INSTRUCTIONS
FOR
TAL-FX SERIES
VACUUM HOPPER LOADER

TAL-15UFX
MAGNETIC LEVEL SWITCH

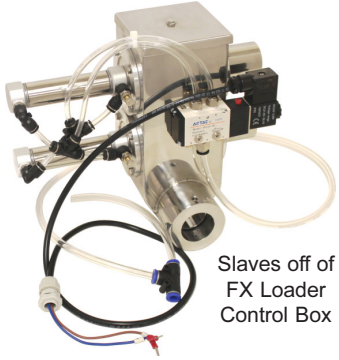
TAL-3U-EFXDS
SIGHT GLASS MODEL
WITH 2-WAY SENSING
& PROXIMITY SWITCH

Includes Wireless Remote Control

TAL-6UFX
MAGNETIC LEVEL SWITCH

TAL-12UFX
MAGNETIC LEVEL SWITCH

TPV-38-CFX
Proportional Dual Feed Valve
Available



Slaves off of
FX Loader
Control Box

Revised 3-26-24

Our PPE Vacuum Loaders are a PPE exclusive only available from PPE. Do not confuse these with any other make, model or manufacturer.

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TAL-FX Series Vacuum Loaders

KNOW YOUR WARNING SIGNS AND SYMBOLS!

This instruction manual and our products may use the following signal words Caution and/or Danger symbols to call attention to the degree or level of possible hazard seriousness. Pay attention to them!

1. **CAUTION:** A warning to indicate a potentially hazardous situation which, if ignored, may result in personal injury or threat of health. Also used to alert against unsafe practices which could cause property damage or accidents. See labels B & BB.

2. **WARNING:** Warns of a potentially hazardous situation which, if not avoided, could result in serious injury. Warning signs are a yellow triangle with a black border and black symbols. See Label A.

3. **DANGER:** Indicates an imminently hazardous situation which, if not avoided, may result in serious injury or death. This signal word is limited to the most extreme situations. Always follow the warnings or instructions that accompany the danger label, such as: High Voltage, Acid, Hot Surface, etc, etc, etc. See Labels C & CC.

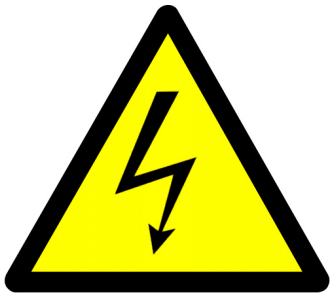
4. **SYMBOL/PICTORIAL:** Conveys a message without words. See labels A & B.

5. **SAFETY ALERT SYMBOL** (an exclamation point inside a triangle)**:** Is a general warning and indicates a potential personal injury hazard. Follow instructions and read labels and/or product information before you proceed! See Label A.

Label A

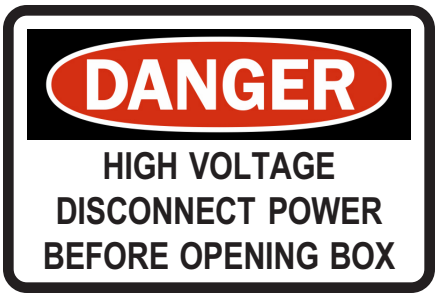
General Warning Sign

Label B



Hazard Warning Sign

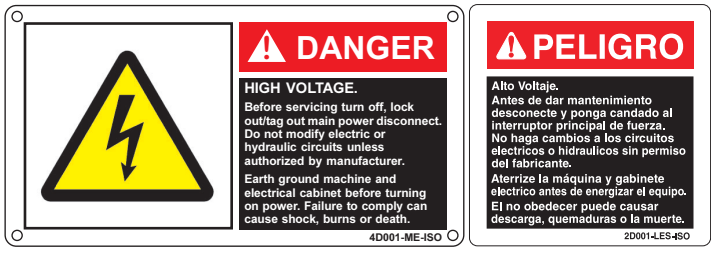
Label C



Danger Warning Sign

Label BB

Label CC



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TAL-FX Series Vacuum Loaders

INTRODUCTION AND GENERAL INFORMATION
TAL-15FX, TAL-3U-EFXDS, TAL-6UFX & TAL-12UFX

RECEIVING

Please thoroughly inspect your PPE TAL-FX Series Vacuum 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.

Before installation of this equipment the user must carefully read the Use and Operating Instructions to avoid damage to the machine and most important to avoid personal injuries. The TAL-FX Series Vacuum Hopper Loaders are designed to convey virgin plastic bead materials via a vacuum motor which is self-contained and does not require outside air pressure except for the filter cleaning blow-off system. A few of our many other features include our latest Euro-Style designs, stainless steel hoppers to avoid material contamination with high surface polish, noise reducing motor covers, air filter blow-off system and most important, a wireless remote control for extra operator safety while making settings and adjustments. Signals up to 25 foot distance.

CHARACTERISTICS OF TAL-FX SERIES VACUUM LOADERS

A. All models TAL-15UFX, TAL-3U-EFXDS, TAL-6UFX and TAL-12UFX utilize a vacuum type carbon brush high speed motor for maximum power in a compact design.

B. The models TAL-15UFX, TAL-6UFX and TAL-12UFX hoppers use a bottom hinged dump valve and a magnetic sensor switch for dependable long life. The dump valve must swing freely to empty the material. See base mounting dimensions beyond. The model TAL-3U-EFXDS features a material sight glass, 2-Way Sensing and proximity level control switch for those that wish to view material flow. It has a shut-off flapper on the dump chute to close during the vacuum mode. It requires a smaller 2-1/4" dia. hole in your hopper lid.

