

INVISIPAC TRAINING

23th May 2025





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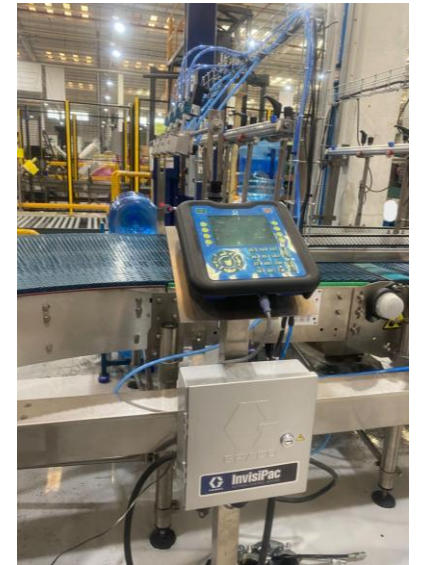
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1. INVISIPAC PRODUCT RANGE

Product Range

A solution for every size and volume end-of-line packaging



InvisiPac HM10

Melter dispenses hot melt adhesive at low to middle volume rates, good for any application.



InvisiPac HM25c

Compact unit for middle to high volume case and carton sealing integrates easily into end-of-line packaging.



InvisiPac HM50

High volume, case and carton sealing benefits the most from the InvisiPac's highest flow model.

Product HM10

A solution for every size and volume end-of-line packaging

HM10	ON-BOARD HOPPER MODELS	
	20B715	SYSTEM, INVISIPAC HM10 2CH 240V
	20B716	SYSTEM, INVISIPAC HM10 4CH 240V
	20B717	SYSTEM, INVISIPAC HM10 2CH 480V
	20B718	SYSTEM, INVISIPAC HM10 4CH 480V

HM10	REMOTE VACUUM FEED MODELS	
	20B725	SYSTEM, INVISIPAC HM10 2CH 240V
	20B726	SYSTEM, INVISIPAC HM10 4CH 240V
	20B727	SYSTEM, INVISIPAC HM10 2CH 480V
	20B728	SYSTEM, INVISIPAC HM10 4CH 480V



InvisiPac HM10

2 to 4 channels
Up to max 4 Kg/Hour
Typical around 1,5 Kg/Hour

Product HM25c

A solution for every size and volume end-of-line packaging

HM25C Generation 3 (the best option)	25C700	SYSTEM HM25C 4CH
	25C701	SYSTEM HM25C 4CH + PC8
	25C702	SYSTEM HM25C 8CH
	25C703	SYSTEM HM25C 8CH + PC8
	25C720	SYSTEM HM25C 4CH 400V W/O N-TR,
	25C721	SYSTEM HM25C 4CH 400V W/O N-TR, + PC8
	25C722	SYSTEM HM25C 8CH 400V W/O N-TR,
	25C723	SYSTEM HM25C 8CH 400V W/O N-TR, + PC8



InvisiPac HM25c

4 to 8 channels

Up to 11 Kg/Hour

Typical around 3 to 6 Kg/Hour

Product HM50

A solution for every size and volume end-of-line packaging

HM50 Generation 2 W/O PC	24Y723	SYSTEM HM50 2CH-AWB
	24Y724	SYSTEM HM50 4CH-AWB
	24Y725	SYSTEM HM50 6CH-AWB
	24Y726	SYSTEM HM50 400V W/O N-TR, 2CH-AWB
	24Y727	SYSTEM HM50 400V W/O N-TR, 4CH-AWB
	24Y728	SYSTEM HM50 400V W/O N-TR, 6CH-AWB
	24Y729	SYSTEM HM50 480V TRANSFORMER 2CH
	24Y730	SYSTEM HM50 480V TRANSFORMER 4CH
	24Y731	SYSTEM HM50 480V TRANSFORMER 6CH



InvisiPac HM50

2 , 4 or 6 channels

Up to 22kg/Hour

Typical more than 7 to 9 Kg/Hour

Feeding Kit

A solution for every size and volume end-of-line packaging



Feed Kit container 25C193

- Ability to hold 80 kg of hot melt pellets



InvisiPac HM10 On board Hopper

- Ability to hold 9 kg of hot melt pellets

Heated hoses

A solution for every size and volume end-of-line packaging

Attention :

=> When using any liquid around the heated hoses , please select the water wash hoses !!



Standard Heated Hoses

- Start from 1,2m to 7,6m

Standard Model Hoses

Standard model hoses are meant for dry environments only. Standard model hoses have a gray braided scuff guard.

Part No.	Length ft (m)	Hose Core Size	Swivel Fitting	Watts per foot
127401	4 (1.2)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	60
127402	6 (1.8)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	60
127404	8 (2.4)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	60
126389	10 (3.0)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	60
127405	12 (3.6)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	60
127406	14 (4.2)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	60
127407	16 (4.8)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	60
127408	18 (5.4)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	60
126483	20 (6.0)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	60
127409	22 (6.7)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	50
126534	25 (7.6)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	50

Heated hoses

A solution for every size and volume end-of-line packaging



Water Wash Heated Hoses

- Start from 1,2m to 7,6m

Attention :

=> When using any liquid around the heated hoses , please select the water wash hoses !!

