Follow these instructions to replace the PCA board in the control box of a Fulfill retrofit or integrated melter.

**Fulfill® Integrated and Retrofit Melter PCA Service Kit - P/N 1096221**

**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.

**Required Tools:**
- Philips head screwdriver
- Flat blade screwdriver
- M3 Allen wrench

**Note:**
If your assembly does not include nylon spacers, you should retain and re-use the block you already have and not use the one included in the kit.

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**Retrofit Melter PCA Service Kit**

1. Disconnect and lock out power to the Fulfill retrofit control box.

4. Remove the 4 M3 socket screws and washers that secure the PCA board to the control box, and then remove the PCA.

**Note:** Take note of the transistor location for reassembly.

6. Install the new PCA board with the 4 M3 screws and lockwashers.

7. Secure the transistor to the heat sink with the philips head screw.

8. Connect the wiring to the new PCA board.

**Note:** Make sure that the ground strap eyelet is secured to the PCA board. The ground strap may be placed in any vacant COM port on the XT2 terminal block. Refer to the wiring diagram on the next page.

2. Remove the 4 screws that secure the top to the control box, and then remove the top.

5. Remove the philips head screw holding the transistor to the heat sink, and set aside.

9. Reinstall the lid onto the control box.

10. Resume normal operation.

Continue
Note: Ensure that the dipswitches are positioned correctly for the Retrofit melter.

Dipswitch #1: OFF
Dipswitch #2: ON
Remove the Existing PCA

1. Disconnect and lock out power to the melter.

2. See Figure 1. Open the control panel of the Fulfill melter.

3. Remove the upper hose/gun module to improve accessibility.

4. See Figure 2. Unplug the 10-position and 3-position terminal blocks from the PCA.

5. See Figure 3. Remove the ribbon cable from the PCA. Note the position of the cable for reassembly.

6. See Figure 4. Remove the two standoffs securing the amplifier bracket to the PCA.

7. See Figure 5. Remove the power connector.

8. See Figure 6. Remove the screw from the transistor that secures the PCA to the melter. This screw must be removed in addition to the four hex head screws.

9. Remove the 4 hex head screws securing the PCA to the melter with a 6 mm hex wrench.

10. Remove the PCA.
Install the New PCA

Install the new PCA by following the steps for removal in reverse order. Note the following:

**Note:** When installing the amplifier bracket, insert the screw at the end of the bracket first.

**Note:** If the 10-position terminal block does not want to plug into XT2, remove the tab on the plug.

**Note:** Observe the position of the ribbon cable. The black strip in the ribbon should be on the right side when installing the cable to the new PCA.

**Note:** The transistor is attached to the PCA. The screw installed through the transistor secures it to the lid for heat sinking and the PCA to secure the PCA to the Fulfill Integrated system prior to installing the four hex head screws.

**Note:** Ensure that the dip switch settings are positioned correctly for the integrated melter.

Dipswitch #1: ON
Dipswitch #2: ON