C. Loader mounting bases have multiple mounting holes to aid installation. See diagram.

D. The filter auto-clean function can be set with the control box or remote control pad. The filter must be kept clean for maximum suction. Keep the filter clean!!

E. The vacuum motors are equipped for a soft start function set with the control box or remote control pad.

F. All electrical components are enclosed within the control box for user safety and security.

All electrical work of any kind, if necessary, must be done by a licensed professional electrician. All power sources and the unit power switch must be turned off before any maintenance can be performed.

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TAL-FX Series Vacuum Loaders

CAUTION NOTICE:

All service work should be carried out by a person with technical training or corresponding professional experience. The manual contains instructions for both handling and servicing. The Trouble Shooting section contains service instructions intended for service engineers. Other sections contain instructions for the daily operator.

MODIFICATIONS:

WARNING! Do not modify this machine in any way. Modifications of any kind not only void any warranty, but it can cause serious injury or damage to personnel or equipment.

INSTALLATION:

The PPE TAL-FX Series Vacuum Hopper Loader must be mounted on a flat horizontal surface. It must be fastened to the cover of the material feed hopper or your barrel feed throat to avoid tipping over. **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 dump valve swings freely without hitting anything. The counterweight has been adjusted at the factory and should not require any readjustments. The feed probe is secured to the feed hose with the supplied hose clamps. The other end of the hose is connected to the inlet tube located on the loader unit. A ground wire must be installed inside the feed hose to make a good connection between the feed probe and the loader unit. We suggest you use 18GA wire and strip 1-1/2" at each end and pinch the stripped ends between the feed hose and the (metal only) mounting tubes it slides over. **Failure to connect the ground wire can cause excessive static buildup and can result in possible static shock to personnel or damage the unit control circuit board.** When the TAL-FX Series Vacuum Hopper Loader is in operation the feed hose should not have any sags or goose-necks, like the trap under a sink. If the hose sags, when the unit shuts off the material in the hose will fall to the bottom of the sag and can plug the feed hose and restrict suction. When inserting the feed probe into your material gaylord, do not jam the probe in! Insert the probe gently until it is about 1/4 to 1/3 submersed. When the unit is turned on, the probe will pull itself toward the bottom of the gaylord. Check this after a few cycles.

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 TAL-FX 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!!

Many variables in plastic material types, sizes, velocity, ambient temperatures, dryness, etc. etc. can or will generate static electricity seeking a release to ground. If you suspect this condition, we strongly suggest you add an additional ground wire from the control box circuit board ground to your molding machine. Excessive static could damage your control circuit board. If the loader is mounted on a plastic drum or plastic material bin, (ungrounded) you must ground the loader to a proper ground source.

TAL-FX Series Vacuum Loaders

ELECTRICAL

The PPE TAL-FX Series Vacuum Hopper Loader comes wired for 115/60/1 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 and keep it as short as possible. Failure to do so could cause a low voltage condition and premature failure of the motor. Be sure the control box power switch is off before you power up!

OPERATING INSTRUCTIONS

After the unit has been installed and grounded, plug in the power cord. Next move the power switch to the "ON" position. When unit is energized it will be in standby mode and the screen will display “STOP”. To start the unit, press the “ON/OFF” button. The “LOADING” LED will flash, indicating the start of a normal cycle. The cycle begins with the Signal Checking Time (FA). During this time, the “REQUEST” LED will light. After the Signal Checking is complete, the unit will activate the Filter Cleaning Time (F1). During the Filter Cleaning Time the “PURGE” LED will light and compressed air is blown in bursts across the filter to remove fine particles. Please note that the Filter Cleaning Time may not activate each cycle. This will depend on the Filter Cleaning Interval (F2) setting. After the Filter Cleaning Time, the Loading Time (F3) will begin. During this time, the motor will run and the “LOADING” LED will change from flashing to constant on. After the Loading Time is complete, the unit will start the Unloading Time phase (F5). During this time, the “LOADING” LED will return to its flashing state and the motor will spool down. After a few seconds gravity will cause the material to drop into the machine material hopper, and the unit will display “DUMP”. While the unit displays “DUMP”, the F5 Unloading Time setting will continue to count down in the background. At the end of the Unloading Time, if the DUMP VALUE is closed, the cycle will repeat. If the DUMP VALUE remains open the unit will display “FULL” and will stay in this mode until material is drawn down in the machine material hopper, allowing the DUMP VALUE to close. At this point the cycle will repeat.

For optimum performance the unit should run just long enough to fill itself. A full unit is indicated by a higher pitched motor sound because it cannot accept more material. Run several cycles and decrease the "LOADING" (F3) time slightly each cycle until the motor shuts off at approximately the same time the unit is full. If the motor is allowed to run after the unit is full, performance will decrease or you may burn out the motor! The load time can be adjusted from 0 to 99 seconds. In general, longer load times will be needed for: longer distances, heavier materials, and increased amounts of regrind. Do not use with powder materials.

