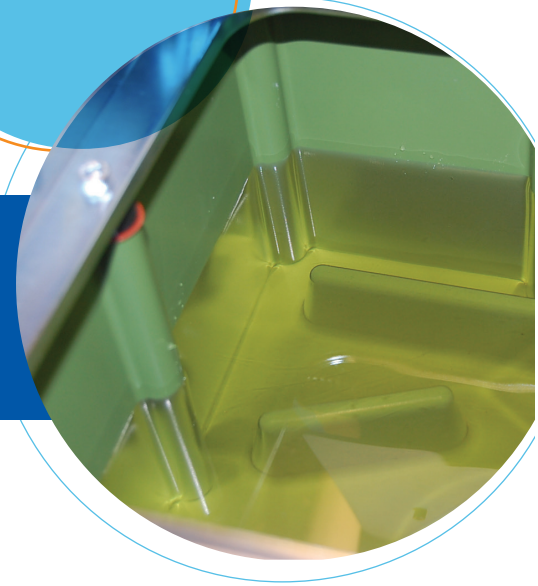




Hot Melt Changeover Procedure



Follow these recommended guidelines when line operators need to replace the hot melt within a tank with a new hot melt product. Be sure line operators use proper safety equipment when conducting the adhesive changeover.

CONVENTIONAL (350°F) TO CONVENTIONAL (350°F)

Use these 8 steps when replacing a hot melt adhesive applied at 350°F with a hot melt adhesive also applied at 350°F.

- 1 **Record current glue pot settings** (temperatures, pressure, nozzle size).
- 2 **Drain the adhesive reservoir** through the backflush drain port.
- 3 **Remove any sludge or char** from the bottom of the tank with a non-abrasive scraper, then wipe out excess adhesive with a rag.
- 4 **Depressurize the system, then remove the pump filter** and determine if it needs to be replaced. Check any inline filters, too.
- 5 **Melt five pounds of new material** in the reservoir and drain through the backflush drain port.
- 6 **Fill the reservoir** to an appropriate level with the new material and allow it to melt for 45 minutes – 1 hour.
- 7 **Purge all hoses** well with any inline filters removed from the guns, or the hoses removed from the heads. Run a minimum of five pounds of adhesive per eight feet of hose until no more char comes out of the system. Replace the filters/hoses and purge a small amount through the guns with the nozzles removed.
- 8 **Begin running** and optimizing the application.

CONVENTIONAL (350°F) TO LOW APPLICATION TEMPERATURE (275°F)

Use these 9 steps when replacing a hot melt adhesive applied at 350°F with a hot melt adhesive applied at a low application temperature at or around 275°F.

- 1 **Record current glue pot settings** (temperatures, pressure, nozzle size).
- 2 **Drain the adhesive reservoir** through the backflush drain port.
- 3 **Remove any sludge or char** from the bottom of the tank with a nonabrasive scraper, then wipe out excess adhesive with a rag.
- 4 **Depressurize the system, then remove the pump filter** and determine if it needs to be replaced. Check any inline filters, too.
- 5 **Reduce the POT TEMP ONLY** to the application temperature of the new adhesive. Do not reduce the hose and gun temperatures. Melt a few pounds of new hot melt material in the reservoir and drain through the backflush drain port.
- 6 **Fill the reservoir** to an appropriate level with the new material and allow it to melt.
- 7 **Purge all hoses** well with any inline filters removed from the guns, or the hoses removed from the heads. Run a minimum of five pounds of adhesive per eight feet of hose until no more char comes out of the system. Replace the filters/hoses and purge a small amount through the guns with the nozzles removed.
- 8 **Reduce the temperature** of the hoses and guns to the desired application temperature.
- 9 **Begin running** and optimizing the application.

LOW APPLICATION TEMPERATURE (275°F) TO CONVENTIONAL (350°F)

Use these 8 steps when replacing a hot melt adhesive applied at low application temperature at or around 275°F with a hot melt adhesive applied at 350°F.

- 1 **Record current glue pot settings** (temperatures, pressure, nozzle size).
- 2 **Drain the adhesive reservoir** through the backflush drain port.
- 3 **Remove any sludge or char** from the bottom of the tank with a nonabrasive scraper, then wipe out excess adhesive with a rag.
- 4 **Depressurize the system, then remove the pump filter** and determine if it needs to be replaced. Check any inline filters, too.
- 5 **Raise the temperature of all components** to the specified setting. Melt a few pounds of new hot melt material in the reservoir and drain through the backflush drain port.
- 6 **Fill the reservoir** with the new material and allow it to melt.
- 7 **Purge all hoses** well with any inline filters removed from the guns, or the hoses removed from the heads. Run a minimum of five pounds of adhesive per eight feet of hose until no more char comes out of the system. Replace the filters/hoses and purge a small amount through the guns with the nozzles removed.
- 8 **Begin running** and optimizing the application.