

STEP BY STEP OPERATOR'S MANUAL FOR THE

INNOVATIVE
Digital Systems

PyroBond 4^{GL}



**Click Here
For Video**



<https://youtu.be/up7LI9byENQ>
view our instructional video

HOW TO:

UNPACK THE CRATE



ITEMS NEEDED:

Band Cutters

T-20 Torx Wrench

T-25 Torx Wrench



The Pyrobond GL is crated to ensure a safe and worry free delivery. With just these few tools, the GL will be out of the crate and in your workflow in no time.

HOW TO:

CONNECT THE PROPANE





The propane connector is reversed threaded and is installed inside the propane tank valve. Turn counterclockwise in order to tighten connection.



The propane connection should be a tight fit. Using a crescent wrench to complete install is recommended.

HOW TO:

CONNECT THE PYROSIL





The Pyrosil connector is fixed to the Pyrobond GL. Simply remove cap from new canister and gently screw into place.



Take care to NOT over-tighten canister.

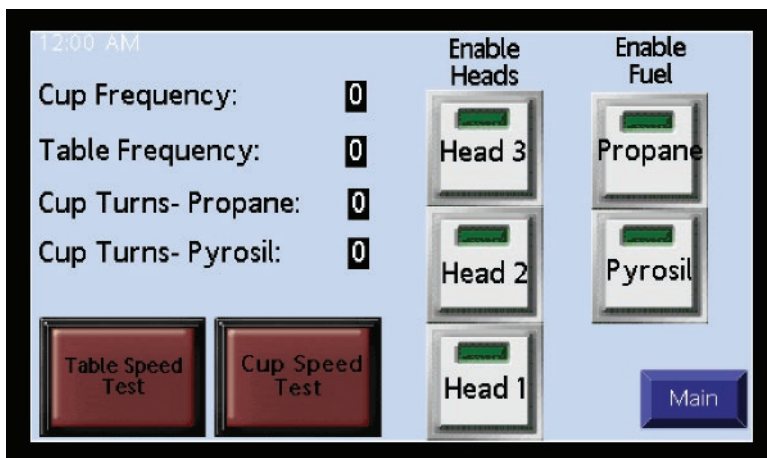
HOW TO:

PERFORM INITIAL SETUP

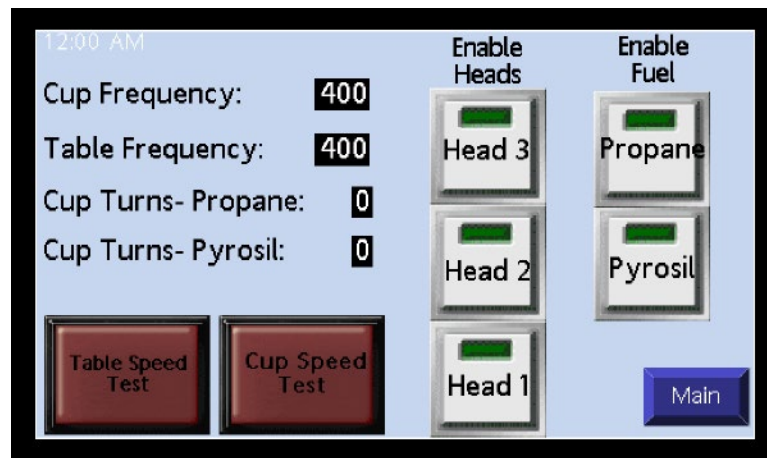




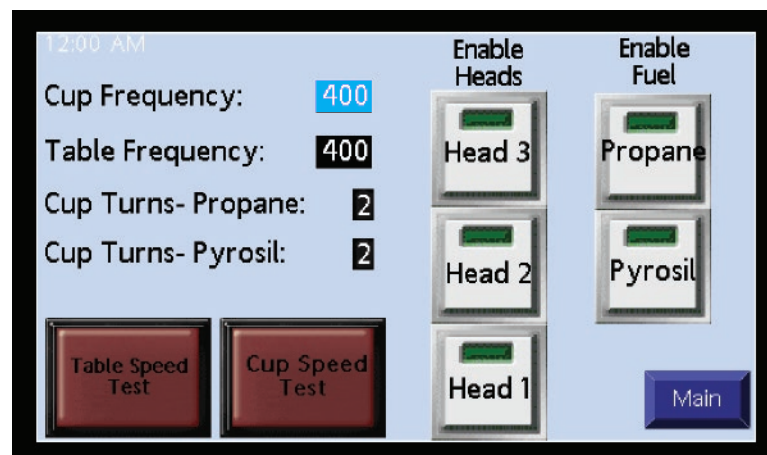
When the Pyrobond is turned on this is the home screen. To get started, select “Setup”.



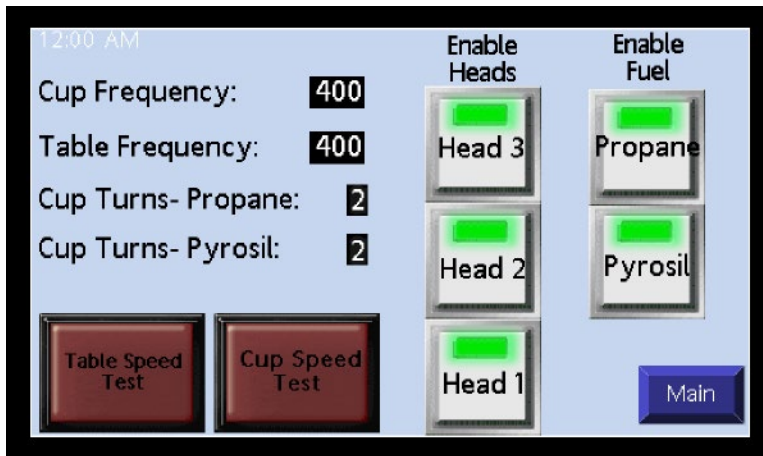
There are several operator options that can be selected. While both propane and Pyrosil are likely needed for your glassware, for stainless and powder-coat propane is likely all you will need for treatment.



