MT-CL 740 RedFlush — Red Tracer PUR Flushing User Guide

This step-by-step user guide instructs machine operators on safely purging, protecting, and neutralizing reactive PUR hot melt applicator systems using MT-CL 740 RedFlush with visual color tracer confirmation.

100 – 140 °C	80 ± 10 °C	Vibrant Red	20,000 mPa·s
Processing Temperature	Softening / Melting Point	Visual Tracer Indicator	Melt Flushing Viscosity

CRITICAL GOLDEN RULE: ALL TRACES OF RED MUST VANISH BEFORE PRODUCTION!

Before commencing active production with fresh reactive PUR hot melt, continue extruding adhesive until all visible traces of red color vanish completely. Any residual flushing wax left in the applicator will delay or inhibit the moisture-curing process of the adhesive.

STEP-BY-STEP RED TRACER FLUSHING WORKFLOW (6 PHASES)

1

STEP 1: DRAIN RESIDUAL PUR ADHESIVE COMPLETELY FROM TANK

Run the applicator pump and extrude all remaining reactive PUR adhesive from the melt tank and hoses until the system is completely empty.

Important: Do not load flushing wax over bulk molten PUR adhesive.

2

STEP 2: ADJUST OPERATING TEMPERATURE TO 100 – 140 °C

Set tank and hose heating zones to 100 – 140 °C (ideally 120 – 130 °C). Confirm temperatures on the machine control console.

3

STEP 3: LOAD RED MT-CL 740 REDFLUSH WAX INTO TANK

Load red MT-CL 740 blocks or granules into the melter reservoir. The product begins softening at ~80 °C and melts smoothly into a homogeneous, bright red purging liquid at 120 °C.

Dosage: Add sufficient cleaner to fill melter, hose lines, and nozzles (~1 – 3 kg).

4

STEP 4: RUN RED FLUSH THROUGH HOSES & NOZZLES (VISUAL TRACER)

Start the pump and circulate the red molten cleaner through hoses and application heads. When bright red liquid begins discharging from the nozzle, it confirms that all old PUR is purged and the system is filled with cleaner.

Indicator: Discharge of pure red color confirms the system is fully passivated.

5

STEP 5: MACHINE SHUTDOWN & STANDSTILL PRESERVATION

If shutting down for the weekend or holidays, turn off heaters with the system filled with red wax. Solidified cleaner insulates hoses and nozzles against atmospheric moisture 100%.

6

STEP 6: RELOAD PUR & VERIFY COMPLETE CLEANER EVACUATION

Upon restarting, heat the system, load fresh reactive PUR adhesive, and pump through. Once the extruded adhesive transitions completely from red to natural PUR color, flushing is 100% complete and production may proceed.

Ready: Zero nozzle clogs, zero gelling risk, and high-strength bonding guaranteed.

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WHEN TO APPLY? — PURGING SCHEDULE & MAINTENANCE MATRIX

Operating Scenario	Operator Action & Protocol	Technical Advantage Achieved
Weekend / Holiday Shutdowns	Drain PUR, flush and fill system with red wax, then power down.	Prevents internal moisture curing; guarantees effortless Monday start.
Adhesive Grade / Color Change	Circulate red wax for 15 min, purge out, then load fresh adhesive.	Eliminates cross-contamination and color streaking in fresh bonds.
Periodic Melter & Hose Purge	Monthly deep flush with MT-CL 740 to clear encrusted deposits.	Multiplies gear pump and filter life; eliminates nozzle clogs.
Unscheduled Extended Line Stoppage	Immediately pump MT-CL 740 through before lines seize up.	Neutralizes free isocyanates, preventing catastrophic hose seizing.

OPERATOR CHECKLIST: CRITICAL DOs AND ABSOLUTE DONTs

MANDATORY PROCEDURES (DOs)

- Melt and pump MT-CL 740 within the 100 – 140 °C operating temperature range.
- Visually verify that pure red color discharges from nozzles to confirm line protection.
- When resuming production, extrude fresh PUR until all traces of red color vanish completely.
- Scrape warm cleaner residues from the tank using a soft teflon scraper.
- Always wear EN 407 certified heat-resistant safety gloves during hot purging operations.

ABSOLUTE PROHIBITIONS (DONTs)

- NEVER commence production bonding while red color traces are still visible in the adhesive!
- NEVER load flushing wax into a tank filled with bulk adhesive (Drain PUR first!).
- NEVER use sharp metal knives, chisels, or wire brushes to scrape tank walls!
- NEVER use MT-CL 740 flushing wax as a bonding adhesive in production.
- NEVER add thinners or solvents into MT-CL 740 to reduce melt viscosity.

TROUBLESHOOTING & FAST OPERATOR INTERVENTION

Observed Condition	Probable Root Cause	Immediate Operator Action
No red wax discharges from nozzle	Clogged nozzle or temperature too low	Verify temperatures (120–130 °C); increase pump pressure gradually.
Red streaks visible in new adhesive	Purge cycle terminated prematurely	Continue pumping fresh PUR until adhesive is 100% natural color.
Fresh PUR exhibits weak bond strength	Residual flushing wax left in line	Flush lines with fresh PUR for 5 more minutes to completely expel wax.
Wax melts very slowly in tank	Tank temperature below 100 °C	Check heating elements; raise temperature setpoint to 125 °C.

OCCUPATIONAL HEALTH, SAFETY & PPE OPERATING GUIDELINES

- Thermal Protective Gloves (EN 407): Wear heat-resistant safety gloves to protect against 100–140 °C molten cleaner.
- Eye & Face Protection (EN 166): Wear safety glasses with side shields to guard against hot melt splatters.
- Eco & Waste Disposal: Discharged solidified red flushing wax is non-hazardous solid polymer waste (EWC 08 04 10). Dispose per local regulations.

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Critical Rule: Cleaner must be completely evacuated before reloading fresh PUR!