

Blue Series Hot Melt Hose with RediFlex™ II Hanger System

Safety



WARNING! Allow only personnel with appropriate training and experience to operate or service the equipment. The use of untrained or inexperienced personnel to operate or service the equipment can result in injury, including death, to themselves and others, and damage to the equipment.



WARNING! System pressurized! Relieve system hydraulic pressure before breaking any hydraulic connection or seal. Failure to relieve the system hydraulic pressure can result in the uncontrolled release of hot melt that can cause personal injury.

NOTE: Refer to the melter-specific product manual for information on relieving hydraulic pressure.

CAUTION! Never heat system components with a torch or an open flame. Use an electric oven with forced air circulation or a flameless electric heat applicator. Do not heat plastic parts above 230 °C (450 °F).



WARNING! Molten material! Wear eye or face protection, clothing that protects exposed skin, and heat-protective gloves when servicing equipment that contains molten hot melt. Even when solidified, hot melt can still cause burns. Failure to wear appropriate personal protective equipment can result in personal injury.

Intended Use

Nordson hoses direct the flow of hot melt and other thermoplastic materials between a Nordson melter and a dispensing applicator. Resistance temperature detectors (RTDs) are built into the hose for precise and consistent temperature control and safety. A closely spaced, spiral-wound heating element surrounds the hose core to provide uniform heat transfer and high-temperature aramid insulation reduces heat loss.

Specifications

Item	Specifications
Maximum operating temperature	230 °C (450 °F)
Maximum operating pressure	10.34 MPa (1500 psi)
Input voltage	See the hose identification plate

Installation

CAUTION! Make sure that a hose with a braided cover (not water wash) does not get wet. If the hose gets wet, replace it immediately and eliminate the cause.

CAUTION! The hose should not come into contact with cold floors, cold supports or other such surfaces. Cold contact restricts the flow of adhesive inside the hose thereby causing potential problems during operation.

Remove the Old Hose

1. Relieve the melter hydraulic pressure. Refer to the melter manual.
2. Shut down the melter and disconnect it from its power source.
3. Turn off any applicator/hand-held applicator triggering devices or drivers. If applicable, turn off the applicator air supply.
4. Disconnect the hose electrical connectors or wiring from the melter and applicator.
5. Disconnect the hose swivel fittings from the melter- and applicator-end hose adapter fittings.
6. Properly dispose of the hose.

Replace Old Hose with a Previously Used One

CAUTION! Do not turn the nut on a hose with solidified adhesive inside. Damage to the hose core may result. Components may be forced apart on some hose cores by turning the fixed nut if the hose end is frozen together with solid adhesive.

CAUTION! Do not lay the hose on the floor while servicing. Doing so can cause heat dissipation and damage to the hose.

1. Refer to the *Hose Installation Guidelines* to route the hose between the melter and the applicator.
2. Heat the end fittings with a heat applicator to ensure that the adhesive in the swivel joints is melted before attempting to turn the nuts.
3. Once the hose is started onto the mating fitting, allow the heat from contact with the fitting to continue softening the adhesive in the end of the hose. Use light pressure when turning the nut to ensure that the melting continues until the nut can be fully tightened.

Connect the New Hose

1. Carefully uncoil the new hose to avoid kinking.
2. Route the new hose between the melter and the applicator. See *Hose Installation Guidelines* on page 4.
3. Connect the melter-end swivel fitting to the adapter fitting on the melter. Refer to *Parts and Accessories* on page 8 for alternate adapter fittings.
4. Plug the melter-end electrical connector into the appropriate melter receptacle. If required, the connector can be rotated 90 degrees. See Figure 1.

