



# **BAX 100ES**

**PART MANUAL - 26375**

**Rev. "C"**

Revised: 03/14

**BAX 100ES**  
**Part Number 55100**



# TABLE OF CONTENTS

BAX 100ES.....	5
Safety Precautions.....	6-7
Limited Warranty.....	8
Warranty Claim Instructions.....	9
Contact Us.....	10
Specifications.....	11
Introduction.....	12
Operating Instructions	
Machine Start Up/Adding Material to the Melter.....	13
Agitator and Speed Adjustment/Dispensing the Material.....	14
Loading The Machine/Shutdown and Clean-Out Procedure.....	15
Electric Hose Care and Cautions/Hose Transport Instructions.....	16-17
Maintenance	
Maintenance.....	18-19
Maintenance Chart.....	20
Service Instructions/Recommended Fluids and Lubricants.....	21
Trouble Shooting	
Speed Control Module.....	22-24
Heated Hose and Wand Testing.....	25
10' and 24" Heated Hose Resistance and Continuity.....	25
Electrical Schematic.....	26
Pump Trouble Shooting.....	27
Parts	
BAX 100ES Melter Diagram and Parts.....	28-31
BAX 100ES Tank and Frame Diagram and Parts.....	32-35
BAX 100ES Control Box Assembly.....	36-39
BAX 100ES Air Piping Diagram and Parts.....	40-41

# BAX 100ES

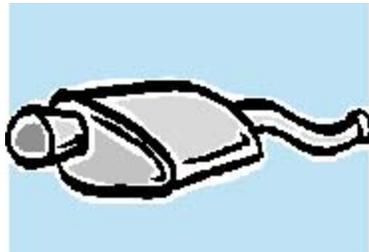
This manual is furnished with each new **CRAFCO BAX 100ES**. This manual will help your machine operators learn to run the applicator properly and understand its mechanical functions for trouble-free operation.

Your **CRAFCO BAX 100ES** is designed to give excellent service and save maintenance expense. However, as with all specially engineered equipment, you can get best results at minimum costs if:

1. You operate your machine as instructed in this manual.
2. Maintain your machine regularly as stated in this manual.
3. You operate your machine as instructed in your safety manual.



**WARNING:** The engine exhaust from this product contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Operate in well ventilated area only. Engine exhaust is deadly.



# SAFETY PRECAUTIONS

- High operating temperatures of sealant and machine require protective clothing, hard soled shoes and heat resistant gloves be worn by operator.

- Always wear eye protection.



- Observe all **CAUTION AND WARNING** signs posted on machine.



- Avoid the entrance of water into any part of the machine. Water will displace sealant, which could be hazardous to personnel surrounding machine when it reaches the operating temperature.

- The melter is operated with 120/240 volts Ac. Exercise extreme caution when maintaining equipment electrical systems. Immediately replace or repair defective electrical components. Service of electrical systems should be performed by qualified personnel only.

- Avoid bodily contact with hot sealant material, serious burns may result.

- Read Operator Manual thoroughly before operating machine.

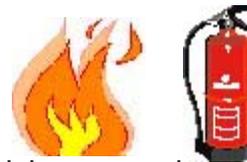
- Make sure operator is familiar with machine operation.

- Do not operate in closed building or confined areas.

- Shut-down the melter and the generator prior to refilling the generator with gasoline.

- When adding solid material to sealant tank, stop mixer, lift lid, place material onto lid and close lid before restarting mixer. Hot material could splash and cause serious burns if this procedure is not followed.

- Keep hands, feet, and clothing away from all moving parts.



- Always keep a fire extinguisher near the unit. Maintain extinguisher properly and be familiar with its use.

- Follow operating instructions for starting and shut-down. Instructions are mounted on control box.

- Replace any hoses which show signs of wear, fraying, or splitting. Be sure all fittings and joints are tight and leak-proof.

- Precaution is the best insurance against accidents.

- The BAX 100 Melter should not be left unattended with heaters "ON".

## SAFETY PRECAUTIONS (con't)

- Tighten all bolts and screws after every 100 hours of operation.



- CrafcO, Inc. assumes no liability for an accident or injury incurred through improper use of the machine.

## LIMITED WARRANTY

Crafco, Inc., through Crafco or one of its affiliated distributor, will replace for the original purchaser free of charge any parts found upon examination by the factory at Chandler, Arizona, to be defective in material or workmanship. This warranty is for a period one year from in-service date, but excludes engine or components, tires, and battery as these items are subject to warranties issued by their manufacturers.

Crafco, Inc. shall not be liable for parts that have been damaged by accident, alteration, abuse, improper lubrication/maintenance, normal wear, or other cause beyond our control.

The warranty provided herein extends only to the repair and/or replacement of those components on the equipment covered above and does not cover labor costs. The warranty does not extend to incidental or consequential damages incurred as a result of any defect covered by this warranty.

All transportation and labor costs incurred by the purchaser in submitting or repairing covered components must be borne by the purchaser. Crafco, Inc. specifically disavows any other representation, warranty, or liability related to the condition or use of the product.



**WARNING:** Use of replacement parts other than genuine Crafco parts may impair the safety or reliability of your equipment and nullifies any warranty.

# WARRANTY CLAIM INSTRUCTIONS

Crafco, Inc., warrants parts and machinery purchased through Crafco or one of its affiliated distributors for one year from purchased or in-service date \*\*. If parts fail to function within the first year of purchase, a return authorization number (RA) must be obtained. If the part was purchased through Crafco, Inc., please contact the Crafco returns department at Returns@Crafco.com for a RA number or if purchased through a Crafco distributor please contact your distributor. Note: if the part has a serial number associated with it, for example; a machine or electric hose or wand, this must be furnished when requesting the RA number. The customer will be emailed or faxed a RA form with all instructions to return the item to Crafco, Inc. See example. If the part is found to be within the one year warranty period and has not been abused or modified, a credit will be issued to the customer's account or credit card. The customer may request the part be replaced instead of a credit, if desired.

