



INSTRUCTIONS

FOR HL-8

Proportional Hopper Loader



PPE Hopper Loaders are manufactured and sold direct by Plastic Process Equipment, Inc. We are not associated with any other manufacturer. Always specify genuine PPE Hopper Loaders! Do not accept substitutes.

MODEL NO.

HL-8

SERIAL NO.

Made in the U.S.A. by Plastic Process Equipment, Inc. © copyright 2019



PLASTIC PROCESS EQUIPMENT, INC.

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www.ppe.com • e-mail: sales@ppe.com

Toll Free: USA, Canada & Mexico
800-362-0706

RECEIVING

Please thoroughly inspect your HL-8 Proportional Hopper Loader and report any damage to the motor freight carrier before uncrating for setup. They are responsible for any damage incurred during transit. Make note of model and serial numbers. These numbers must be used when ordering parts or accessories from PPE.

INTRODUCTION

The PPE model HL-8 Proportional Hopper Loader is a self-contained vacuum conveying system. It is designed to keep your material feed hopper full during operation. The unit will cycle loading and dumping material into the hopper until the hopper is full. It will then wait until the material level drops below the dump valve, at which point it will cycle again until the hopper is full. The load time can be varied to provide optimum performance in virtually all conditions, load time can be divided between the two (2) inlets from 0 to 100%. The HL-8 contains a diaphragm filter and blow-off system. This filter remains clean from the blow-off system, but should be checked every 8 hours of use. Do not use with powders.

ELECTRICAL

The HL-8 Hopper Loader comes wired for 120/60/1 power. Always use a **grounded** 120 volt outlet. If you must use an extension cord, ensure that the extension cord's rating is of the proper size. Failure to do so could cause a low voltage condition and premature failure of the motor. The HL-8 Hopper Loader is equipped with a circuit breaker instead of a replaceable fuse. The reset button is located on the side of the electrical enclosure. **NO FUSE TO LOSE!**

INSTALLATION

The HL-8 Hopper Loader must be mounted on a flat horizontal surface. It is usually fastened to the cover of the material feed hopper. **Precautions must be taken to prohibit the fasteners from loosening and falling into the feed throat (i.e.: nylok nuts, lok-tite, etc.).** It requires a 11-1/4" dia. hole in your hopper lid. The unit must be mounted so that the discharge counterweight valve swings without hitting anything. The counterweight has been adjusted at the factory and should not require any readjustments. The feed probes are secured to the feed hoses with the supplied hose clamps. The other end of the hoses are connected to the inlet tubes located on the loader unit. When the HL-8 Hopper Loader is in operation the feed hoses should not have any sags or goosenecks, like the trap under a sink. If the hoses sags, when the unit shuts off the material in the hoses will fall to the bottom of the sag and can plug the feed hoses and restrict suction. When inserting the feed probes into your material gaylords, do not jam the probes in! Insert the probes gently until they are about 1/4 to 1/3 submersed. When the unit is turned on, the probes will pull themselves toward the bottom of the gaylords.

SETTING THE UNIT

After the unit has been installed and grounded, plug in the power cord and move the "CONVEY" potentiometer clockwise to the max time position. Move the Regrind knob counterclockwise to the max position. Next move the power switch to the "ON" position. The lights should flash and the unit should begin to cycle.

For optimum performance the unit should run just long enough to fill itself. A full unit is indicated by a higher pitched motor sound. Run several cycles and decrease the "CONVEY" time slightly each cycle until the motor shuts off at approximately the same time it is full. If the unit is allowed to run after it is full, performance will decrease. The "CONVEY" time can be adjusted from 10 to 70 seconds (Note: these are approximate times and may vary by a few seconds). In general, longer load times will be needed for: longer distances, heavier materials, and increased amounts of regrind.

Once the "CONVEY" time has been set you can adjust the Regrind percentage knob to split the amount of run time between the two inlets in order to get the percentage of regrind you want in each cycle.

