



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 except Budget Molder's Supply, Inc. Always specify genuine PPE or Budget Hopper Loaders! Do not accept substitutes.

MODEL NO.

HL-8

SERIAL NO.

Made in the U.S.A. by Plastic Process Equipment, Inc. © copyright 2006



PLASTIC PROCESS EQUIPMENT, INC.

www.ppe.com • e-mail: sales@ppe.com

PPE WEST

6385 Montessouri Street, Las Vegas, Nevada 89113
702-433-6385 • 800-258-8877 • Fax: 702-433-6388

PPE SOUTH

11218 Challenger Avenue, Odessa, Florida 33556
727-834-8888 • 800-282-6783 • Fax: 727-834-8873

8303 CORPORATE PARK DRIVE, MACEDONIA (Cleveland), OHIO 44056, USA

216-367-7000 • Toll Free: 800-321-0562 • Fax: 216-367-7022 • Order Fax: 800-223-8305

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 LOOSE!**

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.).** 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 Re grind 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 re grind.

Once the "CONVEY" time has been set you can adjust the Re grind percentage knob to split the amount of run time between the two inlets in order to get the percentage of re grind 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 daily. 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.

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.

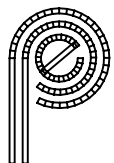
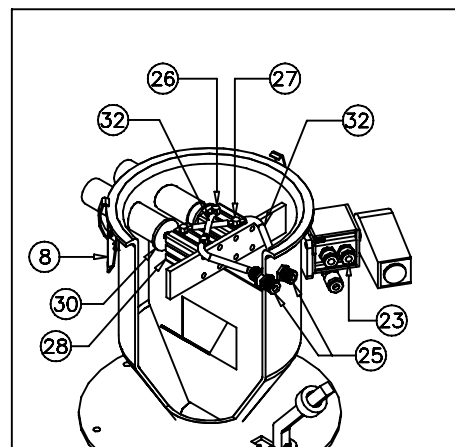
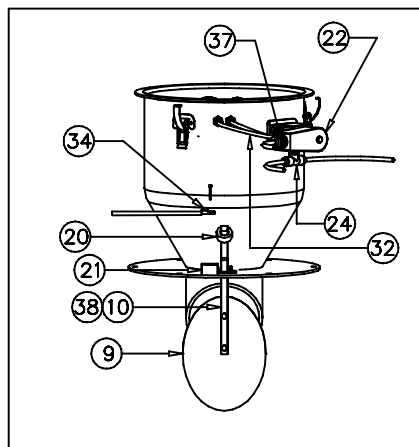
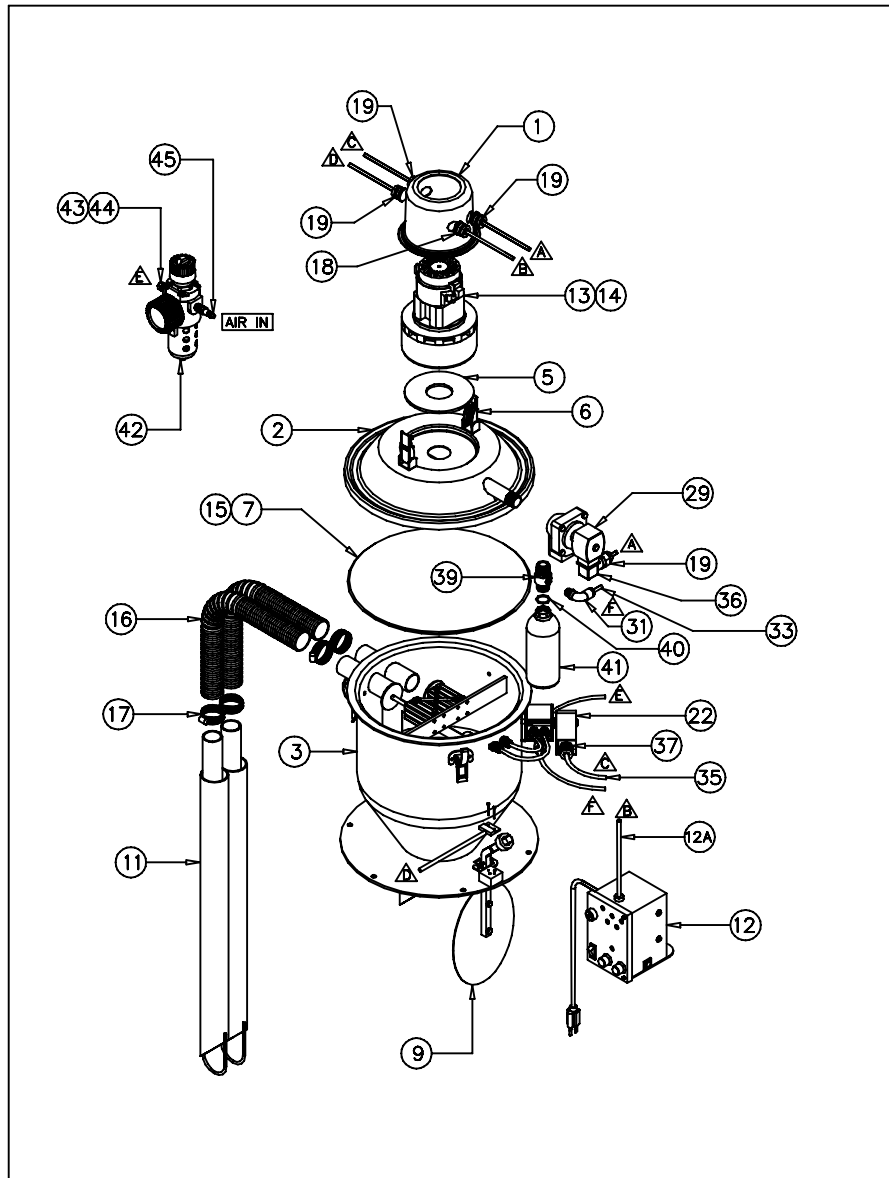
To achieve best performance, the new brushes should be seated on the commutator before full rated voltage is applied. After brush change, apply 50% to 75% of rated voltage for thirty minutes to accomplish this seating. The motor will return to full performance after thirty to forty-five minutes of running 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.).

