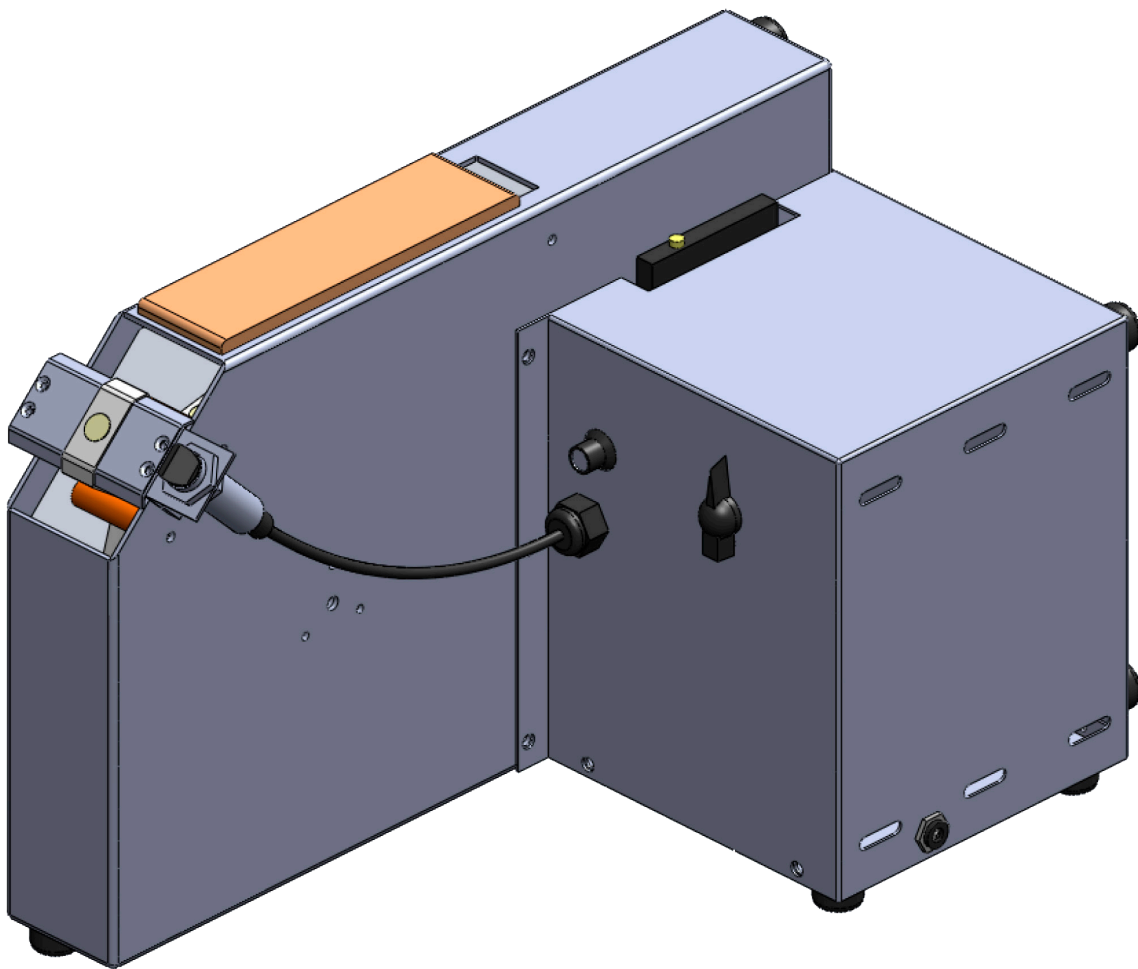


Auto Dot[®] Pro

OPERATIONS MANUAL

ISSUED: JANUARY 2011



IMPORTANT: Read and understand the Operations Manual before operating the Auto Dot[®] Pro.