Your PPE HL-8 Hopper Loader was designed to operate on the **ON DEMAND** principal. The "MOTOR" light indicates that the unit is in its loading cycle and should be conveying material up to the loader. When your machine material hopper is full the unit will sense this because the loader dump valve will remain held open by the presence of your material. As long as the dump valve remains open the unit will not cycle. As the machine hopper material level lowers, the dump valve will freely swing closed and the loader will begin to cycle again.

MAINTENANCE

The HL-8 Hopper Loader is a filtered unit. There is a diaphragm type filter located between the top and bottom halves of the loader housing. This filter should be checked often. The automatic air blow-off system should keep the filter clean, but checking is required to make sure there are no tears or holes. Extra filters are available from PPE. A dirty filter greatly reduces material flow and may cause the vacuum motor to strain and/or fail.

When the "CHANGE BRUSHES" light comes on the motor brushes should be inspected and/or replaced. This light comes on every 300 hours of use and can be reset by pushing the brushes reset button. **WARNING:** The brushes should be changed BEFORE the brush stunt touches the commutator. On reassembly and handling, the lead wires must be kept away from rotating parts and motor frame.

To achieve best performance, the new brushes should be seated on the commutator before full rated voltage is applied. After brush change, apply 50% to 75% of rated voltage for thirty minutes to accomplish this seating. The motor will return to full performance after thirty to forty-five minutes of running at full rated voltage. The motor must not be run with the vacuum air inlet sealed off. **DIRECT APPLICATION OF FULL RATED VOLTAGE AFTER CHANGING BRUSHES WILL CAUSE ARCING, COMMUTATOR PITTING, AND REDUCED OVERALL LIFE.** If reduced voltage is unavailable, connecting two motors of similar rating in series for thirty minutes will accomplish the brush seating.

WARRANTY

All PPE machinery is warranted to be free of defective material and workmanship for a minimum period of 1 YEAR from date of sale. Some machinery components may carry longer warranties per our suppliers policies which are passed on to our customers (i.e. our drier compressors, conveyor motors, etc.).



