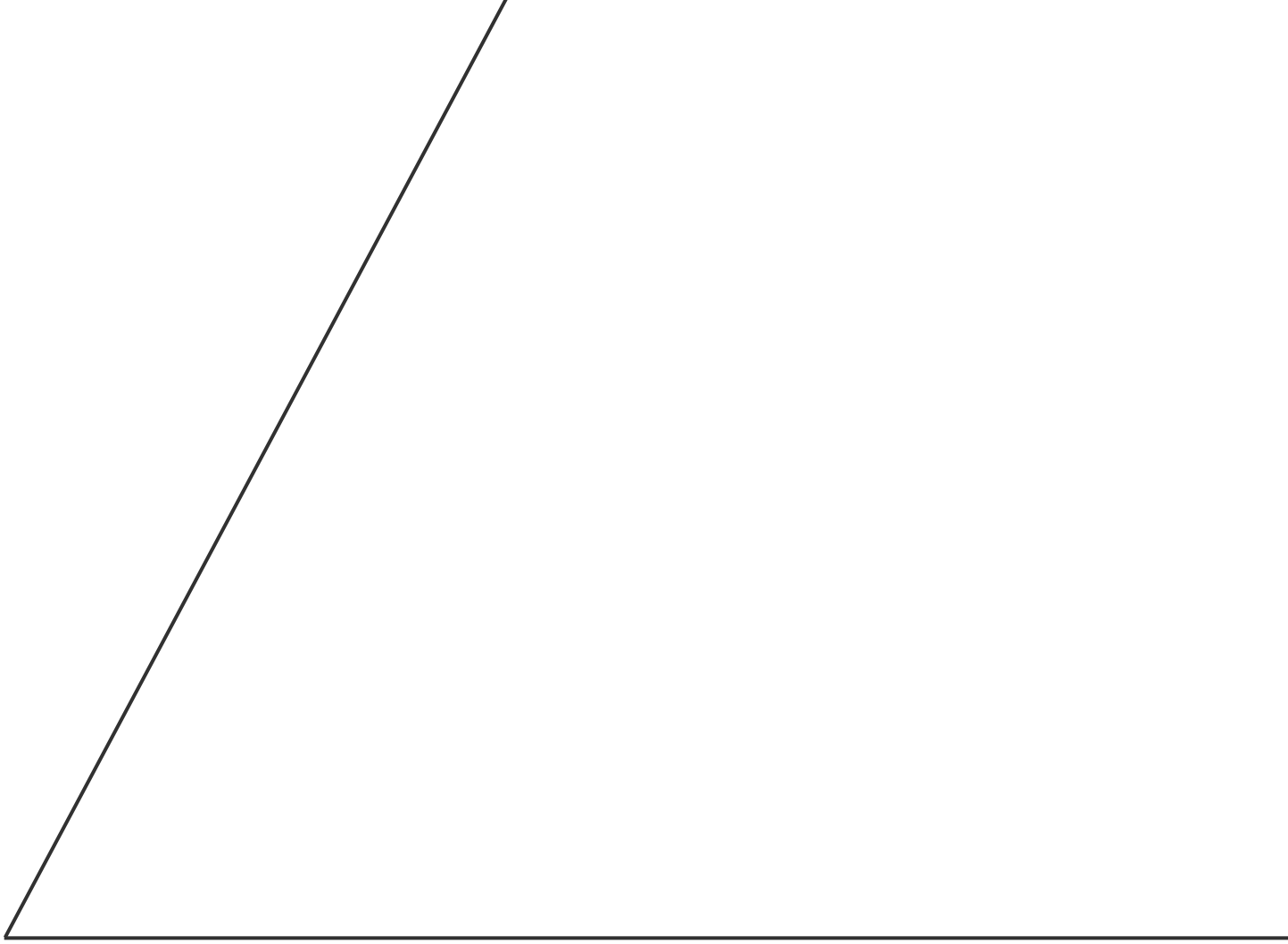


ZATOR S.r.l.

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USER AND MAINTENANCE MANUAL

elettropneumatic valve **MK1**

1 GENERAL INFORMATION

1.1 Introduction

This manual is an essential part of the electropneumatic valve and is destined to trained and well-informed personnel, which is aware of the machine performance at the risk conditions to which it may be exposed. This document supposes that in the plants where the valve is destined, are complied the present norms of safety and hygiene of the work.

Zator Srl won't be liable for actions or improper connections made by unqualified and unformed personnel.

Instructions, drawings and documentation contained in this manual are of reserved technical disposition, only for Zator Srl property and may be not reproduced in any way, neither in full or partially reproduction; not translated into another language, or transmitted in any electronic or mechanical means or form, without written permission of Zator Srl.

The data and values expressed in the manual are approximate and variable depending on fluids, applications and methods of use.

Zator Srl doesn't assume any responsibility regarding the accuracy of the contents of this manual.

The drawings and technical data in this document is updated to the date of their publication and Zator Srl reserves the right to change, without notice, the contents of this manual.

It is therefore forbidden for Technician and Operators of the maintenance to use this manual for different purposes from those relatives to the care and maintenance of equipment in question.

This manual includes the installation, use and maintenance norms of the electropneumatic valve in safety.

Test in production workshop

The manufacturer guarantees the valve, that this document refers, has been inspected and tested by his production workshop.

"At term of law we reserve the property of the data and technical information with the prohibition of play, communicate to third parties or use them anyway for any other executive purpose and what is shown in this document is the property of the Manufacturer"



1.2 Warranty

This warranty is valid for 12 months from the actual delivery.

During the warranty period Zator Srl undertakes to remove in the necessary time the obvious faults and flaws of material and/or production, on condition that machine or equipment has been used properly, according to the best rules of behaviour and maintenance provided in this manual.

The flawed parts under warranty are fixed or replaced free from Zator Srl in the time compatibly necessary, understood that the Zator Srl is exempted from each responsibility for any title, while the buyer give up to ask damages or costs, including those resulting from the temporary not use of the purchased machinery for all the time is necessary to put it back in efficiency; The transport and/or the forwarding costs, the outward and the return trip costs relative to the operation by the Zator's technicians in the Buyer address are always on charge of the buyer.

The labor costs relative to the operation of the Zator's technicians in the Buyer address for the removal of flawed parts under warranty, are on charge of Zator Srl, except these cases when the nature of the flaw can be easily removed on place by the Buyer.

This commitment of Zator Srl excludes each other warranty effects provided by the law.

The warranty for the replaced or repaired spare parts of the electropneumatic valve finishes the same day of the warranty expiration date of the electropneumatic valve, the replaced part warranty however doesn't has lifetime less than three months after its installation.

Replaced parts during the warranty period by the seller are free acquired in the same place with new parts.

Are excluded from the warranty all the tools and consumable materials, possibly supplied by Zator Srl with the machine.

It are excluded and renounced by the buyer every pretensions of items/people damages reimbursement on charge to Zator Srl, for any titles, even if the damages were depending from manufacture or material flaws. It's of equal excluded and given up any reimbursement for people and/or items damages depending on the practise of the electropneumatic valve. Parts replaced free remain of Zator Srl property.

Elapsed the warranty period every operation will be on charge to the buyer.

Application fields

- Packaging machines
- Paper converting industry
- Printing machines
- Tobacco industry
- Assembly industry
- Food industry

Condemnation of conformity flaw - Goods reception

The original configuration of the electropneumatic valve never must be changed.

On goods reception, check that:

- The packaging is intact
- The exact correspondence of the commissioned material

In case of damages or wrong delivery contact immediately Zator Srl.

The buyer, on penalty of warranty decadence, must report in writing the flaw conformity or fault of the electropneumatic valve to the seller, specifying in detail the nature, within eight days from their discovery.

In no case the condemnation of conformity flaw or fault may be validly made after the expiration date of the warranty terms.

Also the buyer decays from the warranty if doesn't allow each reasonable control that the seller requires. It's excluded from this warranty the most damage caused to the machine by the failure timely condemnation to the seller of a conformity flaw or fault of the the electropneumatic valve.

1.3 Warranty restrictions

This warranty is only valid for products of new construction.

This warranty is limited to the reparation or replacement, by the seller, of each parts of the machine or supplied material that results flawed, after checking the existence of the flaw.

In no case the seller will be liable for every consequential or indirect flaws or otherwise derived from production cycle interruption or machine stoppage.

The seller is not liable for flaws of the electropneumatic valve derived from the use of devices, equipments, etc. that are enquired and provided by the customer and installed on the machine to change its use compared to the original design.

The seller is not liable for every conformity flaws of the electropneumatic valve or faults owed for the normal wear of those parts that, by their nature, are subject to rapid and continuous wear.

The seller also is not liable for damages resulting from improper use of the equipment and from the non-observance of the norms expected for the execution of the ordinary periodic maintenance.

The seller is not liable for conformity flaws of the electropneumatic valve or faults that depends on changes, reparations, alterations or tampering attributed to the buyer and however non-authorized personnel of the buyer.

The costs relative to the wear materials necessary for test and restart the electropneumatic valve are on charge of the buyer.



1.4 Maintenance service request

Contact:

Technical office of Zator S.R.L.

Via Galvani 11 - 20095 Cusano Milanino (MI) - Italy
e-mail: info@zator.it www.zator.it
Tel.: +39-0266403235 Fax.: +39-0266403215

Always forward the request in writing (fax or email) and give all the information to identify the machine object of the request:

- **Model**
- **Serial number**

Please refers to the frontispiece of this manual or directly to the nameplate on-board to the machine or to the serial number of the electropneumatic valve.

1.5 Spare parts request

The customer is responsible to purchase original spare parts that guarantee him to keep efficient and safe the electropneumatic valve.

The disassembly and assembly operations must be performed according to the manufacturer's instructions.

Contact the Technical Office of Zator Srl which will give to you the specifications to do the request of the parts and will provide the information about their replacement.

To order the spare parts is necessary to report completely all identification data of the electropneumatic valve and those of spare part to be replaced.

The illustrations in this document are for example.

2 SAFETY RULES AND REGULATIONS

The *electropneumatic valve MK1* is designed and manufactured in compliance with the current safety standard. Only trained personnel is authorized to install and use the valve. For the electropneumatic valve MK1 are provided only and exclusively the application fields describe in this manual. All data and parameters indicated in this manual must be respected. Any other use is considered improper.

All operations performed with the electropneumatic valve MK1 must be carry out in compliance with the following current safety rules and regulations written in part:

1. Rules of fire prevention
2. Directive 2006/42/CE of European Parliament and Council of the 17th of May 2006 regarding to machines and that modify directive 95/16/CE (recasting)
3. Directive 2014/30/UE of European Parliament and Council of the 26th February 2014 regarding the harmonization of the UE Countries laws about the electromagnetic compatibility (recasting)
4. Rule 2016/425/UE of the 9th of March 2016, about the personal protection equipment and that abrogates the directive 89/686/CEE of the Council

2.1 Safety and environment general informations

Before the start-up of the electropneumatic valve the personnel must be adequately informed and trained on its use, direction and start-up process, as well as the safety norms to be performed and also observe how it is prescribed in this document and in other documents possibly attached to the microprocessor control.