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U.S. Patent No.'s 5,935,670; 6,319,442; 6,640,864; 6,686,016. Other U.S. and Foreign Patents Pending. © 2011 Glue Dots® International.

INTRODUCTION

The Auto Dot® Pro is an economical bench-top machine exclusively designed to dispense Glue Dots® Adhesive Products in rolls of up to 8,000 adhesive patterns. This manual shows the basic operation of the Auto Dot® Pro including setup, loading and operation.

SAFETY

For your safety it is important to read and understand this Operations Manual before using the Auto Dot® Pro. It is important to keep hands, hair, clothing, jewelry and other loose objects away from any moving parts during operation of this machine.

The Auto Dot® Pro is designed to exclusively dispense patented Glue Dots® Adhesive Products on registered liner. Operating this machine outside of its intended nature will result in poor results, damage to the machine or compromised operator safety. Glue Dots® International will not be held liable for any damage to products or persons resulting from improper use of the Auto Dot® Pro. If you have any safety related questions, please call 888-688-7131.



IMPORTANT: Only persons who have read this Operations Manual and who are familiar with the proper use of the Auto Dot® Pro should operate this machine.

IMPORTANT: All electrical work performed on the Auto Dot® Pro should be performed by a licensed electrician or trained person supervised by a licensed electrician.

IMPORTANT: Draw-in or squeezing can occur between the motor-driven and clamp rollers. Reference the associated label shown here and on the shroud. (See the components diagram Fig I on pages 6-7)

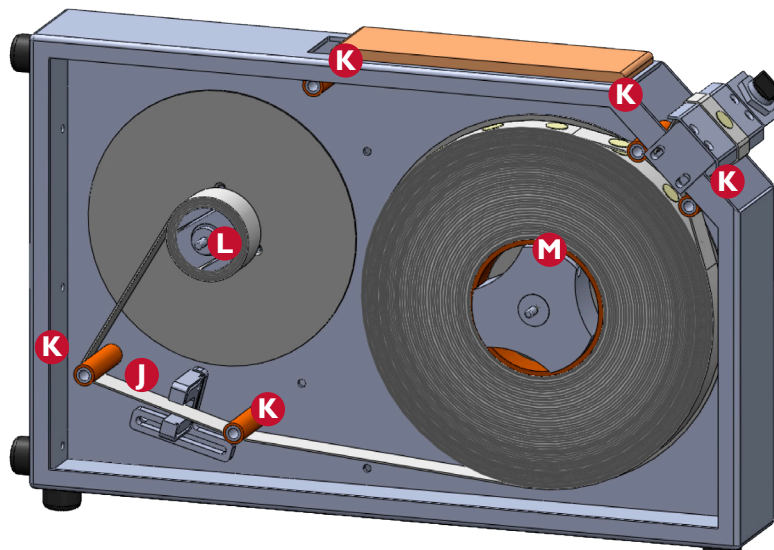
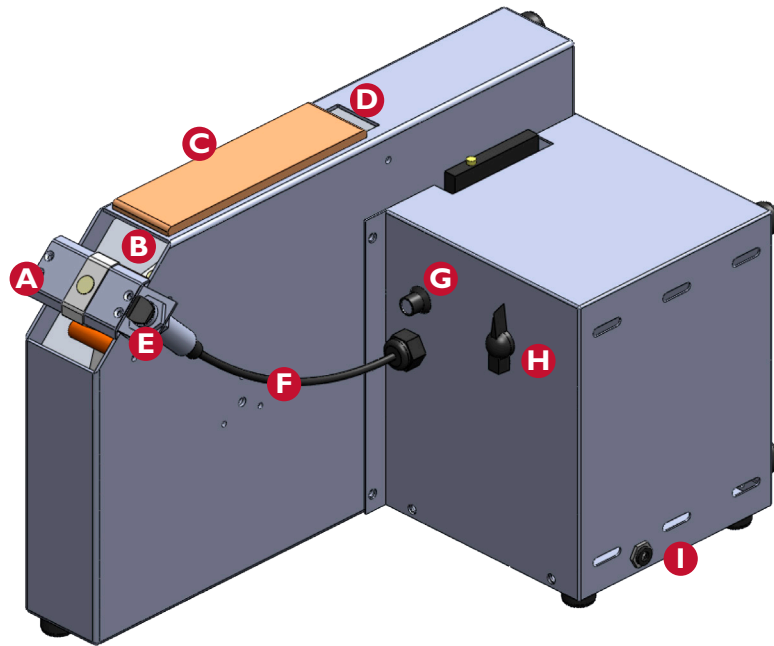


