

Rite-Hete Corporation

STANDARD AND CUSTOM MELTING POTS AND TANKS

7801 Elm Street NE, Fridley, MN 55432

Phone 763-572-7961 ... Fax 763-572-7962 ... email: info@meltingtanks.com

CERRO ALLOY MELTING POT TIPS AND TROUBLE SHOOTING GUIDE

- 1- TANK TEMPERATURE SETTING- SET TANK TEMPERATURE FOR THE MELTING POINT OF ALLOY BEING USED. I.E. (CERROBEND 186, SET TANK FOR 186 DEGREES FAHRENHEIT). SETTING TANK TEMPERATURE HIGHER CAN RESULT IN INCREASED DROSS AND A CLOGGED VALVE.
- 2- VALVE TEMPERATURE SETTING- THE VALVE HAS A TEMPERATURE SETTING OF 1-10 AND COMES PRESET AT 6. IF THE ALLOY IS NOT FLOWING FROM THE VALVE YOU CAN INCREASE TEMPERATURE TO 7 OR 8 BUT NOT OVER THAT. SETTINGS OVER 8 CAN BURN ALLOY, CLOG VALVE OR CAUSE AN EE1 TROUBLE CODE. PLEASE REFER TO THE USER MANUEL FOR SETTING VALVE TEMPERATURE.
- 3- DROSS- DROSS, OR SEPARATED ALLOY PROPERITIES FLOATING JUST BELOW THE SURFACE, MUST BE REMOVED OR "SKIMMED OFF" BEFORE POURING ALLOY. DROSS CAN CLOG THE VALVE.
- 4- DRAFTS- THE VALVE COMES INSULATED FROM THE FACTORY. IF THE INSULATION HAS BEEN REMOVED YOU MUST OBSERVE VENT HOODS, FANS AND AC VENTS IN THE VICINITY OF THE ALLOY MELTER. DRAFTS OVER THE VALVE CAN PULL HEAT AWAY AND RESULT IN A "FROZEN" VALVE. IF YOU MUST USE A VENT HOOD AND ALL OTHER TIPS FAIL, YOU MAY NEED TO INSULATE THE VALVE.
- 5- ALLOY LEVEL- THERE NEEDS TO BE ENOUGH ALLOY IN THE UNIT TO PROVIDE GRAVITY FORCE TO DISPENSE THE ALLOY. A GOOD RULE OF THUMB IS TO KEEP THE UNIT HALF FULL. ANY LEFT OVER ALLOY CAN BE STORED IN THE UNIT AND REMELTED WHEN NEXT NEEDED.
- 6- VALVE- IF THE VALVE OPENS BUT ALLOY DOES NOT FLOW PLEASE REFER TO TIP 5. IF ALLOY STILL WILL NOT DISPENSE THE VALVE IS MOST LIKELY CLOGGED WITH DROSS. MECHANICAL REMOVAL OF DROSS OR REPLACEMENT OF VALVE SHOULD RESTORE FLOW.
- 7- COVER- USE THE COVER TO SPEED MELT TIMES, REDUCE FUMES AND CONSERVE ENERGY.