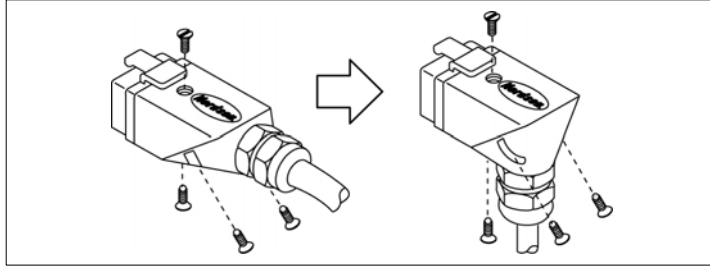
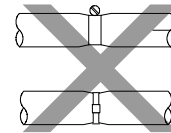


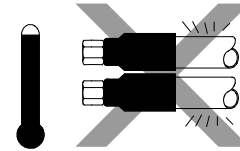
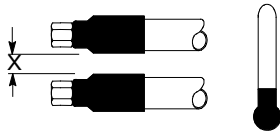
Figure 1 Rotating the melter-end electrical connector

5. Restore power to the melter. Bring the melter and the hose up to operating temperature.
6. Run adhesive through the hose and into a drain pan to purge the hose of any foreign material.
7. Shut down the melter.
8. Connect the applicator-end swivel fitting to the adapter fitting on the applicator.
9. Plug the applicator-end electrical connector into the applicator, or wire the hose to the applicator as described in your applicator-specific product manual. Refer to *Hose Wiring* on page 6 for information on compatible hose wiring.
10. Restore power to the melter and any applicator triggering devices or drivers. Operate the melter normally.
11. Re-tighten the hose fittings and check for leaks.
12. Insulate the exposed hose fittings. Refer to *Parts and Accessories* on page 8 for insulating cuffs.

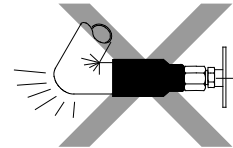
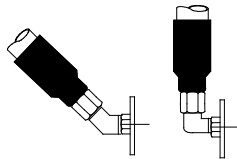
Hose Installation Guidelines



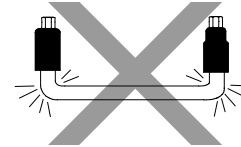
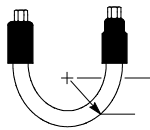
Secure hoses with proper brackets. Do not use clamps that restrict flow or damage hoses.



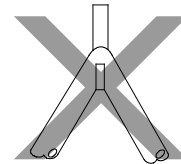
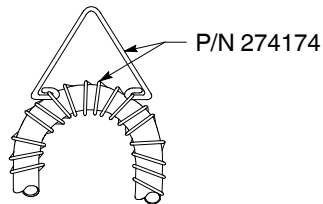
Maintain at least 12.7 mm (0.5 in.) between hoses to maintain temperature. Failure to do so can cause adhesive to overheat, resulting in chars, burns, or fire.



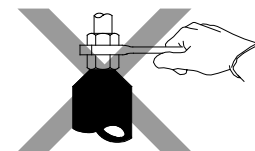
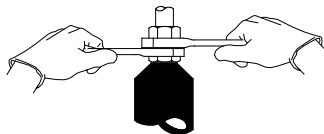
Use 45° or 90° fittings to connect hoses. Failure to do so can cause adhesive to overheat, resulting in chars, burns, or fire.



Do not exceed 203 mm (8 in.) bend radius for $\frac{5}{16}$ in. hose. Failure to do so can cause adhesive to overheat, resulting in chars, burns, or fire.



Properly support hoses so that flow is not restricted.



Use two wrenches to install hose fittings.

Figure 2 Hose Installation Guide

Best Hose Routing Practices for Hangers



Figure 3 RediFlex II hose hanger attached to a RediFlex II frame bracket on parent machine frame.

Use factory-installed RediFlex II hose hangers (or accessory hangers, see page 8) to secure the hoses. The RediFlex II hanger is designed to interface with the RediFlex II frame bracket or to allow zip tie retention to the parent machine. The RediFlex II frame brackets are available separately (P/N 1124221).

