Why choose Nordson?

Nordson hot melt hoses mean less downtime, more safety and durability.

- Separate ground paths provide safer operation and protect against equipment damage.
- Make-first, break-last electrical connections prevent powering the hose or gun without a ground connection.
- Four layers of aramid-felt insulation control heat loss and improve chemical and moisture resistance. Hoses keep flexibility, electrical and mechanical properties even at high temperatures.
- Non-stick core promotes better adhesive flow.
- Hose components are calibrated before assembly. You save time with no need for temperature calibration during installation.
- Controlled watt-density heating minimizes hot spot potential, reducing char. Close wire wrapping means uniform heat transfer for consistent adhesive flow.
- Waterwash hoses are IP-X6 rated and have improved electrical seals for longer life in washdown operations.

Don’t be misled by dual-circuit hose makers. Dual circuits won’t stop adhesive from charring, clogging nozzles or ugly char on end products.

Invest a little and save a lot! Nordson hoses will start paying for themselves right away, and for years to come.

Contact your local Nordson service representative.
Call (800) 234-0506 today or visit www.nordson.com/hotmelt
Adhesive Char = Higher Downtime, Rejects and Operational Costs

Get more productivity and lower TCO

Nordson
Adhesive char is present in your hot melt hose… even if the adhesive in your tank is clear.

**Time + Temp + 0² = Adhesive Char**

- Every hot melt adhesive has a pot life — a point in time at which the heat and oxygen cause it to degrade.
- Heating elements in hot melt hoses are used to keep adhesive flowing at the right viscosity and temperature.
- Char forms during idle periods when your system is on/heated and no adhesive is flowing.
- Adhesive near the heated walls of the hose moves slower than adhesive in the center of the hose. This hotter, slower adhesive degrades faster and sticks to the hose wall — forming char.
- Char inside the hose breaks loose and clogs filters, guns and nozzles.
- Lower-grade hot melt adhesives degrade and form char more quickly.
- Changing adhesive and bending or flexing a hose makes char to break off easier/faster.

**Why should I replace my hose? It looks fine.**

Even if you can’t see it, char cuts your productivity and increases your operating costs.

- Char restricts the adhesive flow and requires more system pressure to force adhesive through the hose.
- Char build-up creates a thermal barrier in the hose. When the adhesive isn’t hot enough, it doesn’t flow correctly.
- Slow, restricted flow increases the melter’s “heater-on” cycle. Problems multiply as more heat produces even more char.
- More heat and char increase your energy use and production costs.
- Char causes uneven adhesive beads, missed beads and clogged nozzles. You lose time and productivity long before your line shuts down.
- Flaking and loose char results in poorly glued packages, pop-opens and char on your products.

**Why can’t I just clean my hot melt hose?**

- Using a cleaning snake can scratch the internal hose core. The scratched areas collect char even faster.
- Using a cleaning probe can damage the hose and is not guaranteed to remove all the char. This practice will also void your system’s UL Listing.
- Flushing your melter can remove some char and prevent it from entering your hose.
- Flushing hoses with solvents is not recommended. Solvent can begin to break down hardened char but will not remove it entirely. Char will break off during system operation, clogging guns and nozzles.
How can I lower char and hose replacement costs?

A good preventive maintenance program, smart operating procedures and common sense can all help. For example:

- Flush your adhesive melter regularly and whenever you change adhesives. Do-it-yourself flushing kits contain everything you need to get the job done. Or, call Nordson we can schedule inspection, maintenance or a design program to fit your specific needs.

- Replace melter filters. Newer Nordson melters have disposable, basket filters that take less than one minute to replace.

- Install Nordson Saturn in-line filters between your hose and gun to trap char before it reaches your guns and nozzles.

- Most Nordson hoses now include integrated, movable RediFlex mounts to improve hose routing and hanging and prevent sharp bends and compression

- Keep hoses off the floor. Stepping on a hose, running it over with a forklift, getting it wet or having it covered in dirt will shorten its life.

- Don’t leave your adhesive system on when it is not in use. Using the 7-day clock or system standby will reduce char and allow the system to be ready when you need it.

When should I replace my hot melt hose?

- At least every 3 years

- If your new nozzles clog in less than 3 months

- If the hose shows external damage

- If the (non-waterwash) hose has ever been wet

- If hose fittings are leaking

Don’t wait. With today’s tight production schedules, smaller maintenance teams and the need to reduce expenses, downtime can be a major factor in your total costs.