Water-wash Model Hoses

Water-wash model hoses are meant for wash-down environments. Water-wash models have a black rubber scruff guard. Water-wash hoses are IPx6 rated.

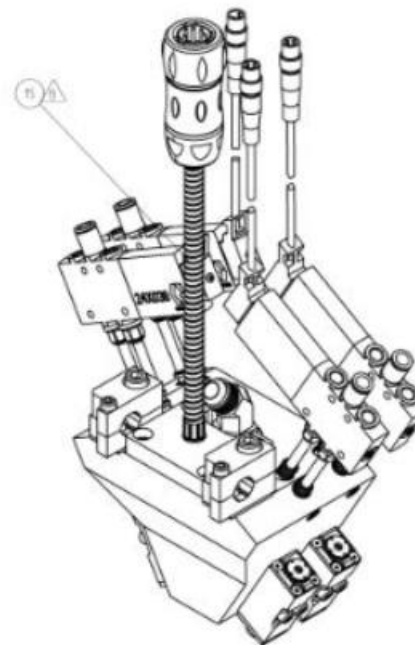
Part No.	Length ft (m)	Hose Core Size	Swivel Fitting	Watts per foot
24U763	4 (1.2)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	60
24U765	6 (1.8)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	60
24U766	8 (2.4)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	60
24U767	10 (3.0)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	60
24U768	12 (3.6)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	60
24U769	14 (4.2)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	60
24U771	16 (4.8)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	60
24U772	18 (5.4)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	60
24U773	20 (6.0)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	60
24U774	22 (6.7)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	50
24U776	25 (7.6)	No. 6 (0.308" ID)	0.31 ID (9/16-18 JIC(f))	50

Applicators

A solution for every size and volume end-of-line packaging



Standard Applicators



Custom Applicators

ACCESSORIES INVISIPAC

Accessories Applicators GM100

1. 24X037 Muffler Kit GM100
2. 24Y170 Cover GM100 single
3. 25P481 Exhaust kit Water wash GM100
4. 24X050 Kit remote GM100 metric

Accessories HM10

1. 20B729 Kit Light Tower HM10
2. 17S264 Kit Stand HM10 & HM25c
3. 25M528 Kit Plate HM10 & HM25c
4. 20B690 Remote Mount for ADM2 touchscreen
5. 20B918 Kit 4 Channel Upgrade HM10

Accessories HM25c

1. 25C662 Kit Light Tower HM25c
2. 17S264 Kit Stand HM10 & HM25c
3. 25M528 Kit Plate HM10 & HM25c
4. 24R710 5m or 24R711 15m ADM extension cable
5. 25M527 Kit Upgrade 4 to 8 Channel HM25c

Accessories HM50

1. 24R226 Kit Light Tower HM50
2. 24R088 Kit Stand HM50
3. 24R083 Kit Plate HM50
4. 24R710 5m or 24R711 15m ADM extension cable

2) HOTMELT ADHESIVES TYPES

HOT MELT ADHESIVE TYPES

- **E.V.A. : (Ethylene-Vinyl Acetate).**
- **Metallocene : (Polyofine)**



What are Hot Melts?

Hot Melt Adhesives Are Solid materials that melt at relatively low temperature (Typically above 80°C). Softening Point = The moment when the glue change from solid to liquid.

These are commonly applied between 110°C to 180°C.

Once Cooled , the materials solidify again.

This will ensure the cohesion and the ultimate adhesion of the bonded surfaces.

HOT MELT ADHESIVE TYPES FOR INVISIPAC

Hot Melt Adhesive Types that work with InvisiPac

1. **E.V.A. :**(**E**thylene-**V**inyl **A**cetate). => Packaging
2. **Metallocene :**(**P**olyofine) => Packaging



Only Hot Melt Adhesive in Granules!!

Hot Melt Adhesive Types that NOT work with InvisiPac

1. **PSA:**(**P**ressure **S**ensitive **A**dhesive). => Labelling
2. **PA :**(**P**olyamide **A**dhesives).=> Special Applications
3. **PUR :**(**P**olyrurethaan **R**eactive).=>Special Applications

Hot Melt in Pillows and Blocks will not work!!



2) LINE AUDIT INVISIPAC

INVISIPAC™ HM10 , HM25C & HM50 LINE AUDIT



GRACO INVISIPAC LINE AUDIT		
Item	Question	Answer
1	Customer Information: * Name: * Location: * New Installation ? * Replacement old unit ? * Which brand and type?	
2	System Selection: * How much KG/Hour do they need? * How many channels do they need? * HM10 , HM25c or HM50 ? * Which Adhesive are they using?	
3	Heated Hoses Selection: * How many ? * Standard or Water Wash? * Length of hoses ?	



INVISIPAC™ HM10 , HM25C & HM50 LINE AUDIT



4	Select Applicators : <i>* Standard, Slim fit or GM100?</i> <i>* Single, Double, Quad or Special Customized ?</i> <i>* Nozzles? Straight or Angle ? Size?</i> <i>* Using existing guns? Which Brand and Type?</i> <i>* Choose the right cable adaptors?</i>	
5	Accessories : <i>* Stand ? Plate ?</i> <i>* Feed container ?</i> <i>* Light tower?</i> <i>* Can cable?</i> <i>*</i>	
6	ATTENTION: Double check Valves <i>* How are the valves controlled?</i> <i>By the Line ?</i> <i>By the old unit?</i> <i>Do we need a Pattern controller ?</i> If yes follow the Line audit for the Pattern Controller!	