The employer must provide to instruct the personnel on the risks of injury, on safety devices and accident prevention general rules provided by the community directives and the legislation of the country where the microprocessor control is installed.



CAUTION: Always disconnect the power supply before proceed to carry out any maintenance or adjustment operations. Discharge the fluid pressure before to proceed to carry out any maintenance or adjustment operations.

2.2 P.P.E. Personal protective equipment

For personnel who will work on the electropneumatic valve, for any functions (installation, assembly, demolition, maintenance and operation) they will be provided with appropriate P.P.E. - Personal protective equipment of type approved and certificate by C.E.:

- **anti-solvent gloves**
- **cut resistant gloves**
- **masks**
- **coverall (no floating coverall)**



CAUTION: The clothes of who will operate on the electropneumatic valve for any functions must be in compliance with the essential safety requirements defined by the regulation 2016/425/UE of 9th of May 2016 and by the actual laws in the country of use.

2.3 Risks, protections, warnings and cautions

2.3.1 General safety

In accordance with the Machine Directive it means for:

DANGER ZONE = area within or near the electropneumatic valve where the presence of an exposed person make a risk to the safety and health of himself.

EXPOSED PERSON = any person that is placed entirely or partially inside a danger zone.

OPERATOR = person who is appointed to install, operate, adjust, perform ordinary maintenance and clean the machine.

All risk areas of the electropneumatic valve have been checked and consequently have been taken the necessary precautions to avoid risks to people and damage to the components of the electropneumatic valve.

Safety glossary

Intended purposes

By this term it refers to the use of the machine as described by the manufacturer.

For “intended purposes” also refers to the use of the unit through its design, its construction and function.

Secondary risks

Secondary risk are unavoidable despite all the preventive measures that are taken.

Competent personnel

A person is competent when it acquired sufficient knowledge in a specific field both through the professional instruction and with the experience. A competent person must get to know with the specific norms for the safety on work and for the accident prevention and generally with the technical knowledge rules.

Trained personnel

A person is trained when it is informed by a competent person about the activities it must perform and the risks relative to improper behaviour and, if necessary, it has received the required training. Also a trained person must be informed about the safety devices and protective measures.

Skilled personnel

A skilled person is a competent one or sufficiently trained.

The operator must be informed of the position and operation of all commands and features of the valve. The maintenance and start-up operations must be performed by qualified technicians after properly setting up the valve.

The unauthorized tampering or replacement of one or more valve parts, the adoption of accessories that modify the original use of the valve and the purpose of different consumer product from those recommended in this manual, can become a cause of injury risks.

The protective devices must not be removed or tampered for the risk to reduce the accident prevention features of our products.

To highlight particular situations for the safety of the instrument, are used the following graphic symbols:



CAUTION and/or DANGER – Accident prevention rules for the operator



R. R. – RESIDUAL RISKS

WARNING - There is the possibility to damage the machine and/or its components

PRECAUTION - Further information about the operation in progress

NOTE - Provides useful information

2.3.2 Unavoidable dangers and risks unavoidable

On the electromagnetic valve also equipped with protection systems remain the following **R. R. RESIDUAL RISKS**:

A - Danger due to electricity in general

B - Danger due to inhalation of dangerous vapours to health and fire danger

C - Danger due to problems/malfunctions of the electromagnetic valve

This can lead an excessive increase of dispensing of glue as well as a fire danger or dangers due to inhalation of dangerous vapours to health.

D - Risk due to the projection of fluids under pressure

In case of improper maintenance of the hydraulic system parts.

E - Risk of fire

Prohibition of smoking and/or high temperature objects near the electropneumatic valve.

2.3.3 Safety devices adopted

In order to safeguard the health and security of the exposed people, the machine is equipped with:

- Fixed guards: removable only by tools
- Mobile guards: depending on the model of electropneumatic valve

The valve can be equipped with area delimiters that prevent operator access to dangerous areas (see R.R.).

2.3.4 More general safety precautions



CAUTION: The maintenance operations must be peremptorily carry out by qualified and authorized personnel.

Make sure the passages around the machine is not hindered by misplaced cables and dangerous for personnel.

The user must always put available to the operators, in the areas that require it, safety goggles, gloves, and any other necessary protections; it must also make sure that these safeguards are being used.

The areas that require the use of protective clothing must be marked with warning signs and pictograms indicating the residual risk



CAUTION: is ABSOLUTELY FORBIDDEN to tamper or remove the plates and the protections on the electropneumatic valve.

The manufacturer declines all responsibility for the safety of the electropneumatic valve in case of omitted observance of the prohibition.

CE norms signage: examples of danger symbols



Danger



High voltage



Flammable



P
Toxic



C
Corrosive



O
Combustive
agent

2.4 Environmental condition

Operating environmental conditions

The electropneumatic valve is designed to operate in a closed local, protected from the atmospheric agents, with all the safety requirements resulting from the laws in force.

Waste disposal

The buyer is responsible to follow the correct process and the norms in force in the country for the disposal of waste and residual material.

Disposal

The pick up of special and/or toxic-noxious waste must be committed with contract to specifically authorized companies and who do the transport materially must be in ownership of the required authorizations and must be turn out to be registered in the haulers register.

It's absolutely forbidden to throw waste in the environment.

For the disposal of the packaging, the user must follow the laws in force in the country of plant installation.

Fire material

There is no fire dangers by the operation of the electropneumatic valve.



CAUTION: The customer must provide an appropriate fire-fighting system, evaluating its internal situation and respecting the laws in force. In case of fire, disconnect immediately the power switch to interrupt the power supply.



CAUTION: explosive atmosphere

The electropneumatic valve is not designed to operate in explosive atmosphere. It is forbidden to use the machine in an explosive atmosphere, even if only partially explosive.

Lighting

The customer is responsible for ensuring an appropriate lighting of the local where the valve is installed, according to the laws in force in your country and the EU directives.

Vibrations

The electropneumatic valve doesn't make vibrations.

2.5 Installation - General instructions

Zator's products are manufactured in compliance with the laws in force during its construction. The personnel will be trained and qualified to take advantage of the installed valve requirements. The personnel must operate in a comfortable space that could be guarantee safety and hygiene for the operator. In case of a different destination or necessity of use of the valve, it's appropriate to refer to the technical offices of the Zator Srl.

Goods in packaging

Outside the package are indicated all the information about the content identification and the safety movement:

- address of the sender and the addressee
- dimensions: length – width – height
- gross – net – tare weight
- annotations and pictograms (ex. brittle, handle with care, high)

CAUTION: The customer must check the condition of the goods upon its arrival.

Predispositions: choose the installation space

Without prejudice to specific dispositions, the customer will be provide to:

- Appropriate logistic arrangement for the placement and conduction of the electropneumatic valve
- Power supply, including the protective conductor usually called "GROUNDED"
- Electrical equipment arrangement and possible pneumatic system
- Wear materials

For the electrical connection it is necessary to have a preferential line of power supply with the features listed in "technical features".

Pneumatic connections



CAUTION: The compressed air must be free of humidity. It is necessary to assemble on the compressor one or more automatic condensation outlet; the air must be filtered and dried out. Make sure that in the pneumatic circuit is not inserted any type of substances (ex. lubricants or other substances).

2.6 Use of adhesives, glues or other fluids

The use of the valve with adhesives, glues or general fluids must be respect the following basic rules.

Before use a specific type of fluid check that:

- The fluid viscosity is compatible with the features of the valve
- The characteristics of the fluid meet the desired requirements
- The datasheet of the fluid provided by the manufacturer includes all the informations about the fluid such as: viscosity, applications, gluing time (for glues or adhesives) and storage
- The storage time of the fluid has not been exceeded
- The fluid has not been exposed to temperatures near or below than zero therefore it has deteriorated
- The packaging of the fluid are sealed

For the use of **special adhesives, glues or fluids** we recommend to contact the Zator company to verify the compatibility of the application.

Before use a different type of fluid clean accurately the valve to avoid possible contamination of the new fluid.

When used water-based adhesives of glues they are easily removable with water in their liquid state. However, when they harden is more difficult to remove it. For this reason, before long stop it is recommended to wash accurately the valve. Please refer to the maintenance program shown in this manual.



3 TECHNICAL DESCRIPTION

3.1 Valve functions

The extrusion valve MK1 is a high frequency dispenser of glues, adhesives and fluids, from low to high viscosity.

Designed to be used on a variety of machines, the MK1, is a pneumatically triggered, single or double acting, compact valve.

The valve has a tungsten carbide needle, the main body is machined from solid metal with non-stick coating, providing a sturdy and easy maintenance valve, even in severe working condition.

A chamber for grease/oil for the lubrication of the internal needle gaskets can be realized, upon request.

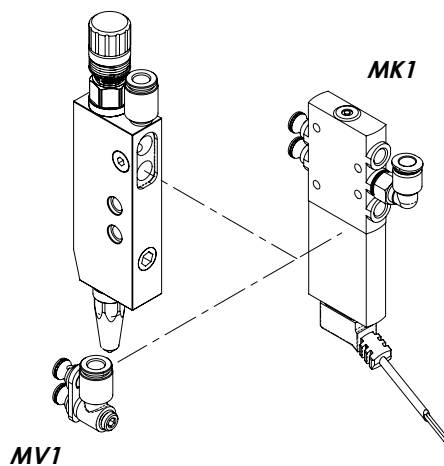


Fig. 1

The MK1 can be equipped with a vast array of stainless steel nozzles, various in shapes and diameters, designed to fulfill various application needs. The micrometric adjustment (optional), allows for a more precise control of the quantity of the dispensed fluid, avoiding product waste.

The MK1 can also be operated completely pneumatically, in this case, it takes the name of MV1 (see the dedicated manual). Both solutions are compatible and interchangeable even after purchase (see fig. 1).