\*\* Wear items are not covered under Crafco, Inc. limited warranty. A wear item is defined as but not limited to: material pumps, sealing tips, tires, etc.

Note: All engine warranties are covered through the engine manufacture. If you need information for a distributor in your area please contact us and we will direct you to the closest engine distributor.

\*\*\*\* All parts returned are tested and evaluated. If the part has been modified in anyway without prior consent from Crafco, Inc. representative, warranty is void.

Please follow the instructions stated below when calling in a Warranty Claim. Failure to follow these procedures may be cause to void the warranty.

1. Call your local Crafco Distributor. If you do not know who your local distributor is, call a Crafco Customer Service Representative, (Toll Free 1-800-528-8242) for name, location, and telephone number.
2. On contacting the distributor, be prepared to identify the serial number, model number, engine model, engine manufacturer, and the date of purchase if available.
3. Should the cause of the malfunction be a defective part, the Distributor will advise you of the procedure to follow for a replacement.
4. The warranty is valid only for parts, which have been supplied or recommended by Crafco, Inc.

If you have any additional questions regarding warranty repairs and parts, please do not hesitate to call toll free 1-800-528-8242.

## CONTACT US

For Warranty:

Crafco, Inc.

25527 South Arizona Avenue, Chandler, AZ 85248

Phone: (480) 655-8333 or (800) 528-8242

Fax: (480) 655-1712

For all other inquiries:

Crafco, Inc.

420 North Roosevelt Avenue, Chandler, AZ 85226

Phone: (602) 276-0406 or (800) 528-8242

Fax: (480) 961-0513

[CustomerService@crafco.com](mailto:CustomerService@crafco.com)

# SPECIFICATIONS

Vat Capacity.....	200 Lbs.
Pump Output.....	0.5 to 4 oz. per shot @ 20 shots per minute @ 425°F
Material Pump.....	Positive displacement piston.
Melting Tank.....	19" I.D. x 25" O.D. x 16" Deep 12 Ga. steel construction.
Maximum Heat Input.....	2500 watts of electrical heater band and (2) 800 watts heater and 260 watt heater cable.
Material Temperature Control.....	Electronic thermostat control to 550°F Adjustable overtemp safety control.
Hose Temperature Control.....	Electronic thermostat control to 400°F
Generator.....	6.5 Kw, 220/110 VAC. Air cooled .
Agitator.....	High speed, two pitched blade agitator.
Agitator Drive and Controls.....	90 VDC gear motor with electronic speed control,current limiting adjustment.
Safety Interlocks.....	Agitator and hose will not activate until the material is at the proper temperature.
Air Compressor.....	2.6 CFM @ 100 PSI, 2.5 gal. tank.
Dimensions.....	71" L x 42" W x 51" H.
Dry Weight.....	1200 Lbs.

# BAX 100ES MELTER

## INTRODUCTION

The CRAFCO BAX 100ES machine was developed to melt CRAFCO Brand Sealant. However, it will work equally well with all road asphalt and federal specification crack or joint sealant.

**DO NOT** operate machine without following these instructions:

1. Check engine crankcase oil level (refer to Engine Operator's Manual).
2. Main power switch and all toggle switches should be turned "OFF" and both temperature control dials at minimum settings.
3. Remember that safe operation of this equipment is the operator's responsibility.



### **CAUTION:**

Extreme care must be used when operating this equipment. Safety is the result of being careful and paying attention to details. Certain exposed parts of this machine, when operating reach 500°F.; the sealant as high as 400°F. Always wear protective clothing, hard soled shoes, and eye protection. Be sure that all joints and fittings are tight and leak proof. Immediately replace any hose, which shows any signs of wear, fraying, or splitting. Tighten all bolts, nuts, and screws every 250 hours.

# MACHINE START UP

## START-UP

1. Turn power switch to “**OFF**” position before starting generator. Be sure all other switches are in the “**OFF**” position and all adjustment knobs are set to their minimum setting (fully counter clockwise.)
2. Turn key to start generator, turn on breaker at generator and turn the main power switch to the “**ON**” position.
3. Turn the kettle temperature switch “**ON**” and set temperature control knob for approximately 425°F. Turn the agitator switch “**ON**” (Note: Agitator will automatically turn on at 300°F). NOTE! Hose temperature controller should be left in the “**OFF**” position until approximately 30 minutes before use. Material may coke in the hose if left in the “**ON**” position for long periods of time without operating.
4. Material temperature will begin to rise and the heaters will turn off automatically as the set temperature is reached. The temperature will continue to rise, due to thermal inertia, peak and then begin to drop. When the temperature of the material has dropped below the set point, the heaters will turn on automatically.
5. About 30 minutes before desired work time, flip the hose temperature switch to the “**ON**” position and set hose temperature control knob to 400°F. The hose will come up to temperature in approximately 30 minutes. After hose is hot, the light in the control box marked “HOSE CONTROLLER” will turn “**OFF**” and the temperature may be reduced to the manufacturers recommended temperature. The material pump will not start until Hose has reached at least 300°F.

## ADDING MATERIAL TO THE MELTER

Material may be added to the melter when hot or cold. The agitator must be turned off when adding material to tank.

1. Break bituminous material into small chunks. **NOTE! The smaller the size of the material pieces the faster it will melt.**
2. Lift lid of melter and slowly add material to the desired level. **DO NOT OVERFILL. DO NOT FILL MORE THAN 6 INCHES FROM THE TOP EDGE.**

***Important!*** Care should be taken to avoid getting foreign particles such as road gravel, dirt and debris in the material. Debris of this nature can clog or damage the output line and pumping system.

3. Material should be added a small amount at a time when in operation rather than in large quantities. This will prevent the material temperature from dropping excessively. Adding material on a continuous basis in small quantities is recommended.

# AGITATOR AND SPEED ADJUSTMENT

The agitator is powered by a gear reduced 90 Volt DC motor which can be run continuously to prevent settling of the filler in the material. The agitator speed can be varied by adjusting the control knob that is mounted at the main control panel. The proper start-up procedure is as follows.