INVISIPAC™ HM10 , HM25C & HM50 LINE AUDIT



7	Points to take care: * Power Supply ? Right Cable , Length & Connector ? * Air Supply ? Right length & size? * Air connectors ? The right sizes? * Check valves & air regulator? * Fluid Adaptors ? Straight On, 45° or 90° ? * Special brackets to mount applicators!!!!	
8	Special Requirements & Notes	



2) LINE AUDIT PATTERN CONTROLLER

INVISIPAC™ PATTERN CONTROLLER



GRACO INVISIPAC PATTERN CONTROLLER LINE		
Item	Question	Answer
1	Customer Information: * Name * Location * Line Description * 1 or 2 Lines?	
2	System Configuration: * Integrated or Stand-Alone? * PC-8 or PC-8e?	
3	Mode of Operation: * PC-8: * Time mode or Fixed-Speed Distance mode? (Time & Fixed-Speed: Define/measure line speed) * PC-8e: * Variable Speed. Need Encoder. * = Customer's existing encoder compatible?	
4	PCM Mounting: External one: * Pattern Control: VESA mount. Define location for mount. * Power Input Wiring: 110-240VAC single phase. Define and prepare circuit to power PCM.	



INVISIPAC™ PATTERN CONTROLLER

5	Solenoids to Control: * How many solenoids ? * What type of valves? (mini, standard, electric, etc.) (defines which cables are needed) * How long will the cables be? * Verify all solenoids are 24VDC * Verify all solenoids $\leq 24W$ (1A @ 24VDC)	
6	Trigger sensors : * How many triggers? * What type of triggers? (Reflective, Proximity, limit/trip switch) * Use customer's existing trigger(s)? Verify all existing trigger(s) are 24VDC NPN or PNP or dry contact. * How will the trigger(s) mount (and reflector if needed)? How long will the cables be? * Verify Gun-Trigger offset is sufficient for desired pattern (Mirror mode or Random Length Bead mode) * Bracket to install trigger?	
7	Encoder: * How will the encoder couple to the line (direct couple, friction wheel)? * Where will the encoder mount? How long will the cable be? * How will the encoder mount (universal bracket, custom bracket)? * Direct Couple: What size is the motor shaft? * Line 1&2 setups: Define requirements for both lines.	



INVISIPAC™ PATTERN CONTROLLER

8	Run-Up Control: * Need Run-Up control? Customer supplied V/P or Graco supplied? (Verify customer V/P is compatible) * How long will the cable be? * Define pressure curve (min speed/pressure, max speed/pressure). Min InvisiPac air motor pressure = 20psi * Consider Valve's tip size in relation to pressure curve * Line 1&2 Setups: Define requirements for both lines.	
9	Setup Information: * How many programs are needed? What are they named? * How often do you change the pattern? Define "protection" level (lock pattern, etc.). * Stitching required? Consider Valve solenoid speed/life. * Use Mirror Mode? * Use Modulated Bead mode? * Use PLC I/O? Verify customer's PLC signals are compatible or make adjustments to PLC program)	
10	Special Requirements & Notes	



3) CONFIGURATIONS AFTER LINE AUDIT

CONFIGURATION 1.

Info after Line Audit

- Nordson Problue 4kg unit installed.
- 2x hose 3M
- 2x hoses 4,5m
- 4x single guns
- Nozzles straight 0,012"
- Solenoids controller by existing PLC

Configuration InvisiPac

1. 1x 25C700 HM25c 4CH
2. 1x 25C193 feed container
3. 2x 126389 Heated hose 3m
4. 2x 127407 Heated hose 4,8
5. 4x 25B021 GM100 single gun
6. 4x 130012 nozzle straight 0,012"

Options & Extra Info

- Stand unit.
- Light tower.
- Mufflers
- They apply 1,11gr/box => 60boxes/minute standard packaging adhesive. See data sheet
- Data Sheet [TECHNOMELT SUPRA 130 COOL-EN.pdf](#)

Options InvisiPac

1. 1x 17S264 Kit stand HM25c / HM10
2. 1x 25C662 Kit Light tower.
3. 4x 24X037 Muffler kit GM100
4. [Prices InvisiPac euro-dollar-pounds 2025.xlsx](#)
5. [Offer Template 2025_EUR.xlsx](#)

CONFIGURATION 2.

Info after Line Audit

- Nordson ProFlex 7 kg unit installed.
- 1 x hose 3M
- 1x single gun
- Nozzles straight 0,014"
- Solenoid controlled by existing PLC

Configuration InvisiPac

1. Will not work with InvisiPac because we can not feed pillows with our InvisiPac units!!!

Options

- Stand unit.
- Light tower.
- Mufflers
- They apply 0,2 gr/box => 60boxes/minute
- Info from customer The adhesive they are using is coming in PSA blocks.
- Data Sheet [TECHNOMELT SUPRA 7220-21 PS-EN.pdf](#)

Options InvisiPac

1. [Prices InvisiPac euro-dollar-pounds 2025.xlsx](#)
2. [Offer Template 2025_EUR.xlsx](#)

CONFIGURATION 3.

