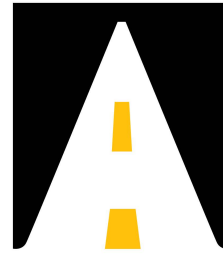


FASTMELT 650

QUICKSTART GUIDE



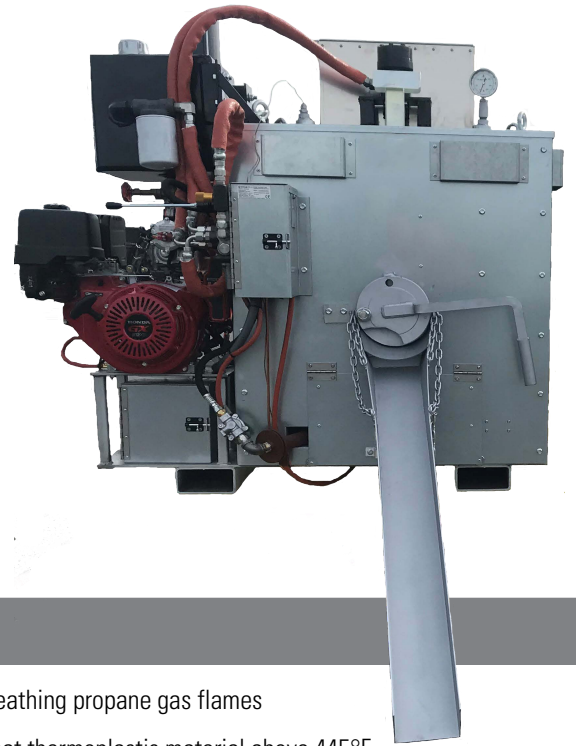
ADVANCED STRIPING EQUIPMENT

PURPOSE

The FastMelt 650 is a completely self-contained thermo-plastic melting system that holds 650 lbs. of material.

It's one of the most versatile/efficient supply systems with the ability to be placed in the back of a pickup, flat-bed truck, or a work trailer for easy transport.

Compatible with any Thermomark applicator and most competitive models.



SAFETY

- ▶ Wear protective gloves, clothing, and face shield at all times
- ▶ Check all connections and ensure there are no gas leaks Do
- ▶ not leave kettle unattended when lit
- ▶ In case of molten thermoplastic burns, submerge in cold water and seek immediate medical aid. Do not attempt to remove thermoplastic from skin.
- ▶ Avoid breathing propane gas flames
- ▶ Never heat thermoplastic material above 445°F
- ▶ Do not over-fill kettle

MAINTENANCE

Follow the appropriate steps below to properly maintain the system.

DAILY MAINTENANCE

- 1 Check hydraulic oil level.
 - 2 Check that hydraulic shut-off valve is open.
 - 3 Check propane lines.
 - 4 Check hydraulic lines for leaks and hose deterioration.
 - 5 Check engine oil level.
 - 6 Check propane tank condition.
- ▶ Tanks should be leak-free and rust-free.

BI-ANNUAL MAINTENANCE (Every 6 Months)

- 1 Remove and replace hydraulic filter

WEEKLY MAINTENANCE

- 1 Grease shaft bearing with lubriplate AC-2A, Enco Andock B or equivalent.
- 2 Change engine oil at least every 24 hours of operation, and maintain oil change records.
- 3 Check material and oil temperature gauges with a long stem, high-temperature thermometer. Calibrate gauges when necessary.
- 4 Check interior of kettle and remove excessive resin buildup, particularly inside kettle top.

ANNUAL MAINTENANCE (Every Year)

- 1 Replace hydraulic fluid with #46 or equivalent.



