**PUR Adhesive System Operations & Maintenance Tips**

*See your Nordson product manual for specific instructions, procedures and safety precautions. Copies of product manuals are shipped with each system. Manuals are also available online at emanuals.nordson.com*

*The tips below are for quick reference, to help you prevent unwanted downtime and maintain system productivity.*

### Daily Start-Up

1. Drain a small amount of PUR from the melter de-aeration valve into a drip pan
2. Drain a small amount of PUR from gun filter/drain valve
3. Purge 2-3 cups (16 to 24 ounces) of PUR from slot nozzle
4. Grease gun nozzle and nozzle screw
5. Grease pressure control valve stem
6. Check/adjust nozzle width setting and gun/nozzle height setting
7. Open gun nozzle
8. Wipe gun nozzle
9. Check/clean side glue applicators (if equipped)
10. Check clamp on gun (back-side) for alignment

### Daily Operation

1. Check pressure gauge movement
2. **Close/cap/cover nozzles and apply high-temperature grease to prevent curing during system idle times of 10 minutes or more!**

### Daily Shut Down

1. Close nozzle
2. Wipe nozzle
3. Open nozzle one-half to three-quarters inch
4. Apply high-temperature grease to nozzle
5. Clean gun exterior and remove all adhesive build up
6. Turn bulk melter “OFF” to prevent material heat curing
7. Seal all exposed nozzles and gun openings with high-temperature grease

### Weekly

1. Gun: Flush with approved purging material
2. Hose: Remove from gun, drain and flush/purge with material approved by adhesive supplier
3. Gun filter/screen: Inspect/clean
4. Pressure-control regulator: Stem should move approx. one-half inch, from 0 to 90 psi air inlet pressure
5. Airlines: Check for kinks to retract-on-close (snuff-back) and control module (on gun back)
6. Control module: Check operation. Create baseline for glue flow and compare weekly
7. Gun: Manually fire and confirm PUR pulls back/retracts from gun nozzle (snuff-back)
8. Hose: Check for kinking, leaking, damage and condition of proper hose supports
9. Fittings: Check all for tightness

### Quarterly

1. Clean and purge entire system
2. Remove PUR between nozzle and gun body
3. Check and replace as needed:
   - A. Nozzle and gun body
   - B. Filter screen on gun assembly
   - C. Nozzle seals
   - D. Pressure control seals
   - E. Adhesive hose
   - F. Control module
   - G. Retract-on-close (snuff-back) module

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*Nordson*
Prevent Unwanted Downtime and Protect Your Investment

Your Nordson system is designed for reliable and consistent performance. All equipment benefits from proper maintenance and service.

Nordson PUR System Service Plans are a cost-effective way to protect your investment in Nordson equipment and lower your Total Operating Costs (TCO). A choice of service plans provides you with the flexibility to meet your operational needs.

Service plans offer: Quarterly maintenance reminders, quarterly maintenance, inventory parts planning, factory-trained technicians and discounts on genuine Nordson parts.

Call toll-free (800) 234-0506 ■ Nordson accepts all major credit cards and corporate procurement cards

Service Plan pricing is for maintenance and service performed during normal business hours 8 a.m. to 5 p.m. Monday-Friday excluding holidays. Additional charges may apply for service to be performed outside of these normal business hours. Service scheduling based on availability. Nordson reserves the right to schedule or reschedule appointments.