Info after Line Audit

- Tank unit 10kg installed.(very old system)
- 2x hose 3M
- 3x hoses 4,5m
- 3x single guns
- 2x Double guns 32mm between module 2x solenoid
- 3x nozzles straight 0,012" & 4x nozzles 90° 0,012"

Options & Extra Info

- Patten Controller Extra's : Like Sensor , encoder ,
- Adaptor plate.
- Longer feeding hose.
- Light tower.
- Mufflers
- Solenoids needs to be controlled by pattern controller
- They apply around 6kg per hour
- Data Sheet [Advantra® 9255 LP_EN.pdf](#)

Configuration InvisiPac

1. 1x 25C703 HM25c 8ch+PC8
2. 1x 25C193 feed container
3. 2x 126389 Heated hose 3m
4. 3x 127407 Heated hose 4,8
5. 3x 25B021 GM100 single gun.
6. 2x GSC007 GM100 double 2x solenoid 32mm
7. 3x 130012 nozzle straight 0,012"
8. 4x 130111 nozzle 90° angle 0,012"

Options InvisiPac

1. 1x1x 24X446 Kit , Sensor
2. 1x 24X448 Kit , Encoder
3. 1x 17F712 Kit,Upgrade to PC8e (Blue Token)
4. 17S264 Kit stand HM25c / HM10
5. 1x 24R043 Feeding Hose 10m
6. 1x 25C662 Kit Light tower.
7. 4x 24X037 Muffler kit GM100
8. [Prices InvisiPac euro-dollar-pounds 2025.xlsx](#)
9. [Offer Template 2025_EUR.xlsx](#)