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HL-8 HOPPER LOADER PARTS



PLASTIC PROCESS EQUIPMENT, INC.

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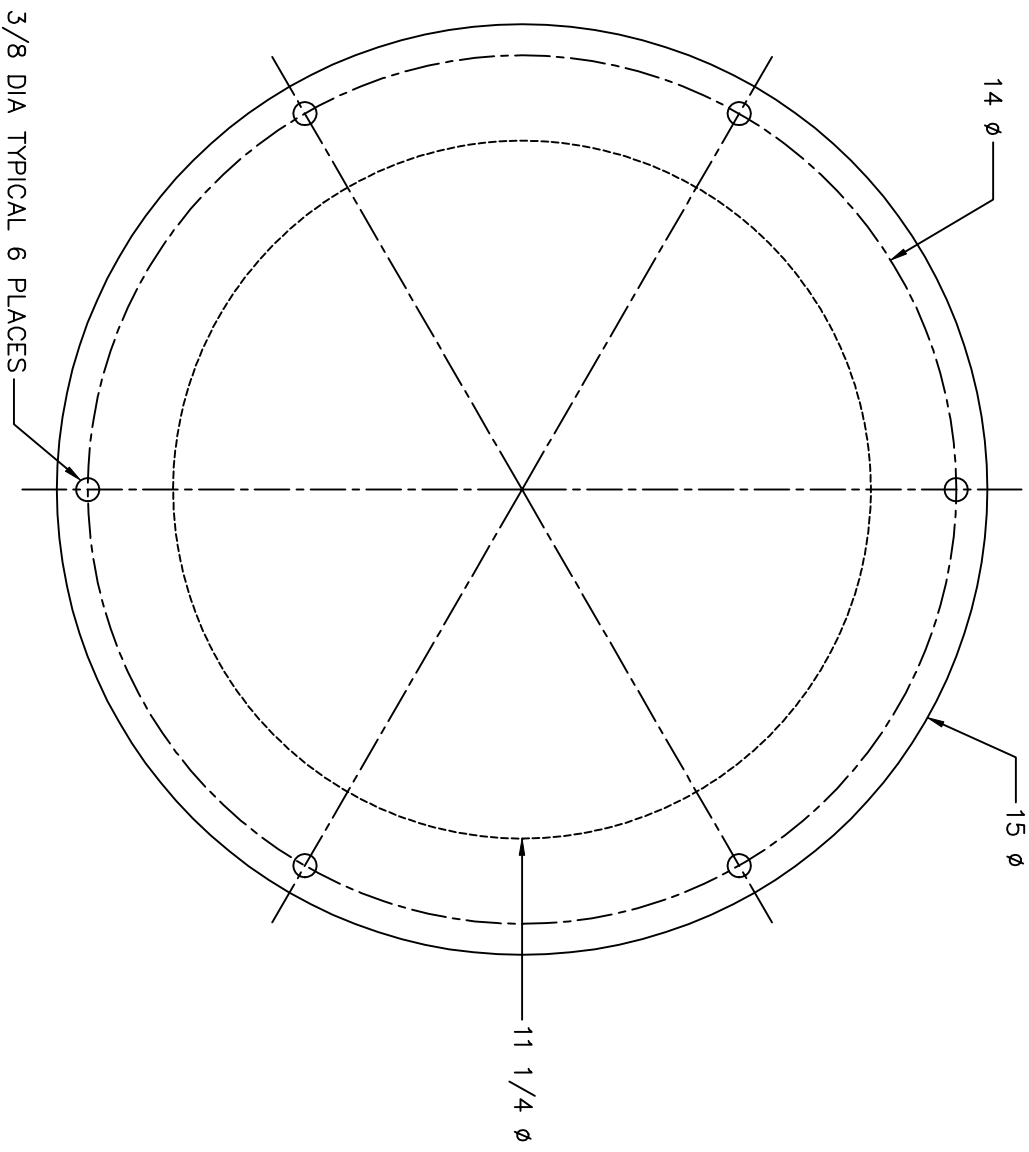
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PARTS LIST