3.2 Technical data

Available nozzle diameters	from 0,3 to 1,5 mm
Air pressure control	min. 5 bar
Drive type	double action
Maximum working pressure	80 bar
Coil	24V
Maximum working frequency	80 dots/sec.
Weight	380 g



Dots and lines

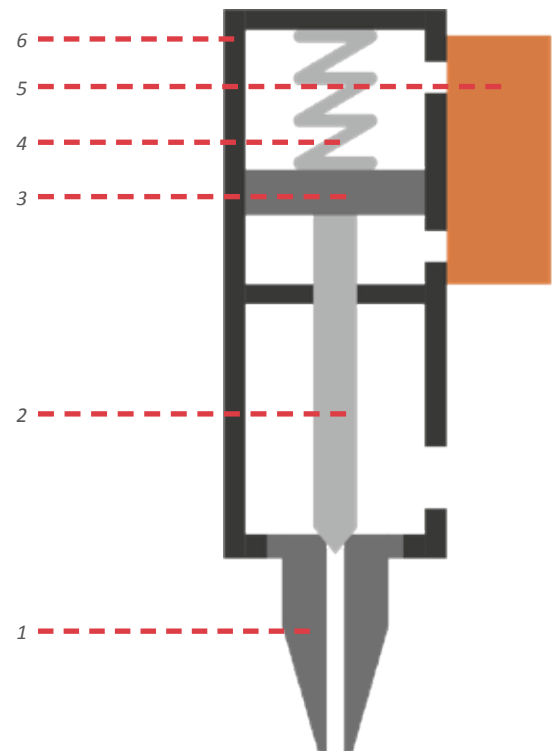
fluid types

- | adhesives and glues
- | inks
- | paints
- | lubricants
- | low and medium viscosity fluids

3.3 Functioning description

The valve^{3A} is composed mainly of:

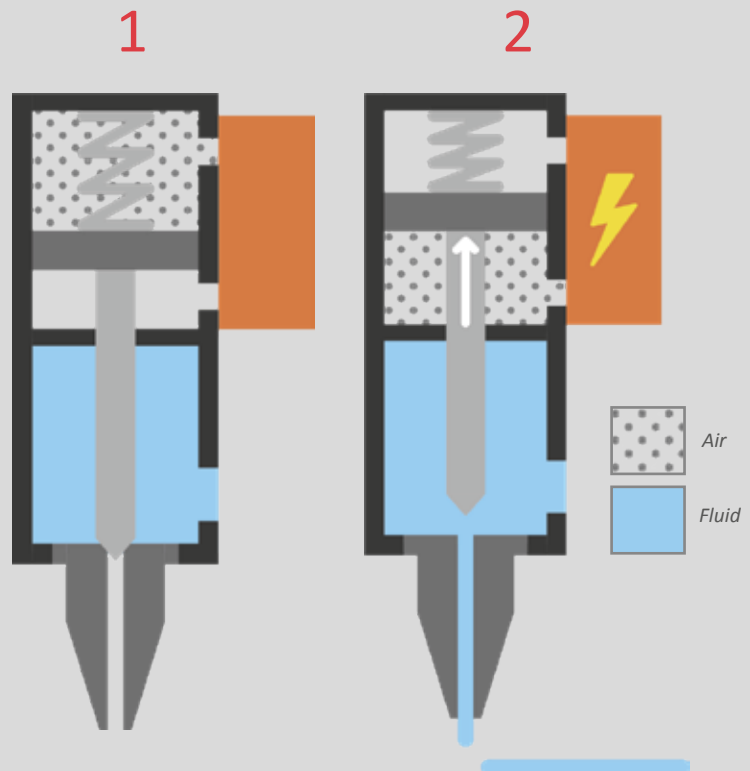
1. Nozzle
2. Needle
3. Piston
4. Spring
5. Solenoid valve
6. Valve body



3A. Internal section diagram of the main components (for illustration only)

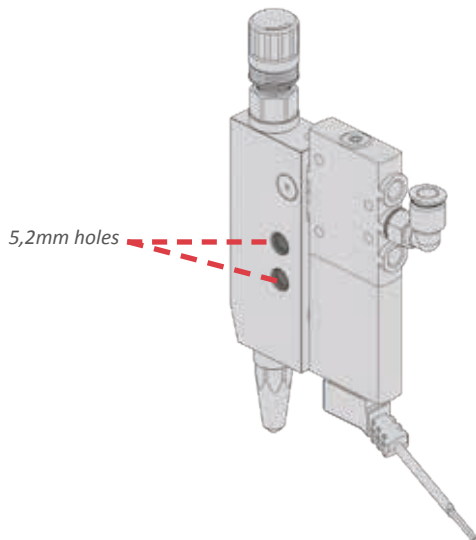
Functioning diagram

- 1 When the valve is not activated, the needle closes the nozzle seat, pushed by a spring, and stops the fluid under pressure to flow out from the nozzle hole.
- 2 When the solenoid valve that allow the drive air to flow inside the piston chamber is activated, this action activated the valve. Then the piston moves back together with the needle, allowing the fluid flow to come out from the nozzle.



4 INSTALLATION

4.1 Fixing of the valve



The MK1 valve must be fixed on a proper bracket by using the **Ø 5,2mm holes** machined on the valve body.

If necessary, calibrated holes can be used for fixing with calibrated bushes Ø 7mm (see *section 10 - Dimensions*).

A vibration-free environment and a good accessibility for regulation, cleaning and maintenance and a good fixing of the valve to the support/bracket and of the latter to the machine must be guaranteed.

4.2 Contact-less gluing application

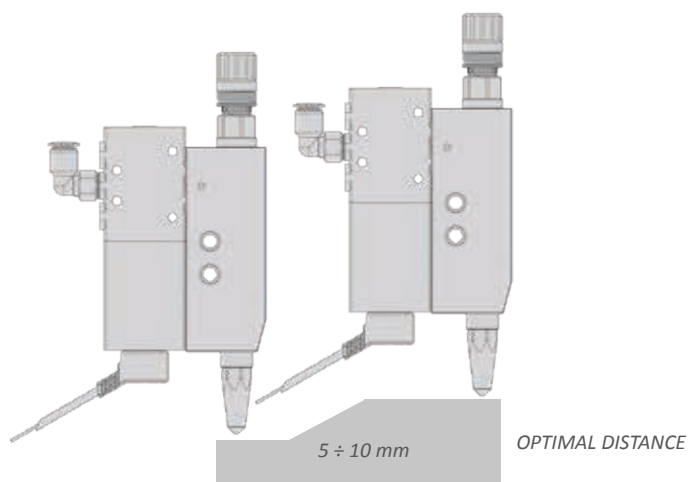
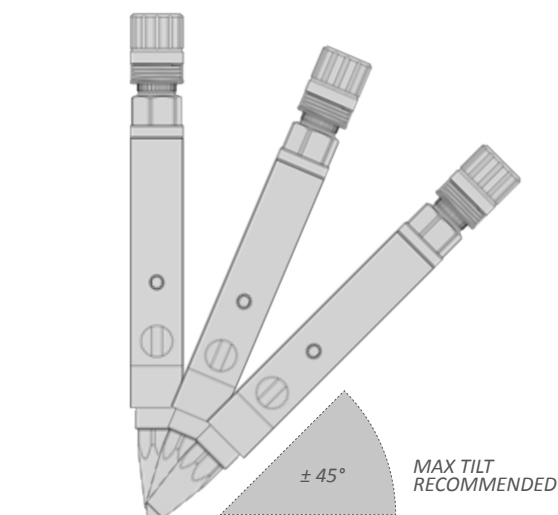
Where possible it is always better to adopt this type of application since it is convenient for both easy application and to avoid nozzle wear.

The **ideal working position** of the valve is vertical, with the nozzle facing downwards.

It's possible to tilt the valve of $\pm 45^\circ$ degrees (see next page).

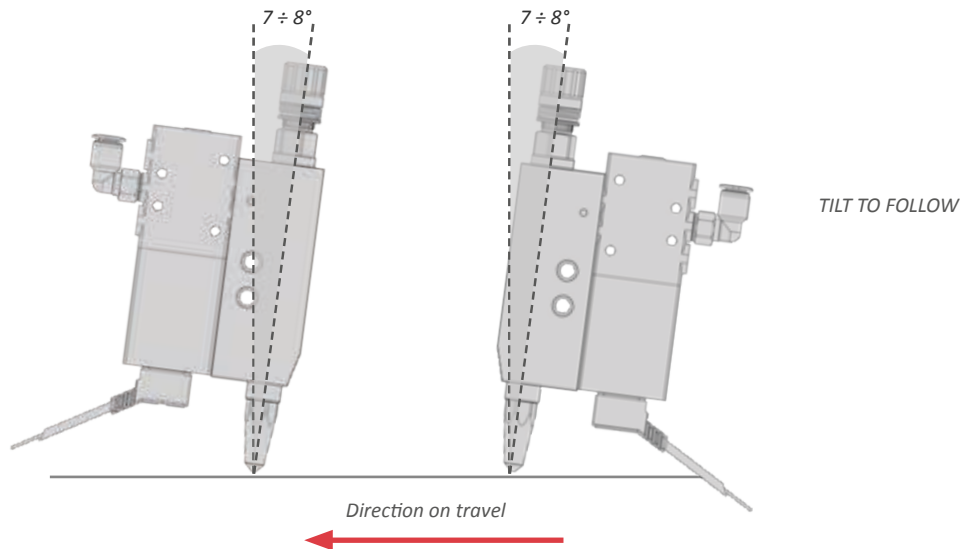
The **optimal distance** between the nozzle and the surface to be glue is between 5 and 10 mm (see next page).

Other different positions are possible upon approval of the Zator.



4.3 Contact gluing application

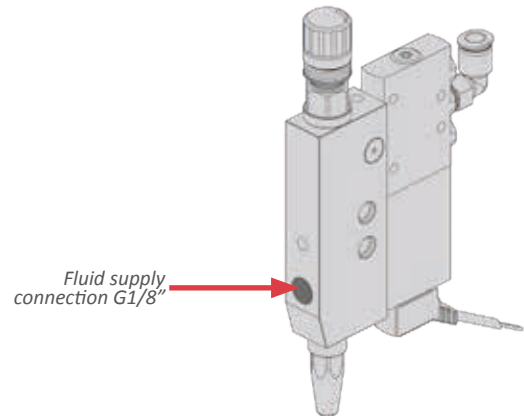
The contact gluing application is used when is necessary to dispense very thin glue lines. In this case the valve must always be positioned vertically, with the nozzle facing downwards but with an **inclination of $7 \div 8^\circ$** with respect to its axis towards the direction of travel and the nozzle must lightly touch the surface to be glued.



4.4 Fluid supply connection

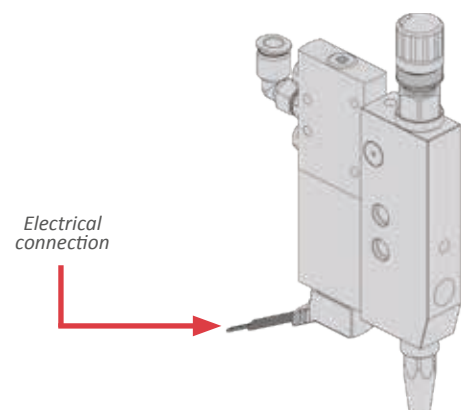
The valve must be connected to a *glue feed units**. A *flexible plastic pipe** (**for applications up to 8 bar**) must be connected to a *pipe fitting (G1/8")** to be screwed on the fluid supply connection of the valve. For applications with working pressure **over 8 bar** use *fittings and pipes** for high pressure must be used.

**Parts are supplied separately*



4.5 Electrical connection

Electrical connection to be made using the two cables on the solenoid valve.

