



**PLEASE READ OPERATING INSTRUCTIONS CAREFULLY !  
NEVER OPERATE DIP TANK UNATTENDED!**

**... THERMOSTAT FAILURE CAN CAUSE FIRE ...  
... DO NOT OPERATE MELTING POT OR TANK BELOW 50% CAPACITY ...**

Temperature control is the most important factor in the use of Hot Melt Coatings and we recommend electrically heated, thermostatically controlled melting equipment, such as we have available. Excessively large equipment or improper equipment may result in overheating or heating the material too long and degrading will occur. It should NEVER be heated over a direct flame, hot plate or gas operated equipment, as there is the possibility that the coating may catch fire.

**IF THE TANK IS NOT GOING TO BE USED FOR EXTENDED PERIODS OF TIME, IT SHOULD BE TURNED OFF OR THE THERMOSTAT LOWERED.** Keep tank covered with lid when not dipping. It is important to try to use as much plastic as possible from the dip tank before new plastic is added. If approximately 1/4 of the molten coating material can be used every day, the coating will stay light in color and free from odor. These products are thermoplastic and can be remelted and reused. Make sure the material is clean and not contaminated before returning it to the tank. Degraded material will deteriorate the material in the tank. These materials are non-toxic and 8 pounds of solid coating will melt into 1 liquid gallon. One pound of coating will cover 500 square inches at 1/10" in thickness.

**DO NOT MIX TOGETHER ANY OF THE TYPE I, II, OR IV COATINGS AS THEY ARE INCOMPATIBLE.** However, any coatings of the same type may be mixed together *with the exception of the B-52.*

**ALWAYS MONITOR THERMOSTAT TEMPERATURE !**

The following temperatures are recommended for use with the various coating. Keep in mind that these temperatures are for the coating compound, not necessarily the thermostat setting. The thermostat can be out of calibration and we suggest obtaining a thermometer and inserting it in the molten compound and use this reading to set the thermostat. When the thermostat is correct, use the following temperatures:

CODE	TYPE I - DESCRIPTION	OP-TEMP
E-1	TRANSPARENT GOLDEN	350°F / 171°C
E-2	CLEAR GOLDEN	360°F / 182°C
E-5	AMBER TOUGH	360°F / 182°C
E-30	WATER CLEAR & COLORS	350°F / 177°C
E-40	CLEAR & COLORS - TOUGH	360°F / 182°C

CODE	TYPE II - DESCRIPTION	OP-TEMP
B-50	CLEAR & COLORS - THIN	340°F / 171°C
B-52	CLEAR & COLORS - LOW	310°F / 155°C
B-60	CLEAR - JAN-C-149	350°F / 177°C
B-90	TOUGH TRANSPARENT	350°F / 177°C
B-100	PLATING - MIL-P-23242B	360°F / 182°C
B-149	CLEAR - MIL-P-149D	350°F / 177°C

CODE	TYPE IV - DESCRIPTION	OP-TEMP
K-25	CLEAR & COLORS THERMO-PLASTIC	300°F / 149°C
K-25S	CLEAR THERMO-PLASTIC	300°F / 149°C
PM-350	CLEAR & COLORS THERMO-PLASTIC	350°F / 177°C

The item to be protected should be immersed in the molten plastic for 1 - 2 seconds. When the item is removed the coating will solidify within 60 seconds and the part is ready for handling. The coating thickness can be varied by raising or lowering the temperature or by preheating the part. The item to be protected should be clean and if possible cotton or canvas gloves should be worn.

If you desire to completely envelop the item, the coating should be double-dipped or single-dipped by using a non-wicking string, such as fiberglass or nylon. Hot melt coatings are very heat sensitive and in the initial melt, **THE THERMOSTAT SHOULD NEVER BE ELEVATED ABOVE THE OPERATING TEMPERATURE**, as the plastic is a very good insulator and this will cause overheating of the solid plastic. To prevent darkening and degrading of the plastic, you must try to use 20 to 25% capacity, of the liquid in the melting tank, each time the tank is operated. The coating can be very easily removed, as it does not adhere, it but envelops. To remove, it can be slit and peeled like a banana.

The best method to clean the tank is to insert a piece of scrap metal into the molten plastic, allow it to solidify, turn on the tank for less than 5 minutes, then pull the plug from the tank by means of the scrap metal, like pulling a cork from a bottle. The remaining plastic can be removed with a rag. **IF YOU DO NOT UNDERSTAND THESE INSTRUCTIONS, ASK SOMEONE WHO DOES OR CALL EVANS COATINGS LLC**



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