



Compendium for **Cleaning of BÜHNEN Melters**

for EVA, PO, PA and PSA hot-melt adhesives



Instructions manual in 6 steps



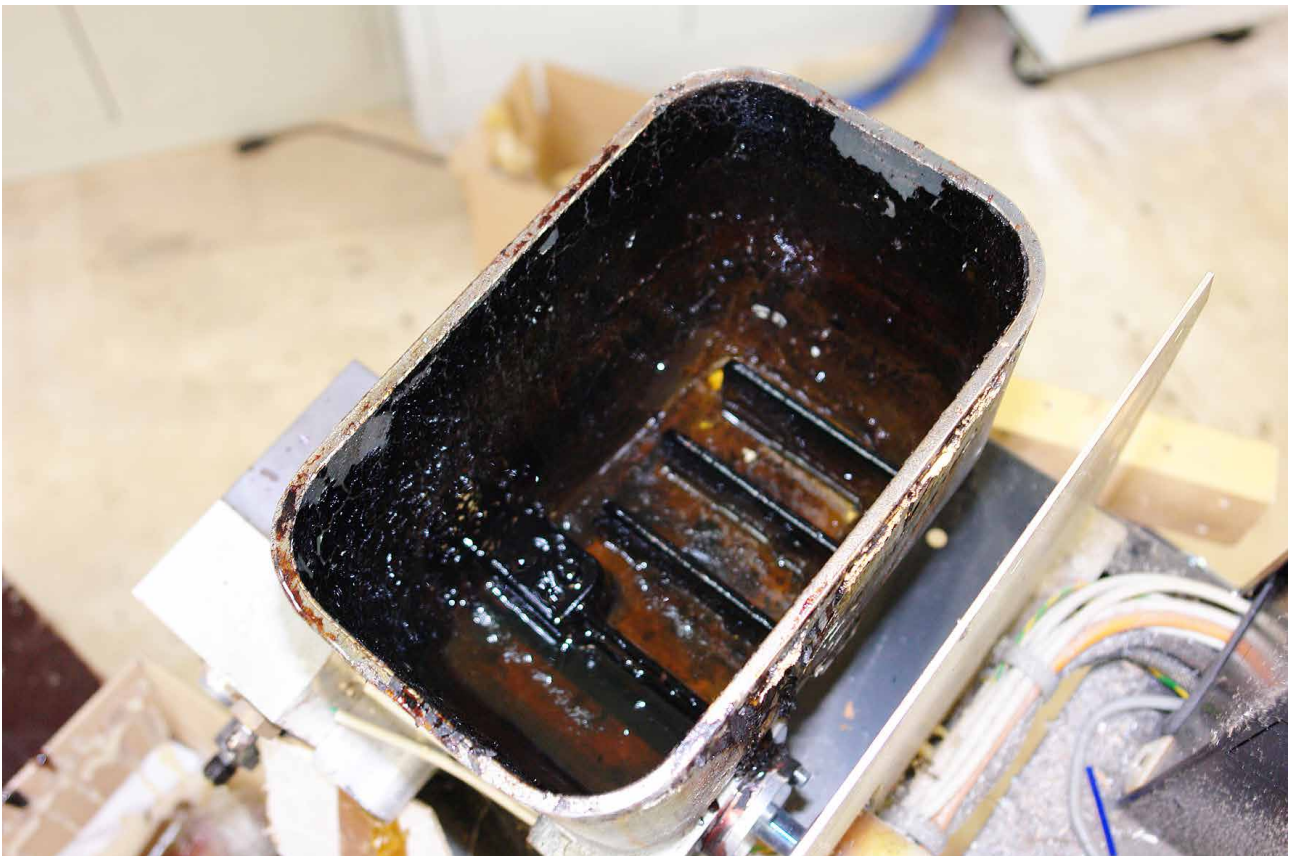
Step 1: Run empty the melt tank

- “Switch off” the pump switch on the heated device or disconnect the melter from the compressed air system.
- Place a suitable collecting container under the application heads / hand guns.
- Activate the solenoid valves on the application heads.
- Mechanically separate the heating hoses and application heads / hand guns from the melter. All elements to be separated must be hot to avoid damage.

Attention: Risk of burns!

This measure prevents the contaminated hot-melt adhesive from flowing through the heating hoses and application heads / hand guns and also contaminating these.

- Remove the hot-melt adhesive that is still in the melt tank. It should be noted that a small amount of hot-melt adhesive must remain in the tank so that the gear pump or piston pump does not run dry.
- Where this is available, the hot-melt adhesive is drained off into a suitable collecting container via a “quick drain valve”.
- Otherwise, activate the pump switch and drain the hot-melt adhesive into a suitable collecting container at low speed or low pump pressure.