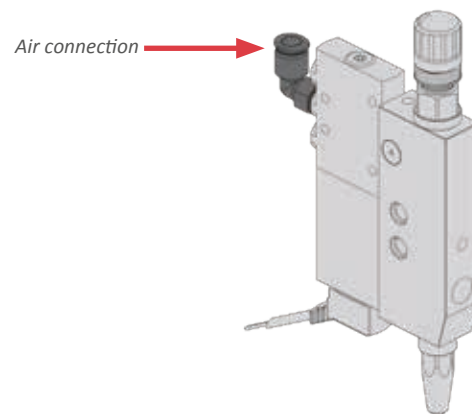


4.6 Drive air connection

Connect a *pipe* $\varnothing 6 \times 4$ to the air connection on the solenoid valve.

The air pressure must be between 5÷6 bar.

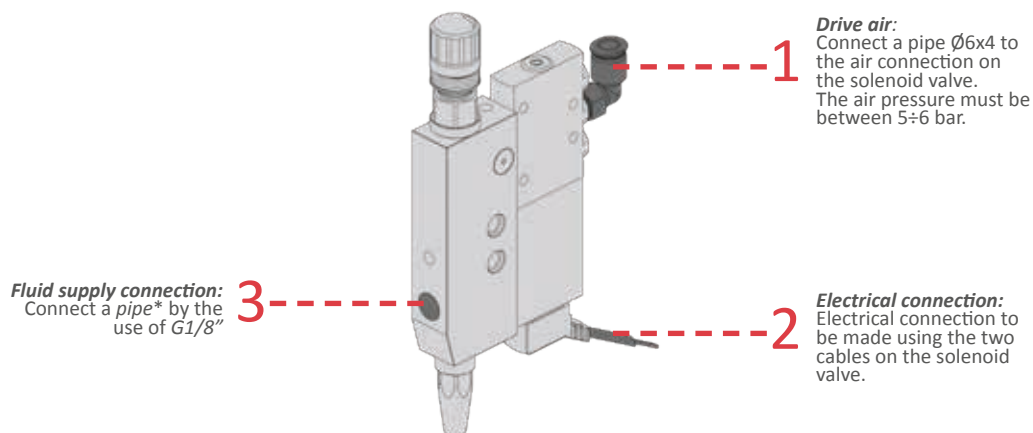
**Parts are supplied separately*



4.7 Installation diagram

Provide the positioning and the length of the pipes such as to ensure a good accessibility to the valve in order to easily perform maintenance and cleaning operations.

The connections required for the operation of the MK1 valve are:



**Parts are supplied separately*

5 VALVE ADJUSTMENTS

5.1 Fluid quantity adjustment

The adjustment of the dispensed fluid quantity (ex. glue) by the valve is determined by:

- The nozzle diameter: **greater diameter → more fluid quantity**
- The fluid pressure: **greater pressure → more fluid quantity**
- The needle travel adjustment: **greater needle travel → more fluid quantity**

Operating on this points it's possible to adjust the dispensed fluid quantity.

5.2 Needle travel adjustment

5.2.1 Screw adjustment version

To adjust the needle travel, operate on the *adjustment screw* placed on the top of the valve as follows:

1. Unscrew the nut with a 10mm wrench **by holding** the screw with a 3mm hex key;
2. Then by holding the nut:

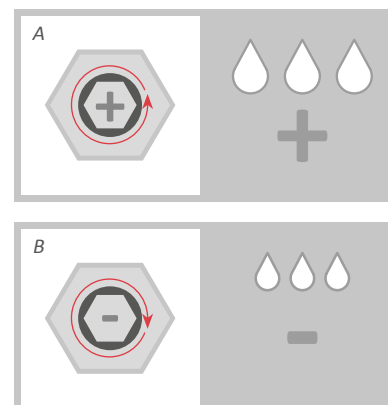
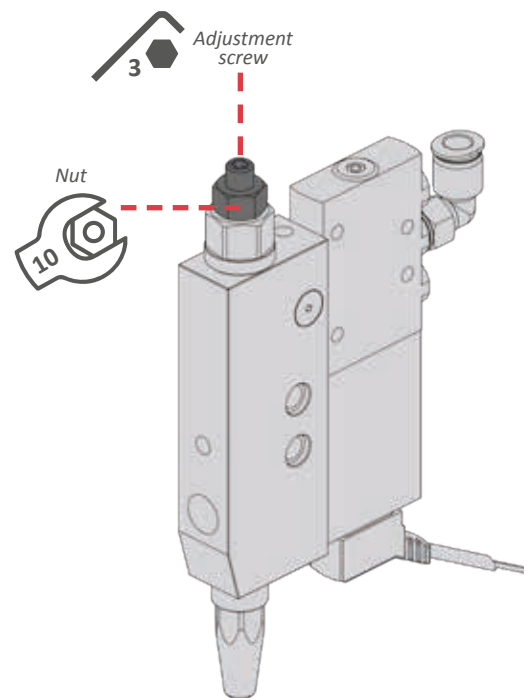
A Turn **counter-clockwise** the screw to **increase** the needle travel therefore the dispensed fluid quantity;

B Turn **clockwise** the screw to **decrease** the needle travel therefore the dispensed fluid quantity. At the **end of the needle travel**, the valve is **completely closed**, therefore it doesn't dispense any fluid;



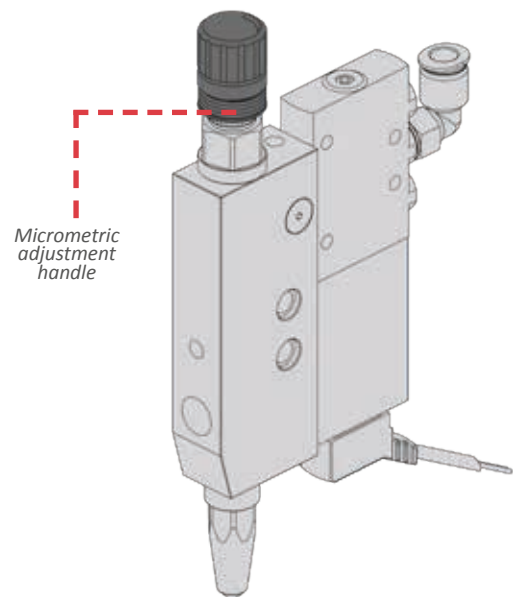
Don't tighten with excessive force the needle adjustment screw to avoid damage to the nozzle and the needle.

3. Finally tighten the nut **by holding** the screw.

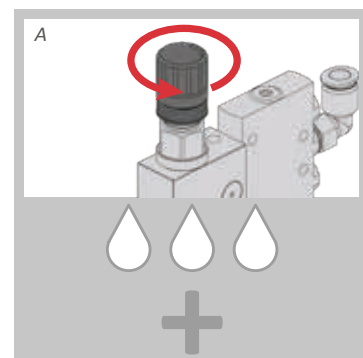


5.2.2 Micrometric adjustment version

To adjust the needle stroke, operate on the *micrometric adjustment handle* placed on the top of the valve. This handle allows to adjust the dispensed fluid quantity with a fine control.



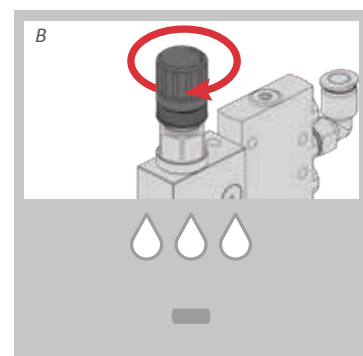
- A** Turn **counter-clockwise** to **increase** the needle travel therefore the dispensed fluid quantity.



- B** Turn **clockwise** to **decrease** the needle travel therefore the dispensed fluid quantity. At the **end of the needle travel**, the valve is **completely closed**, therefore it doesn't dispense any fluid.



Don't tighten with excessive force the needle adjustment handle to avoid damage to the nozzle and needle.



6 MAINTENANCE

6.1 General norms

The *electropneumatic valve Mk1*, thanks to the construction methods and employed materials, is easy to maintain. A minimal, simple, accurate and constant maintenance allows a long-lasting and regular functioning of the valve, keeping unchanged its performance.



- For the general cleaning of the valve **don't use** metallic, sharp or pointed objects. Use only soft brushes or cotton rags.
- All the maintenance works on the valve **must be performed by qualified personnel** and after the supply pressure system has been discharged
- For the nozzle cleaning **use only** cleaning needles supplied by the valve manufacturer: if you use other sharp objects the nozzle could be **damaged**
- **Use only** original spare parts
- The valve must be washed **only and exclusively** with water, especially if you need to replace the nozzle or the needle
- Every evening and if you expect a long work break put some grease on the nozzle tip

6.2 Maintenance program

	TIMING*	WHAT TO DO
1	Every day, before the start production	<ul style="list-style-type: none"> • Do a valve test • Clean the valve externally
2	Every day, at the end of production	<ul style="list-style-type: none"> • Do a valve test • Clean the valve externally • Put some grease on the nozzle tip
3	Before a production break longer than two weeks	<ul style="list-style-type: none"> • Drain the fluid from the system and wash it completely with water • Leave the system with water inside
4	After a production break longer than two weeks	Discharge the water from the system and fill it with the adhesive fluid
5	Every month or after 2000 working hours	As point 3 and 4
6	Every year or after 4000 working hours	<ul style="list-style-type: none"> • As point 3 and 4 • Replace possible worn parts

*Approximate values that can change depending on the type of glue, adhesive or fluid used.
For the use of special fluid we recommend to contact the Zator company for any questions.