WARNING
STATIC SHOCK HAZARD



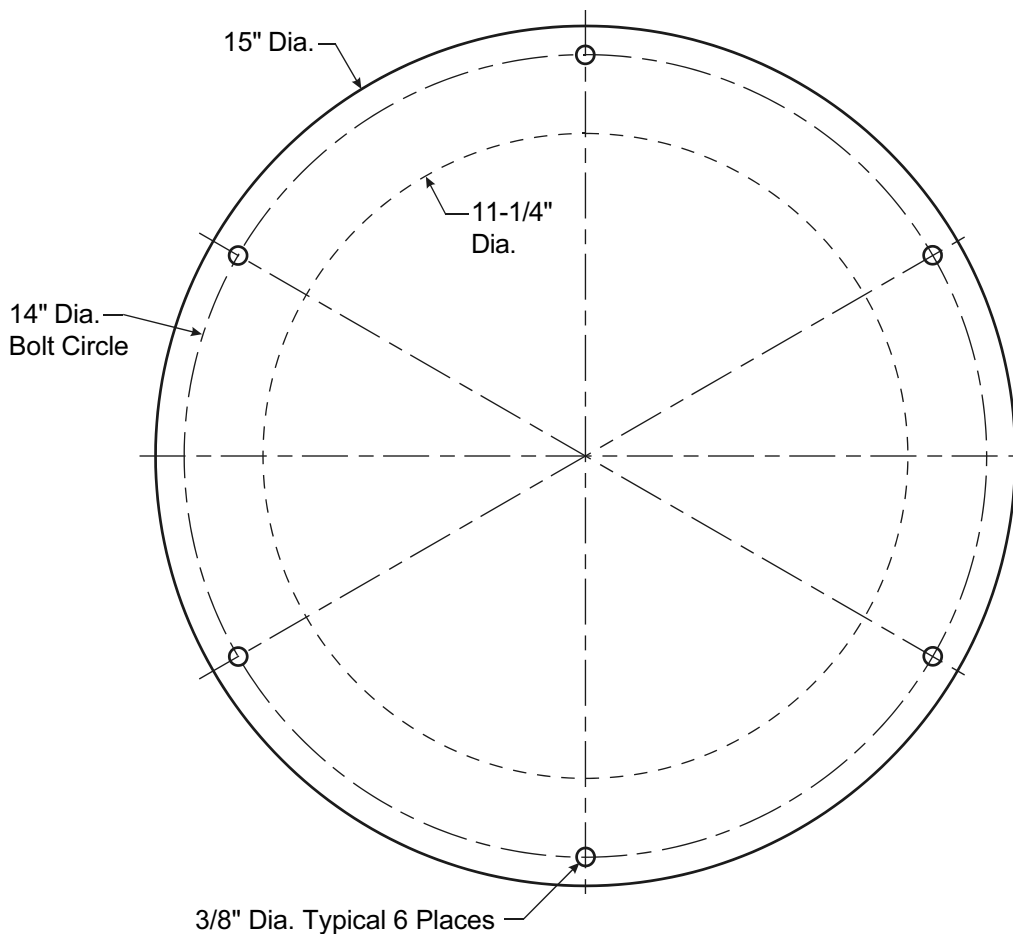
All PPE Vacuum Hopper Loaders are supplied with a vacuum hose that contains a ground wire to help control static electricity for user safety. We also recommend you install an extra static ground wire on your HL Series Vacuum Hopper Loader unit. The ground wire should be run **INSIDE** your feed tube and connect the metal probe to the hopper loader frame. This will help to dissipate the static charge generated by some plastics as they are conveyed up the tube. You can use a standard 18 gauge electrical wire, strip the ends about 1-1/2" and pinch them between the plastic feed hose and the metal tubes that it mounts over, then clamp it securely with the supplied hose clamps. Do not use plastic suction probes!