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COMPONENTS

- | | | | | | |
|----|-----------------------|----|-----------------------|----|----------------------|
| A: | Nose Plate | F: | Trigger Cable | K: | Rollers |
| B: | Front Liner Feed Slot | G: | Speed Adjustment Knob | L: | Liner Return Spindle |
| C: | Top Nose Plate | H: | Rotary Switch | M: | Supply Reel Spindle |
| D: | Rear Liner Feed Slot | I: | Power Supply Plug | | |
| E: | Photo Eye | J: | Photo Eye #2 | | |



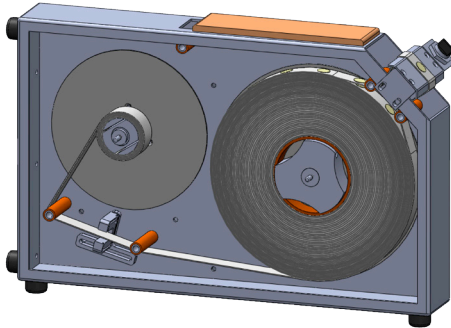
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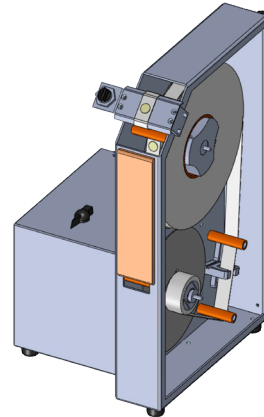
FEATURES & OPTIONS

UNIT ORIENTATION: To accommodate workspace, or preferred working height. Also accommodates left handed operator (when in vertical orientation).

Horizontal Orientation

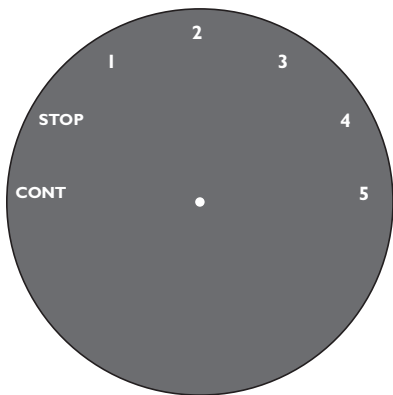


Vertical Orientation



MULTIPLE THREADING OPTIONS: For easier application of various sized items; based on preference (see recommendations given with each option).

ROTARY SWITCH:



Position:

- Cont
- Stop
- 1
- 2
- 3
- 4
- 5

Pattern:

- Continuous pattern advance
- Stops pattern advance
- One dot advance
- Two dots advance
- Three dots advance
- Four dots advance
- Five dots advance

SPEED ADJUSTMENT KNOB: To incorporate variable speed intervals into operation.

ATTENTION: The speed adjustment knob serves a different function based on the desired rotary switch setting.

1. **Continuous** - When the Rotary Switch is in this mode the Speed Adjustment Knob controls the advancement speed
2. **1- 5 Dot Pattern** - When in these modes the speed adjustment knob controls placement of the dot on the pad(s). This feature reduces the need to adjust the position of the fiber optic sensor. During advancement, the speed of liner remains constant at the unit's fastest speed.

PHOTO EYE: To advance another dot after each application. (Photo eye 1 senses items being applied to dot while Photo Eye 2 senses registered liner.) Note: Registered liner required.