09/16/15

ID	P/N	DESCRIPTION	UOM
1	A-10060	HOPPER LOADER MOTOR COVER	EA
2	A-10076	HOPPER LOADER LID	EA
3	C-10074	PROPORTIONAL HOPPER LOADER HOUSING HL-8	EA
5	ZX2056	ROUND MOTOR GASKET FOR HOPPER LOADER	EA
6	91-99-218	MOTOR COVER CLAMP FOR HOPPER LOADER	EA
7	FR2SS	STAINLESS FILTER RING 14" A-10088	EA
8	V2-0068-07	HOUSING CLAMP FOR HL-7 HL-8 HL-9	EA
9	A-10046	HOPPER LOADER FOOT VALVE	EA
10	B-10044	HOPPER LOADER FOOT VALVE ARM	EA
11	D7210	ANNODIZED PICK UP WAND 1-1/2" X 36"	EA
12	CBHL8	MICROPROCESSOR CONTROLLER FOR HL w/15FT CORD	EA
12A	207000A01F150	SPARE 15FT CONTROL CABLE FOR HL W/SINGLE FITTING	EA
	HL-5PCB	PC BOARD FOR HL-5/8	EA
13	2M433	MOTOR 10.8 AMP	EA
14	2UV66	BRUSHES FOR 10.8 AMP MOTOR	EA
15	ZX2059	FILTER GASKET 14" DIA	EA
16	VHG11215	GROUNDED VACUUM HOSE 1-1/2" DIA 15FT	EA
17	HSS-28	HOSE CLAMPS	EA
18	2R7006A20A120	PANEL MOUNT CONNECTOR FOR CONTROL CABLE	EA
19	SEC50BA	STRAIN RELIEF FOR ELECTRIC CORD	EA
20	A-10163	WEIGHT FOR HOPPER LOADER DUMP VALVE	EA
21	A-7418	SWITCH MOUNTING BLOCK FOR HOPPER LOADER	EA
22	JSP8340G1-120	4 WAY SOLENOID VALVE FOR PROPORTIONAL LOADER	EA
23	KQH06-02S	HALF UNION	EA
24	KQT07-02S	UNION TEE 1/4"	EA
25	KQ2E06-00	BULKHEAD UNION	EA
26	TOPM5LB4	90 DEGREE STEM END FOR 6MM TUBING	EA
27	TOPM5T4	DOUBLE STEM END FOR 6MM TUBING	EA
28	NCQ2A20-50D	CYLINDER 20mm X 50mm DOUBLE ACTING	EA
29	FP20	TURBO BLOWOFF SOLENOID	EA
30	A-10069	PROPORTIONAL LOADER INLET DISK	EA
31	KQL07-35S	MALE ELBOW	EA
32	TUP0604B	6mm OD TUBING	FT
33	TUP1065B	10mm OD TUBING	FT
34	PRX8300P	MAG SWITCH WITH 6" LEADS AND PLUG	EA
35	703000D02F060	SMALL CABLE FOR BLOWOFF HL	EA
36	88122601	DIN CONNECTOR FOR SOLENOID	EA
37	7R3006A19A120	SOCKET FOR PROPORTIONAL SOLENOID	EA
38	MASL02501000	MAGNET FOR HL-1 SWITCH	EA
39	A-10073	TANK ADAPTOR FOR HOPPER LOADER	EA
40	BNR116	3/4 X 3/32 O-RING	EA
41	F0698AFGR	AIR TANK FOR HOPPER LOADER	EA
42	AMC403D	AIR REGULATOR	EA
43	TUS07-W22	1/4" NYLON TUBING 22FT	EA
44	KQL07-35S	MALE ELBOW	EA
45	H2C	HOSE NIPPLE	EA
46	ZF10172N	FOOT VALVE MOUNTING BRACKET HOPPER LOADERS	EA