1. The agitator will not start until the material has reached 300°F. Slowly, turn the knob on the agitator speed control to approximately 25% of maximum speed. Agitator should now start turning slowly.
2. Once the agitator has begun to turn, the speed may be adjusted to the desired RPM. When the material reaches operating temperature the speed should be adjusted to a minimum of 75%.



## DISPENSING THE MATERIAL



**NOTE: PROTECTIVE CLOTHING, GLOVES, HARD SOLED SHOES, AND FACE SHIELD OR SAFETY GLASSES SHOULD BE WORN WHEN OPERATING OR FILLING THIS EQUIPMENT. READ ENTIRE MANUAL BEFORE OPERATING.**

### Reed Switch Mode

Adjust the shot size by loosening T-Handle bolt at air cylinder and moving the switch assembly up to decrease the shot size or down to increase the shot size.

### Cube Timer Mode

Move the toggle switch from manual mode to auto mode. Adjust the shot size by rotating the knob counter-clockwise to decrease the shot size or clockwise to increase the shot size. The hose **MUST BE UP TO 350°F MIN** (heated approximately 30 to 45 min.) before dispensing. Depress trigger or switch then release and material will dispense up to a full shot (4 ounces), and return to the top of stroke.



**CAUTION!**

**NEVER POINT THE WAND AT ANY PART OF THE BODY OR AT ANY OTHER PERSON. HOT MATERIALS CAN CAUSE SEVERE BURNS. WEAR PROTECTIVE EQUIPMENT WHEN FILLING OR OPERATING THE EQUIPMENT. READ MANUAL BEFORE OPERATING EQUIPMENT.**



## LOADING THE MACHINE



**CAUTION!** Hot melt material can cause severe burns. Protective clothing and eye protection should be worn at all times when adding material or operating this equipment. Do not overfill the tank. Turn the agitator off when adding the material. Avoid getting any foreign particles, such as road gravel, dirt, packaging cardboard, and debris into the material tank. Such particles can clog the output line and/or seriously damage the pumping system.

The material may be added to the tank whether the melter is hot or cold. The best melting and agitating performance is when the tank is 1/2 to 3/4 full. Temporary jamming of the solid blocks is not harmful to the equipment. However, do not add more than four blocks at once. Instead, adding material on a continuous basis in small quantities is recommended.

Use sealant or adhesive packaged to fit into the lid opening. Contact CRAFTCO Inc. or your distributor if you have any questions regarding this matter.

Turn the agitator switch “**OFF**”, raise the lid, and slowly add material as recommended previously. Close the lid and turn the agitator switch “**ON**”. Should the agitator gearmotor start to surge, turn the agitator speed down or off for a few minutes.

## SHUTDOWN AND CLEAN-OUT PROCEDURE

There are several schools of thought about how much material should be left in the tank when shutting down the melter at the end of the shift. Craftco Inc. recommends leaving the melter about half full. This will give a fairly rapid heat up rate at the beginning of the next shift and will provide enough material to start dispensing before newly added material will melt. Also, if your material contains fillers which tend to settle, it is advisable to allow the material to cool off while agitating it until the material thickens to prevent the fillers from settling down to the bottom of the tank. The following procedure is recommended.

1. Turn the heated hose switch “**OFF**”. Turn heated hose temperature knob to the lowest setting.
2. Turn the material temperature knob to the lowest setting.
3. Wind the heated hose around the hose hanger (approximately 20” diameter). Do not kink or sharply bend the hose. Rotate the wand as you wind the hose to prevent wires from wrapping around hose and damaging wires. Insert the wand into the drip pan tube. Secure the hose on the hose hanger with the chain.
4. Turn agitator to the “**OFF**” position when the material begins to noticeably thicken (approximately 200°F).
5. Turn main power switch to the “**OFF**” position.



## ELECTRIC HOSE CARE AND CAUTIONS



Twisting and kinking of the electric hose (used on LF, BAX, SS60, and SS125 Melter) is the number one cause of hose failure.

When this happens, the electric heating wires are shorted out to the metal hose cover and the hose stops heating.

**This type of failure is not covered under the Crafcro warranty.**

To help prevent twisting and kinking and the resulting hose damage, the operator should:

- a. Do not move or use hose unless it has been turned on a least 35 minutes and set at a minimum temperature of 300°F.
- b. Make sure hose swivel between hose and wand moves freely.
- c. Limit the hose bending to a radius of 10 inches.
- d. Avoid bending the hose over sharp edges such as the edge of the frame or tank.
- e. Avoid twisting.
- f. Do not exceed 400°F. on the hose controller or material temperature.
- g. Follow all instructions of the melter as well as those in the instruction manual.
- h. Avoid pulling hose beyond it's limits.

# HOSE TRANSPORT INSTRUCTIONS

Remove hose from jib support and rotate jib support towards front of machine until it locks into position.

2. Wrap hose on hose hanger two complete wraps (Approximately 20 inch diameter).
3. Store wand tip in the drip pan



## **CAUTION:**

Hose damage will occur if:

- a. Hose is bent or moved when cold.
- b. Hose is twisted or bent at less than a 10 inch radius.
- c. Hose is moved prior to being turned on at least 35 minutes and set at 380°F.
- d. Operator crosses over or under hose causing hose to twist or wires between hose and wand connection to twist or wrap up.
- e. Swivel is cold and not free to move allowing hose to twist.
- f. Hose to wand wiring is pulled, stressed, or used to support the wand.

# MAINTENANCE

## RECOMMENDED TOOLS

These tools, while not required for the operation of the BAX machines, are necessary to easily and efficiently trouble shoot the equipment whether in the field or in the shop. All tools listed are recommendations. Equivalent brands/styles would be acceptable.

Volt ohm meter Micronta LCD Digital Multimeter #22-188. Available from Radio Shack Stores.

Clamp on ampmeter Amprobe. #4X221 available from W.W. Graingers Inc.