LOADING INSTRUCTIONS

LOADING OPTION #1

To apply a single Glue Dot pattern to an item. *Examples Include: Credit/Gift Cards, Jewel Cases, Small Cartons.*

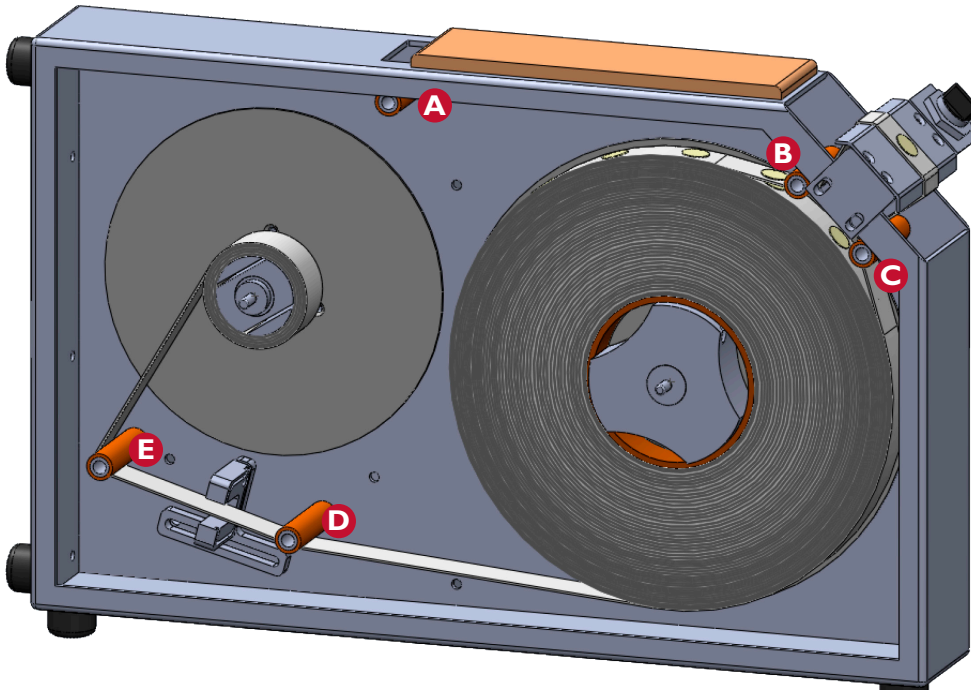
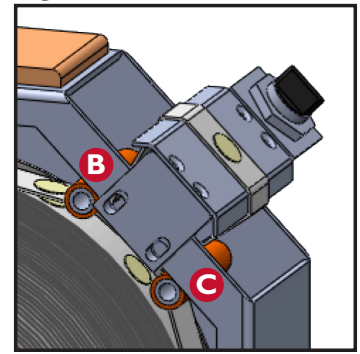


Figure 1



1. Turn unit on. Turn down Speed Adjustment Knob.
2. Remove wing nuts and corresponding cover plates on Spindles 1 & 2.
3. Place Supply Roll onto Spindle with liner releasing from left to right.
4. Thread liner under roller **B** through front feed slot, pull over Nose Plate; feed over roller **C** (See Figure 1). Feed liner over top of rollers **B** and **C** if using High or Super High Tack Glue Dots®.
5. Continue to pull liner down and around roll.
6. Feed liner under roller **D** and behind roller **E** ensuring that edge of liner between rollers **D** & **E** is being sensed by photo eye.
7. Pull enough liner to weave between notches on Spindle 1.
8. Turn up Speed Adjustment Knob momentarily, allowing liner on spindle 1 to become taut.
9. Turn down Speed Adjustment Knob and ensure liner between Rollers **D** and **E** is recognized by the Registration Photo-eye.
10. Replace cover plates and tighten wing nuts.



