

The Superior Air - Jacketed Hot Rubber Melters
(Propane, Diesel, & Electric Heat Systems Available)

From the Innovators of Rubber Master Technology

A&A MELTERS

WARRANTY

A&A STEEL ENTERPRISES of Canada warrants its product to be free from defects in material and workmanship under normal use and service for a period of one year from date of end-user purchase. Our obligation shall be limited to the repair or replacement of any parts at our option, F.O.B. our factory. Defect of a part or parts of a unit which can be replaced shall not be construed to indicate that the unit is defective. This warranty shall not apply to any part which has been subject to accident, alteration, abuse, misuse, damage or flood, fire or act of god.

A&A STEEL ENTERPRISES of Canada shall not be liable for service, labour or transportation charges or for damages or delay caused by defective material or workmanship or for personal injuries or damages to property caused directly or indirectly by any A&A STEEL product or by its use or operation, or for work done or repairs effected by others. In the case of components purchased by A&A STEEL ENTERPRISES such as controls, gear reduction, motor, pump, etc., the warranty the manufacturer will be extended to the purchaser in lieu of any warranty by the company.

The above warranties are in lieu of all other warranties expressed or implied. No representative or other person is authorised or permitted to make any warranty or assume for the company any liability not strictly in accordance with the foregoing.

Our A&A STEEL melters are designed for long, trouble free life under a wide variety of application conditions with a minimum of maintenance, however, the purchaser and or user should read the maintenance and operation manual before firing and operating any equipment.

A & A STEEL ENTERPRISES LTD.
220 Myrnam St. Coquitlam, B.C. Canada V3K 6G4

WARRANTY REGISTRATION CARD

MODEL #:

DATE PURCHASED:

SERIAL NUMBER:

CUSTOMER NAME:

TELEPHONE/FAX

ADDRESS:

CITY:

STATE:

ZIP:

DEALER:

TELEPHONE/FAX:

A&A Melters - Model - A-25

IMPORTANT NOTE: TO OPERATE YOUR A&A STEEL MELTER SAFELY AND EFFICIENTLY, FOLLOW THESE OPERATING INSTRUCTIONS. FAILURE TO COMPLY MAY RESULT IN VOIDING WARRANTY AND MAY CAUSE SERIOUS INJURIES.

A) INITIAL START UP:

When melter has been purchased and is ready to be placed into service, an overall check should be performed to ensure that the melter is in working order as described in INSPECTION AND FAMILIARIZATION below. **IT IS VERY IMPORTANT** that the melter is connected to a VAPOUR DRAW PROPANE GAS cylinder for which it was designed to operate!

B) INSPECTION AND FAMILIARIZATION:

1. Read operator's manual for the engine, gear reduction unit and this manual thoroughly to become familiar with the operation of your A&A Steel melter.
2. Ensure all moving components are clear of any objects and are free to move (including interior of melter).
3. Check all mounting bolts are tight, drive belt is correctly aligned (gas engine only) and cotter pins and keys are in place.
4. Grease all moving parts, check engine and reduction gear oil levels. Use manufacturers recommended oil, add if required.
5. Ensure all guards are in place and securely mounted

C) START UP

1. Move melter to a suitable, level working surface and block caster wheels. Open exhaust rain cover.

CAUTION: Do **not** wear loose clothing near moving belts or other moving parts.

Once the melter has been inspected and connected to VAPOUR Propane Gas, the melter is ready to be charged with the first load of material.

IT IS VERY IMPORTANT that the material is of small enough size to allow it to be in direct contact with the bottom surface. This allows the heat to be directly transferred to the material in the least amount of time to avoid any excessive heat build-up. When the material has started to melt into a liquid, it will transfer the heat to the rest of the material very quickly.

2. Follow recommended propane safety precautions and propane torch light up procedures, adjust outlet pressure to 10 psi and light torch. Insert lit torch into Torch Holder. Open exhaust stack

3. Adjust torch to ensure correct position. Tighten Torch Securing Bolt on Torch Holder. Start with low flame for 5 minutes to allow melter to warm up, then open ball valve until firing at a high rate while still maintaining complete combustion (no back flame out of chamber).
4. **WARNING: DO NOT OVERLOAD ! If the Agitator is engaged on the electric motor before the material has partially melted, the excessive solid material may cause damage to the Agitation Rack or drive mechanism.**
5. Always open Material Loading Door from the opposite side of melter to prevent injury from spontaneous ignition which may occur due to a sudden rush of incoming air. Add material to centre of Agitation Rack.
6. Once material has BEGUN to melt (about 10 minutes), on the Electric motor - turn power switch ON

Observe:

- material has melted sufficiently (not completely) to allow complete movement of Agitation Rack, if large chunks of material bind Agitation Rack, allow more time for them to melt
- all moving parts have a uniform motion.

When confirmed all of the above is correct:

Electric motor - the power switch can remain ON.
Never run machine empty, this can cause damage to the tub.

NOTE: This melter will heat material very quickly and should NEVER be left unattended. Even when the propane torch is extinguished, temperatures will continue to rise due to the remaining thermal energy stored in the Superheated Air Chamber below (Depending on the amount of material in the melter, the temperature can rise approx 50 - 100 degrees Fahrenheit).

7. When material is melting and has become a thick, uniform consistency, more material can be added.
8. Check temperature regularly. Heat material to manufacturer's specifications.
9. Once the material has reached correct temperature, adjust propane torch as necessary.
10. Open material Loading Door (from opposite side), add material to centre of moving Agitation Rack.
11. Add material as required.

