

Hotmelt adhesive switching guide



1

Remove the old adhesive from your hot melt tank

Reduce pump pressure to 0 bar. Remove as much adhesive from the system as you can.

Use the drainage point on your tank and take safety precautions due to high temperatures of the glue.

Check the main filter and if heavily polluted, change it following the instructions in your equipment manual.

2

Prepare and fill your tank

With an empty tank, set the temperature to around 20°C higher than the softening point of your new adhesive. You can find the softening point on the technical data sheet.

Carefully remove any burnt glue from inside the tank with a non-metallic spatula.

Now, fill the tank with your new glue and allow it to melt.

3

Start pumping the new adhesive through the system

Return pump pressure to 1 bar. Pump the hot melt through the hoses and nozzles.

You may see small, black particles in the extruding glue. This is usually existing, burnt glue particles being pushed through.

This effect is particularly noticeable when switching from an EVA to one of our Optimise® adhesives. These products are formulated to keep tanks and nozzles free from char and blockages.

4

Start pumping the new adhesive through the system

Refill and pump through the system again. This may require two purges or more, depending on the size of your equipment and substrates.

Check the extruding glue for any signs of marbling. A visual marbling effect indicates that two glues are present and you may need to purge again until an even colour is achieved.

Use appropriate PPE. Wear plastic goggles, heat-proof gloves and suitable clothing.



Avoid cleaning products during the switching process

[Book an engineer](#)

For Service & Preventative Maintenance Contracts please call us on **+44 (0) 1953 882899** to arrange an engineer.