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LOADING INSTRUCTIONS

LOADING OPTION #2

To accommodate two person operation (i.e. one person presses item to pattern & second person peels item off liner). *Examples Include: Business Cards.*

Also used to apply several dots or a custom pattern, such as Glue Lines®.
Examples Include: Magazine Sample Inserts.

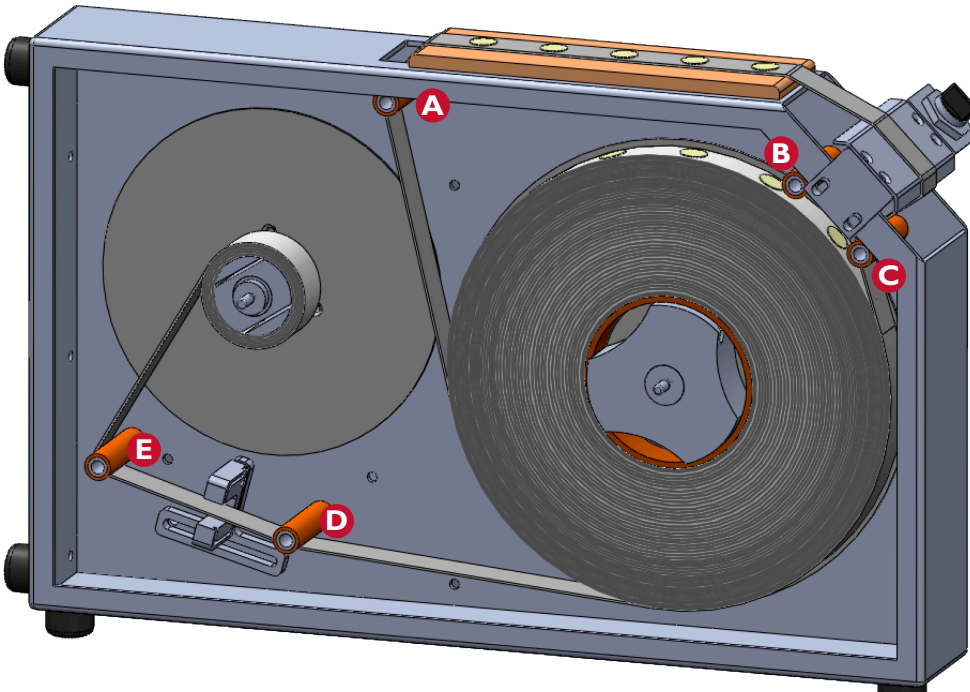
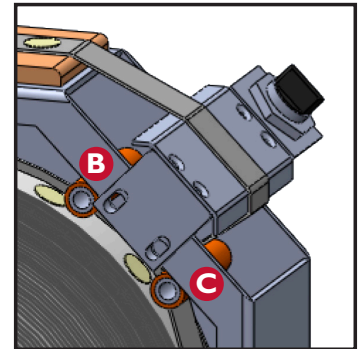


Figure 1



1. Turn unit on. Turn down Speed Adjustment Knob.
2. Remove wing nuts and corresponding cover plates on Spindles 1 & 2.
3. Place Supply Roll onto Spindle with liner releasing from left to right.
4. Thread liner behind roller **A**, pull through rear feed slot and bring forward over Nose Plate; feed liner over roller **C** (feed liner under roller **C** for High or Super High Tack Glue Dots®).
5. Continue to pull liner down and around roll.
6. Feed liner under roller **D** and behind roller **E** ensuring that edge of liner between rollers **D** & **E** is being sensed by photo eye.
7. Pull enough liner to weave between notches on Spindle 1.
8. Turn up Speed Adjustment Knob momentarily, allowing liner on spindle 1 to become taut.
9. Turn down Speed Adjustment Knob and ensure liner between Rollers **D** and **E** is recognized by the Registration Photo-eye.
10. Replace cover plates and tighten wing nuts.



