The melter flushing kit includes materials used to clean Nordson melters. Follow these procedures to clean your melter system.

**WARNING:** Risk of personal injury or equipment damage! Refer to the safety information provided in the melter manual before servicing the melter. Failure to comply with the safety information provided can result in personal injury, including death.

**WARNING:** Wear the safety glasses, gloves and protective clothing provided in this kit when performing these procedures. Failure to do so could result in serious burns.

### Kit Components

- **Bucket with lid**
- **Type “R” fluid, 1 gal., P/N 270755**
- **HMC cleaner, P/N 1054189**
- **Cleaning cloth, pkg. 15 (reorder P/N 1054210, cs/1008 pc.)**
- **wooden scraper, P/N 1061074**
- **Safety glasses with shields, P/N 1072381**

### Flushing the Tank, Hose, and Gun

1. Drain adhesive from the tank. Refer to the melter manual for information about draining the tank.

2. Set the tank temperature to 14–19 °C (25–35 °F) above the recommended application temperature of the adhesive.

3. Fill the tank with R fluid. Use the soft bristle brush to apply R fluid to all interior surfaces of the tank.

   **CAUTION:** Do not use the brass bristle brush to clean the tank. The brass bristles will damage the PTFE coating.

4. Heat the R fluid until char and adhesive float to the top (2–12 hours). Use the wooden scraper to remove adhesive from the sides of the tank. Skim off the char and adhesive as they rise to the surface.

   **WARNING:** Risk of fire or explosion! Do not use C–2 cleaner inside the tank. HMC cleaner is solvent-based and could flash at temperatures above 65.5 °C (150 °F). The solvent in the cleaner may also be incompatible with some adhesives.

5. Place the bucket under the drain valve, open the drain valve, and drain the R fluid from the tank.

   **CAUTION:** Never run R fluid through the hoses. Doing so can result in damage to the hoses.

6. Wear the latex rubber gloves provided in the kit for protection. Use the HMC cleaner and cleaning cloths to clean the top of the tank and the exterior panels of the melter.

7. Fill the tank with fresh adhesive. Disconnect the gun(s) from the hose(s). Adjust the tank temperature to 14–27 °C (25–50 °F) below normal application temperature—the lowest temperature at which the adhesive can be pumped is desired.
Flushing the Tank, Hose and Gun, contd.

8. When the melter and hoses reach setpoint, position the hose(s) so that they are pointing into the bucket. Slowly start pumping adhesive through the hoses until clean, noncontaminated material flows. Use the hose straps for support if needed.

9. Turn off the pump and reconnect the gun(s). When the gun reaches setpoint, place an aluminum drain pan under the gun, start the pump, and open the gun. Keep the gun open until clean, noncontaminated material flows.

10. Replace all filters.

11. Refill the tank with fresh adhesive. Adjust the temperature of all heating zones to the adhesive vendor’s suggested application temperature. Restore the system to operation.

Tips for Preventing Char in Hot Melt Systems

• Maintain the operating temperature at the lowest possible setting to prevent degradation of adhesive. Discuss this with your material supplier.

• Store extra adhesive in a covered container to prevent contamination.

• Use a scoop to load material into the tank.

• Reduce the temperature of the system during periods of inactivity that are longer than one hour.

• Do not leave the system heated overnight or over the weekend if it is not in use. Turn the system off. Fill the tank to the recommended level shown in the melter manual.

• Use inline filters between the hose and gun to help prevent nozzle clogs.