1) INVISIPAC INSTALLATIONS

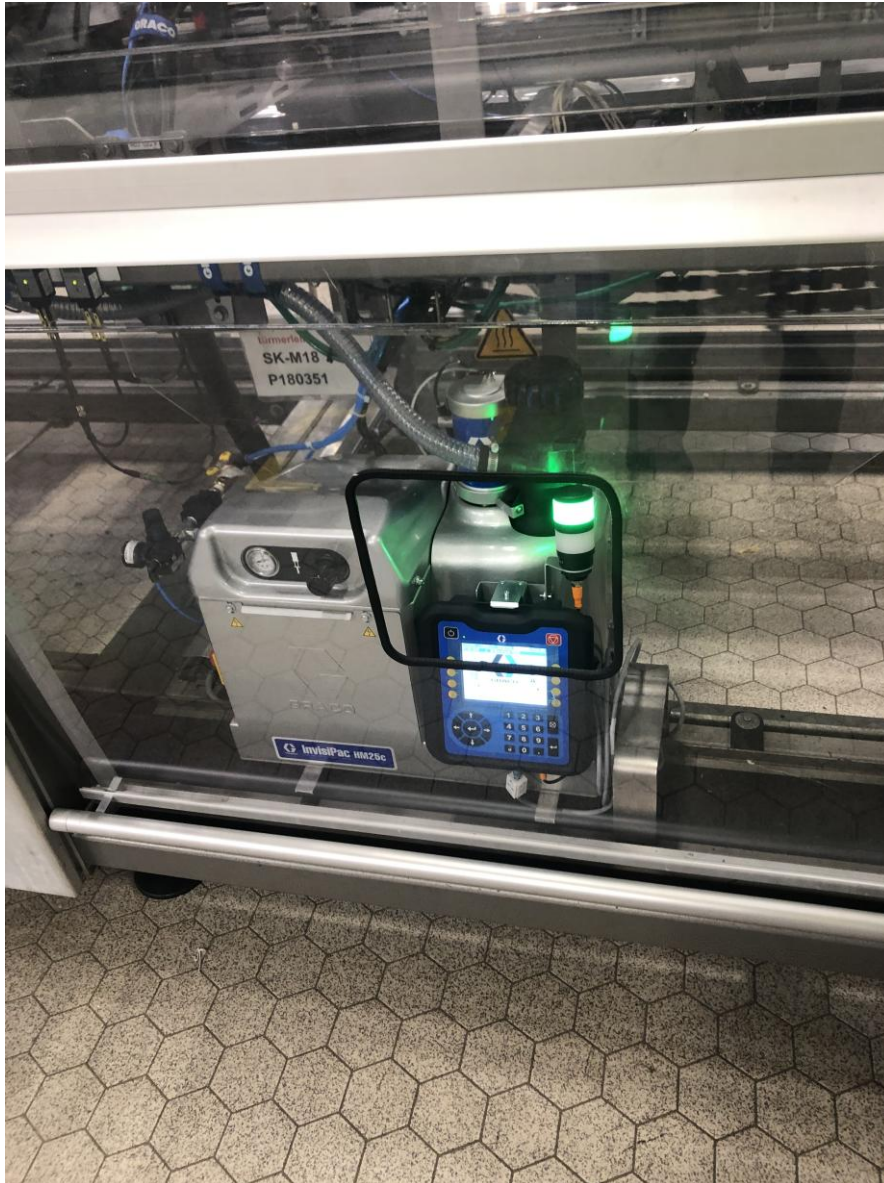
INVISIPAC™ INSTALLATION REFRESCO



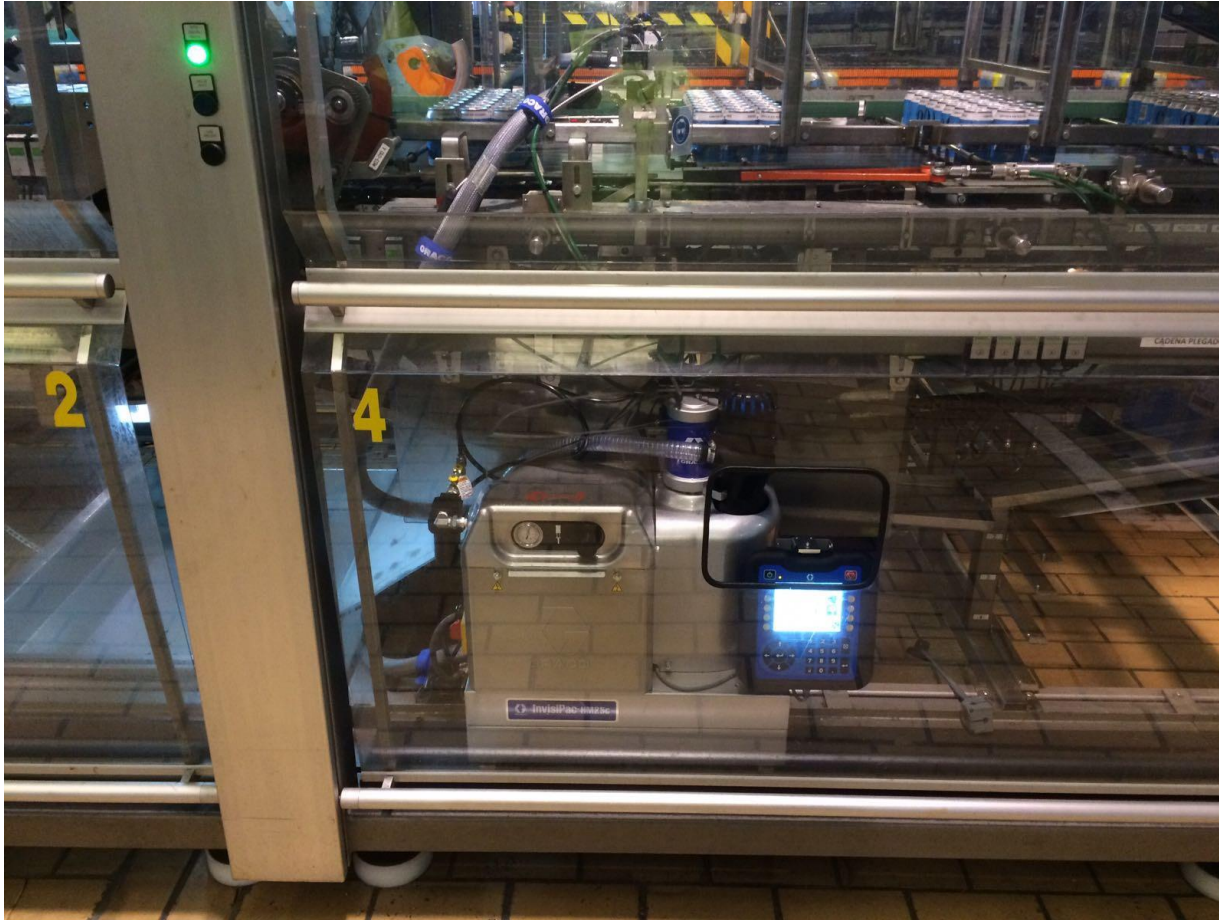