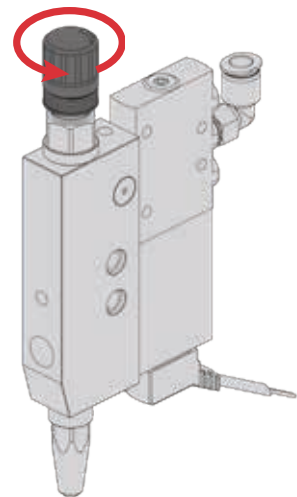
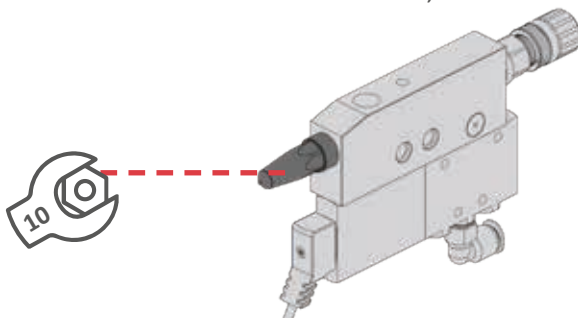
6.3 Cleaning and/or replacement of the nozzle

Before you disassembling, cleaning or replacing the nozzle the following steps **must be done**:

- Wash the valve with water
- **Discharge the pressure from the supply system**

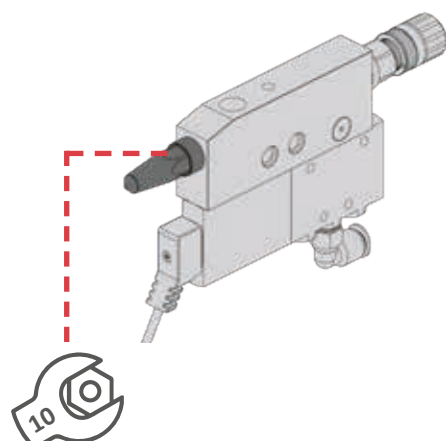
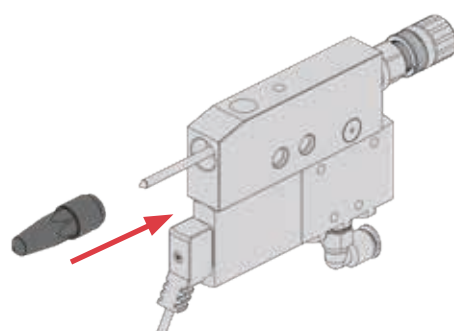
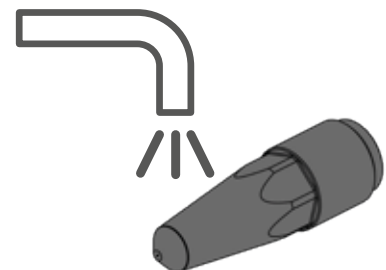
Then proceed as follows:

- 1 Loosen the needle adjustment with the *micrometric adjustment handle* (see section 5.2 - *Needle travel adjustment*), by turning it counter-clockwise until it doesn't resist anymore;
- 2 Unscrew the *nozzle* with a 10mm wrench;



After removing the nozzle, to clean it:

- 3 Put the *nozzle* under running water then blow it with compressed air and clean the *nozzle* hole with the *cleaning needle*;
- 4 Repeat the step until you have removed all the impurities inside and outside the *nozzle*;
- 5 Screw the *nozzle* on the valve with a 10mm wrench.



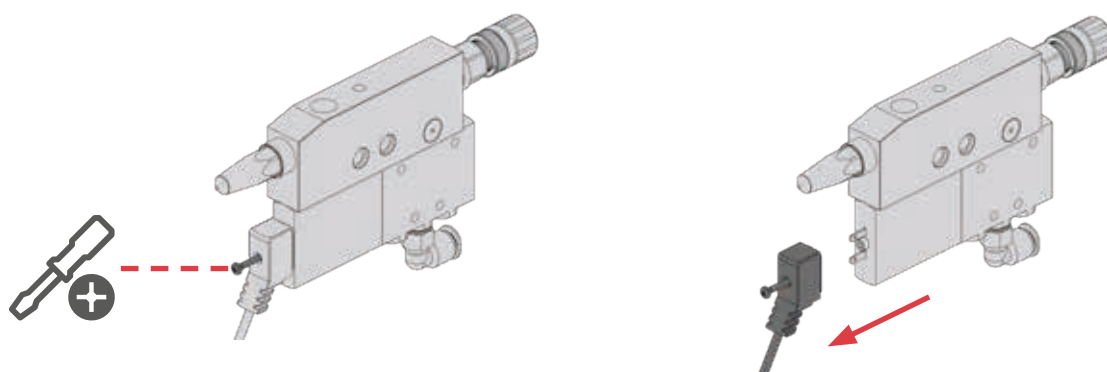
6.4 Valve disassembly

Before you disassembling the valve the following steps **must be done**:

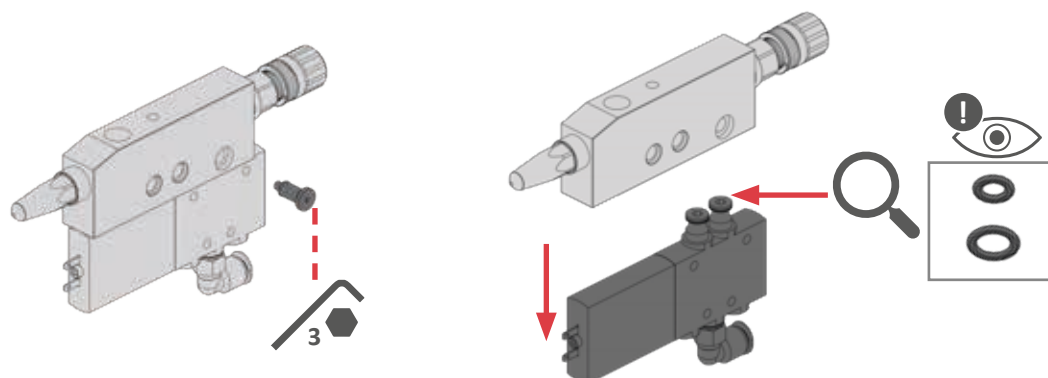
- Wash the valve with water
- **Discharge the pressure from the supply system**
- **Disconnect air connection**

Then proceed as follows:

- 1 Unscrew the solenoid valve connector screw; then pull out the *solenoid valve connector*;



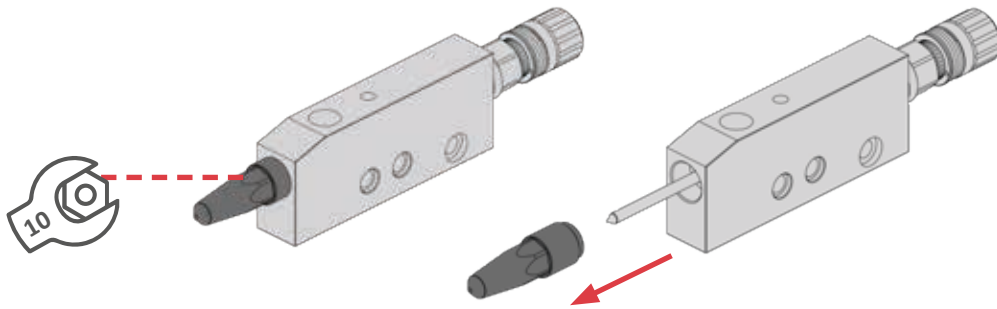
- 2 Unscrew with 3mm hex key the *fixing screws* of the solenoid valve, Be careful of the *O-ring* inside the solenoid valve;



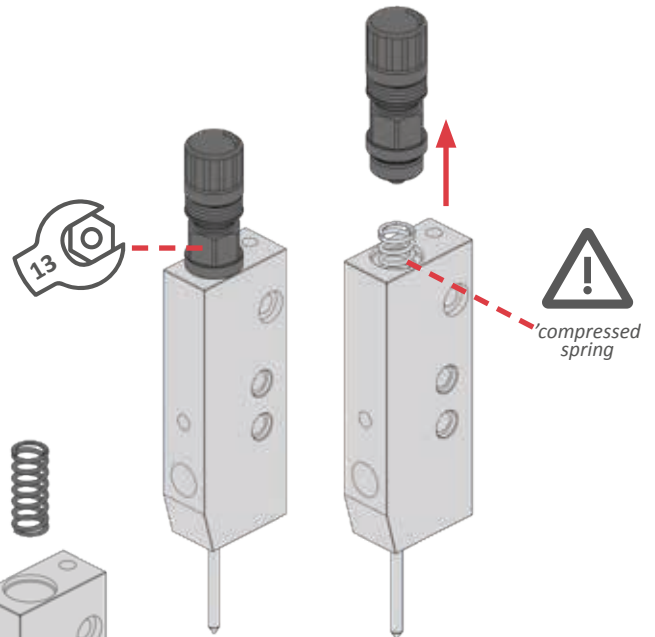
- 3 Loosen the needle adjustment whit the *adjustment screw* or the *micrometric adjustment handle* (see section 5.2 - Needle travel adjustment), by turning it counter-clockwise until it doesn't resist anymore;



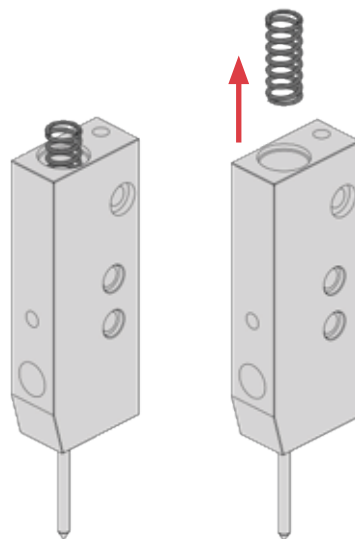
- 4 Unscrew the *nozzle* with a 10mm wrench;



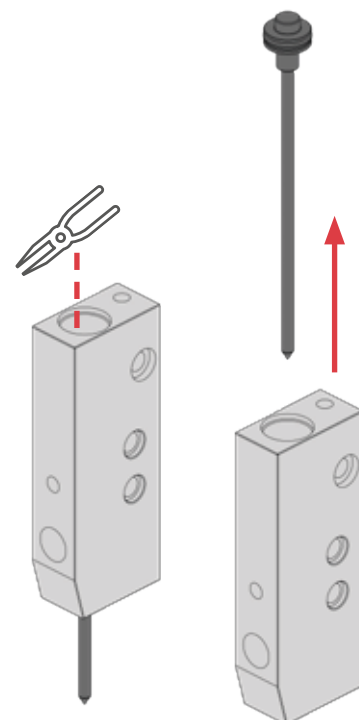
- 5 Unscrew the *adjustment block* with a 13mm wrench, **being careful** of the inner compressed spring;



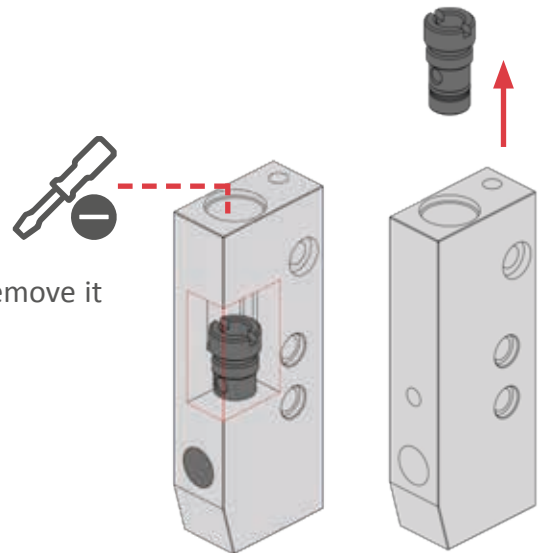
- 6 Extract the *spring*;



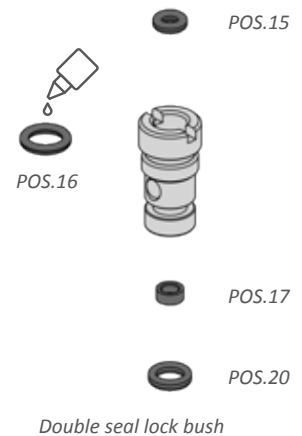
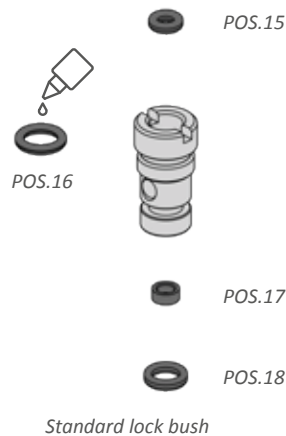
- 7 Pull out the *needle* with the help of a smooth plier;



- 8 Unscrew the *lock bush* with tubular spanner, then remove it from the valve body;



- 9 Check the wear of the lock bush *O-ring* and of the *gasket* and, if it is necessary, replace it. Always grease* the new O-rings before assembling them.



