



# Horrods

70 years of engineering excellence

## Operating Instructions



**1.5 Drum 3-Phase 415 Volts 32 Amps**

**Hot Rubber Melters**

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## **I n t r o d u c t i o n**

**Thank you for choosing to purchase a new W.J. Horrod Ltd 3-Phase Hot Rubber Melter**

**All our products are made to a very high, and recognised engineering standard, and if used correctly by a trained, certificated operative, to our operating and maintenance instructions, will increase the machines longevity.**

**Operatives must always read the manufacturers operating instructions before attempting to use the machine.**

**No attempt must be made to carry out any repairs or maintenance whilst equipment is in operation. Safe working practise is a legal requirement and must always be adhered to. Protective clothing should always be worn when operating this equipment.**

**Faulty equipment should be immediately shut down, and reported directly to the supervisor/person in charge, and not used again until the fault has been rectified.**

### **PLEASE NOTE**

**This unit was manufactured for use with rubberised materials only. Using any other material goes against its intended use.**

***Using this unit for any other material is done so at your own risk, and could nullify the manufacturer's warranty.***

## **I m p o r t a n t I n f o r m a t i o n**

- 1] **Never attempt to operate the Melter before carefully reading the following operating instructions, and having been instructed to do so by a qualified person.**
- 2] **Always check the power connection lead for damage and wear – POWER LEAD MUST NOT BE ANY LONGER THAN THE SUPPLIED 20 METRES.**
- 3] **Important when adding material please ensure that the stirrer is NOT moving and are always stopped in the centre of the pan i.e., vertical to the shaft, once material is added close the lids and re-engage the stirrer.**
- 4] **Never carry out any repairs or servicing before the machine is shut down with the motor stopped, electric disconnected and the machine is allowed to go cold.**
- 5] **When faults are discovered the Melter should be shut down immediately, then reported to the person directly responsible. The Melter should on no account be used again till all faults have been corrected.**
- 6] **Never operate the Melter with safety guards or covers removed.**
- 7] **Always carry out oil level checks on the gearbox when Melter is cold, before starting work. Never attempt to fill oil level while the Melter is running. Carry out all lubrications and checks at the same time – using correct lubrication.**
- 8] **The machine should never under any circumstances be left unattended when being used.**
- 9] **Care should be taken when using scrapers, trowels and re-bar, if these items are dropped into the Melter it will JAM the stirrer, which in turn will burn out the electric motor/gearbox.**
- 10] **Please check at the start of the day that there is no water in the pan, if any water is present it should be removed before loading the machine. Likewise, the material should also be checked and cleared of any water before it is loaded.**
- 11] **Material MUST always be covering THE THERMOSTAT CAPILLARY sensor tube to avoid over heating of the material which can cause the material to flash and catch alight.**
- 12] **Melter must be used outside only**

## **Useful Operating Information and Advice:**

**1] Never leave material in the machine unless;**

**A] It is unavoidable due to circumstances beyond your control – i.e., weather conditions or the area of intended use is not ready.**

**B] Material is going to be used the following day.**

**We recommend this for the following reasons;**

**When a large volume of the material is allowed to go cold, the time required to re-heat this now solid lump is increased. It is essential to ensure it is heated slowly into a fluid state prior to agitation.**

**Material heated up too quickly may cause a layer of built up burned material on the bottom of the pan which will jam the stirrer.**

## **M e l t e r   S t a r t   U p :**

- 1] Plug female 3-pin neutral and earth power lead into the machine control panel, which is a male 3 pin neutral and earth.**
- 2] Plug the other end of the lead which is a 3-pin male neutral and earth into your power source.**
- 3] Switch on the power supply at source.**
- 4] Open the control panel cabinet.**
- 5] Turn isolator switch to 'on' position – red beacon located on top of control panel will now flash to indicate the power is on.**
- 6] Load the material into the Melter, ensuring as much material is in contact with pan as possible.**
- 7] Press GREEN heater on button – once the material show signs of melting, press Green stirrer start button.**
- 8] Should the stirrer motor trip out for any reason, press the YELLOW stirrer reset button to restart. Should this problem persist the fault should be reported.**
- 9] Should heater element trip out for any reason press the YELLOW heater reset button to restart. Should this problem persist the fault should be reported.**

## **Temperature Controller :**

To set the required material temperature, press the 'UP/DOWN' button on the digital controller. The controller will only go up to a maximum of 190°C.

We recommend a set temperature of 180°C.

## **Electric Motor / Gearbox :**

Power – 3 Phase 415 volts.

## **Working temperature :**

160°C – 190°C – We recommend 180°C

This is based on the information available at the time of writing. However, this may vary depending on the material manufacturer. Always check the manufacturers guidelines and instructions when using these materials.

## **Expansion :**

Material expansion is approximately 25% at working temperature **NEVER OVERFILL.**

## **Agitation of Material :**

**ONLY** agitate once the material starts to **MELT** and the stirrer will operate, be very careful at first, as un-melted material may be present. **NEVER** force the Melter if the stirrer is stuck, this will only result in damage to drive arm etc.

**IMPORTANT** – when adding material full-face visors must be worn, and the stirrer must be stopped in the centre of the pan. Once the material is added, close the lids and restart the stirrer.

## **C l o s i n g M e l t e r D o w n :**

- 1] Press RED heater off button.**
- 2] Press RED stirrer off button ensuring stirrer is left centre of the pan.**
- 3] Switch Isolator to the off position.**
- 4] Switch power supply off at source.**
- 5] Disconnect power cable:**
- 6] Store power cable in a safe and dry place.**



## **H e a l t h   &   S a f e t y :**

- 1] Equipment should only be used by a trained, certified operative.**
- 2] Lids must be closed at all times whilst the stirrer is engaged.**
- 3] Protective clothing and full-face mask should always be worn when operating or loading Melter.**
- 4] Never leave equipment unattended when in use.**
- 5] If a fault occurs, shut down the equipment immediately and report the fault to the person directly responsible.**
- 6] Always completely shut down the Melter and disconnect from all power supplies, allowing the Melter to cool before attempting any maintenance.**
- 7] When the Melter is being used where the general public may come into contact 'HOT SURFACE' warning signs should be posted on and around the Melter, and enclosed with protective fencing.**
- 8] Melters fitted with lifting eyes should always have examination certificates showing eyebolts have been inspected.**
- 9] All Melters require a current PAT test certificate.**
- 10] Last, but not least, always remember that safety is everyone's responsibility, never do anything that is likely to put yourself or anybody else at risk.**

Regulators must be marked BS:3016 or BS: EN:12864 or BS: EN:16129. Any regulator marked BS:3016 will be over 10 years old and should be replaced.

Use only certified hoses to BS:3212 or BS: EN:1763-1 or BS: EN:16436-1 which bear the year and name of manufacturer or stainless-steel convoluted hoses marked EN:10380 as LPG attacks and erodes natural rubber.

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