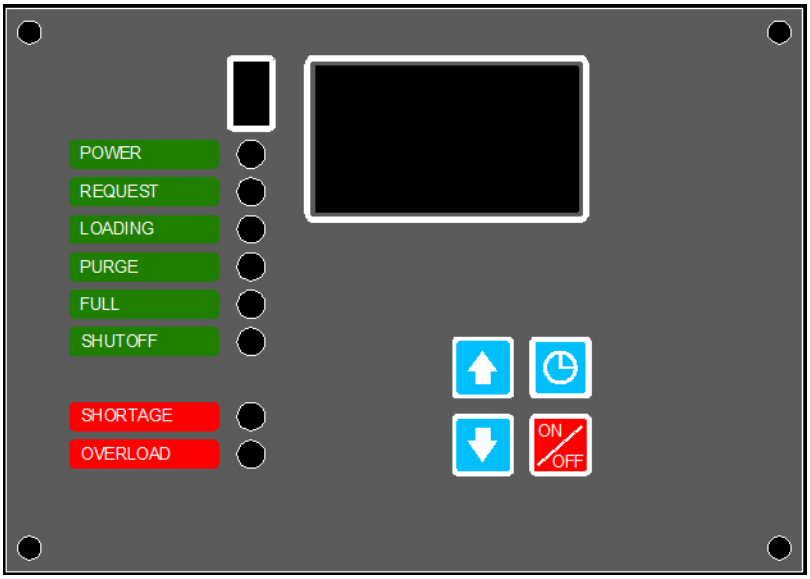
Your PPE TAL-FX Series Vacuum Hopper Loader was designed to operate on the **ON DEMAND** principal. In the event there is a shortage of material supply the yellow Material Shortage light will begin flashing and an alarm buzzer will sound. When your machine material hopper is full the unit will sense 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.

MODELS WITH 4-WAY SENSING

If the “PROX” Sensor is used, material must be manually loaded up to the Prox Sensor level or the Alarm Interval Setting (F7) must be disabled to prevent the unit from showing a Material Shortage Alarm (after the number of cycles F7 is set to). After the material is loaded up to the level of the Prox Switch, the Alarm Interval Setting can be set. Note: Depending on the rate of material draw down, the F7 parameter might need to be set higher than normal to prevent false alarms.

TAL-FX Series Vacuum Loaders

LOADER CONTROL BOX



NAME	IMAGE	DESCRIPTION
IR Sensor		Aim Remote at IR Sensor when using the remote controller.
Power		Power light
Request		Lights during the signal checking time (FA).
Loading		Flashes during normal cycle operation, except light is solid when motor is running (F3).
Purge		Lights during the filter cleaning time.
Full		Lights when the unit is unloading or full.
Shutoff		Not used.
Shortage		Lights when there is a material shortage.
Overload		Lights when an overload is detected. Reset power via swith on side of control box.
Display		LED Display shows set values and current cycle.
Timer		Enter the programming menu and cycle through the parameters.
ON/OFF		Starts the unit cycling. Press again to stop.
Up		Increase the value of the parameter.
Down		Decrease the value of the parameter.

Rev. 3-26-24

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TAL-FX Series Vacuum Loaders

PROGRAMMING INSTRUCTIONS

PROGRAMMING

Press the **"Timer"** button on the control box or **"Set"** button on the remote control pad to enter the programming mode. Press it again to cycle through the different parameters based on the table below. Press the **"Up"** button to increase the value of the displayed parameter and press **"Down"** button to decrease the value. Once settings have been reviewed, press and hold the **"Timer"** button on the control box for approximately 2 seconds or **"Enter"** button on the remote control pad to exit programming mode.

REMOTE CONTROL PAD

Wireless Remote Control Pad must be within 25 ft. of IR Sensor.

NAME	IMAGE	DESCRIPTION
ON/OFF		Starts the unit cycling. Press again to stop.
Set	Set	Enter the programming menu and cycle through the parameters.
Enter	Enter	Save value and Exit
Up		Increase the value of the parameter.
Down		Decrease the value of the parameter.

CODE LIST

Code	Name	Value	
		Default	Range
F1	Filter Cleaning Time	10 secs	0 - 99
F2	Filter Cleaning Interval (number of cycles between cleanings)	3	0 - 99
F3	Loading Time	15 secs	1 - 99
F4	Not used	0	0 - 99
F7	Alarm Interval (number of cycles loading material before alarm)	3	0 - 99
FA	Signal Checking Time	3 secs	0 - 99
FE	Regrind Proportion* %	0%	0 - 99
FF	Regrind Cycles*	2	1 - 4

* Requires optional TPV-38-CFX Proportional Valve.

Rev. 3-26-24

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TAL-FX Series Vacuum Loaders

MACHINE PARAMETERS

1. To enter Parameters, press  and set F3 to 98 and F4 to 97, then press  .

   Press and hold  +  keys until F0 is shown. (Note original values for F3 & F4)