In addition these tools would be helpful for operation of the equipment.

Large and small folding allen wrench sets.

Assorted phillips and slotted head screw drivers.

Large pliers.

Large channel locks.

Gloves.

Safety glasses or face shield.

NOTE: All items may not apply to all machines.

## DAILY MAINTENANCE (OR EVERY 4 HOURS WHICHEVER IS LESS)

Check generator oil. Fill as required.

Check compressor oil level. Fill as required.

Drain moisture from tank.

Check air lubricator. Fill as required.

Inspect machine carefully for loose nuts and bolts, damaged hoses, duckbills etc.

## PERIODIC MAINTENANCE

Clean or replace intake filter. Change oil. Check vibration pads. (100 hours)

Agitator bearings (Lubriplate AR Shield Heavy)

Grease monthly.

# MAINTENANCE

Air Compressor See owners manual.

Replace the oil after the first hours of use.

Do not overfill with oil.

**Recommended Straight Weight 30 wt. (55 deg. and above).**

Check oil level daily.

Change oil every 100 hours or sooner if needed.

Clean air intake filter every 25 hours or sooner if needed.

Always operate with rubber vibration pads (feet) intact.

## Generator

See Generator Operator's Manual for schedule.

## Drip Pan

To clean up the drip pan melt the material in the pan with a propane torch.

## Battery

Check acid level weekly. Keep battery and terminals clean.

**NOTE!! PROTECTIVE CLOTHING, GLOVES AND FACE SHIELD SHOULD BE WORN WHEN OPERATING OR PERFORMING MAINTENANCE ON HOT MELT EQUIPMENT!!**

# MAINTENANCE CHART

		HOURS			
LOCATION	PROCEDURE	8	50	250	500
Generator check oil level	See generator instruction manual.	*			
Other generator maintenance	See generator operating and maintenance instructions.				
Generator	Check water level weekly.		*		
	First change (10 hours)				
	Subsequent changes (250 hours)			*	
	Check oil	*			
	Change oil				*
	For proper oil, see recommended fluids & lubricants.				

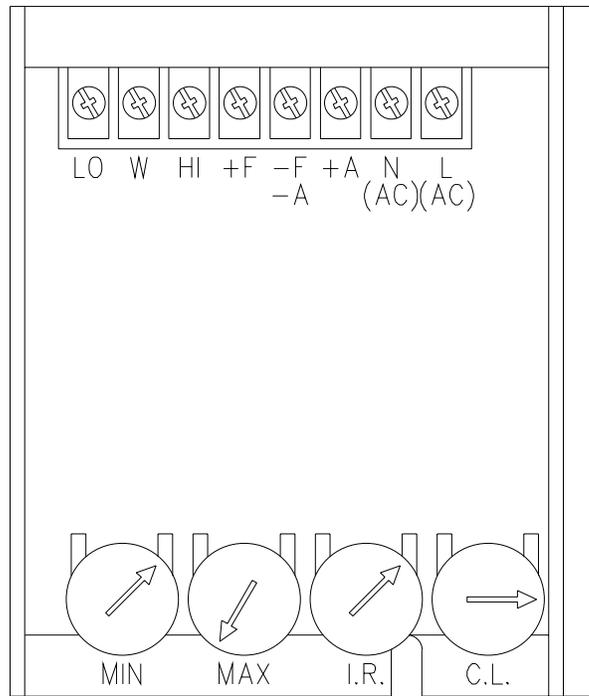
## SERVICE INSTRUCTIONS

1. Conduct a general inspection of your machine at least once a week. Replace all worn or damaged parts, make any necessary adjustments and tighten all loose nuts or screws.
2. Keep regular replacement items in stock for emergency repairs, to avoid costly “down” time.
3. Watch for leaks. Tighten fitting or repair as necessary.
4. Clean machine externally periodically. Check with sealant manufacturer for recommendation.
5. Follow recommended maintenance procedures on maintenance chart.

## RECOMMENDED FLUIDS AND LUBRICANTS

APPLICATION	RECOMMENDED	FULL POINT
Generator	NorthStar	See owners manual.

# SPEED CONTROL MODULE



**Figure 1**

MODULE	MINIMUM VOLTAGE, VDC	MAXIMUM VOLTAGE, VDC	I.R. COMP.	CURRENT LIMITER AMP. DC
AGITATOR	0.0	90.0	N/A	1.2

## SPEED CONTROL MODULE

BAX100ES melter is equipped with electronic speed control modules (part # 50234). These two modules allow the operator to control the speed of the agitator gearmotor. They also protect the gearmotor from being overloaded by limiting the maximum current through the motors. The modules are located inside the control box. If there is a necessity to replace one of the modules, the following installation procedure must be followed. The service of the modules should be performed by qualified personnel only, and appropriate safety precautions must be observed.

Melter power must be shut off and propane valves must be closed. Open the control box door and remove the front panel. Secure the front panel outside of the enclosure with plastic ties. Take a good look inside the box and make yourself familiar with the arrangement of components. The agitator control module is the one on the front. Record the wire arrangement on the module, disconnect the wires, and remove the module that is to be replaced.

On the new module, adjust the thumbwheel dials to the following positions (see Figure 1):

- MIN. 2:00 o'clock position
- MAX. 7:00 o'clock position
- I.R. 2:00 o'clock position
- C.L. 3:00 o'clock position

Install the new module in place and attach the wires.

Remove chain guards from the gearmotor bracket. Disconnect the chain if you are replacing the agitator module.

Remove the junction box cover on the top of the agitator gearmotor and attach DC voltmeter leads to the wire nut connections. Set the voltmeter to measure at least 130 volt DC.

Start up the generator as described in the Start Up section of this manual. Set all temperature controls and speed controls to the lowest settings. Then do the following:

- Turn "ON" the Burner switch, then turn "ON" the Agitator switch.

Slowly turn MIN. thumbwheel dial in the clockwise direction on the module until the gearmotor starts to rotate, then turn the thumbwheel dial in the counter-clockwise direction until the rotation stops.