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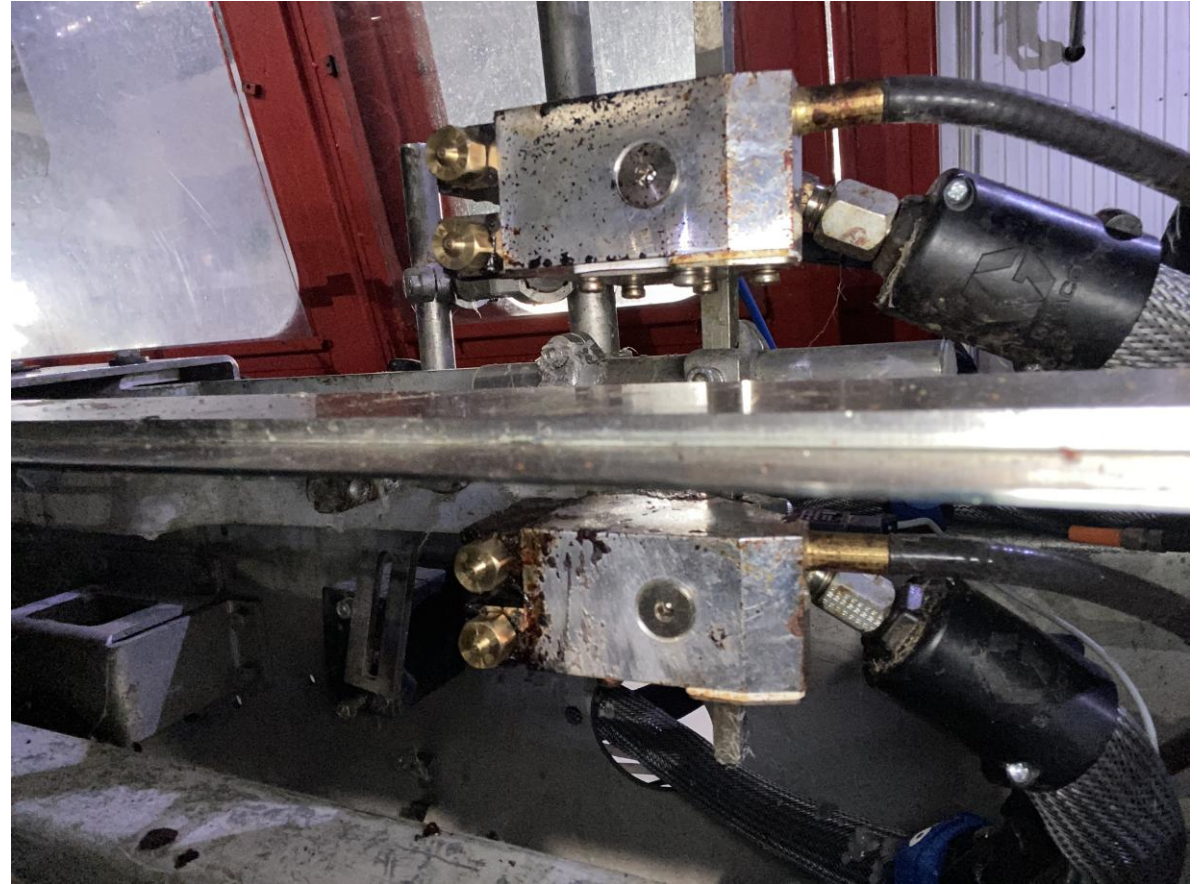
INVISIPAC™ INSTALLATION COCA COLA