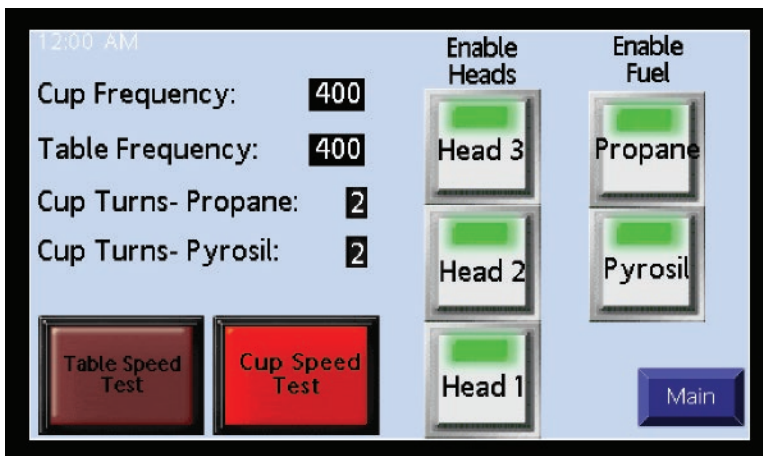
The Cup Frequency and Table Frequency are factory set to 400. To change any of the values, simply press on the numeric corresponding field.



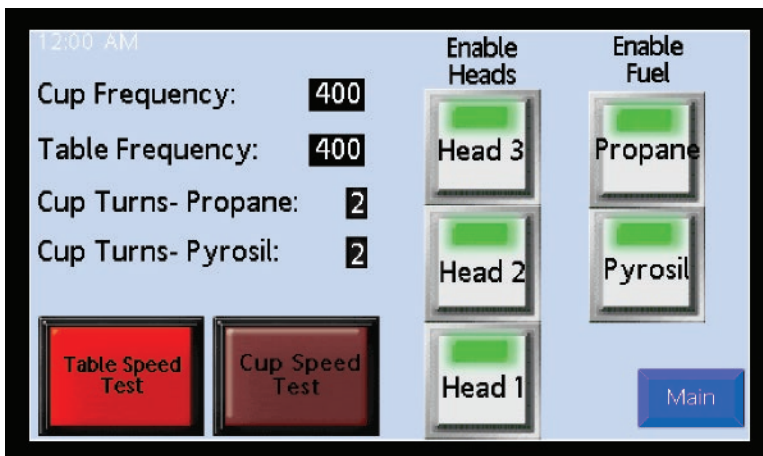
When you select a field, a numeric keypad will appear and allow you to make the necessary changes.



For this example, we will prepare the Pyrobond GL to treat glassware that will need 160° propane heat for pretreatment, and 2 turns of Pyrosil for maximum adhesion.



There are 2 test buttons to check the speed settings for the GL. Cup Frequency and Table Frequency. Before making any changes, select both test buttons to see how fast the table turns,



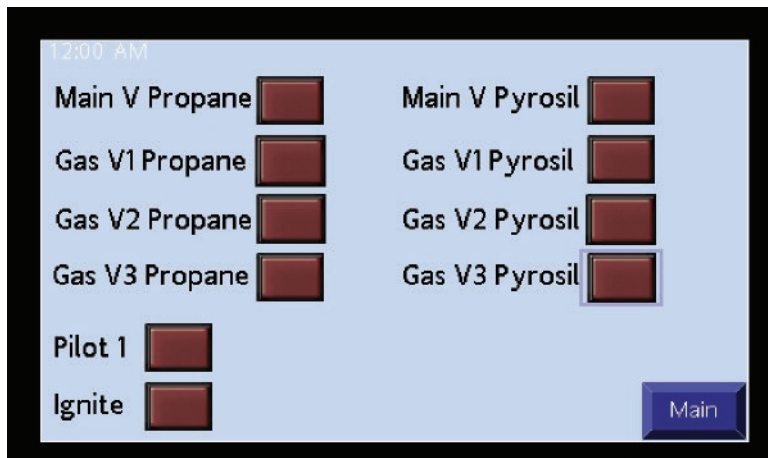
and how fast the cup turns. Adjust according to your needs. Once you are satisfied with your settings, select Main.



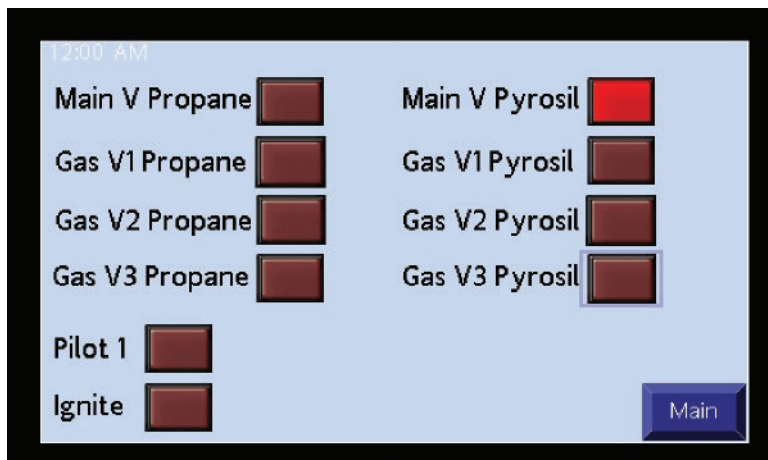
You are almost set to start treatment. One more setting needs to be adjusted and you will be ready to start!