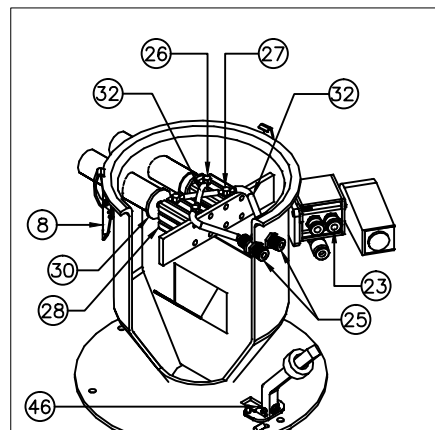
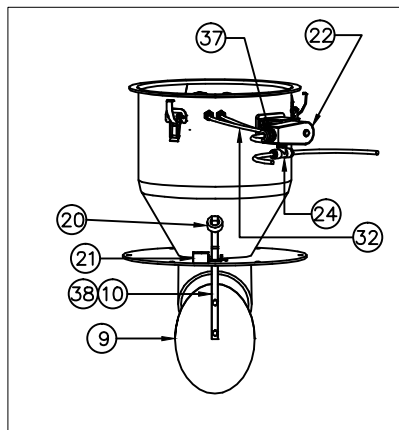
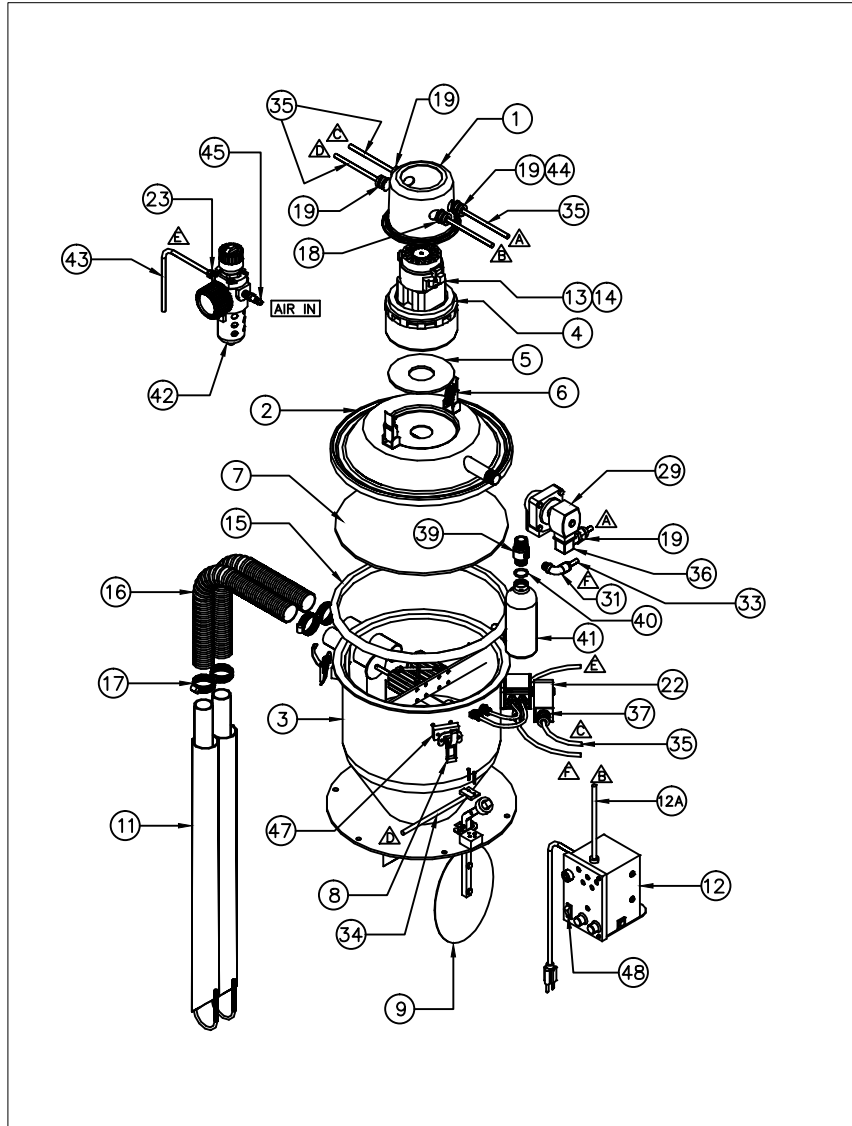
STATIC SHOCK HAZARD
WARNING



BASE MOUNTING DIMENSIONS



HL-8 HOPPER LOADER PARTS



PLASTIC PROCESS EQUIPMENT, INC.