INVISIPAC™ INSTALLATION HEINEKEN



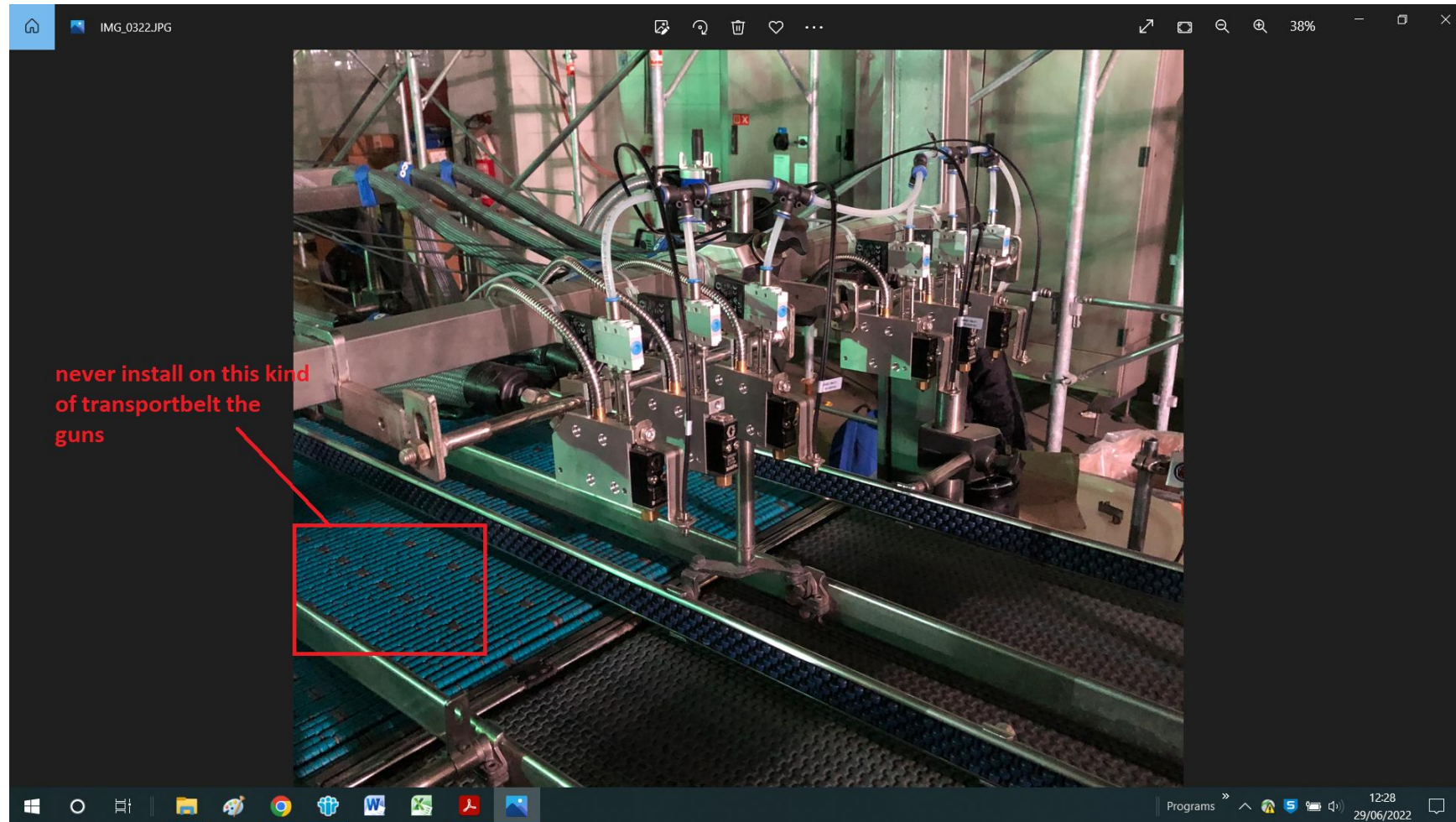
INVISIPAC™ INSTALLATION HEINEKEN



1. INSTALLATION

PLACE POP & LOCK

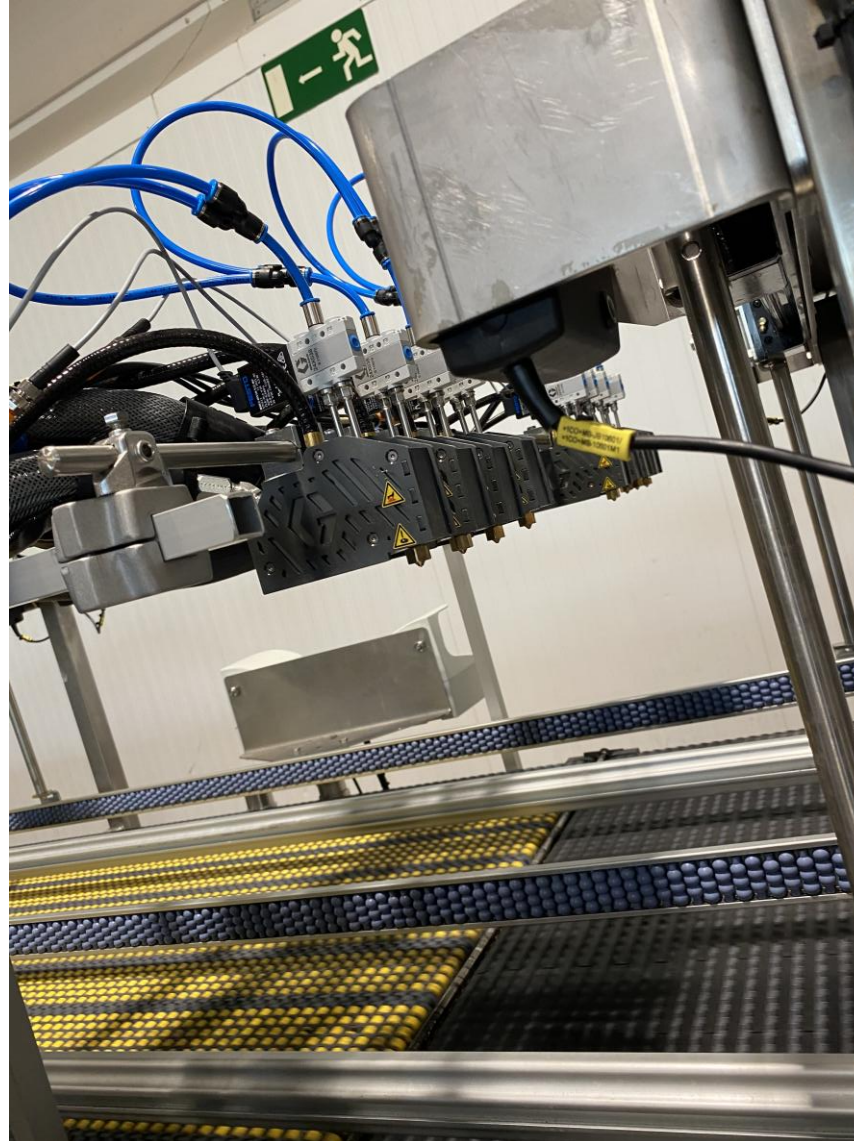
INVISIPAC™ INSTALLATION PLACE INVISIPAC



INVISIPAC™ INSTALLATION PLACE



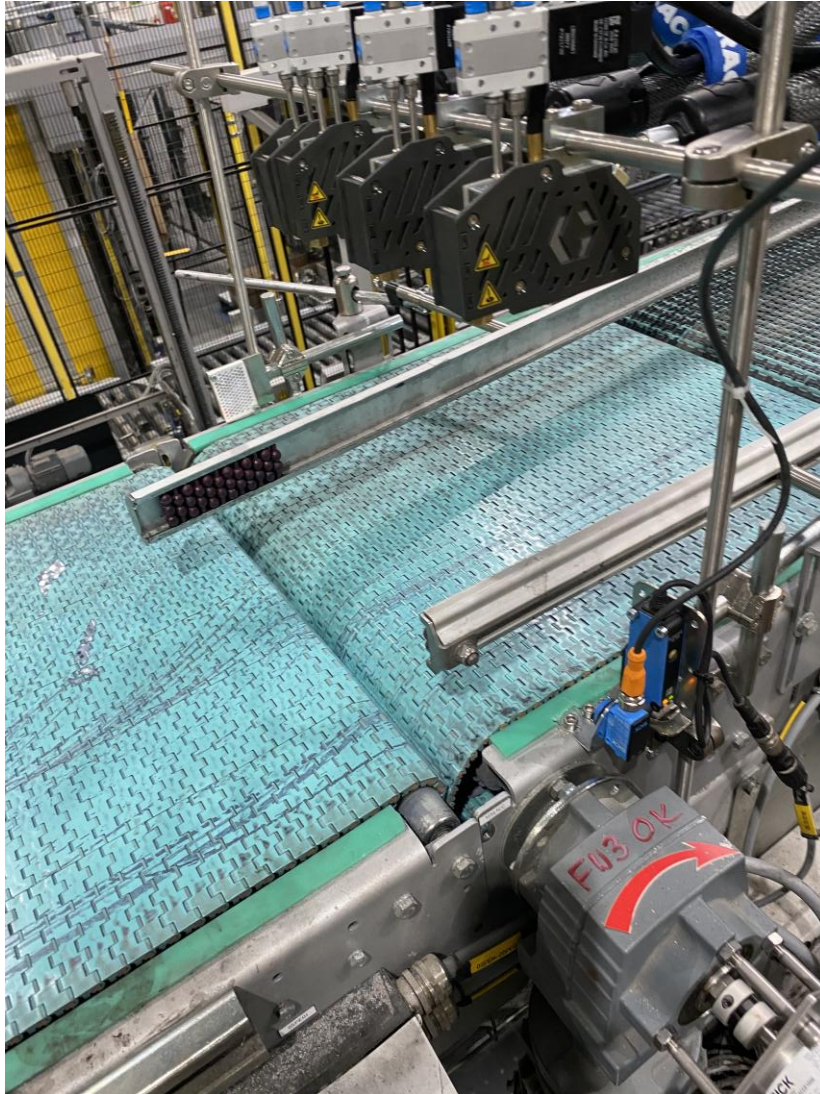
INVISIPAC™ INSTALLATION PLACE