Step 2: Mechanical cleaning of the melt tank

- Mechanically clean the inside of the tank using a suitable plastic or wooden spatula.
- Larger encrusted or burnt hot-melt adhesive residues should not be conveyed by the gear pump or piston pump, but removed from the tank using the spatula.
- The non-stick coating of coated melt tanks may not be damaged!
- In the case of coated melt tanks, the hot-melt adhesive can usually be easily peeled manually from the tank walls. To do this, the melter must be heated to approx. 60 °C. Wear protective gloves!
- Remove contaminated hot-melt adhesive residues from the melt tank.





Step 3: Change the filter cartridge

- The filter cartridge should **always** be changed after mechanical tank cleaning.
- To do this, remove the filter cartridge from the device according to the type of device. This may only be carried out when the melting tank is empty and the pump system is switched off.
- The contaminated filter cartridge must be disposed of properly in accordance with statutory regulations.





Step 4: Fill the melting tank with BÜHNEN *avenia* B41577.2

- Fill the melting tank approx. $\frac{3}{4}$ full and melt completely.
- Clean the inside of the tank again manually using a suitable plastic or wooden spatula.





Step 5: Let BÜHNEN *avenia* 41577.2 drain out of the tank

- Let the BÜHNEN *avenia* drain out through the “quick drain valve” (if available).
- Alternatively, the pump switch / compressed air is activated, so that the cleaner flows through the gear pump / piston pump.
- In addition, the filter chamber must be flushed without the filter cartridge until the cleaning fluid runs clear.
- Only then a **new** filter cartridge is to be inserted.
- After this, fill approx. $\frac{1}{4}$ of the melting tank again with BÜHNEN *avenia*, connect



the heatable hose and flush.

- Then connect the application head / hand gun and flush through.
- Finally, the hot-melt adhesive used for production is poured into the melting tank. This is rinsed with the adhesive until no more cleaner flows out of the application head / hand gun.



Step 6: Overview BÜHNEN products for rinsing and cleaning

Melt tank rinsing

B41577.2 - Mode of action: Heat the detergent (displacer) for hot-melt adhesive until the adhesive has completely melted – if possible up to 180 °C. Leave to cool down overnight and then heat the tank again to remove any residues from the tank wall.

- Softening point (SP) = 108 °C
- Viscosity at 170 °C = 1.200 mPas
- Processing temperature (PT) = 150 -180 °C

Cleaning outside of housing

F93492 – Mode of action: Cold cleaner for adhesive residues, good surface compatibility.

- Cold cleaner on the basis of orange terpenes
 - Liquid viscosity = approx. 1 mPas at 20 °C
 - Must be labelled, flammable (**flash point approx. 50 °C**)
- Important: Keep away from sources of ignition! Under no circumstances may hot objects or electrical connections be brought into contact with the cleaner! Observe the safety data sheet!**

F93567 – Mode of action: Cold cleaner for adhesive residues

- Non-labelled cold cleaner
- Liquid viscosity = approx. 1 mPas at 20 °C
- No labelling required, flammable (flash point approx. 65 °C)

Important: Keep away from sources of ignition! Under no circumstances may hot objects or electrical connections be brought into contact with the cleaner!

Can attack sensitive surfaces, e.g. Plexiglas (acrylic glass), PC, lacquer or rubber. Before using, check the surface compatibility in an inconspicuous place!



Safety measures

- The cleaning measures may only be carried out by qualified personnel.
- Standard-compliant protective clothing must be worn for working on hot and sometimes pressurised devices.
- It may be necessary to ensure adequate ventilation.
- The hot-melt adhesive residues and cleaner arising during the cleaning must be disposed of in accordance with statutory requirements.
- When disposing of these substances, the safety instructions and specifications in the safety data sheets supplied by BÜHNEN must always be observed.

We will be happy to assist you with any further questions you may have!
Write to us (service@buehnen.de) or give us a call on: +49(0)421-5120-243

All information given here is based on our many years of experience and was compiled to the best of our knowledge and belief.

These are **general instructions** for cleaning melters. We point out that, in individual cases and depending on the type of melting devices and the hot-melt adhesive used, other procedures may be necessary. We, together with our technicians, will be happy to provide you with advice and assistance as required.

We cannot, therefore, assume any liability for damage caused by the procedure for cleaning melters described above, unless, in individual cases, you have previously agreed the procedure with us.

The general terms and conditions of Bühnen GmbH & Co KG apply.