Adjust the AGITATOR SPEED control knob to "10". Adjust the MAX. thumbwheel dial until the voltmeter reads 90 volts DC.

Check the rotation direction. The agitator motor must rotate in the clockwise direction, as looked at from the top of the motor. If needed, turn the power off and reverse the red and black gearmotor lead wires to reverse the direction of the rotation.

## **SPEED CONTROL MODULE (con't)**

Set all the speed control knobs to zero positions, turn all switches off, and shut down the generator. Remove the voltmeter leads and install the junction box cover into place.

Jam the gearmotor shaft with a small pipe wrench so the motor will not turn when the power is applied.

Attach a clamp-on AC ammeter around the wire that leads to the "L(AC)" terminal on the speed control module (yellow wire). Set ammeter to measure at least five amps AC.

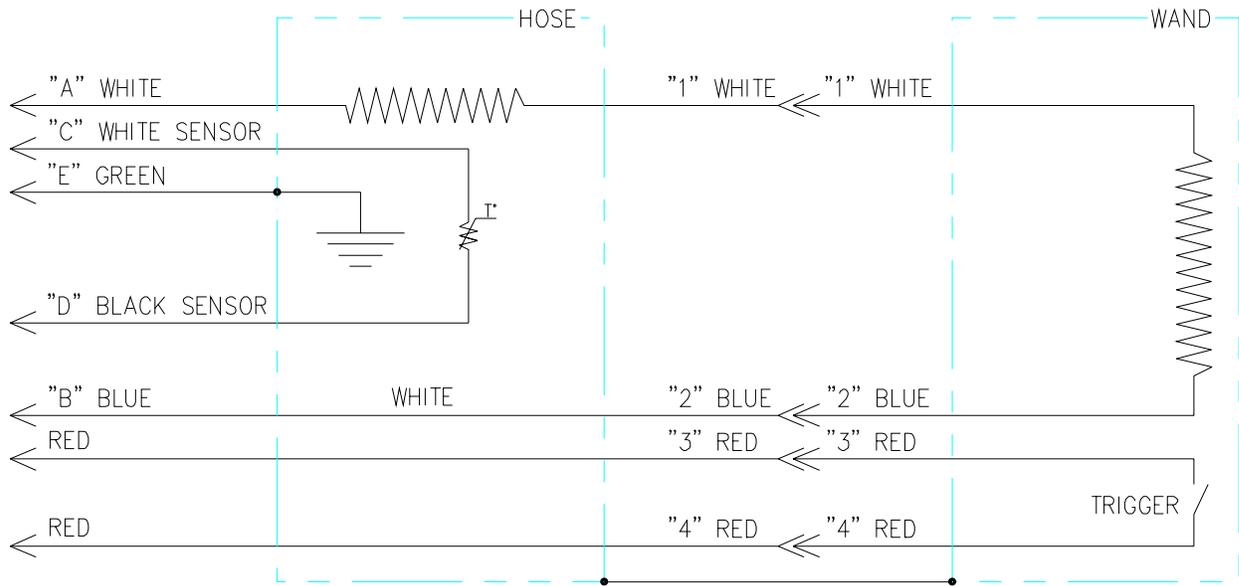
Start up the generator as described in the Start up section of this manual. Set all temperature controls and speed controls to lowest settings. Then do the following:

- Turn "ON" the BURNER switch, then turn "ON" the AGITATOR switch.

Slowly turn the agitator gearmotor speed control knob to "10". Turn the C.L. thumbwheel dial on the module to adjust the current to 1.2 amps. This is maximum allowable gearmotor current.

Set all speed control knobs to zero positions, turn all switches "OFF", release the trigger, and shut down the generator. Unlock the jammed gearmotor. Install chain and/or coupling. Install chain guards. Remove the ammeter from the control box and install the front panel

# HEATED HOSE AND WAND TESTING



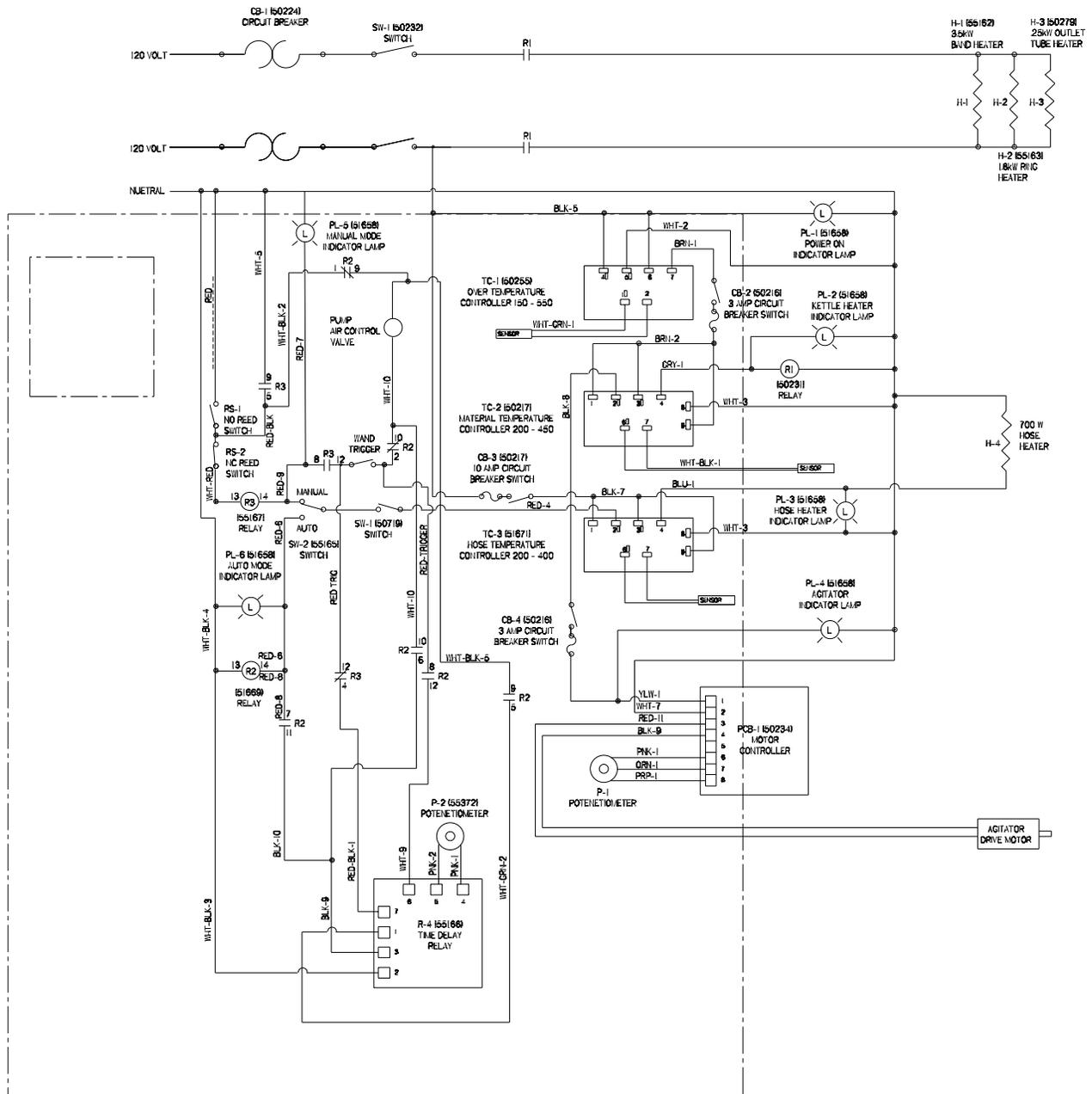
## 10' HEATED HOSE RESISTANCE AND CONTINUITY