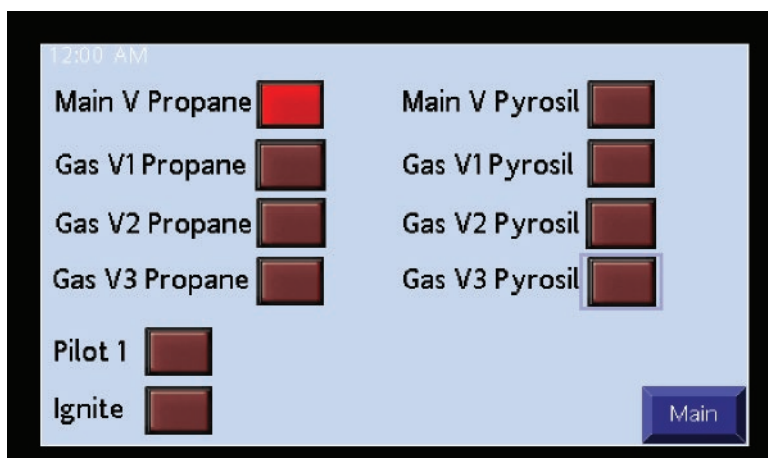
Once you are done making the necessary changes, press main, to get back to the home page. Now we can press manual.



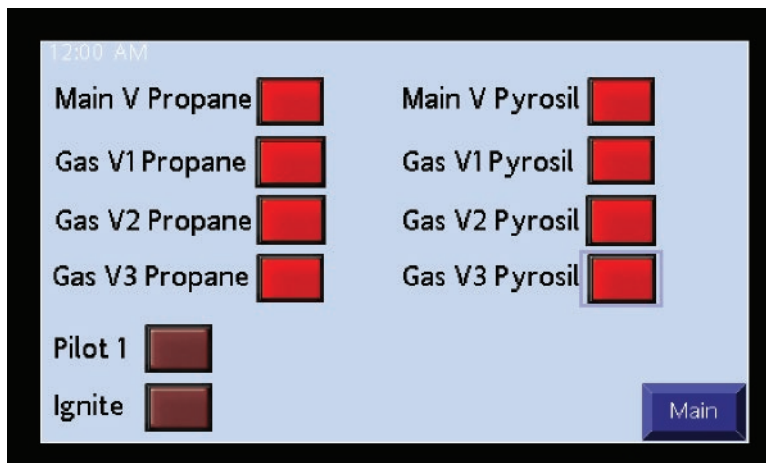
In Manual, we have the options of which fuel sources to select, and depending on the height of your product, which flameheads to ignite.



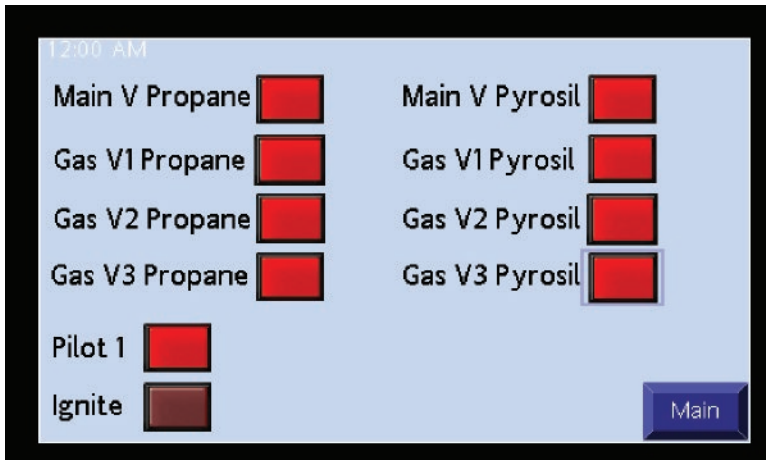
As you can see, we have the option of selecting the Pyrosil,



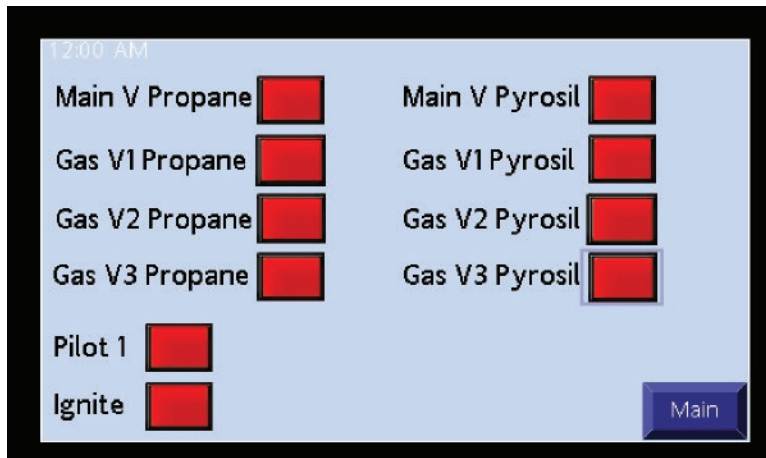
As you can see, we have the option of selecting the propane,



or, as in this case both. We also have all the flameheads set to ignite for full coverage.



Next select the pilot 1.



Finally select ignite pilot. If the pilot does not ignite, check the pilot valve and make the necessary adjustments until you achieve pilot ignition.



You are all set!, Load the Pyrobond GL bed and Start Cycle.

CONSIDER:

CUSTOM TOOLING



At IDS, we know that no 2 cups are alike. That's why we have a team of engineers dedicated to making your Pyrobond GL the perfect fit for all your adhesion needs.

There are countless ways to maximize output through customization of the GL.