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HL-8 HOPPER LOADER

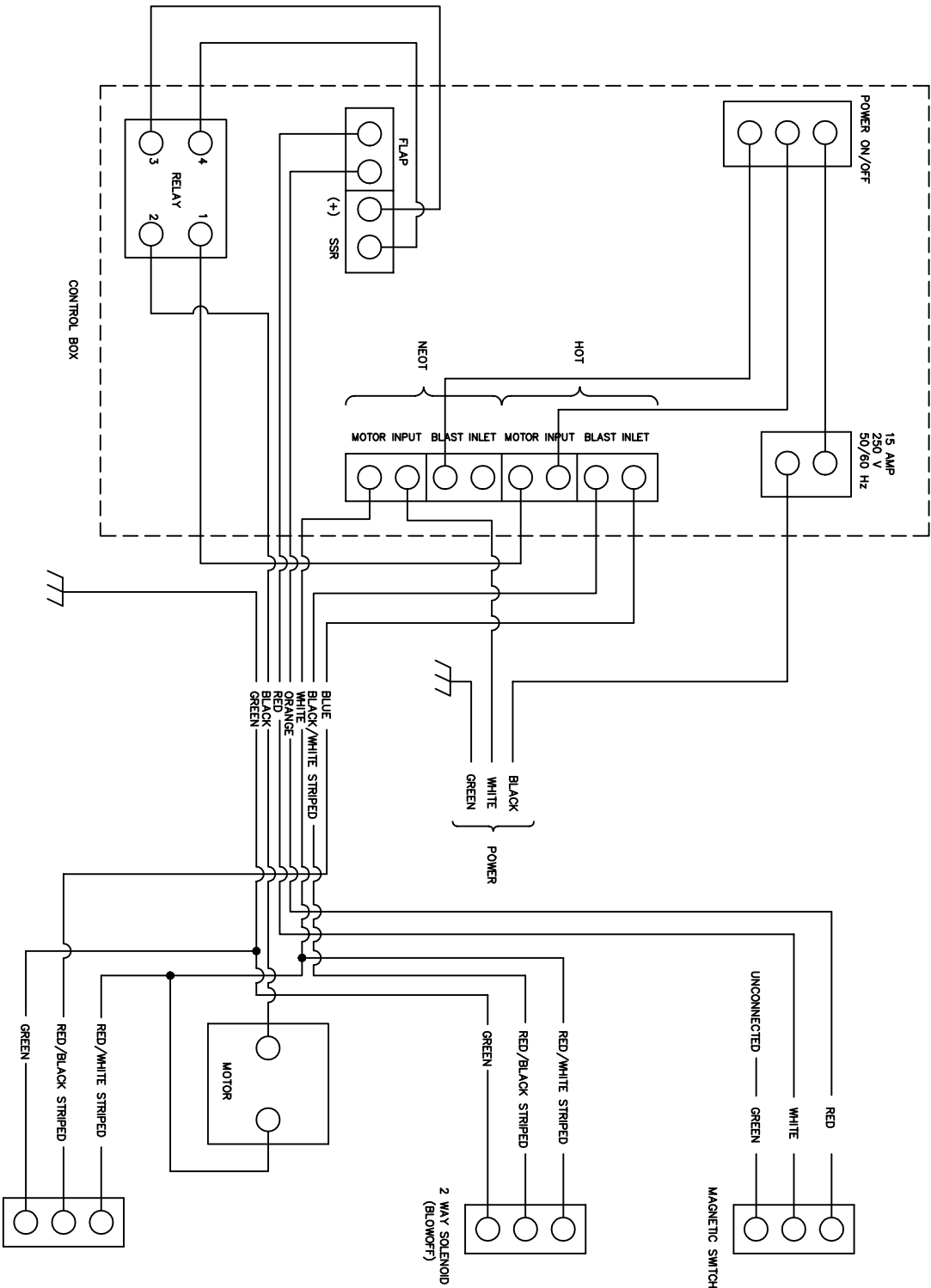
06/24/24

PARTS LIST

06/24/24

ID	QTY	P/N	DESCRIPTION	UOM	
1	1	A-10060	HOPPER LOADER MOTOR COVER	EA	
2	1	A-10076	HOPPER LOADER LID	EA	
3	1	C-10074	PROPORTIONAL HOPPER LOADER HOUSING HL-8	EA	
4	1.5 ft	8694K14	FOAM MOTOR GASKET MATERIAL PER FT (was 8694K86)	FT	
5	1	ZX2056	ROUND MOTOR GASKET FOR HOPPER LOADER	EA	
6	2	91-99-218	MOTOR COVER CLAMP FOR HOPPER LOADER	EA	
7	1	FR2SS	STAINLESS FILTER RING 14" A-10088	EA	
8	3	V2-0068-07	HOUSING CLAMP FOR HL-7 HL-8 HL-9	EA	
9	1	A-10046	HOPPER LOADER FOOT VALVE	EA	
10	1	B-10044	HOPPER LOADER FOOT VALVE ARM	EA	
11	2	TALP36	36"S.S.PROBE 1.5"OD INLET FOR TAL	EA	
12	1	CBHL8	MICROPROCESSOR CONTROLLER FOR HL w/15FT CORD	EA	
12A	1	HL-RC1507	SPARE 15FT CONTROL CABLE FOR HL W/SINGLE FITTING(207000A0	EA	
	1	HL-5PCB	PC BOARD FOR HL-5/8	EA	
13	1	2M433	MOTOR 10.8 AMP	EA	
14	2	2UV66	BRUSHES FOR 10.8 AMP MOTOR	EA	
15	1	ZX2059	FILTER GASKET 14" DIA	EA	
16	15 ft (2)	VHG11260	GROUNDED VACUUM HOSE 1-1/2" DIA 60FT (PER FOOT)	EA	
17	4	HSS-28	HOSE CLAMPS	EA	
18	1	2R7006A20A120	PANEL MOUNT CONNECTOR FOR CONTROL CABLE	EA	
19	5	S2112	STRAIN RELIEF FOR ELECTRIC CORD	EA	
20	1	A-10163	WEIGHT FOR HOPPER LOADER DUMP VALVE	EA	
21	1	A-7418	SWITCH MOUNTING BLOCK FOR HOPPER LOADER	EA	
22	1	JSP8340G1-120	4 WAY SOLENOID VALVE FOR PROPORTIONAL LOADER	EA	
23	3	KQ2H07-35AS	MALE CONNECTOR	EA	