Check Points	Resistance/Continuity	Note
A to #1	Continuity	
B to #2	Continuity	
C to D	1.08 Kohms	@ 70°F
E To Ground	Continuity	
B To #1	20 Ohms	
Red to #3	Continuity	
Red to #4	Continuity	
A or B To Ground	No Continuity	

## 24" HEATED WAND RESISTANCE AND CONTINUITY

Check Points	Resistance/Continuity	Note
#1 to #2	69 Ohms	
#3 to #4	No Continuity	Trigger released
#3 to #4	Continuity	Trigger squeezed
#1 or #2 to ground	No Continuity	

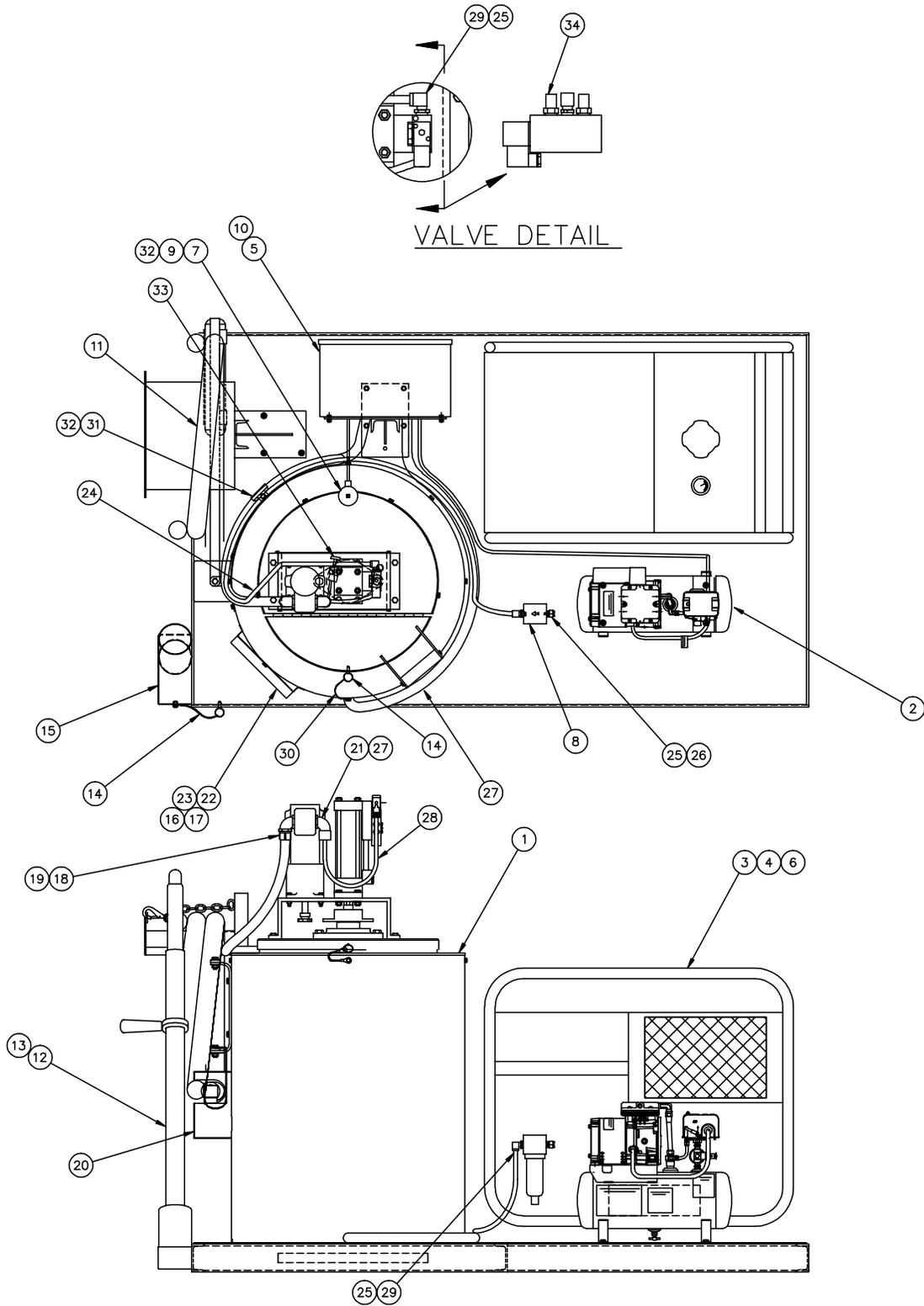
# ELECTRICAL SCHEMATIC



# PUMP TROUBLE SHOOTING

PROBLEM	CAUSE	REMEDY
Pump will not actuate. No movement at all.	Material not up to temperature. No air pressure. No voltage to valve. Bad switch in hand gun. Defective air valve. Defective drive cylinder. Obstruction in pump.	Continue to heat material.
Pump moves but does not make complete stroke. No material is dispensed.	Material not up to temperature. Hose not up to temperature. Duckbill valve obstructed. Hose plugged or obstructed. Hose twisted or kinked. Pump inlet obstructed.	Continue heating material.
Pump actuates and goes full stroke. No material is discharged.	Not enough material in melter. Hose not up to temperature. Pump rod disconnected from drive cylinder. Piston and or pump plate worn and will not seal.	Add more material or heating material until more liquid material is available.
Machine pumps, but dispensing is too slow.	Material not up to temperature. Hose not up to temperature. Hose setting too low. Air pressure too low.	Continue to heat material. Allow to heat longer. Set wand tip inside material tank.
Agitator does not turn, or turns sporadically.	Material not molten yet. Obstruction in melter jamming agitator. Brushes need replacement. Defective motor. Defective gearbox. Defective agitator bearings. Loose set screw at sprockets. Broken drive chain.	Find and repair. Remove and replace. Remove and replace. Remove and replace.
Hose does not get hot.	Hose not plugged in. Controller turned off or not set properly. Not enough time allowed for heat up. No voltage or low voltage from generator. Defective hose (Consult the factory). Defective Controller (Consult the factory).	Allow machine to cool. Remove deposits and flush with solvent. Repair/adjust.  Make sure fluid level is set at recommended temperature.