The RediFlex II hanger attaches to the frame bracket when you slide it into place, and it is retained by a spring lock. Remove the hanger by pressing the thumb tab and sliding the hanger out of the bracket.

RediFlex II frame brackets are designed to attach to a frame member with a single M6 or 1/4 inch socket head screw. For more information, see the *Hose Hanger Bracket Kit* instruction sheet (P/N 1124224_01).

NOTE: Ensure that the hose length is appropriate to prevent it from being pulled, stretched, or twisted.



Figure 4 Two hoses connected to a single RediFlex II frame bracket.

Space the hangers as evenly as possible and use the frame brackets or other means to retain the hose. The maximum distance between supports should be less than 2.5 m (8 feet) for a single hose and less than 1.25 m (4 feet) for multi-hose support. No more than two hoses should be supported per bracket.

The RediFlex II hanger is designed to facilitate the routing of solenoid air tubing and signal cabling. M8 terminated solenoid cabling and 6 mm OD tubing can be routed in tandem through the mount as shown in Figure 5.

NOTE: If necessary, pass the connector end of the cable through the mount before installing the tubing.



Figure 5 Solenoid tubing and a signal cable routed through the RediFlex II hose hanger.

Additional Notes

Applicator End Electrical Connector Cover

When non-transfer type hoses are used in applications where they are not electrically connected to an applicator or other device on the applicator end, an electrical connector cover must be installed to ensure the hose will meet the intended I.P. rating.

Refer to this table for the appropriate electrical connector cover part numbers.

Electrical Connector Cover Part Numbers

Kit Part Number	Hose Type
274724	Standard Automatic
276781	Waterwash
148612	FM130