C) SHUT DOWN:

1. Upon completion of working period, the melter should be as empty as possible. This will ensure a quick warm up for the following working period and prevent any stress on moving components due to excessive solid material.
2. Remove propane torch. Close all valves.
3. Before transporting, melter should be as empty as possible, cool to the touch and the residual material should be solidified.

D) LIFTING

The A&A Steel A-25 can be lifted vertically by utilizing the 4 eye bolts at each corner.

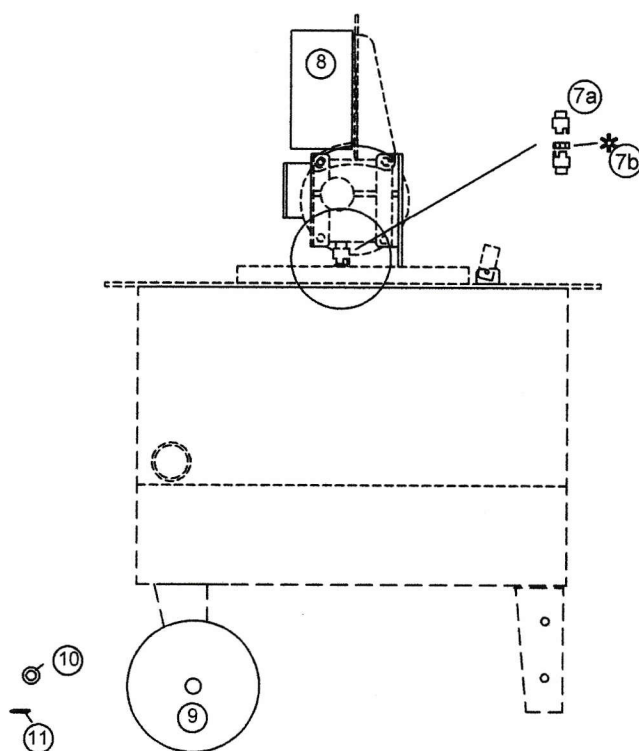
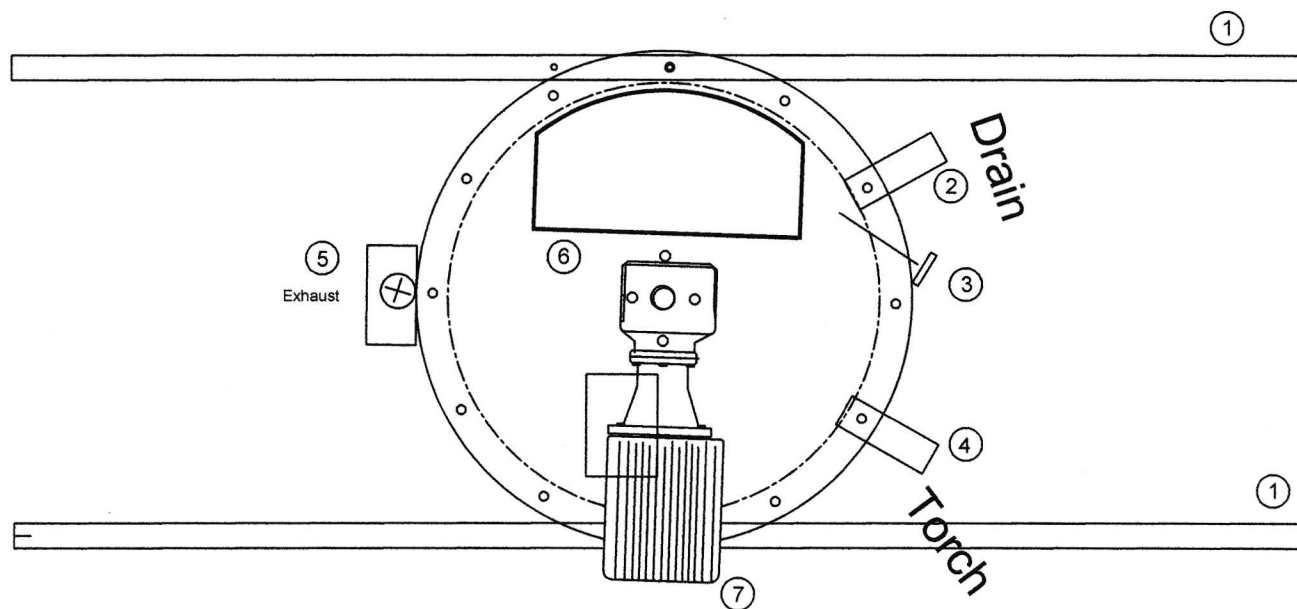
The weight of the A-25 is approximately 375 lbs. empty.

It should be as empty as possible, cool to the touch and the residual material should be solidified before lifting.

E) LIFTING - MANUALLY:

The A-25 can be manually lifted with the Handles

A 25



- ① 2 Position Handle
- ② Material Drain Valve
- ③ Thermometer
- ④ Vapor Torch (#50 Oriface)
- ⑤ Exhaust
- ⑥ Gear Unit
- ⑦ Electric Mtr
- ⑦a Jaw coupler
- ⑦b Spider
- ⑧ Speed Control
- ⑨ 8" wheel
- ⑩ Washer
- ⑪ Cotter Pin

A&A Melters

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Recommended Maintenance schedule

Daily - Check motor and crankcase oil level

50 hours - Check all nuts, bolts, belts, pulley alignments + grease all nipples

100 hours check propane fittings for leaks

500 hours – Check all drive arm bolts, bushings, wheel nuts, gear box oil level

1000 hours – Clean tub out, pull agitator, check clearances between tub and agitator, check pillow block bearings, material valve