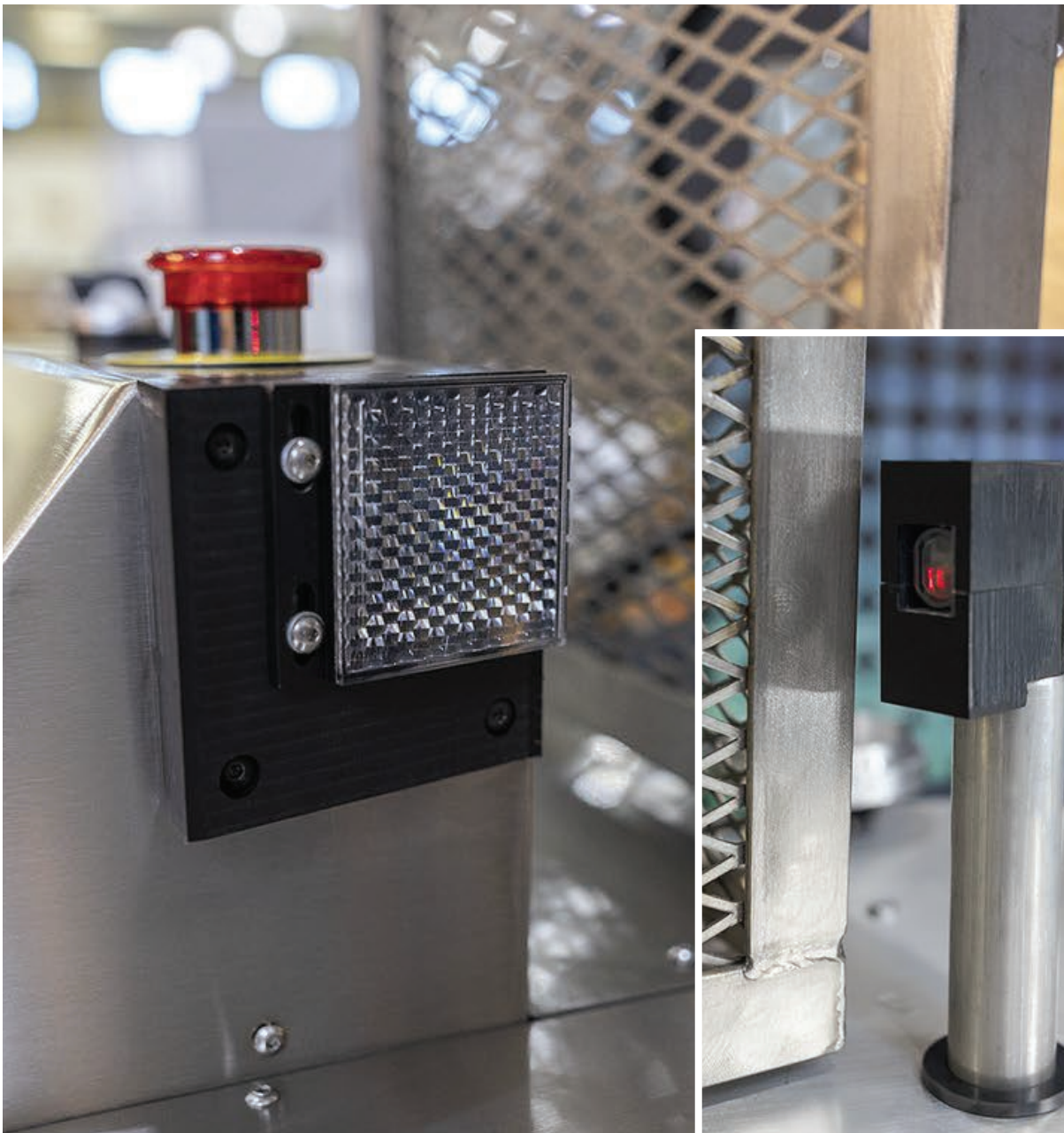
Many clients have found that sending us sample cups prior to shipping the Pyrobond will allow us to create fixtures to your specifications and hit the ground running!

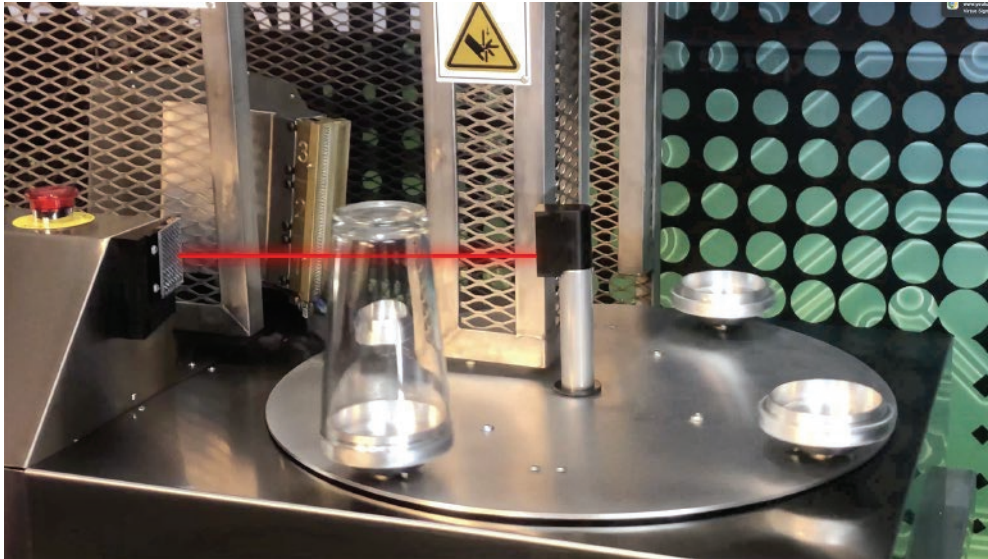


contact our Engineer Dept. at
engineering@ids-digital.com
for more details.