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OPERATION INSTRUCTIONS

The Auto Dot® Pro is designed for use as a bench top device. It may be used in either a horizontal or a vertical orientation. The Auto Dot® Pro uses a standard 120VAC 60 hertz at 5 Amps.

Only Glue Dots® Products on registered liner can be used with the Auto Dot® Pro. Regardless of the Glue Dot size or configuration selected, the general operation of the Auto Dot® Pro remains the same.

Threading the Unit

There are several ways to thread the Auto Dot® Pro:

- For items that require a single Glue Dot, the Auto Dot® Pro may be threaded to allow for a single dot to be exposed on the Nose Plate. (Refer to Loading Instructions Option 1). In the event you are using High Tack or Super High Tack Glue Dots, thread the liner over (not behind) roller B, through the front feed slot. Pull the liner over the nose plate and feed the liner over (not behind) roller C.
- For items that required the application of multiple dots the Auto Dot® Pro may be threaded so that several dots are exposed. (Refer to Loading Instructions Option 2)
- For two-person operations or when applying custom patterns like Glue Lines. (Refer to Loading Instructions Option 2)

How the Auto Dot® Pro Operates

Regardless of how the unit is threaded, the operation of the Auto Dot® Pro remains the same.

- A) The exterior photo-eye located near the Nose Plate detects an object in front of it and signals the controller.
- B) When the controller detects that the object is no longer within sight of the photo eye, it will delay momentarily... then advance the next Glue Dot.
- C) When the controller begins advancing the liner to the next Glue Dot it will look for a signal from the interior (registration) photo-eye. (This photo-eye is located below Spindle 1.)
- D) The photo-eye sensing unit detects the registration mark is in place and signals the controller. The controller then stops the liner with a new Glue Dot in position. (Should the photo-eye sensing unit not detect a registration mark within a few seconds, the controller will automatically stop the liner from advancing. Refer to Troubleshooting section below)

Understanding the Standard Exterior Photo Eye

The standard exterior photo-eye supplied with the Auto Dot® Pro is a right angle (periscoping) photo-eye designed to sense objects within approximately a 3/8" to 4-1/2" range. When installed properly, the right angle photo-eye should be 'looking' slightly over the top of the Nose Plate.

Shiny objects require less sensitivity than dull objects. If your Auto Dot® Pro is prematurely advancing due to movement nearby, the sensitivity should be reduced. The sensitivity of the photo-eye can be adjusted by turning the small blue screw on the side of photo-eye. (Jewelers screwdriver required.)

Note: There is also photo-eye sensing unit located on the opposite side of the unit from the rewind reel. Adjustment of this sensing unit may be required in the event the liner/Glue Dot is not advancing as desired. This is described in the Troubleshooting section below.



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TROUBLESHOOTING

Proper dot application is not possible as the shape/size of the object causes it to interfere with the periscoping photo-eye device:

An optional axial photo-eye can be used for objects interfering with the periscoping photo-eye. This photo-eye is designed to sense objects approximately 3/8" to 4-1/2" directly in front of the sensor. This photo-eye is flush with the nose plate.

- Contact your Glue Dots Distributor for additional information.

Liner Tearing in Interior of Unit:

- Make sure the spindle cover plates are on the spindles.
- Check to ensure that liner is threaded correctly (see Loading Instructions).
- Ensure a Glue Dot has not transferred to the nose plate/nose roller.
- In the event you are using High Tack or Super High Tack Glue Dots, thread the liner over (not behind) roller B, through the front feed slot. Pull the liner over the nose plate and feed the liner over (not behind) roller C. See illustration on Loading Instructions for location of rollers C and C.

