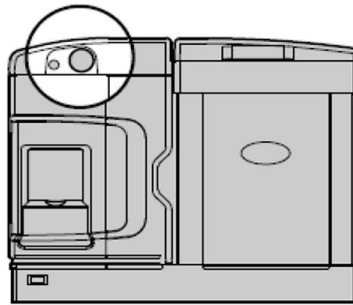




How to Purge and Clean the Hot Melt System

Instructions for purging the hot melt tank of old glue.

Written By: Wexxar WISE Admin



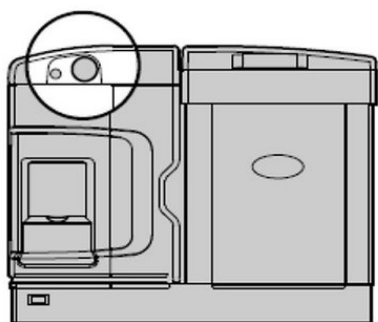
**Pressure regulator and
adjustment screw**

(Image source: Nordson Corporation)

INTRODUCTION

The hot melt system needs to be purged of glue and cleaned every 6 months. You will need a flushing agent and cleaner. There are various cleaners that you can use; however, paraffin wax is cost effective and readily available in most hardware stores.

Step 1 — Decrease the Air Pressure



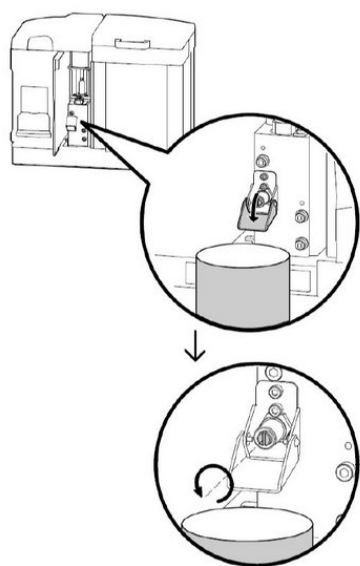
**Pressure regulator and
adjustment screw**

(Image source: Nordson Corporation)

⚠ The hot melt system must remain on during this entire procedure. We recommend that you wear personal protection equipment and use extreme caution while performing this procedure.

- Lower the glue pump's air pressure to 0 psi by using a 5 mm hex wrench to turn the pressure adjustment screw counterclockwise until it stops.

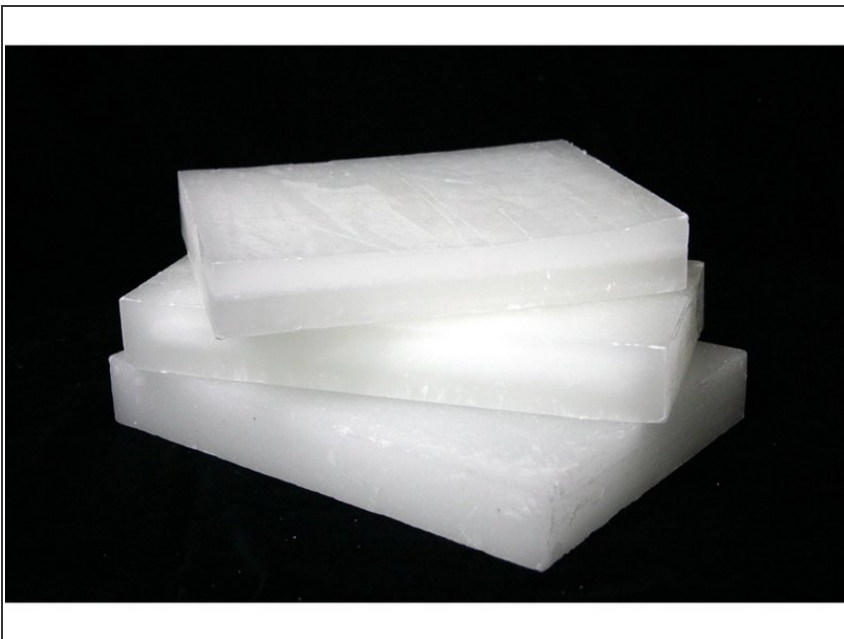
Step 2 — Purge the Hot Melt System



Lowering the drain chute and opening the drain valve
(Image source: Nordson Corporation)

- Lower the drain chute and place a suitable container under the drain valve.
- Open the drain valve until a steady flow of glue starts pouring into the container.
- When the glue flow starts to lessen, increase the glue pump's air pressure to 10 psi.
- When the tank is empty, decrease the glue pump's air pressure to 0 and close the drain valve. The tank is ready for cleaning.

Step 3 — Melt the Paraffin Wax



- Disconnect the hoses from the glue heads, but leave them connected electrically.
- Place several blocks of paraffin wax into the hot melt tank and allow them to melt.
- Increase the glue pump's air pressure to 10 psi.
- Place the hose ends into a disposable container.

Step 4 — Pump the Wax

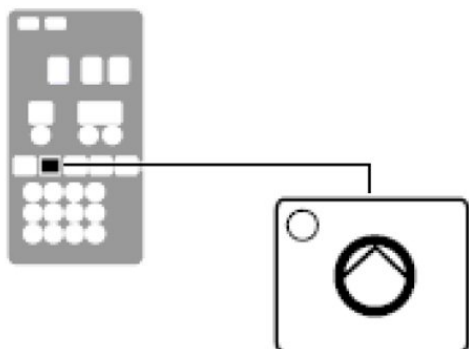


Figure 5-3: Pump Button

(Image source: Nordson Corporation)

- On the hot melt control panel, press the **Pump** button to turn on the glue pump. The melted wax and glue residue is pumped through the hoses and into the container. Add more wax if necessary.
- Once all of the melted wax has passed through the glue hoses, turn off the pump by pressing the **Pump** button.
- Replace the tank filter with a new one. (Refer to the attached Nordson documentation for instructions.)
- Fill the tank with glue. Once the glue is melted, increase the glue pump air pressure to 30 psi and turn on the pump by pressing **Pump**.
- Pump approximately half a tank of glue through the hoses and then shut off the pump by pressing **Pump** again.

Step 5 — Restore the Hot Melt System



- Reattach the glue hoses to the glue heads.
- Remove the glue nozzles. Turn on the glue pump by pressing **Pump**. Using the manual override on the glue valve (solenoid), purge glue through the glue head until new, clean glue is extruded.
- Replace the glue nozzles with new ones, if necessary.
- Refill the hot melt tank and return the system to all original settings.

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