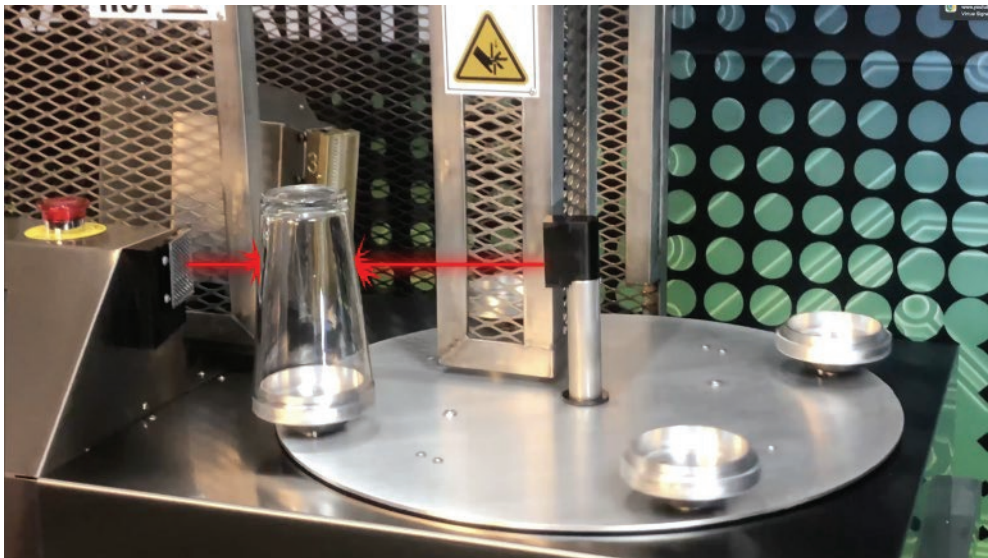
UNDERSTANDING:

LASER SENSORS

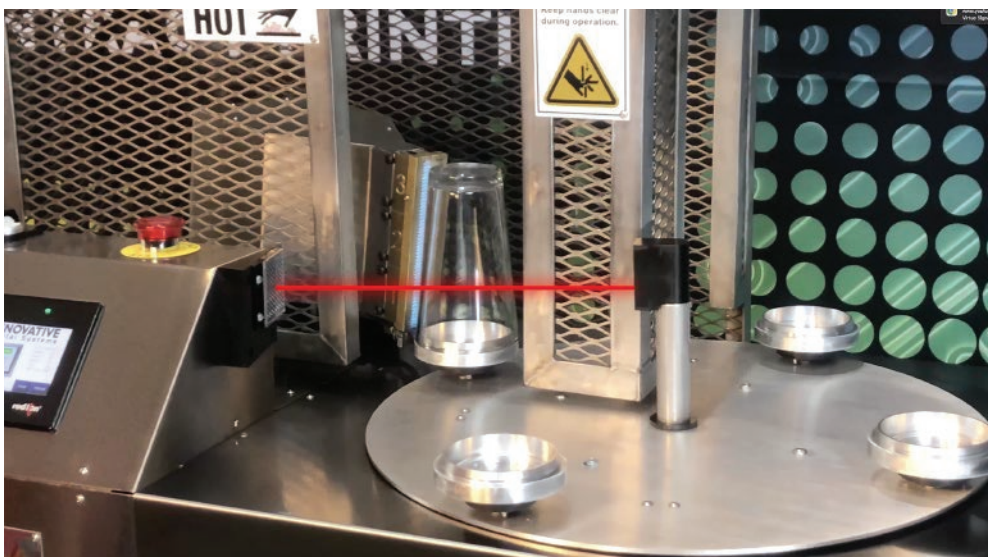




The laser sensor is designed to ensure the flamehead will only fire when a cup is detected, thus saving valuable resources.



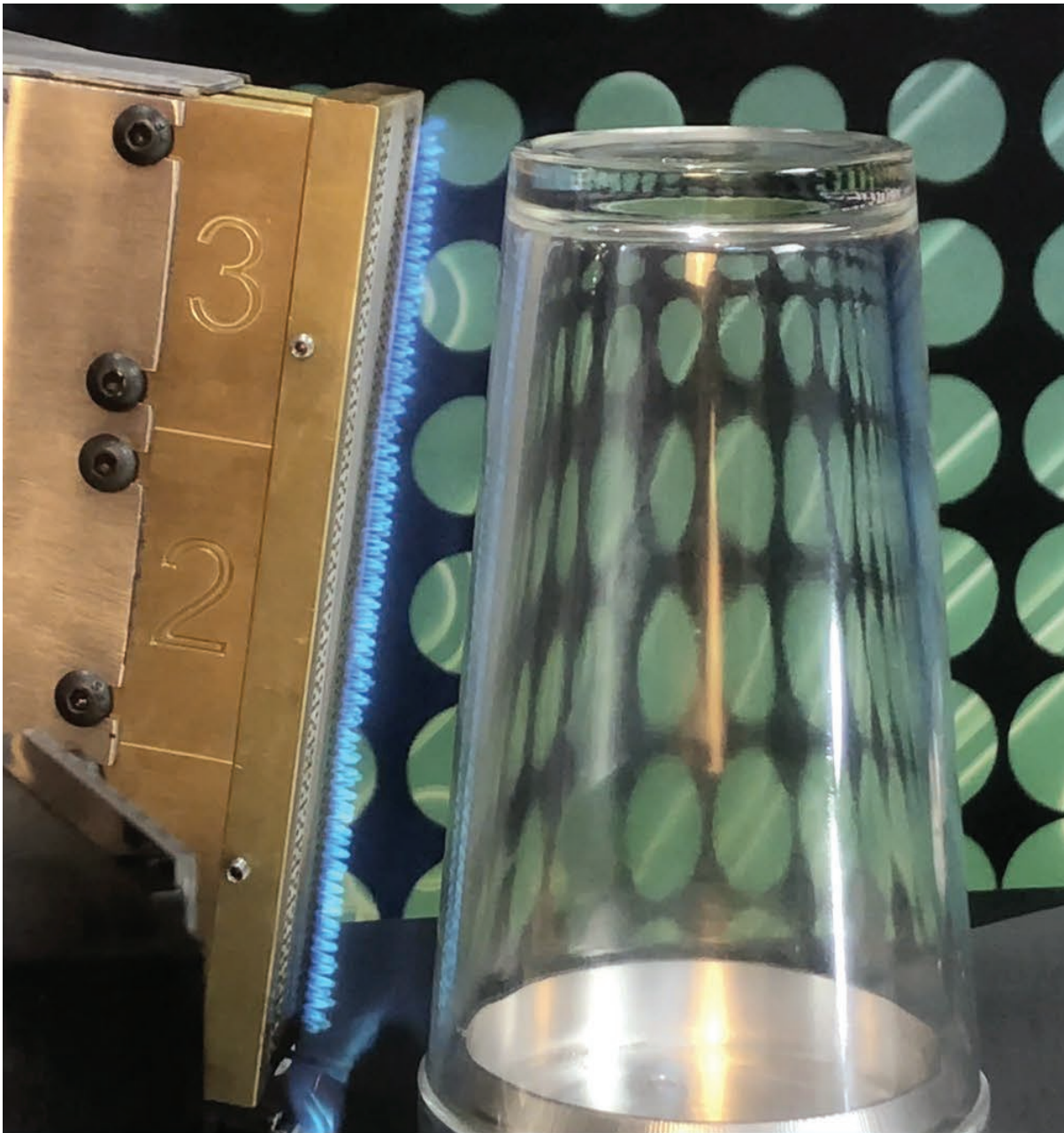
Once a cup has broken the line of sight the cup will stop in front of the flamehead,