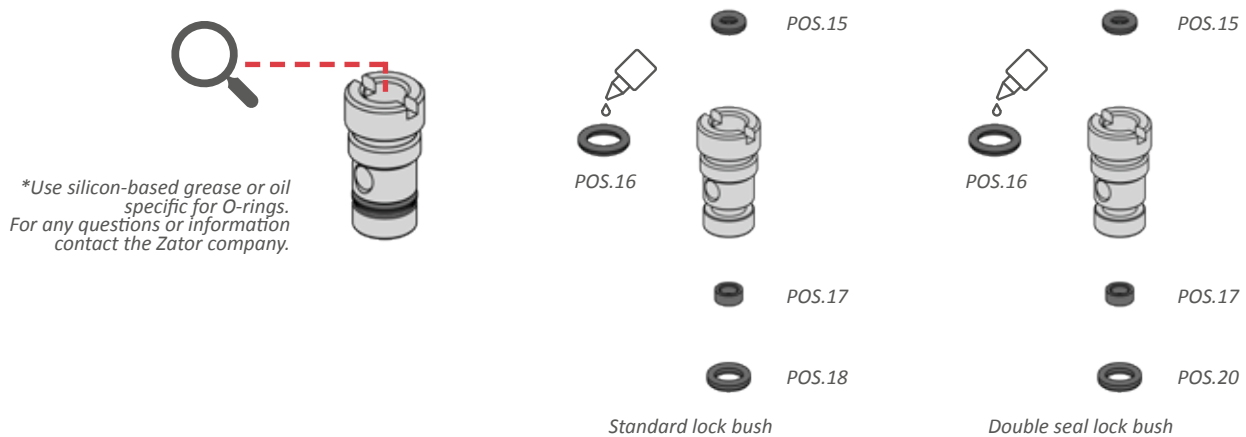
6.5 Valve assembly

Before to assembling the valve the following steps **must be done**:

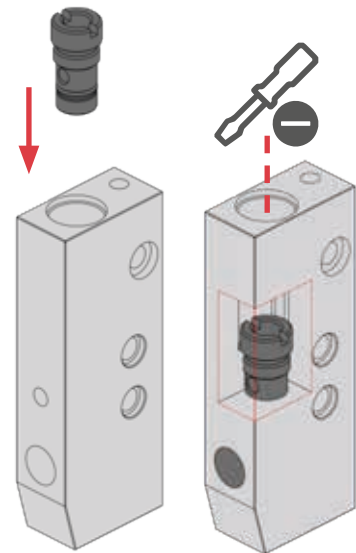
- Remove the residual glue from the valve using a wet rag or soft brush
- Clean the nozzle and if it is necessary put it under running water then blow it with compressed air and clean the nozzle hole with the cleaning needle
- Check the wear of the O-rings and if it is necessary replace it
- Before the assembly always grease the O-rings

Then proceed as follows:

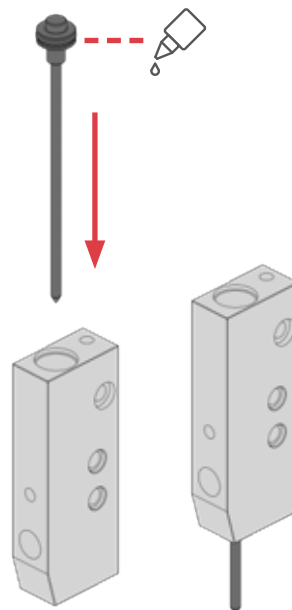
- 1 Insert the *gasket* and the *O-ring* in the *lock bush*. Always grease* the new O-rings before assembling them;



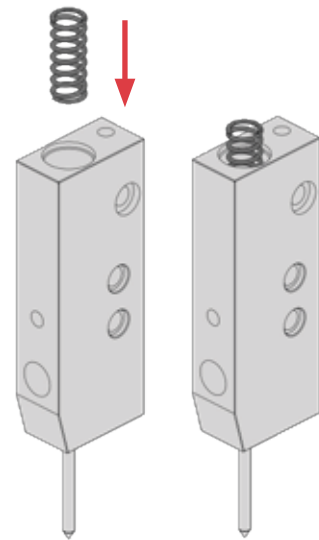
- 2 Insert the *lock bush* inside the valve body, then screw it with a tubular spanner;



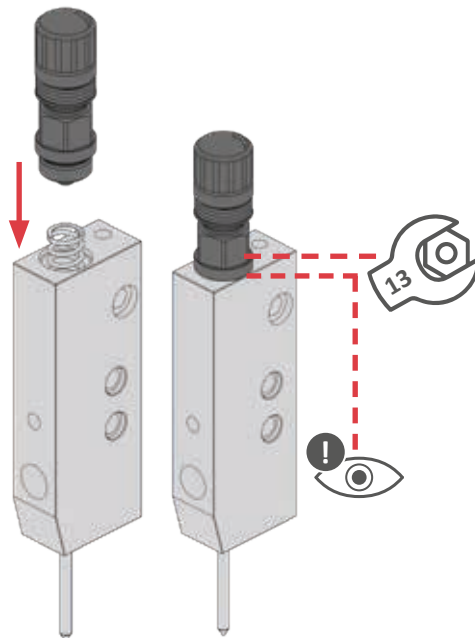
- 3 Insert the *needle* and grease the piston O-ring;



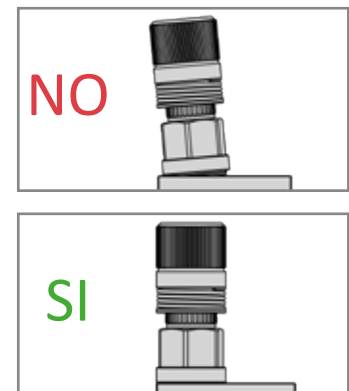
4 Insert the *spring*:



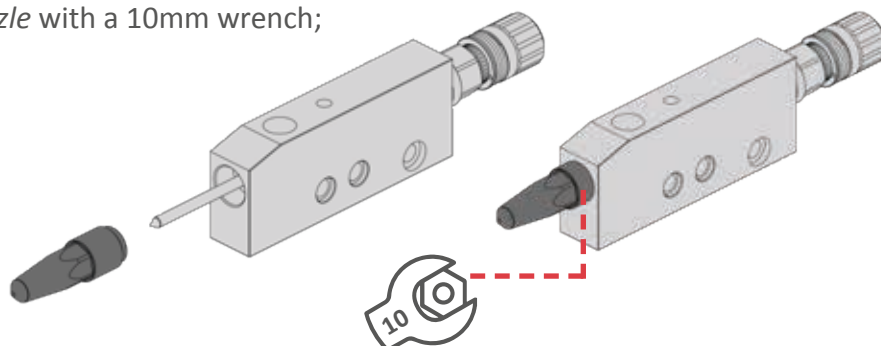
5 Screw* the *adjustment block* in the valve body with a 13mm wrench;



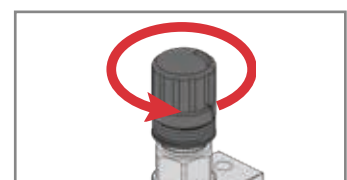
***Pay attention** that the adjustment block is not tilted during the screwing to avoid damage to the thread.



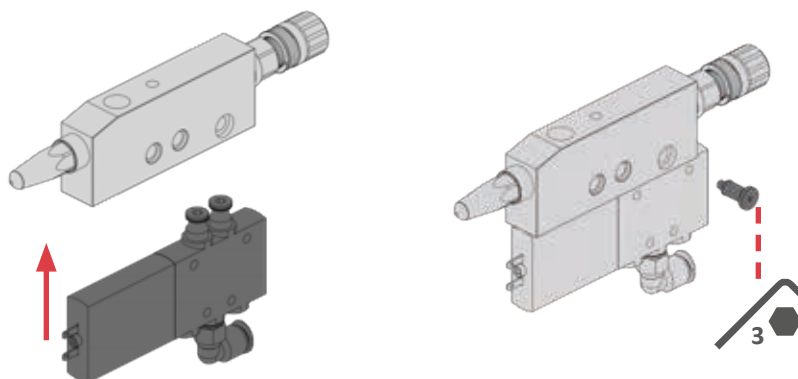
6 Screw** the *nozzle* with a 10mm wrench;



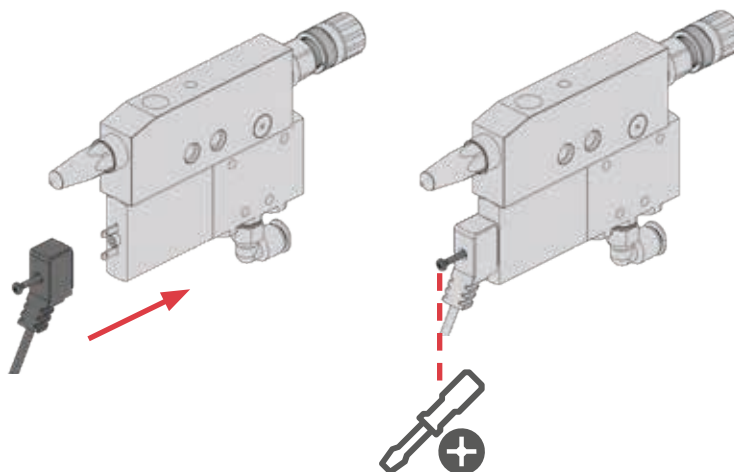
****Before screwing the nozzle**, check that the adjustment screw/the micrometric adjustment handle are completely loosened to avoid damage to the nozzle and needle. To loosen the adjustment screw/the handle, turn it counter-clockwise until it doesn't resist anymore.



- 7 Screw with 3mm hex key the solenoid valve mounting screws, be careful of the *O-ring* inside the valve body;



- 8 Insert the *solenoid valve connector*; finally screw the *solenoid valve connector screw*.



7 TROUBLE SHOOTING



CAUTION: the trouble shooting **must be performed only by qualified personnel** observing the safety norms.