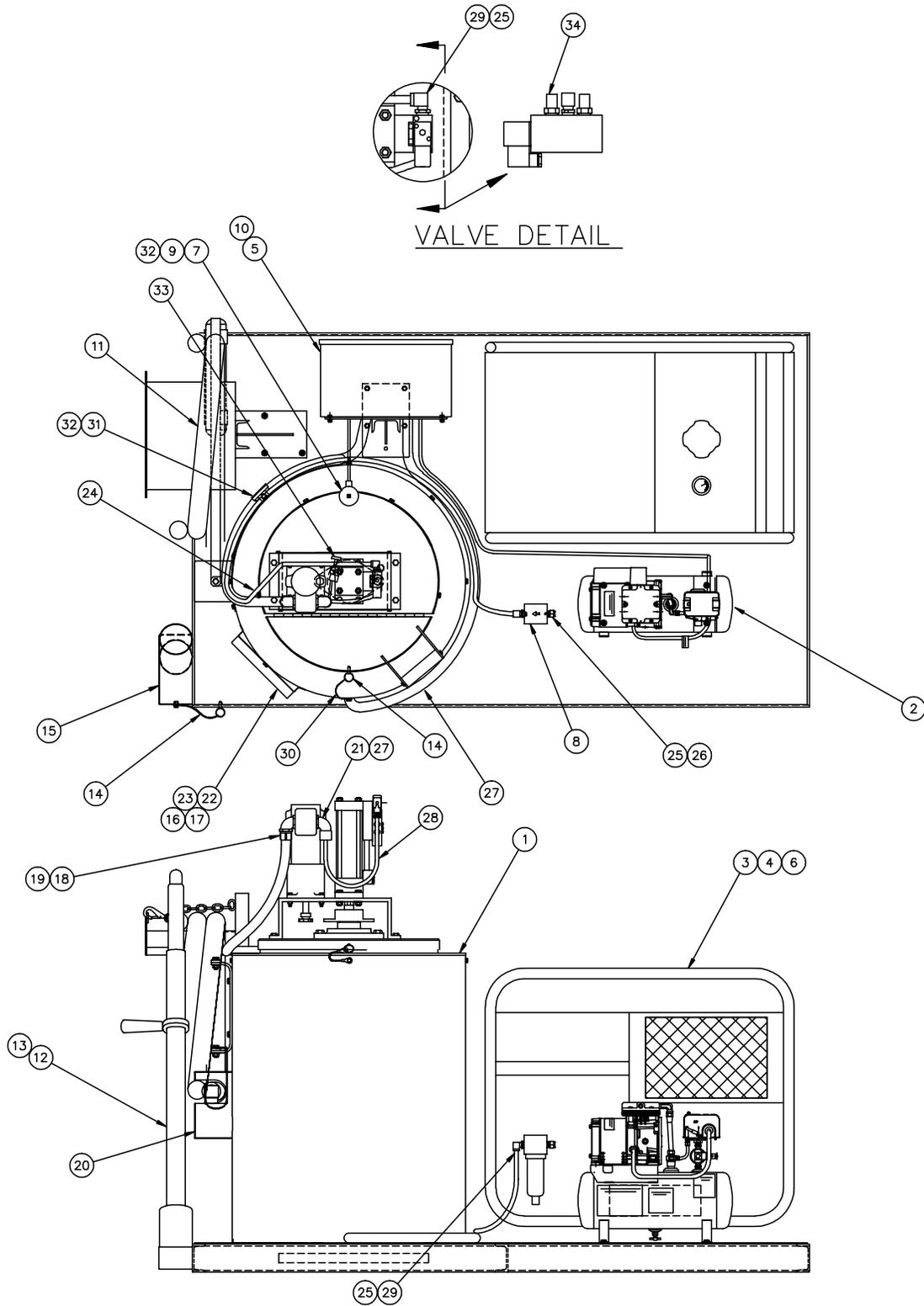
# BAX 100ES MELTER



## BAX 100ES MELTER

NUMBER	PART NUMBER	QTY	DESCRIPTION
1	55101	1	TANK AND FRAME
2	50457	1	AIR COMPRESSOR
3	50390	1	6500 WATT GENERATOR
4	50387	2	SPACER, GENERATOR
5	55130	1	CONTROL BOX
6	24076	1	HOUR METER
7	43465	1	SENSOR
8	55113	1	FILTER
9	55137	1	CABLE ASSY. - SENSOR
10	55138	1	POWER CORD
11	51702	1	HOSE ASSY. - 10 FT.
12	50036	1	24" HEATED WAND
13	50270	3	DUCKBILL VALVE
14	26103	2	1/4 X .5 QUICK PIN
15	55040	1	DRIP PAN
16	26221	1	SAFETY MANUAL
17	26375	1	PARTS MANUAL
18	40433	135"	1/2 SEAL TITE CONDUIT
19	40445	1	90° CONDUIT CONN.