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QUICK START CHECKLIST

PRE START

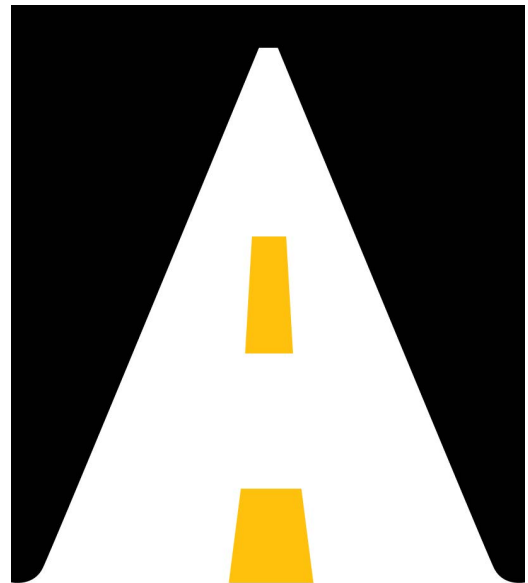
- 1 Ensure material slide gate is closed and open burner access door
- 2 Set Thermostat to **OFF**
- 3 Add 3 - 4 Bags of material to kettle if needed
- 4 Fully Open LP tank valve
- 5 Open main system propane valve
- 6 Check hydraulic bypass valves:
Left Valve **(A)** Open
Right Valve **(B)** Closed
- 7 Place agitation direction lever in the neutral (middle) position

SYSTEM STARTUP

- 8 Start engine
- 9 Ignite Pilot:
 - 1) Press and hold **RED** pilot button and **BLACK** igniter button at the same time
 - 2) Release **BLACK** igniter button upon successful pilot light
 - 3) Continue to press **RED** pilot button until pilot flame is achieved
 - 4) If flame goes out or unsuccessfully lights, wait 30 - 60 seconds and try again
- 10 Set thermostat to 300°F
- 11 Adjust oxygen relay disc if needed, otherwise close burner access door
- 12 Wait for material to reach 250°F - 300°F
- 13 Toggle agitation direction lever to begin agitation (either up or down).
Note: If material is too thick, wait before enabling agitation.
- 14 Set desired agitation speed by adjusting the Cycle Speed control dial.
- 15 Set thermostat to desired temperature of 380°F - 400°F
- 16 Add additional material if needed
- 17 Install material extrusion chute, then check material consistency
- 18 Move applicator (handliner) into position

SHUTDOWN

- 1 Set thermostat to **OFF** and make sure the flame goes out
- 2 Drain material in the kettle into draw-off pans until either 25% full or completely empty.
- 3 If leaving material for next day, adjust the Speed Cycle dial to a "slow" setting until temperature reaches 150° F
- 4 Set agitation direction lever to the neutral (middle) position
- 5 Turn engine key to **OFF** position
- 6 Close main system propane valve and close 100lb LPG tank valve
- 7 Make sure the material feed hopper door is closed



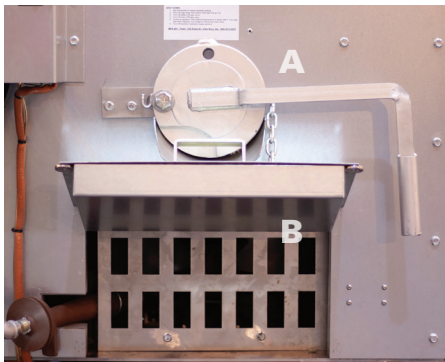
ADVANCED STRIPING EQUIPMENT

QUICK START INSTRUCTIONS

PRE START

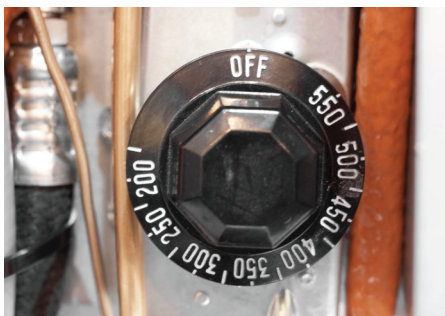
STEP 1

- A)** Ensure the material discharge valve (slide gate) is closed.
- B)** Open the burner access door and latch chain to hold access door open.



STEP 2

Open thermostat door and make sure thermostat knob is at lowest position possible.



STEP 3

Check the material level of the kettle and add more as needed up to 25% of the kettle. If empty, add 3-4 (50lb) bags of thermoplastic material. Note: Do not fill kettle full of material yet.