TROUBLE	POSSIBLE CAUSE	WHAT TO DO
No or little quantity of dispensed fluid	The valve doesn't receive any signal	<ul style="list-style-type: none"> • Check the cables of the solenoid valve; • Check the solenoid valve command; • Make a manual test; • Check the functioning of the solenoid valve
	The pressure of the fluid is low or missing	Check the supply pressure
	The nozzle is clogged	Unscrew and clean the nozzle
	The filter is dirty (If in use)	Wash or replace the filter
	Bent pipe	Check the condition of the supply pipe
	No or weak drive pressure	Check the drive air pressure (6 bar)
	Residual glue into the system	Wash the complete system
Leak of fluid from the lock bush	O-ring or gasket inside the valve body is damaged	Replace the O-ring (POS. 15-16-18-20) or the gasket (POS. 17)
Nozzle drips fluid even if the valve is not activated	Presence of dirt inside the nozzle	Clean or replace the nozzle
The valve is activated with a lag	No or weak drive pressure	Check the drive air pressure (6 bar)
	Piston O-ring is damaged	Replace the piston O-ring (POS.13)

8 MODELS

code	description
MK01B00XX0	Extrusion valve MK1LVNR screw adjustment

*Replace XX value with nozzle diameter desired
Available nozzle diameters from 0,3 to 1,5 mm*

code	description
MK01C00XX0	Extrusion valve MK1LVRM micrometric adjustment

*Replace XX value with nozzle diameter desired
Available nozzle diameters from 0,3 to 1,5 mm*

code	description
MK09B00150	Extrusion valve MK1SYNR screw adjustment

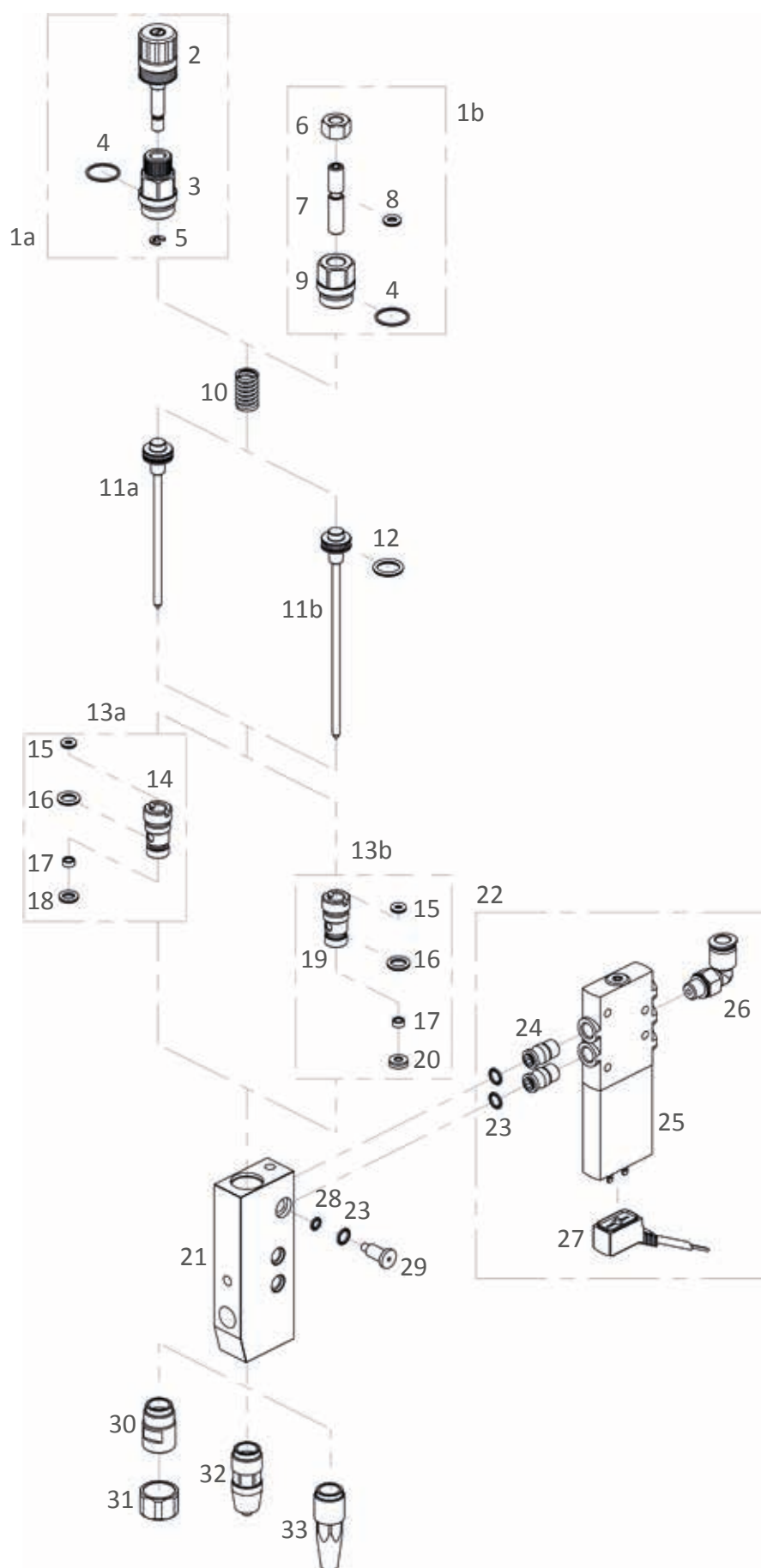
code	description
MK09C00150	Extrusion valve MK1SYRM micrometric adjustment

code	description
MK06B00200	Extrusion valve MK1MGNR screw adjustment

code	description
MK06C00200	Extrusion valve MK1MGMR micrometric adjustment



9 PART LIST



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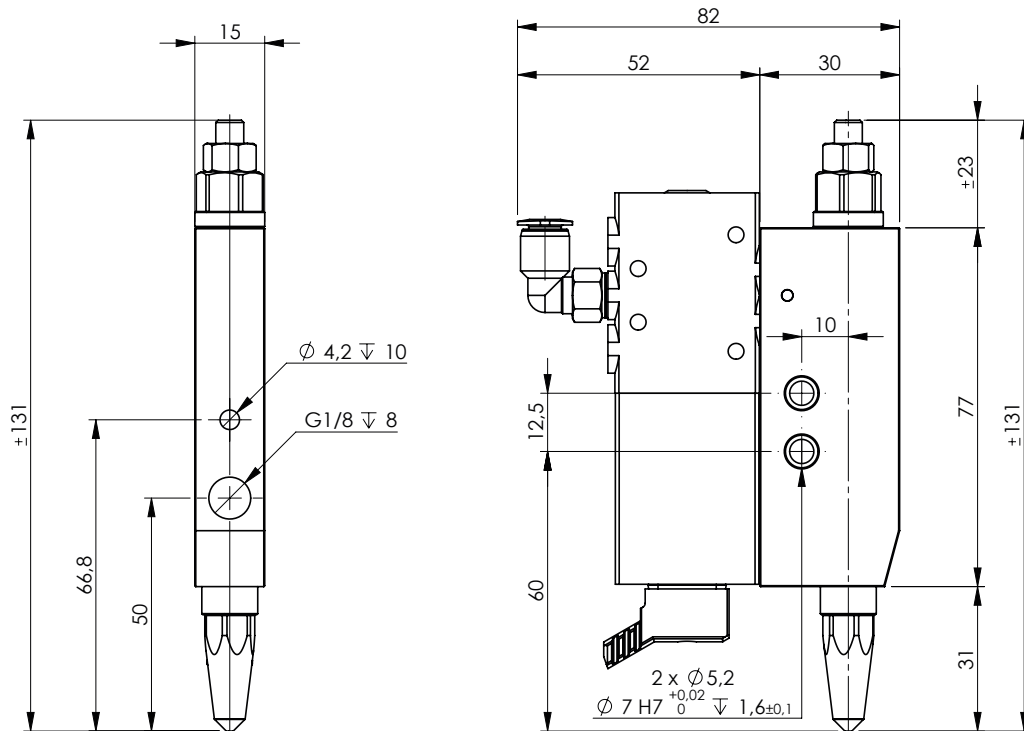
pos.	code	q.ty	description
1a	C32500007	1	Micrometric adjustment complete
1b	C32500002	1	Screw adjustment complete
2	C32500008	1	Micrometric adjustment knob
3	C32500009	1	Micrometric adjustment block
4	RNG100X10E	2	O-ring ¹⁻²
5	SGG200231	1	Adjustment circlip
6	NT0006010	1	Nut
7	C32500003	1	Screw
8	RNG000007E	1	O-ring ¹⁻²
9	C32500004	1	Screw adjustment block
10	CCS000400	1	Spring
11a	NDL402002	1	Needle KV
11b	NDL401002	1	Needle LV
12	RNG000011E	1	O-ring ¹⁻²
13a	H83100204	1	Standard lock bush complete
13b	BSG00400	1	Double seal lock bush complete
14	H83100104	1	Standard lock bush
15	RNG000006E	1	O-ring ¹⁻²
16	RNG000010E	1	O-ring ¹⁻²
17	SHS30790T	1	Gasket ¹⁻²
18	RNG000008E	1	O-ring ¹
19	BSH000400	1	Double seal lock bush
20	VRS30760T	1	Gasket ²
21	BG004001	1	Valve body
22	KCN004000	1	Coil connection kit
23	RNG050X10E	3	O-ring ¹⁻²
24	BSH004000	2	Connection lock bush
25	ELT000550	1	24V Coil
26	RRBE0452	1	90° fitting
27	WCB250005	1	Connection cable