2. Adjust Parameters as needed (see table below).

3. After revision, press  or  over two seconds to exit.

4. After exiting, press  and reset F3 & F4 to their original values.

Code	Name	Function	Value	
			Default	Range
F0	Signal Checking Time	When there is a lack of material, the system considers the signal of lack of material to avoid misoperation, and will delay for a while before starting to act. F0 is used to set this delay time.	5 secs	0 ~ 99
F5	Unloading Time	This is the time for the motor to spool down and the material to unload. During this time the display will show "DUMP" after the Dump Value is opened, but the time will still count down.	15 secs	0 ~ 99
F8	Stop after Alarm	0: If there is a Material Shortage Alarm, continue to cycle. 1: If there is a Material Shortage Alarm, the unit will stop immediately after the alarm.	0	0 ~ 1
F9	Waiting Time before Filter Cleaning	Adds time to Cleaning Interval.	0 sec	0 ~ 99
FB	Waiting time of Filter Cleaning	The motor will continue to run into the F5 Interval for this many seconds.	0 sec	0 ~ 99
FC	Drop Detection Time	Detect Signal OFF Time	1	1 ~ 99
FD	Filter Cleaning ON Time	Duration of the filter cleaning air pulse. The duration displayed is the value times 0.1 (Example: 30 = 3 seconds) 0 = continous on	30	0 ~ 99
FG	Waiting Time Filter Cleaning	Waiting Time before Filter Cleaning	0 sec	0 ~ 99
FH	Delay Time of Breaking Vacuum	Breaking Vacuum Delay Time after conveying	0 sec	0 ~ 99
FI	Filter Cleaning OFF Time	Duration of the time between filter cleaning air pulse. The duration displayed is the value times 0.1 (Example: 8 = 0.8 seconds)	8	1 ~ 99
FJ	Motor Delay Time Unit	[01]:1 sec/Unit. [02]:2 sec/Unit. ... [10]:10 sec/Unit.	1	1 — 10
FK	ConveyingTime Unit	[01]:1 sec/Unit. [02]:2 sec/Unit. ... [10]: 10 sec/Unit.	1	1 — 10

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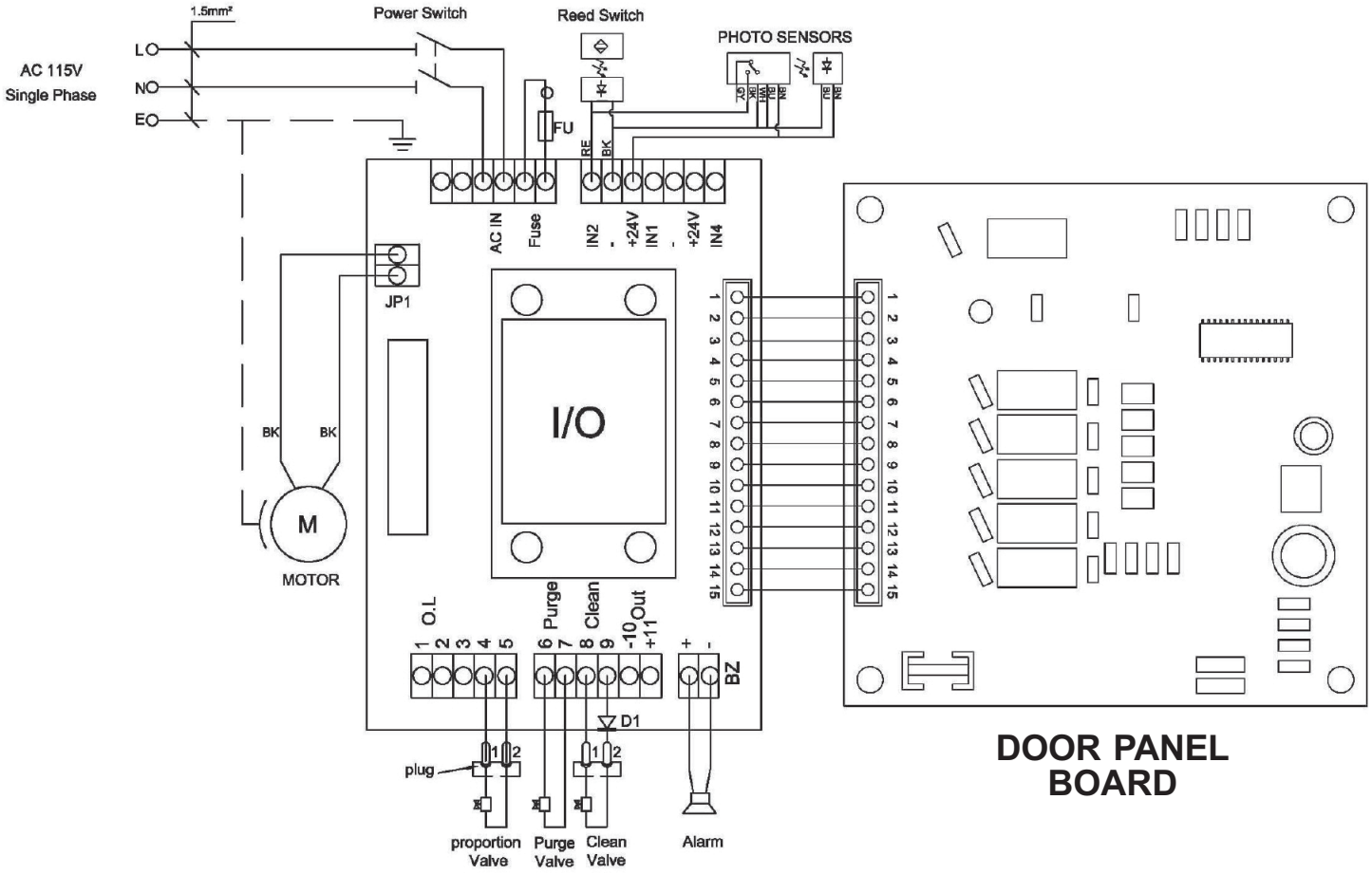
CIRCUIT BOARDS



CONTROL BOX BOARD

DOOR PANEL BOARD

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TAL-FX Series Vacuum Loaders

MAINTENANCE

The PPE TAL-FX Series Vacuum 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 and cleaned weekly. The automatic air blow-off system should help keep the filter clean, but checking is required to make sure there are no tears or holes. CAUTION: Extreme air pressure on the filter blow-off could cause the filter to tear. The Air Blow-Off requires a 8mm dia. air hose. Extra filters are available from PPE.