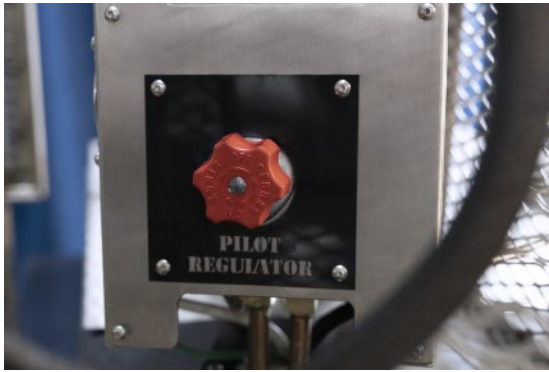


and based on options selected, the preset fuel and flameheads will fire, the cup will spin for each fuel source, once the cycle is complete, the table will turn.

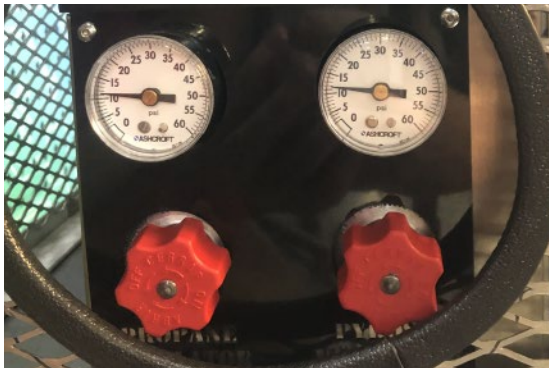
A CLOSER LOOK AT:

BURNER SYSTEM

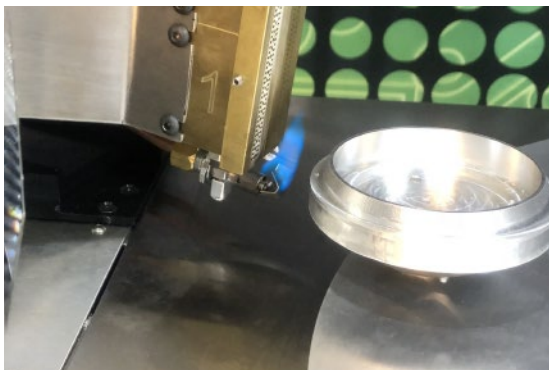




Once the fuel sources are installed, you need to open the valves for the pilot and the propane and Pyrosil. The propane has no gauge, but only needs be open enough to light the pilot.