DATE	S/N	REVISION RECORD	AUTH	DR	CK



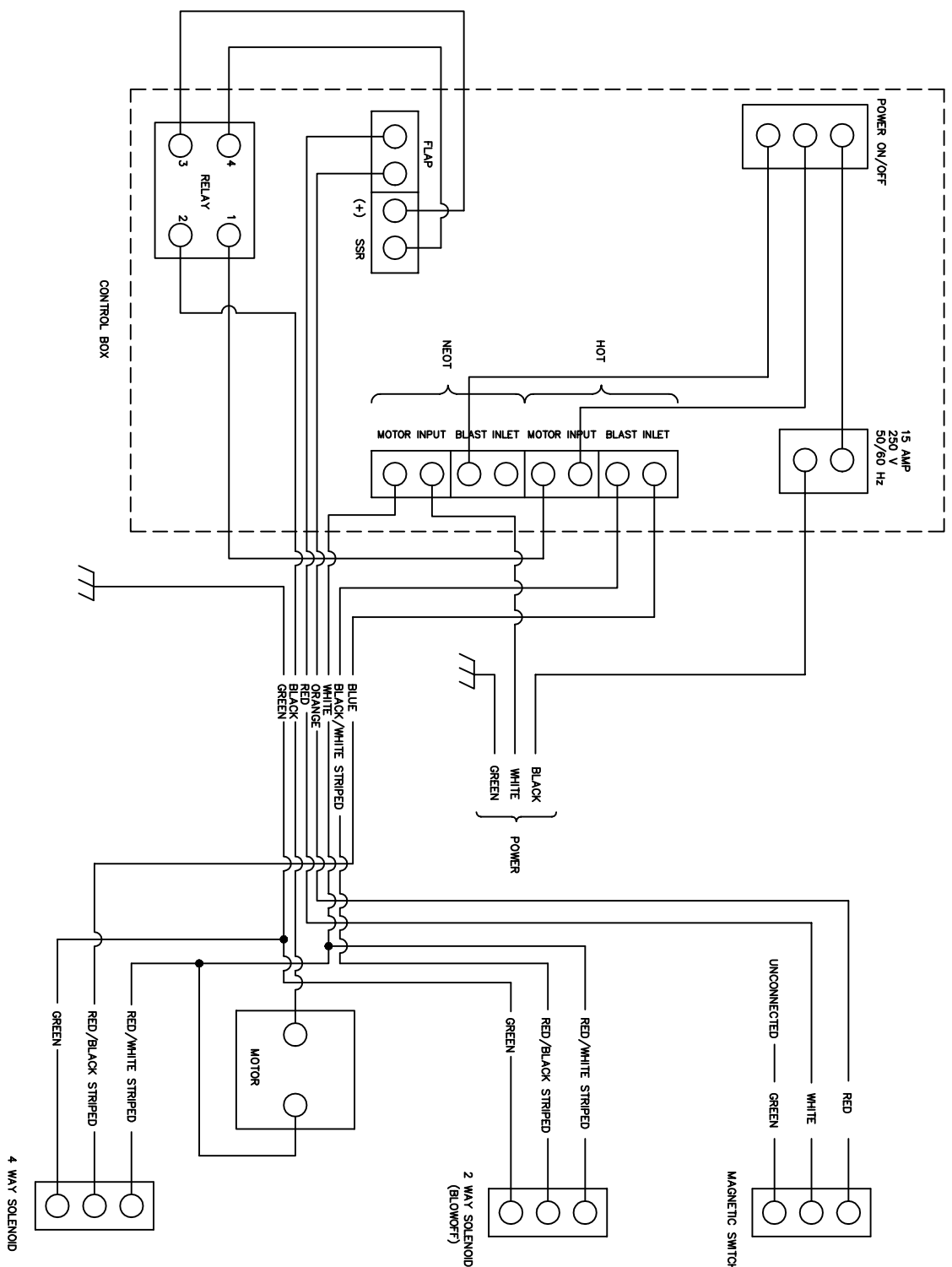
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DECIMAL	MACEDONIA, OH	
± .015	HLL=7, HLL=8, HLL=9	SCALE
FRACTIONAL	±1/16	DRAWN BY DE
ANGULAR	±1/2°	APPROVED BY
DATE	TITLE	DRAWING NUMBER
4/15/07	HOPPER LOADER MOUNTING TEMPLATE	A-10331

DATE	S/N	REVISION RECORD	AUTH	DR	CK
10/05	A	REMOVED RED & WHITE ON MAIN SWITCH SHOWN GREEN UNCONNECTED ON MAIN SWITCH	JS	DE	



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