FILTER CAUTION: When changing filters, always install the filter support frame in the slot within the rubber filter gasket. This ensures an air tight seal between the lid and loader body. Do not put frame on top of filter gasket!!!! Do it right! See photos on last page.

WARNING: The brushes should be changed BEFORE the brush shunt 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. CAUTION: The motor must not be run with the material vacuum suction line air inlet blocked or sealed off. Check your material probe for blockage. DIRECT APPLICATION OF FULL RATED VOLTAGE AFTER CHANGING BRUSHES MAY 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.

MACHINE SPECIFICATION TABLE

MODEL	TAL-15UFX	TAL-3U-EFXDS	TAL-6UFX	TAL-12UFX
Motor Type	Carbon Brush	Carbon Brush	Carbon Brush	Carbon Brush
Motor Power	1.5 H.P. / 1.1 kW	1.5 H.P. / 1.1 kW	1.5 H.P. / 1.1 kW	1.5 H.P. / 1.1 kW
Pipe Diameter	1-1/2"	1-1/2"	1-1/2"	1-1/2"
* Conveying Capacity	450 lbs / hr	450 lbs / hr	660 lbs / hr	900 lbs / hr
Hopper Volume	3 lbs	3 lbs	8 lbs	12 lbs
Sight Glass	n/a	Yes / 16 oz.	n/a	n/a
Power Supply	110V / 50Hz / 1	115V / 60Hz / 1	110V / 50Hz / 1	110V / 50Hz / 1
★ Filter Automatic Blow-Off	Standard	Standard	Standard	Standard
Discharge Hole Req'd.	6" dia.	2.25" dia.	8.25" dia.	8.25" dia.
Height	22-1/2"	28-1/8"	26-3/4"	24-1/2"
Width	11-1/2"	9"	14"	15"
Depth	13-1/2"	13"	17"	18-1/2"
Weight	25 lbs	29 lbs	29 lbs	30-1/2 lbs

* Conveying capacity tested @ 10 ft. vertical & 10 ft. horizontal.
★ Filter Blow-Off Air Pressure required 70 to 90 P.S.I.

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Revised 2-2-21

TAL-FX Series Vacuum Loaders

ALARMS

Error Code	Description	Cause	Inspection
AL-1	Material shortage after loading several times	1. No raw materials 2. Absorption pipeline with or without blocking	1. Add raw materials 2. Eliminate pipeline obstruction
AL-2	Motor overload shutdown alarm	1. Motor overload 2. Output current is abnormal	1. Check the motor 2. Check the power cord 3. Check the filter is blocked

TROUBLESHOOTING

Most loader problems are the result of dirty filters, air leaks, or improper adjustments. These items should be checked first before assuming equipment failure.

Problem	Solution
Motor will not run	A, B, C, H, K
Inadequate or no vacuum	D, E, F, G, J
Inadequate or no material flow	C, D, E, F, G, I
Motor runs but pulse solenoid not operating	K, L
Loader runs 1 cycle then shows full	M

TROUBLESHOOTING SOLUTIONS

	Problem	Check	Solution
A	No voltage or incorrect supply-voltage at outlet	Power supply	Check incoming power
B	No voltage through switch	On/Off Switch	Replace switch
C	No voltage at motor	Vacuum Motor	See A, B, and K
	Voltage at motor, amperage incorrect	Vacuum Motor	Replace motor
D	Low performance	Cloth Filter	Clean or replace filter (also see G and J)
E	Obstructed	Vacuum and material	Remove obstruction lines
F	Air leaking into system	Leaks in system	Replace gaskets, repair leaks as necessary
G	Low pressure	Blowback air pressure incorrect	Increase pressure (not to exceed 90 PSI)
H	No voltage through switch	Reed Switch	Replace or adjust switch
I	Chamber not filling sufficiently	Load time	Increase load time
	Chamber overfilling	Load time	Decrease load time
J	Insufficient to clean filter	Pulse rate	Increase rate
K	No voltage output to solenoids or motor SSR	Power and/or pulse	Replace board
	No voltage through SSR	Power and/or pulse	Replace SSR
L	No voltage to solenoid	Pulse Solenoid	See K
	Voltage present at solenoid, but no pulse	Pulse Solenoid	Replace solenoid (also see G)
M	After 1 cycle loader shows full. Turn power off to reset.	Magnet Power Loss	Replace magnet