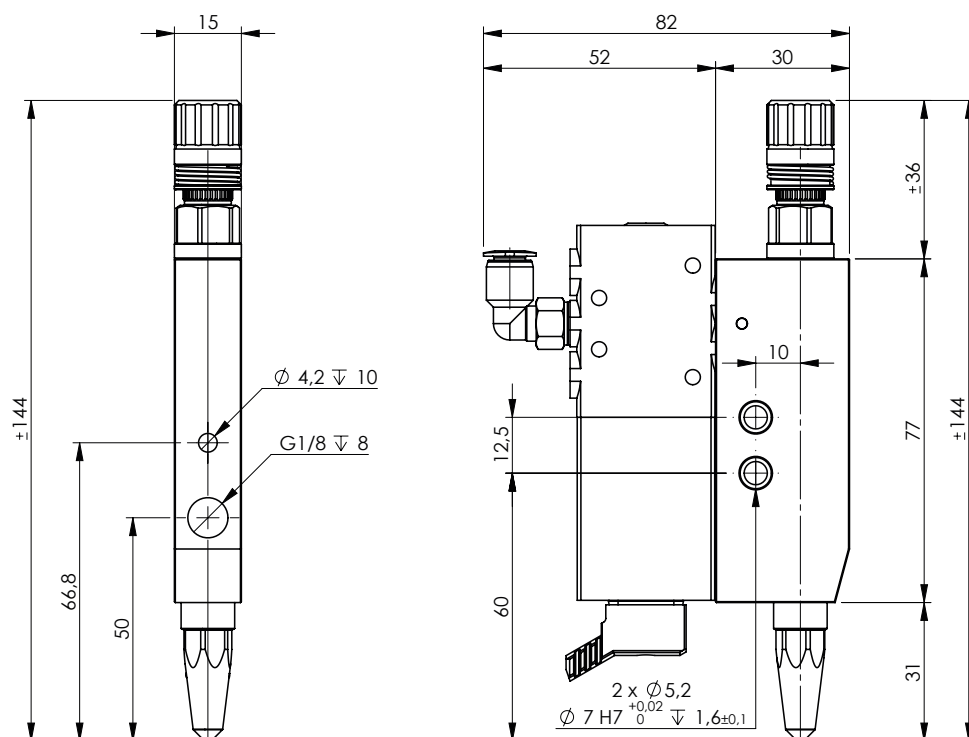
pos.	code	q.ty	description
28	RNG030X10E	1	O-ring ¹⁻²
29	SC09030131	1	Screw
30	H85800101	1	Nozzle MG
31	H85800204	1	Nozzle nut MG
32	H85100150	1	Nozzle Syrin
33	H853100XX	1	Nozzle LV
<i>Replace XX value with nozzle diameter desired Available nozzle diameters from 0,3 to 1,5 mm</i>			
	KG0040000	1	Gasket kit ¹
	KG0040001	1	Viton gasket kit ¹
	KG0040002	1	Double seal gasket kit ²
	KG0040003	1	Viton double seal gasket kit ²

10 DIMENSIONS

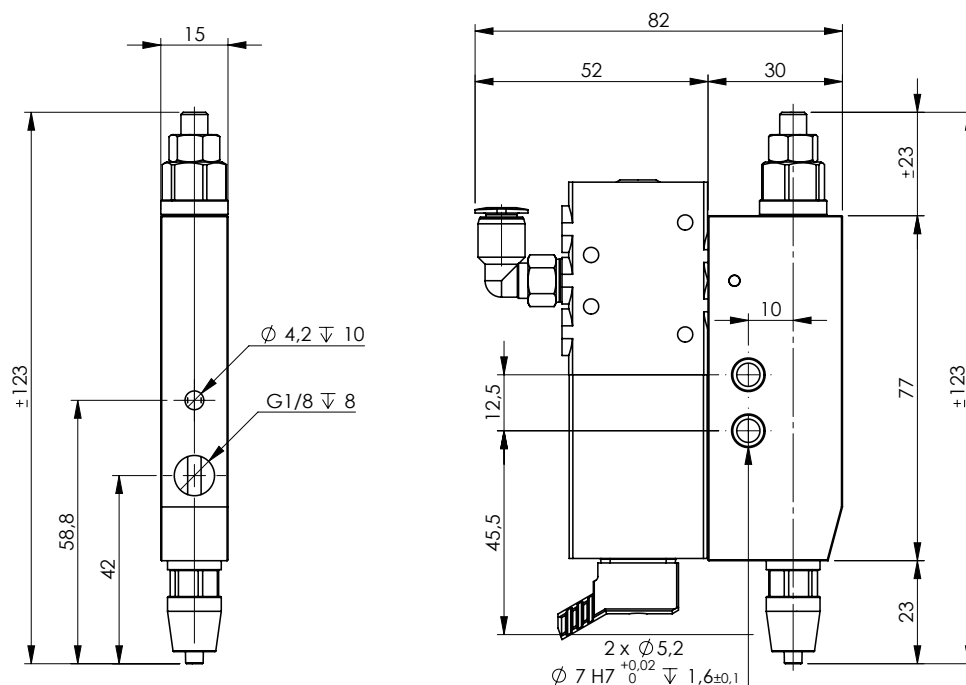
MK01B00XX0



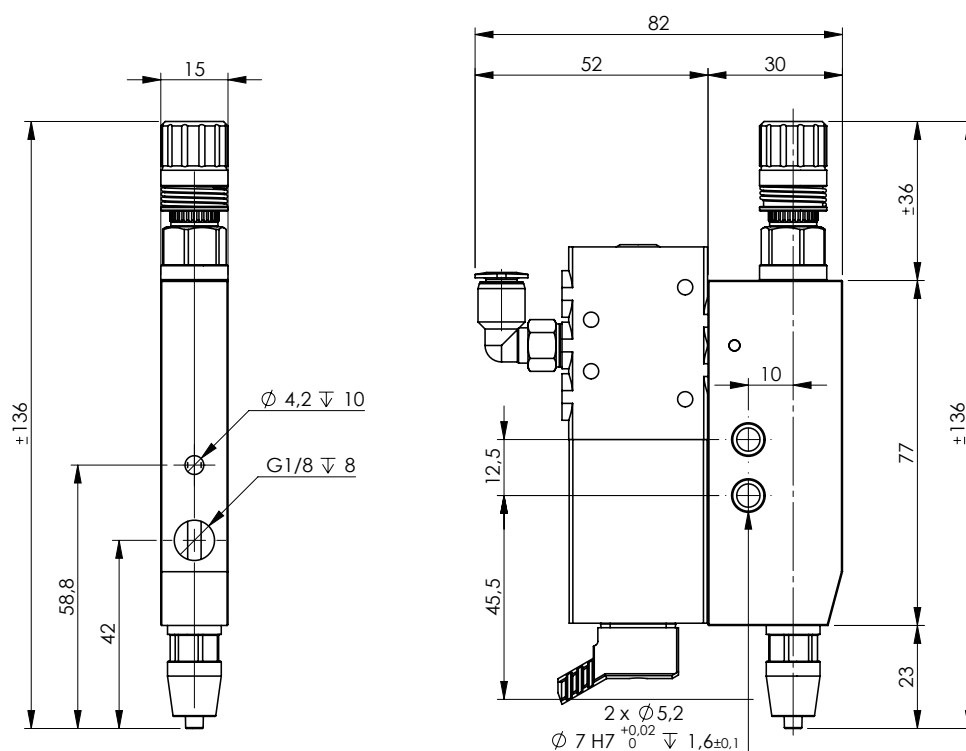
MK01C00XX0



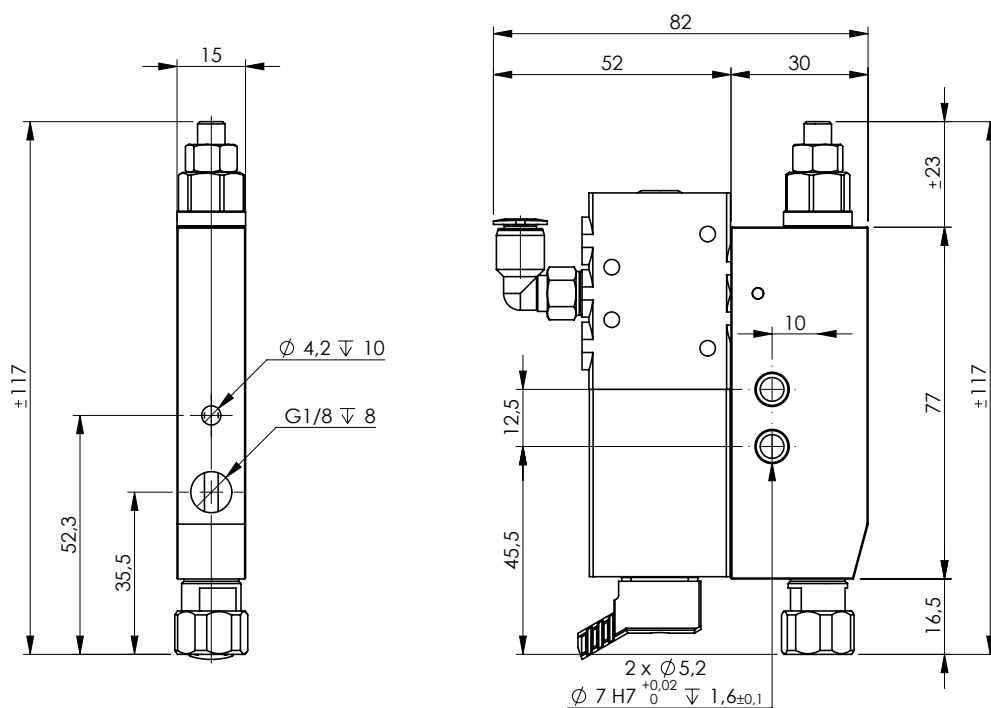
MK09B00150



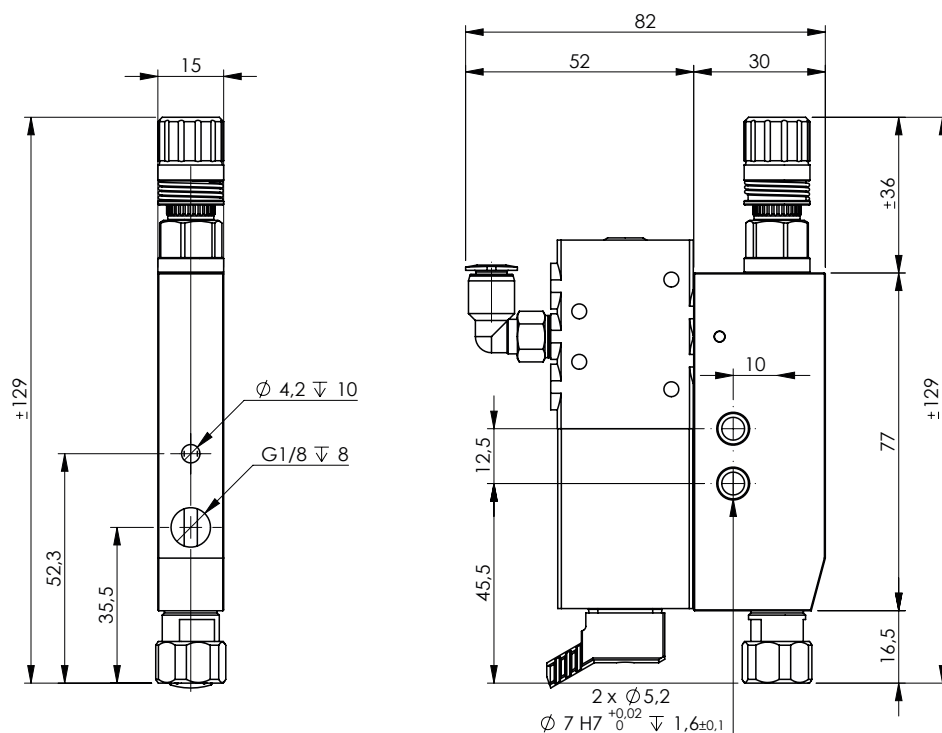
MK09C00150



MK06B00200



MK06C00200



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