Hose Wiring

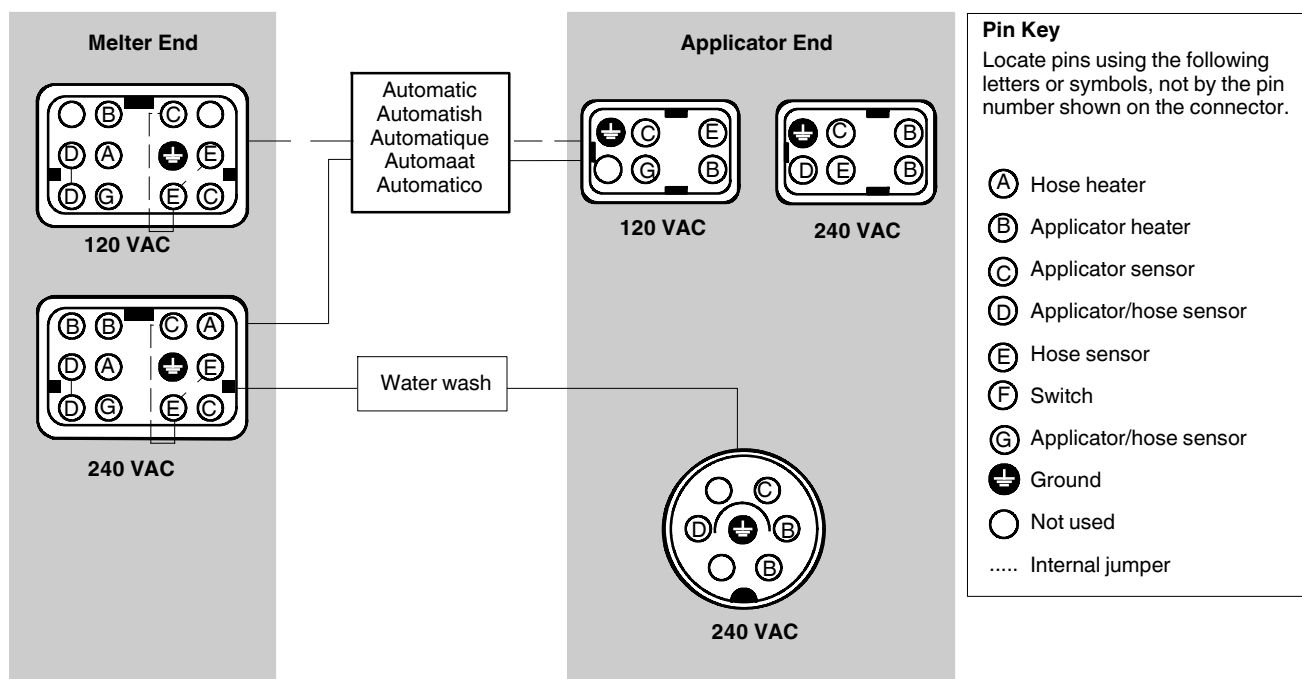


Figure 6 Hose Wiring

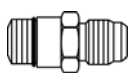
Troubleshooting

The following table contains hose troubleshooting procedures. For melter troubleshooting procedures, refer to the melter-specific product manual.

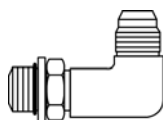
Problem	Possible Cause	Corrective Action
Hose does not heat or underheats	No input power Missing contact pin(s) or damaged electrical connector Failed heater or sensor Incorrect hose routing	Check that the melter is on, the hose electrical connections are secure, and that the channel is set to the correct temperature. Repair the contact pin(s) or replace the hose. Connect the hose to a known good channel. -If the hose heats, the original channel is bad. -If the hose does not heat, replace the hose. The hose should not come into contact with cold floors, cold supports, or other such surfaces. Cold contact restricts the flow of adhesive inside the hose thereby causing potential problems during operation.
Little or no adhesive output (Melter OK)	Clogged hose	Check the hose: 1. Replace the hose if there is little or no adhesive flow. 2. Turn on the pump and check for full adhesive flow. 3. Disconnect the hose from the applicator. 4. Replace the hose with braided cover if it gets wet. CAUTION! Make sure that a hose with a braided cover (not water wash) does not get wet. If the hose gets wet, replace it immediately and eliminate the cause.
Hose leaks at the connection with melter or applicator	Loose hose fitting Damaged O-ring, hose adapter fitting, or hose swivel fitting	Ensure that the melter and hose are at operating temperature, and then tighten the fitting. Replace the O-ring or adapter fitting. Refer to <i>Parts and Accessories</i>. Replace the hose if either hose swivel fitting is damaged.

Parts and Accessories

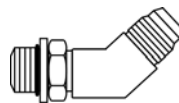
Adapter Fittings and O-Ring ($\frac{5}{16}$ -in. hose, long body)



P/N 972628



P/N 274180



P/N 147352



P/N 945032

Accessories



Hose hanger bracket w/latch

P/N 1124221

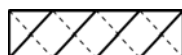
Used to support up to two hoses at a single suspension point (Qty: 2 per kit)



Heat-protective gloves

P/N 902514

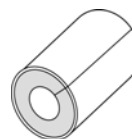
For use while servicing hot melt hoses



Hose protector

P/N 273314

Spiral-wrap chafe guard



Insulating cuff

2.5 in. (64 mm)
P/N 273634

2 in. (51 mm)
P/N 273635
1.75 in. (44 mm)
P/N 274429

Used to insulate hose fittings



Hose mounting block

P/N 111940

Molded corrugated tube and clips used to route and fasten hoses



Hose Separator Kit

P/N 1047408

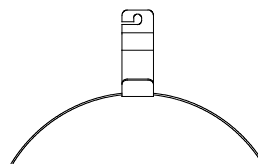
Maintains distance between two hoses for maximum heat transfer efficiency



Spiral support

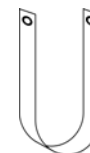
P/N 274174

Used to evenly support a hose using a single suspension point



Hose Hanger Kit

P/N 1034380



Hose strap

14 - in.
P/N 142513
18 - in.
P/N 142512

Used to evenly support a hose using multiple suspension point



For CE Declaration, refer to melter manual.

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