

Technogram 4

This is a series of Industrial Information Sheets relating to Hot Adhesive and Machines associated with applying it.

The following information relates to the Pro Built Melters, the Nordson 3000 Series, Nordson ProBlue Series, Robatech MPCs and Concepts with 14:1 and 21:1 pumps

Changing the In-Line Filter 100 Mesh (Old Style): Part No – 6613
This Filter is fitted between the Hose and the Gun

Hot Adhesive Systems are equipped with an In-Line Filter. The filter prevents contaminants and char from entering the hoses or the extrusion guns.

The In-Line Filter **MUST** be changed on a regular basis.

A contaminated In-Line Filter will cause in-line filter blockages, poor adhesive flow, blocked nozzles and production loss.

The **CORRECT** Procedure to change an In-Line Filter is as follows:

1. WEAR safety gloves
2. WEAR safety eye wear, clothing covering exposed skin & safety footwear
3. REDUCE pump air pressure to “0 PSI “
4. OPEN drain valve over a suitable container. Unscrew in a counter clockwise direction
5. INCREASE the pump air pressure until a clean and steady flow of hot material flows from the drain valve.
6. Reduce pump pressure to Zero. Lock out air supply. Leave drain valve open.
7. Using a 22mm and a ¾ inch spanner undo in line Filter Fitting.
8. Remove Old Filter from the ¾ inch (Hose End), a small screw driver will help here.
9. Fit new filter (Part No – 6613) and tighten, if filter assembly is loose on the Gun tighten locking nut using 11/16 inch spanner.
10. After In-Line Filter Change is completed, CLOSE drain valve in a clockwise direction.



11. Slowly INCREASE pump air pressure and CHECK for leaks. If leak occurs from gun end between the filter and the gun. The filter “O” Ring (Part No – 6906) may be faulty. Replace O-Ring but go back to steps 1 through to 6.

Filters per pack of ten, 100 mesh.	Part No - 6613
Complete Filter Assembly Straight.	Part No - 6501
Complete Filter Assembly, 45 deg.	Part No - 6504
Complete Filter Assembly, 90 deg.	Part No - 6507

TIPS

- Spanners ¾, 11/16 and 22mm can be bought from Super Cheap. Cut these spanners in half (150mm is a good length).
- Grind the Jaws of the 11/16 spanner to a thickness of 5mm (this will make it easy to tighten filter lock nut.)
- Be sure to grease O-ring