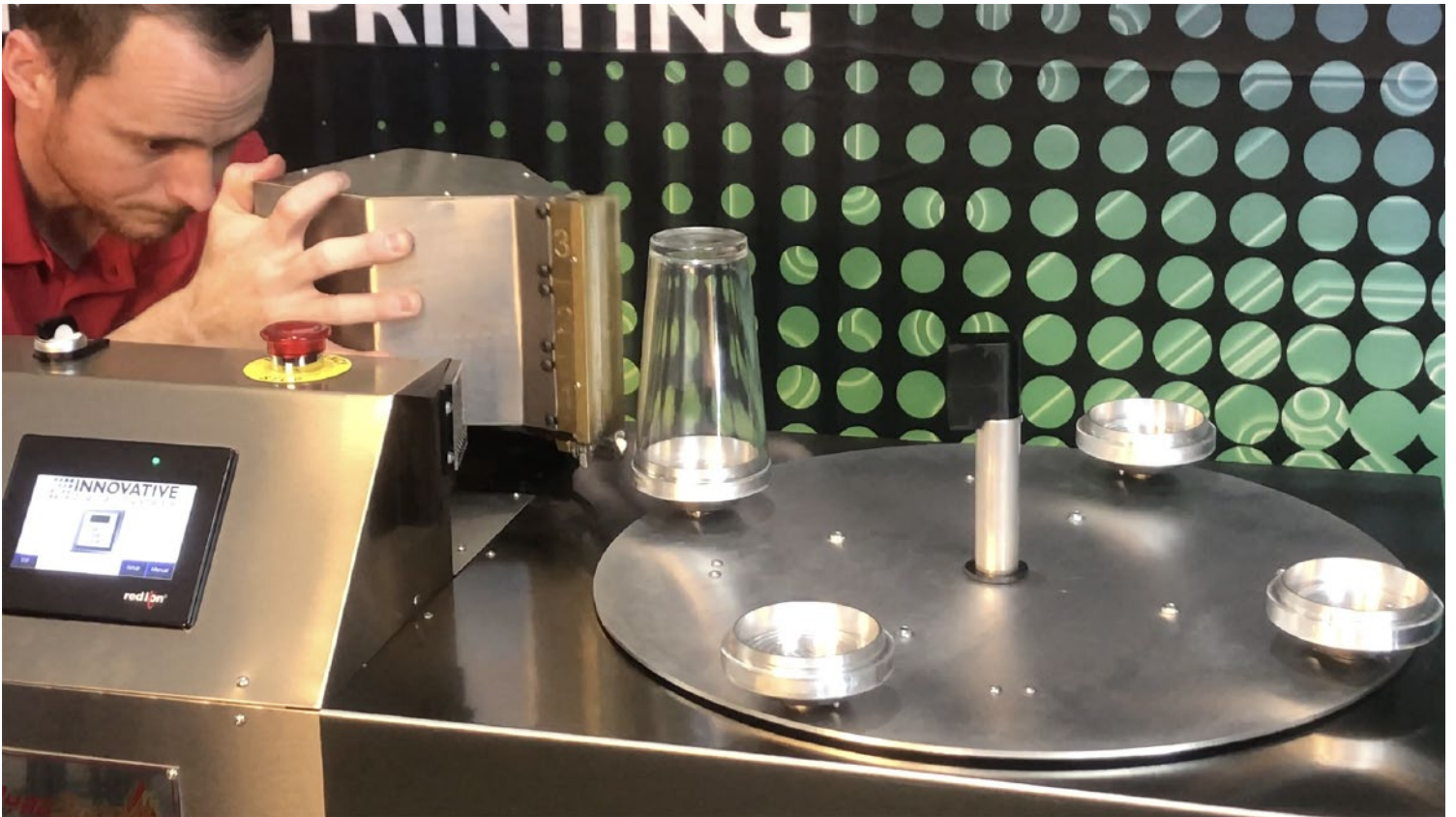
Found below the pilot valve are the propane on left and the Pyrosil on right. While in use, both should be set to 10 PSI.



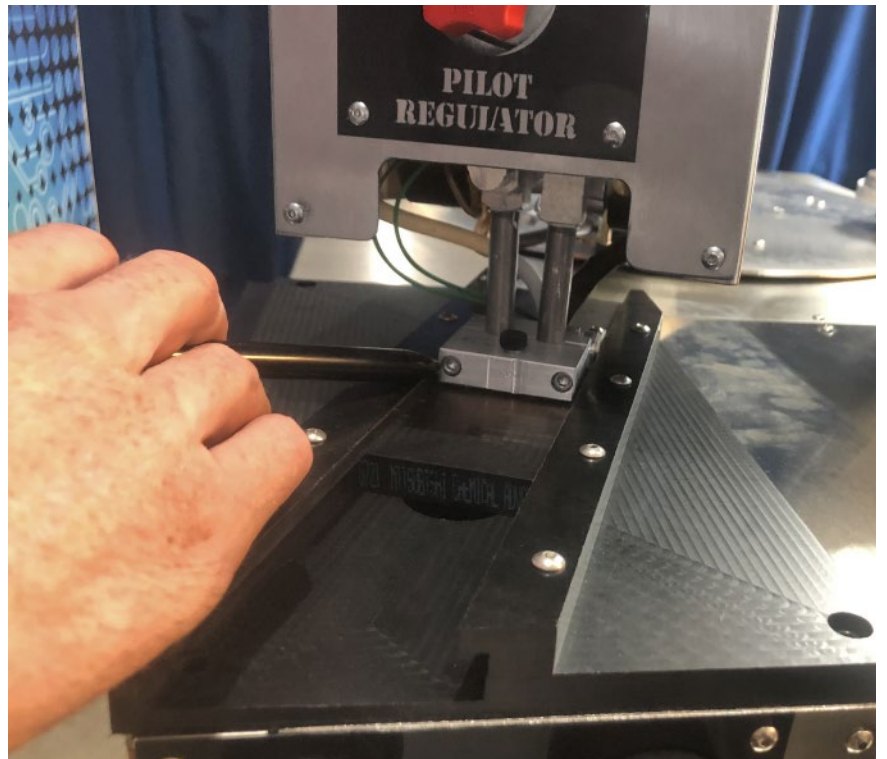
Here is the pilot light ignited and ready for use.

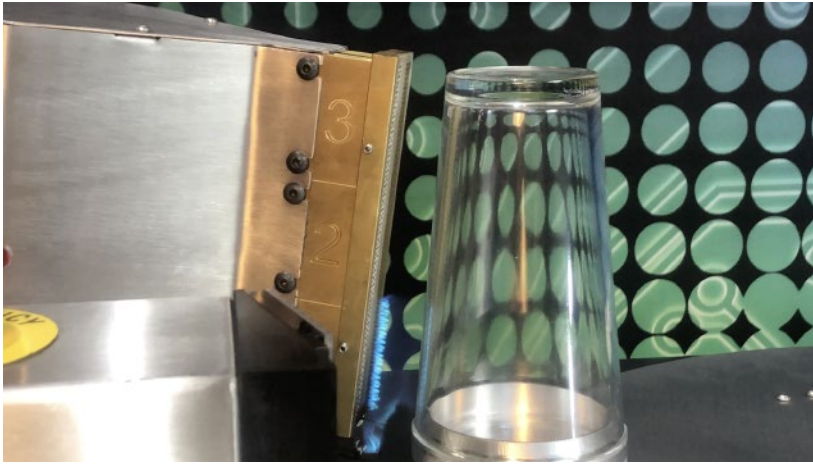


As you can see, we have 3 separate flameheads for each fuel source. This ensures that depending on the size of the cup, only the heads needed will flame.