Advancing liner moves more than one Glue Dot at a time; Glue Dot is not advanced to the correct position or Auto Dot® Pro is not properly detecting the object:

- Check to ensure a Glue Dot or other debris has not obstructed the photo-eye. Check both the top and bottom of the photo-eye bracket.
- Check to ensure the liner is threaded correctly such that the liner is moving through the approximate center of the eye bracket. When the Auto Dot® Pro is working correctly a green light should be clearly visible on the liner indicating where the photo-eye is sensing (or seeing) the liner.
- Shiny objects require less sensitivity than dull objects. If your Auto Dot® Pro is prematurely advancing due to movement nearby, the sensitivity should be reduced. Adjust the sensitivity of the exterior photo-eye by turning the small blue screw on the side of photo-eye. (Jewelers screwdriver required).
- Check to ensure the liner has not tracked off to one side or the other such that the photo-eye is not 'seeing' the registration lines. (On some rolls of liner there may be a continuous stripe down one edge of the liner. This is normal and should not effect the operation of the Auto Dot® Pro. However it is important that the photo-eye is seeing this line.)
- In rare cases the photo-eye sensitivity may need to be adjusted. The sensitivity adjustment is under the cover on the photo-eye sensing unit that is located on the opposite side of the unit from the rewind reel. There are two switches and an adjusting screw on the top of the unit. The switch nearest the LEDs should be in the DO (Dark Operate) position. The switch marked delay should be in the 0 ms position. (Please note when the switch is in the 0 ms position it appears to be in the middle position. This is normal. Do not try to force the switch further.)

In normal operation of the sensor the green power on light should remain steadily lit at all times. The yellow signal strength LED blinks at a rate that is proportional to the strength of the signal from the registration sensor. When the liner is stopped away from the registration line, the yellow LED should blink several times per second. When stopped on the line the yellow LED should go out completely.

Turning the adjusting screw clockwise will increase the sensitivity of the eye. Turning counterclockwise will decrease the sensitivity. If the yellow LED is off while the liner is stopped between the lines, increase the sensitivity until the yellow LED begins to blink. Note the position of the sensitivity indicator (next to the adjustment screw). Move the liner by hand such that the registration line is in front of the eye. The yellow LED should go out. Continue to increase the sensitivity by turning the adjustment clockwise until the yellow LED begins to blink. Note the position of the sensitivity indicator again. Adjust the sensitivity counter clockwise until the sensitivity indicator is approximately half way between the noted positions.



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LIMITED WARRANTY

Auto Dot® Pro Limited Warranty

Limited Warranty: Glue Dots® International LLC ("GDI") warrants the Auto Dot® Pro product (the "Product"), when shipped in its original container and used in accordance with the Product specifications and documentation, will be free from material defects in material and workmanship for a period of 90 days from the date of purchase by the original customer. GDI agrees that within this time period, it will, at its option and sole discretion, either repair the defect or replace the defective Product or part thereof with a new or remanufactured equivalent at no charge to the purchaser for parts or labor.

Warranty Exclusion: This warranty does not apply in cases of damage in transit, negligence, abuse, mishandling, failure to follow GDI's instructions, improper installation, unauthorized repair, modification or maintenance. This warranty does not apply to defects or variations in the appearance of the Product or portion thereof or to any Product the exterior of which has been damaged or defaced, which has been subjected to improper voltage or other misuse, abnormal service or handling, or which has been altered or modified in design or construction.

Remedy: GDI's sole and exclusive obligation under this warranty (and Purchaser' sole and exclusive remedy) shall be, upon prompt written notice by Purchaser during the Warranty period of any warranty breach, to either, at GDI's option, repair or replace without charge, F.O.B. Authorized Distributor/End User Location, any defective Product or part thereof expressly warranted herein by GDI against defects and found by GDI to be defective and covered by this warranty, or credit Purchaser for the purchase price paid for such Product. GDI shall not be liable to Purchaser, or to anyone claiming under Purchaser, for any other obligations or liabilities including, but not limited to, obligations or liabilities arising out of breach of contract or warranty, negligence or other tort or any theory of strict liability, with respect to the Products or GDI's acts or omissions or otherwise. This warranty covers only replacement or repair of defective Product or parts thereof at GDI's main facility.

