

# Heated Hoses Care & Maintenance Guide



hot melt parts  
O N L I N E

[www.hotmeltparts.com](http://www.hotmeltparts.com)

Every hot melt adhesive has a pot life -- a point in time when the heat and oxygen cause the part to degrade.

Heating elements in hot melt hoses are used to keep adhesive flowing at the right viscosity and temperature. Degradation and char form during the idle periods when your system is on and no adhesive is flowing.

Adhesive near the heated walls of the hose moves slower than adhesive in the center of the hose. The hotter, slower adhesive degrades faster and sticks to the hose wall. Char inside the hose can then break loose and clog filters, guns and nozzles.

Product assembly hot melt adhesives like polyamides, APAOs and PSAs degrade and form char more quickly.

## **Should I replace my hose? It looks okay.**

Even if you can't see it, degradation inside your hose cuts productivity and increases your operating costs. Degradation restricts the adhesive flow and requires more system pressure to force adhesive through the hose. This 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.

## **But can't I just clean my hot melt hose?**

DO NOT use a cleaning "snake" or "probe" to clean your hose. It will damage the internal hose core. DO NOT flush a hose with any solvents.

DO flush your melter. System flushing may remove degradation and char. Contact us to get recommendations on the appropriate flushing agent.

A good preventive maintenance program, smart operating procedures and common sense can help you get the most life out of your heated hose.

Tips:

- Flush your adhesive melter regularly and whenever you change adhesives. We can suggest the best flushing agent for the type of adhesive you're using.
- Improve hose routing and hanging to 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 lifespan.
- Don't leave your adhesive system on when it's not in use. Many systems are equipped with 7-day timers as well as Auto Standby timers. Using these features correctly will extend the life of your hoses.
- Properly maintained, hoses can last 3-5 years depending on the adhesive used, the temperature of your application and the amount of flexing the hose is subject to. Replace your hoses when they've reached expiration to ensure you're not wasting time in production.

# USER INSTRUCTIONS

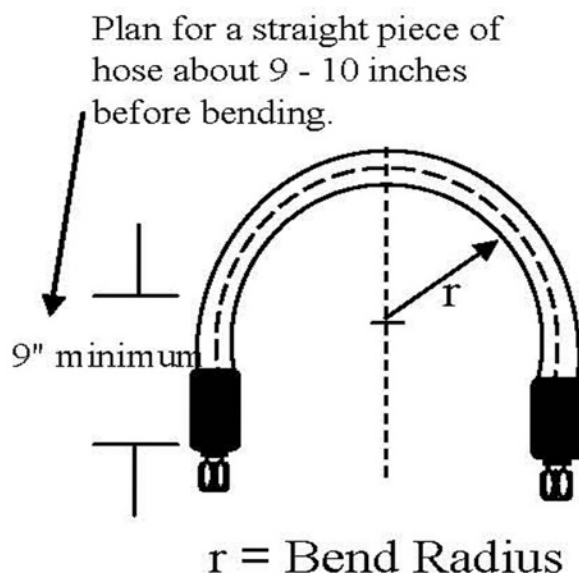
## I. General Instructions

1. Do not apply any motion or bending stress directly to the hose fittings.
2. Keep within the allowed bend radius marked on your hose tag.
3. Prior to disconnecting a hose, depressurize the system completely.
4. Always use two wrenches when disconnecting a hose. Loosen slowly, wear protective clothing.

## II Allowable Bend Radius

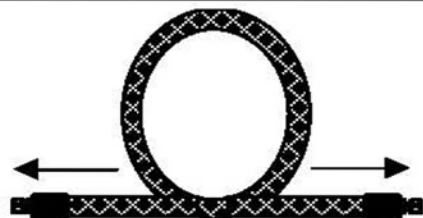
Below are standard Teflon lined single braided hose specifications. See your hose tag for your hoses specifications.

Hose		Bend
Trade	Inside	Radius
Size	Diameter	Inches
4	3/16	2.5
5	1/4	3.0
6	5/16	5.0
8	13/32	6.5
10	1/2	8.5
12	5/8	10.0
16	7/8	11.5
20	1 1/16	20.0



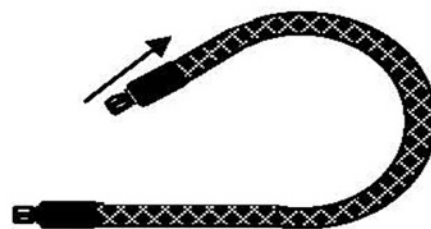
## III. Handling Instructions

Wrong



Unrolling a hose by dragging it by the ends creates stress as well as exceeding the bend radius.