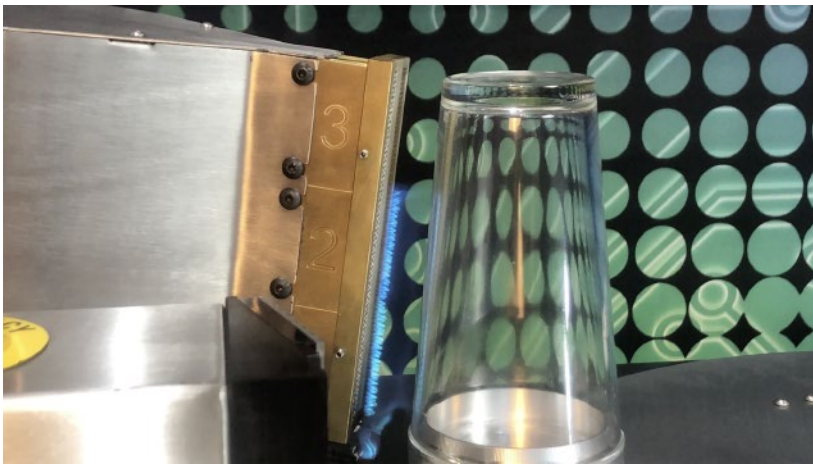


The Pyrobond GL is built on a sled, this makes adjusting the distance from flame to cup a breeze. There are 2 screws, and by using a 9/64" Allen key, loosening the aluminum clamp allows you to raise and lower flamehead. There are thumb screws to change the angle of flamehead, ideal for conical products.

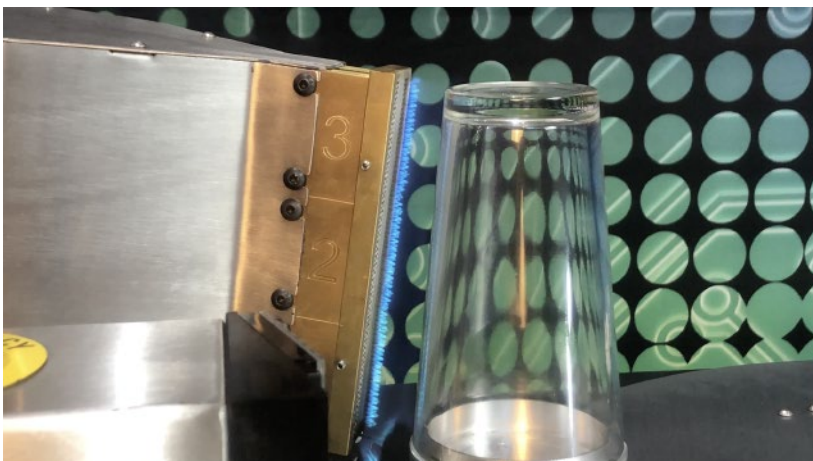




In this sequence we see each individual flamehead ignited. Here is propane Head 1.



Here is propane Head 1 and 2.



Here is propane Head 1, 2 and 3.

UNDERSTANDING:

SAFETY MEASURES

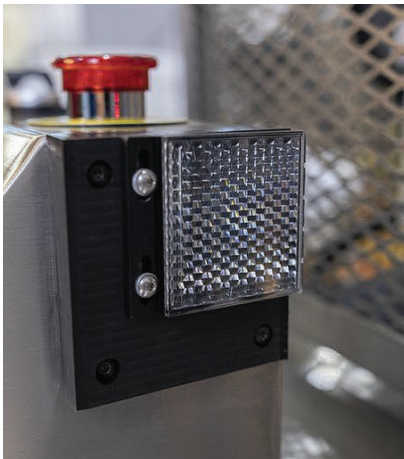




The emergency E-Stop is located in the front of the machine and right above the control panel for optimum access in case there is a need to stop the GL during a cycle.



Given the nature of the flame treatments temperature, PPE is absolutely required. All operators should wear heat resistant gloves, and protective eyewear.



The laser sensors not only save valuable resources, since they only fire the flamehead when a cup is detected, they act as a safety precaution as well.



The steel cage barrier protects the operator from both high temperature zones, as well as pinch points.

ADDRESSING:

TROUBLESHOOTING MEASURES





If the PyroBond does not operate as expected, check to make sure there is fuel in the propane and or Pyrosil canisters.



Make Sure the valves are opened and reading 10 PSI and that the pilot valve is opened as well.



If the Pilot does not light, You may need a lighter to manually ignite the pilot.

For any other issues, contact our Tech Department right away. 704-628-7679 or email at techsupport@ids-digital.com

MAXIMIZING THE:

ADHESION PROCESS



The ideal flame distance is 1/2" from the light blue of the flame to the surface of your product. This will maximize adhesion.

Glass product

should be at a range of 160° and 180° of propane pretreatment, prior to Pyrosil. Pyrosil treatment should cover 1 complete rotation, even overlapping if necessary.



Stainless steel

typically only needs a propane treatment to burn off any debris or surface coatings. While Pyrosil is typically not necessary, you should always run an adhesion test on all products prior to a production run.

Pioneers of Digital Decorating.



view our instructional video at:

<https://youtu.be/up7LI9byENQ>



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