STEP 4

Open the 100lb LPG tank valve.



STEP 5

Open the main system propane valve.

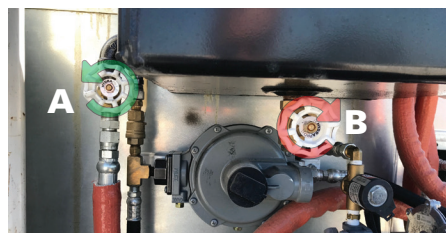
▶ **UP** = Open **DOWN** = Closed



STEP 6

A) Check hydraulic bypass valve left of the black tank to make sure it is Open (counter-clockwise)

B) Check the hydraulic bypass valve under the black tank to make sure it is Closed (clockwise).



STEP 7

Ensure the agitation direction lever is in the neutral position.



SYSTEM STARTUP

STEP 8

Start the gas engine using the engine key.

▶ Engine must be running to activate the burner flame.

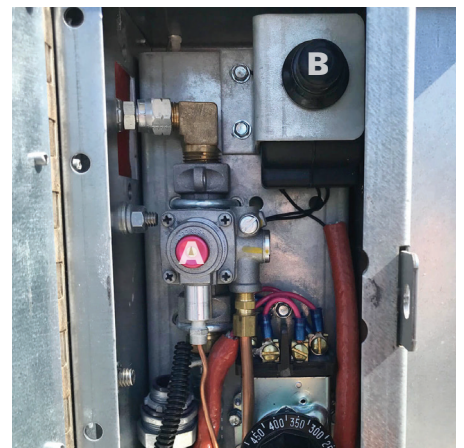


STEP 9

Press and hold down **RED** pilot button (A), while at the same time pressing the **BLACK** ignitor button (B) to generate spark to light the pilot.

TIP: If the pilot light stops, repeat step 5, but depress the red pilot button for an additional 15-20 seconds after the spark/pilot is activated.

Once the pilot is lit, allow the flame to stabilize for a few minutes.



STEP 10

Set thermostat to 300°F which will activate the large burner flame.



SYSTEM STARTUP *conti.*

STEP 11

- A)** If the majority of the burner flame is blue, close the burner access door and continue on.
- B)** If the majority of the burner flame is yellow, adjust the oxygen relay disc (pictured below) to establish a blue flame, then close the burner



STEP 12

Check kettle temperatures and continue to heat until it reaches 250° F - 300° F.

- ▶ Do NOT set to desired temp



STEP 13

Move the agitation direction lever up or down to begin agitating material. If agitation struggles, allow more time to heat material and try again.



STEP 14

Adjust the hydraulic needle valve to achieve the proper cycle rate.

Note: Allow material to completely liquefy before extruding into handliner.



STEP 15

Once agitation is working properly, adjust desired temperature, usually between 380° F – 400° F (depending on weather and material used).

Caution: Never exceed 445° F!



STEP 16

Add additional thermoplastic material as needed.

Tip: Let the machine melt/agitate new material while you are using your handliner.



STEP 17

Install material extrusion chute just beneath the slide gate, using the two chains provided. Move your applicator into position under the chute so it is ready to fill with material.

Do a final material consistency check before giving the green light. Continue agitating material until it has fully melted before extruding into your thermoplastic machine.



STEP 18

Open the material slide gate and fill the applicator. **Tip:** Add more material to the kettle immediately after filling the applicator.



SYSTEM SHUTDOWN

STEP 1

Turn thermostat knob to lowest possible position. (counter-clockwise)

Look inside the burner access door to verify that the flame is out.

STEP 2

Drain the material from the reservoir into draw-off boxes, pan, etc., until kettle reservoir is either empty or a maximum of 25% full if planing to use machine the following day.

STEP 3

If material is left in kettle after draining, adjust needle valve agitation speed to a "slow" setting until temperature reaches 150° F.

STEP 4

Set agitation lever to neutral position.

STEP 5

Turn engine ignition key to OFF position.

STEP 6

Close main system propane valve and close 100lb LPG tank valve.

STEP 7

Keep material feed door closed to avoid water or foreign matter from entering kettle.