WARRANTY

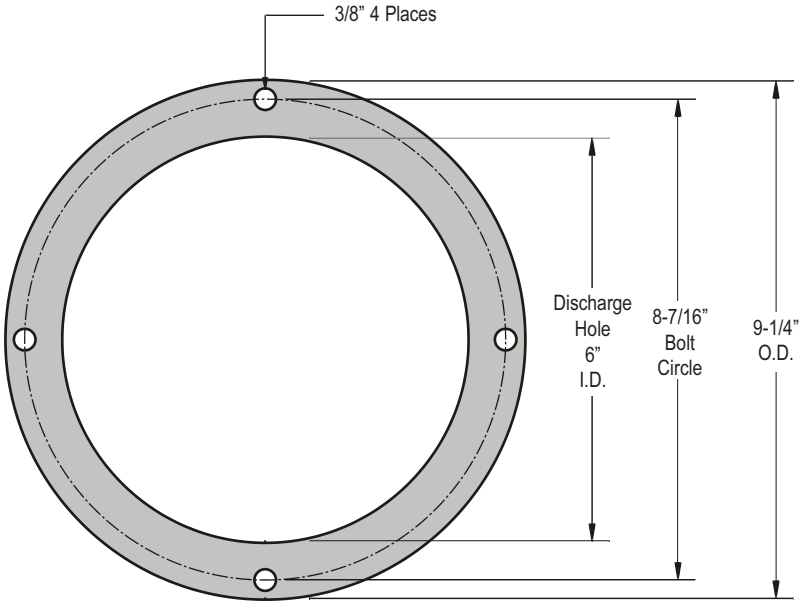
All PPE machinery is warranted to be free of defective material and workmanship for a minimum period of 1 YEAR from date of sale. Some machinery components may carry longer warranties per our suppliers policies which are passed on to our customers (i.e. our drier compressors, conveyor motors, etc.).

Rev. 10-27-22

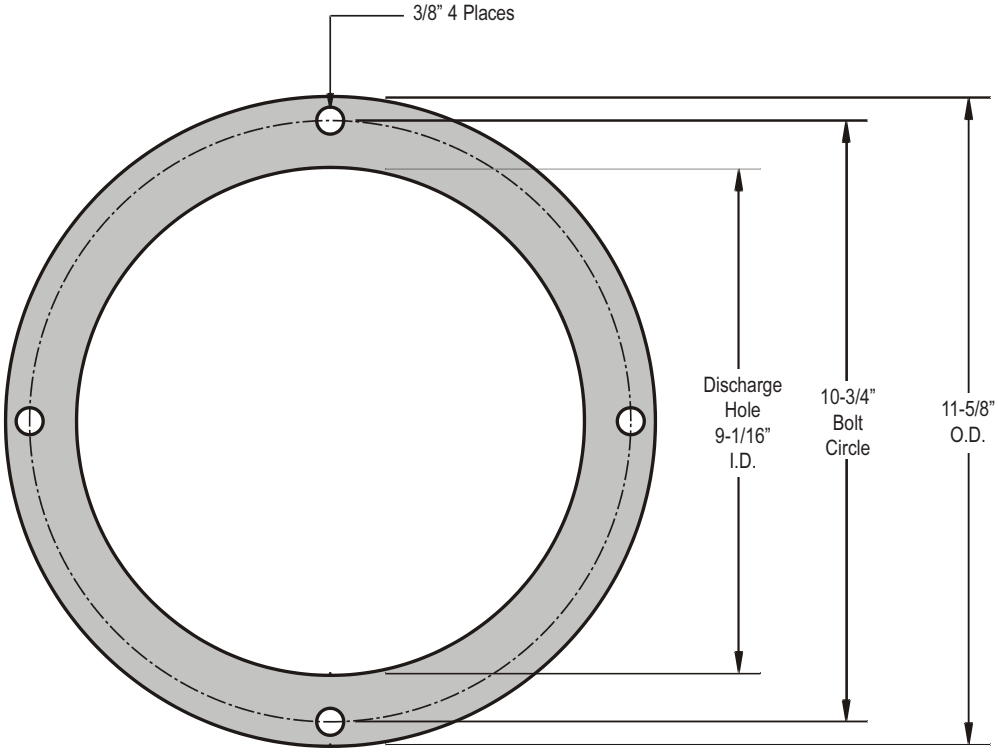
TAL-FX Series Vacuum Loaders

BASE MOUNTING DIMENSIONS

MODEL TAL-15UFX



MODELS TAL-6UFX & TAL-12UFX



Rev. 3-8-22

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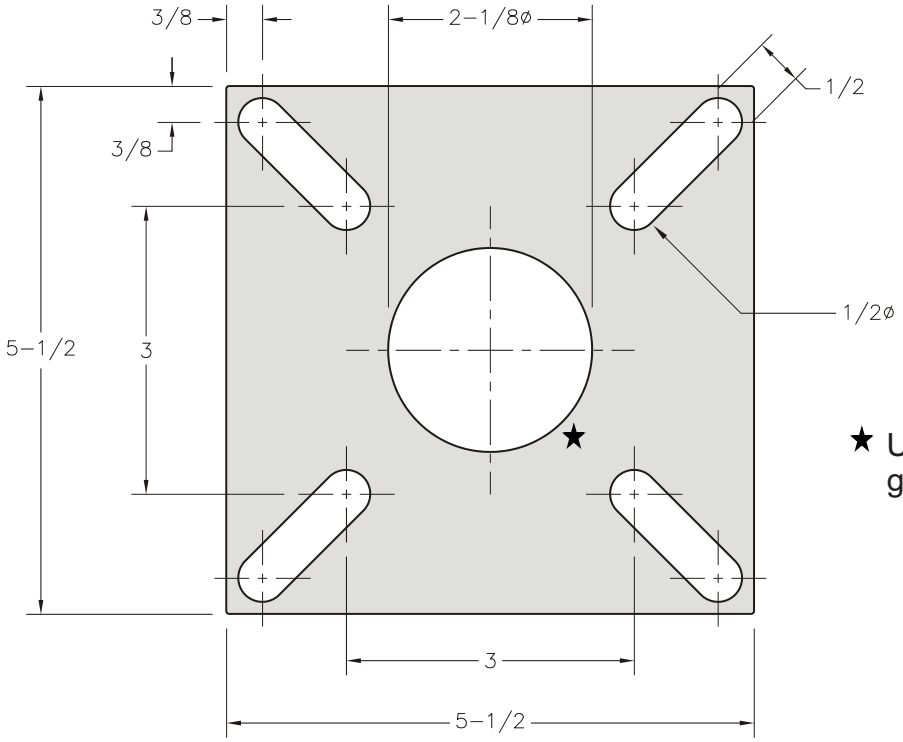
TAL-FX Series Vacuum Loaders