24	1	KQ2T07-35AS	BRANCH TEE	EA	
25	2	KQ2E07-00A	BULKHEAD UNION 1/4" X 9/16-18UNF	EA	
26	2	TOPM5LB4	90 DEGREE STEM END FOR 6MM TUBING	EA	
27	2	TOPM5T4	DOUBLE STEM END FOR 6MM TUBING	EA	
28	2	NCQ2A20-50D	CYLINDER 20mm X 50mm DOUBLE ACTING	EA	
29	1	FP20	TURBO BLOWOFF SOLENOID W/DIN CONNECTOR	EA	
30	2	A-10069	PROPORTIONAL LOADER INLET DISK	EA	
31	1	KQ2L07-35AS	MALE ELBOW	EA	
32		TISA07B-20	1/4" NYLON TUBING 22FT	EA	
33		TISA07B-20	1/4" NYLON TUBING 22FT	EA	
34	1	PRX8300P	MAG SWITCH WITH 6" LEADS AND PLUG	EA	
35	1	703000D02F060	SMALL CABLE FOR BLOWOFF HL	EA	
36	1	88122601	DIN CONNECTOR FOR SOLENOID	EA	
37	1	7R3006A19A120	SOCKET FOR PROPORTIONAL SOLENOID	EA	
38	1	MASL02501000	MAGNET FOR HL-1 SWITCH	EA	
39	1	A-10073	TANK ADAPTOR FOR HOPPER LOADER	EA	
40	1	BNR210	3/4 X 1/8 O-RING	EA	
41	1	F0698AFGR	AIR TANK FOR HOPPER LOADER	EA	
42	1	AMC403D	AIR REGULATOR	EA	
43	1	TISA07B-20	1/4" NYLON TUBING 22FT	EA	
44	4	BL-50	1/2" TIGER GRIPS	EA	
45	1	H2CH	1/4" NPT MALE THREAD HOSE NIPPLE	EA	
46	1	ZF10172N	FOOT VALVE MOUNTING BRACKET HOPPER LOADERS	EA	
47	3	A-11812	HOPPER LOADER SPACER BLOCK	EA	
48	1	1500R11E	ROCKER ON/OFF SWITCH	EA	

DATE	SYM	REVISION RECORD	AUTH	DR	CK
10/05	A	REMOVED RED & WHITE ON MAG SWITCH SHOWED GREEN UNCONNECTED ON MAG SWITCH	JS	DE	



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DECIMAL	± .005	SCALE	DRAWN BY DE
FRACTIONAL	± 1/16	TITLE	HL-5 WIRING DIAGRAM
ANGULAR	± 1/2°	DATE	DRAWING NUMBER
		10/26/05	A-9630