INVISIPAC™ CUSTOMIZED INSTALLATION PARTS YOU NEED TO HAVE!



INVISIPAC™ INSTALLATION PLACE SENSOR



INVISIPAC™ INSTALLATION PLACE SENSOR

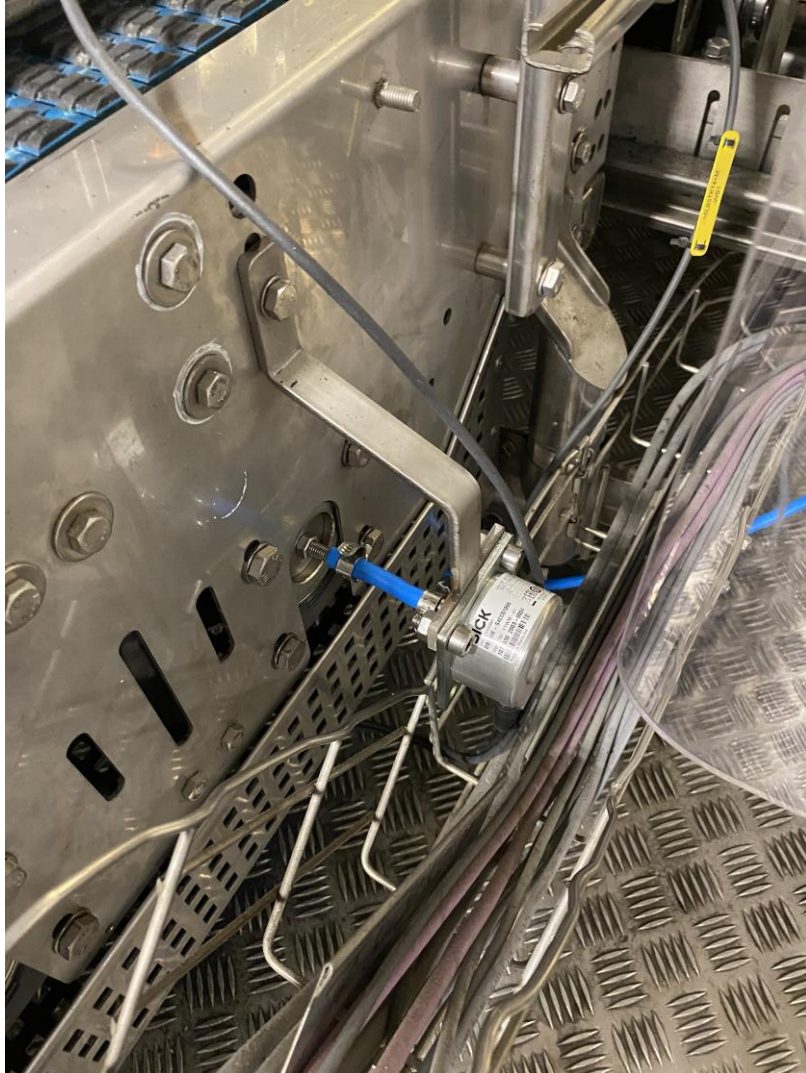


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INVISIPAC™ INSTALLATION PLACE ENCODER



**MOST PROFITABLE,
MOST RELIABLE**





QUESTIONS?

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