BASE MOUNTING DIMENSIONS

MODEL TAL-3U-EFX & MODEL TAL-3U-EFXDS



★ Use RTV or seal gasket here.

FILTER & SUPPORT FRAME INSTALLATION

CORRECT:
Filter Support Frame sandwiched in slot within the rubber filter gasket. Ensures air tight seal.

CORRECT

WRONG:
Filter Support Frame laid on top of rubber filter gasket. No air tight seal.

WRONG

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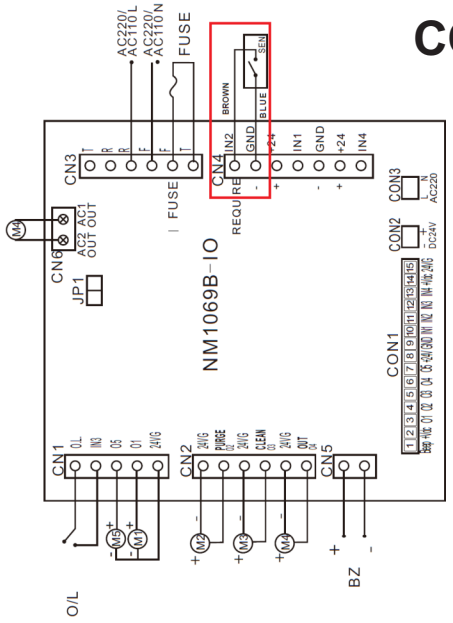
TAL-FX Series Vacuum Loaders

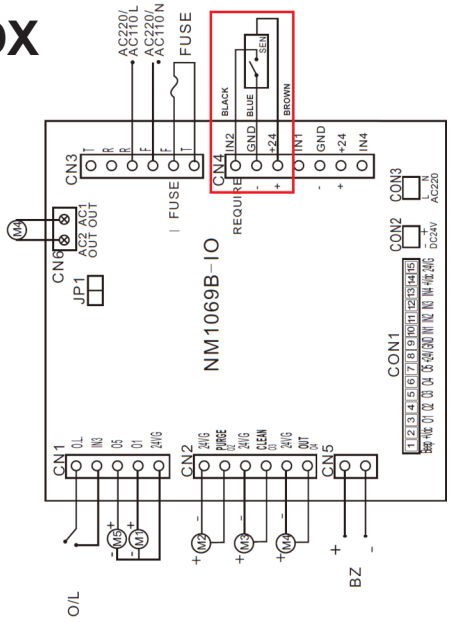
TO CONVERT TAL-FX LOADER MATERIAL SENSOR FROM FLAPPER VALVE & REED SWITCH W/MAGNET TO A PROXIMITY SWITCH FOR SIGHT GLASS SENSING

TALFC12VFX Reed Switch

KI5082 Proximity Switch &
K15082LC, 16 ft. Line Cord

CONTROL BOX BOARD





CAUTION: POWER OFF

STEP 1: Locate 2 terminals on circuit board marked IN2 & GND ports.

STEP 2: Remove IN2 & GND wires that controlled the Reed Switch from the circuit board in the control box.

STEP 3: Pull old Reed Switch wire thru strain relief fitting in bottom of control box.

STEP 4: Use Proximity Switch line cord part number K15082LC. It has a plug to fit KI5082 Proximity Switch and a 4 wire open end.

STEP 5: Fish new K15082LC Line Cord wire back thru relief fitting into control box.

STEP 6: Connect black wire to IN2, the blue wire to GND & the brown wire to +24. The white wire is moot & not used.

STEP 7: Thread line cord fitting on to back of KI5082 Proximity Switch. Tighten box fitting to hold new line cord in place.

Proximity Switch is now ready for use on material bin sight glass to sense material level and control loader cycle. Switch must be programmed (taught) the sensitivity level for full or empty sensing. For detailed technical instructions go to www.ifm.com.

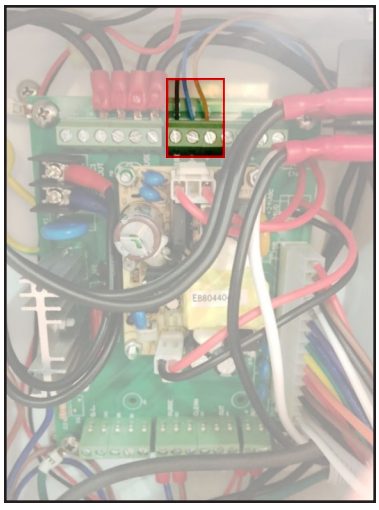


Photo shows 3 wires connected from proximity switch.

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TAL-FX Series Vacuum Loaders

ADVANCED MODELS HAVE A 2 WAY MATERIAL SENSING OPTION AS A STANDARD FEATURE

2 WAY SENSING AT THE LOADER OR REMOTE

Selector Switch for sensors.
HIGH, senses from loader.
LOW, senses from remote.