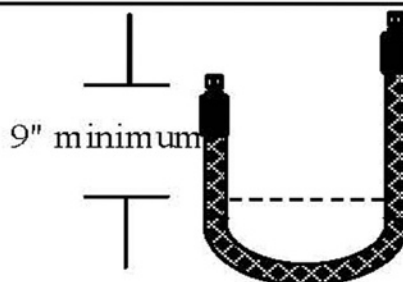
Right



SOLUTION: Unwind the hose.



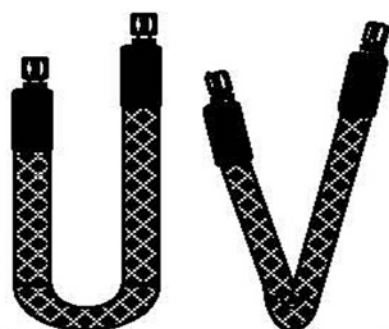
If heated hoses are too short, the hose will become kinked at the fittings.



SOLUTION: Plan for a straight piece of hose about 9 - 10 inches before bending.

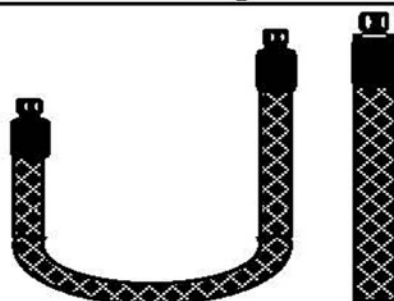
### III. Handling Instructions (con't)

Wrong



Heated hoses are often destroyed by torsional motions caused by improper installation.

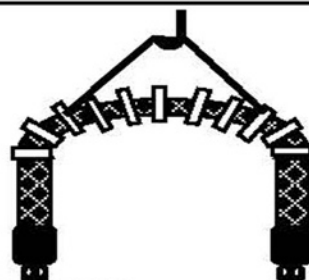
Right



SOLUTION: Make sure that the axes of the heated hose run parallel and the motions are always on one and the same level.



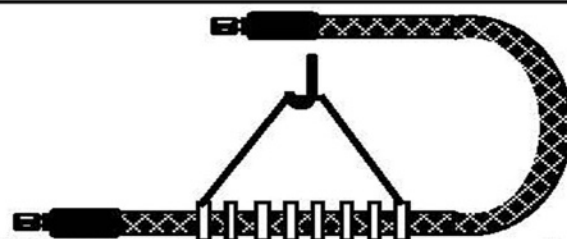
Avoid kinking and bending stresses.



SOLUTION: Use a support with the proper bend radius. Do not enclose the hose.



Hose sags when installed



SOLUTION: Support the hose and ensure that the hose is long enough. Do not enclose the hose.

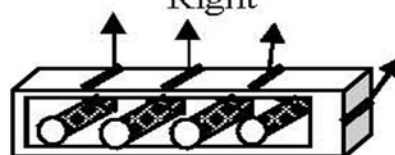
### IV. Installation

Wrong

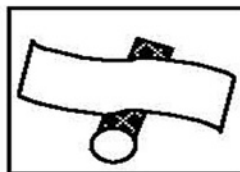


Heated hoses mounted within a closed channel or shaft will cause heat build - up.

Right



SOLUTION: Heated hoses must not touch each other. Sufficient ventilation is required.



Avoid overheating by keeping hoses and work area clean. Hose enclosure will cause overheating of contact areas.



SOLUTION: Provide sufficient spacing for air movement.

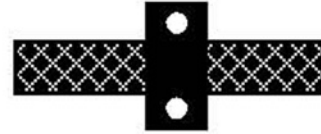
## IV. Installation (con't)

Wrong



Don't squeeze the outer insulation on to the heated hose during installation. This can damage the wiring under the insulation, and may destroy the hose.

Right



SOLUTION: Use mounting hardware that is large enough to accommodate Hose O.D. with out crushing. Sufficient ventilation is required in mounting hardware.

Our hoses are designed with a unique core to offer longer life with increased durability. Our priority is that you have a product you can trust to last. Please let us know if you have any questions about the care and maintenance of your heated hose.

Rich Infurna  
[www.hotmelparts.com](http://www.hotmelparts.com)