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## LPMS Melt Tank Maintenance Instruction

**\*\*Always wear protective gears to prevent burns\*\***

Cleaning the melt tank is critical for successful operations. It is recommended to be done every 80-300 hours of heat cycles (depending on the consumption of materials. Higher consumption will decrease the interval). This is a manual operation and is carried out in manual mode as follows:

1. Set up purge pan to catch all the unwanted materials. Go to manual mode and purge materials out from the tank.
2. Remove and/or change screen on melting unit.
  - o Screen can be recovered by soaking in alcohol solvents such as toluene, denatured alcohol, or acetone.
  - o Screen can also be recovered by carefully removing the char and hot melt from the unit in a laboratory ceramic furnace or with a handheld propane torch.
3. Scrape down inside of melting unit and fins with wooden paint sticks to remove char and darkened material.
  - o The melting unit has a protective coating that will be scratched if metal tools are used to scrape the degraded material.
4. Flush unit with 5 lbs (enough material to cover grid in melting unit) of Omega Purging Resin—**Spectra-Melt Omega Purge 200** for tanks used **below 185C** or **Spectra-Melt Omega Purge 225** for tanks used **above 185C**. Material will be provided by LPMS upon request.
  - o Material should be melted completely and allowed to sit at 185C for SM 200 or 200C for SM 225 for 30 minutes prior to flushing through entire system using injection feature in the manual mode.
    - i. Repeat this process until clear, amber material dispenses without char particles present
    - ii. **This process should be performed every time when switching from carbon black colored material to the translucent amber.**

### USE OF Epsilon WAX CLEANER:

5. Use of the Epsilon wax cleaner is a process that will only be used when purging with hot melt will not clean system.
  - o Wax polyamide cleaning material is available from LPMS-USA.
  - o System should be completely purged of all hot melt.
  - o System should be scraped down and purged at least one time with the Spectra-Melt Omega Purge 200 material.
  - o Add the Epsilon wax to a level above the melt grid.
  - o Heat to 170C and leave melt unit lid tightly shut as the wax will give off an oily odor.
  - o Once empty, add and purge approximately 5 lbs of the next hot melt to be used.