TALFC12VFX Reed Switch comes standard.

Jack on the control box fits K15082LCP cord plug.

LDA154AFX Sensors comes standard.

Models
TAL-15UFXDS
TAL-6UFXDS
TAL-12UFXDS

TALFC12VFX Reed Switch

FROM THIS TO THIS

K15082LCP Line Cord

KI5082 Proximity Switch & K15082LCP 16 ft. Line Cord

Model
TAL-3U-EFXDS

FROM THIS TO THIS

LDA154AFX Sensors

K15082LCP Line Cord

KI5082 Proximity Switch & K15082LCP 16 ft. Line Cord

Plug fits Prox. Switch.

Plug fits Control Box.

K15082LCP Line Cord with plugs.

TALSP131 Mounting Bracket

For mounting KI5082 Proximity Switch on Sight Glass pillar you need this bracket.

TO CONVERT:

1. Buy a KI5082 Proximity Switch.
2. Buy a K15082LCP 16 ft. Line Cord, plugs at both ends.

Rev. 2-7-23

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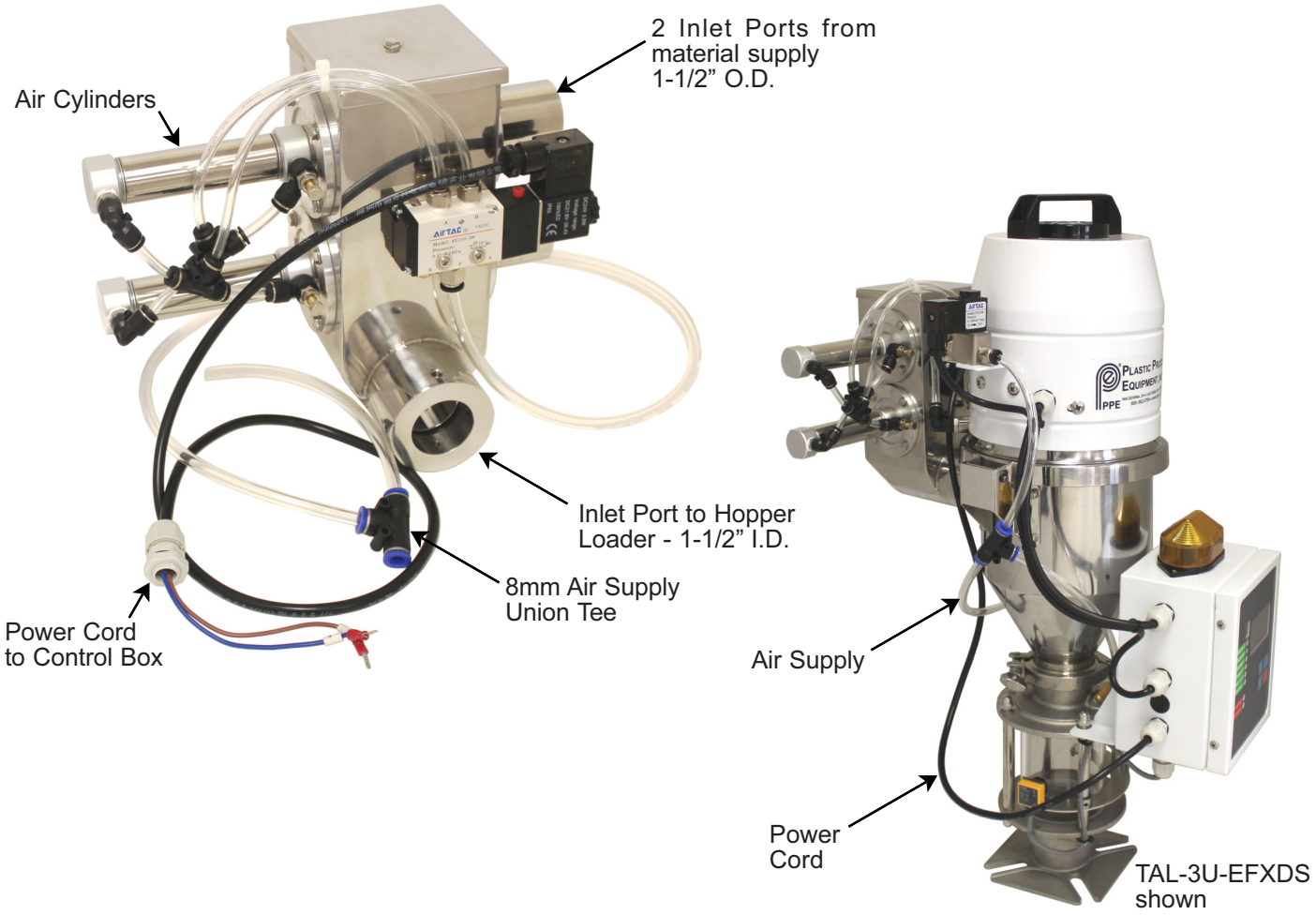
TPV-38-CFX
Proportional Valve

FOR USE WITH PPE VACUUM LOADER MODELS TAL-15UFX, TAL-3U-EFXDS, TAL-6UFX & TAL-12UFX

These loaders have a provision in the Control Box circuit to allow the TPV-38-CFX Dual Feed Valve to slave off both power and settings. Settings made via the Control Box or Remote Pad.



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