Notice of any warranty claim or request for warranty service should be sent to:

Glue Dots® International LLC
5515 South Westridge Drive
New Berlin, WI 53151

Limitation on Damages: IN NO EVENT SHALL GDI BE LIABLE FOR INCIDENTAL, COMPENSATORY, PUNITIVE, CONSEQUENTIAL, INDIRECT, SPECIAL OR OTHER DAMAGES. GDI'S AGGREGATE LIABILITY WITH RESPECT TO A DEFECTIVE PRODUCT SHALL BE LIMITED TO MONIES PAID TO GDI FOR THAT DEFECTIVE PRODUCT. GDI WILL NOT REIMBURSE PURCHASER FOR ANY EXPENSES INCURRED BY PURCHASER IN REPAIRING, CORRECTING OR REPLACING ANY DEFECTIVE PRODUCTS, EXCEPT FOR THOSE INCURRED WITH GDI PRIOR WRITTEN PERMISSION. ANY ASSISTANCE GDI PROVIDES OR PROCURES FOR PURCHASER OUTSIDE THE TERMS, LIMITATIONS OR EXCLUSIONS OF THIS WARRANTY WILL NOT CONSTITUTE A WAIVER OF TERMS, LIMITATIONS OR EXCLUSIONS OF THIS LIMITED WARRANTY, NOR WILL SUCH ASSISTANCE EXTEND OR REVIVE THE WARRANTY.

Disclaimer of Other Warranties: GDI AND PURCHASER AGREE THAT, TO THE EXTENT PERMITTED BY LAW, THE EXPRESS WARRANTIES ABOVE ARE EXCLUSIVE AND IN LIEU OF ALL OTHER WARRANTIES. GDI HEREBY DISCLAIMS AND EXCLUDES ALL OTHER WARRANTIES (INCLUDING WITHOUT LIMITATION ANY IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE). ANY ORAL OR WRITTEN DESCRIPTION OF THE PRODUCT IS FOR THE SOLE PURPOSE OF IDENTIFYING THE PRODUCT AND SHALL NOT BE CONSTRUED AS AN EXPRESS WARRANTY. PRIOR TO USING OR PERMITTING THE USE OF THE PRODUCT, PURCHASER SHALL DETERMINE THE SUITABILITY AND FITNESS OF THE PRODUCT FOR THE INTENDED USE AND PURCHASER SHALL ASSUME ALL RISK AND LIABILITY WHATSOEVER IN CONNECTION THEREWITH. PURCHASER AGREES THAT GDI HAS NO POST-SALE DUTY TO WARN PURCHASER OR ANY OTHER PARTY ABOUT ANY MATTER.

Miscellaneous: This Warranty shall not create a joint venture, partnership or principal and agent relationship between the parties. This Warranty may not be modified, amended or supplemented except by mutual written agreement by GDI. Either party may waive in writing any term or condition contained in this Warranty and intended to be for its benefit; provided, however, that no waiver by a party, whether by conduct or otherwise, in any one or more instances, shall be deemed or construed as a further or continuing waiver of any such term or condition. This Warranty represents the entire agreement of the parties with respect to the subject matter hereof and no provision or document of any kind shall be included in or form a part of this Warranty except by mutual, written consent of GDI. The provisions contained in this Warranty are severable. If any provision of this Warranty is determined for any reason to be invalid, illegal or unenforceable, such determination shall not affect the validity, legality or enforceability of the remaining provisions, and the rights and obligations of the parties shall be construed and enforced as though this Warranty did not contain such invalid, illegal or unenforceable provision. This Warranty shall be governed by and construed in accordance with the internal laws of the State of Wisconsin without reference to any rule or provision thereof which would cause the application of the law of any other jurisdiction. Purchaser agrees that any lawsuit, mediation, arbitration or other legal action taken against GDI to enforce this Warranty must be brought in a competent court located in Wisconsin.



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