20	41137	1	1" YELLOW INSULATION
21	51665	1	1/2" ELB. CORD. GRIP
22	25289	1	RECORD BOX
23	25290	1	BRACKET - RECORD BOX
24	29586	9 FT.	1/4' FUEL HOSE
25	28342	3	3/8 X 1/4 REDUCER BUSH.

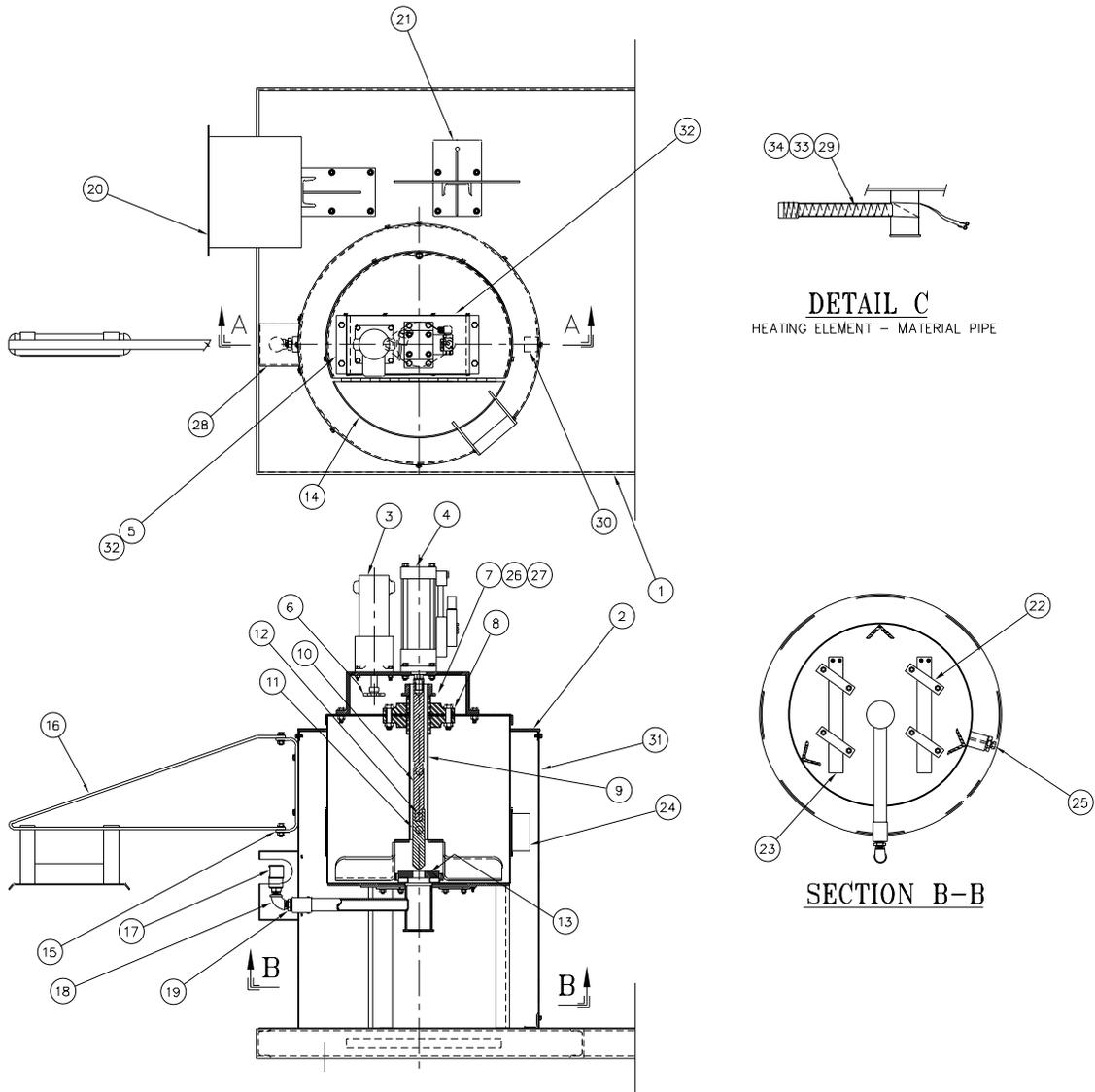
# BAX 100ES MELTER



## BAX 100ES MELTER

<b>NUMBER</b>	<b>PART NUMBER</b>	<b>QTY</b>	<b>DESCRIPTION</b>
26	28001	1	1/4" CLOSE NIPPLE
27	50280	1	1/2" CONDUIT NUT
28	55141	1	CABLE ASSY. - VALVE
29	28203	1	1/4 X 90° HOSE ELBOW
30	44157	1	IN ATTACHMENT CABLE
31	55120	1	SENSOR, 2" STEM
32	51065	2	CORD GRIP
33	55117	1	T-HANDLE SCREW
34	50163	2	AIR MUFFLER

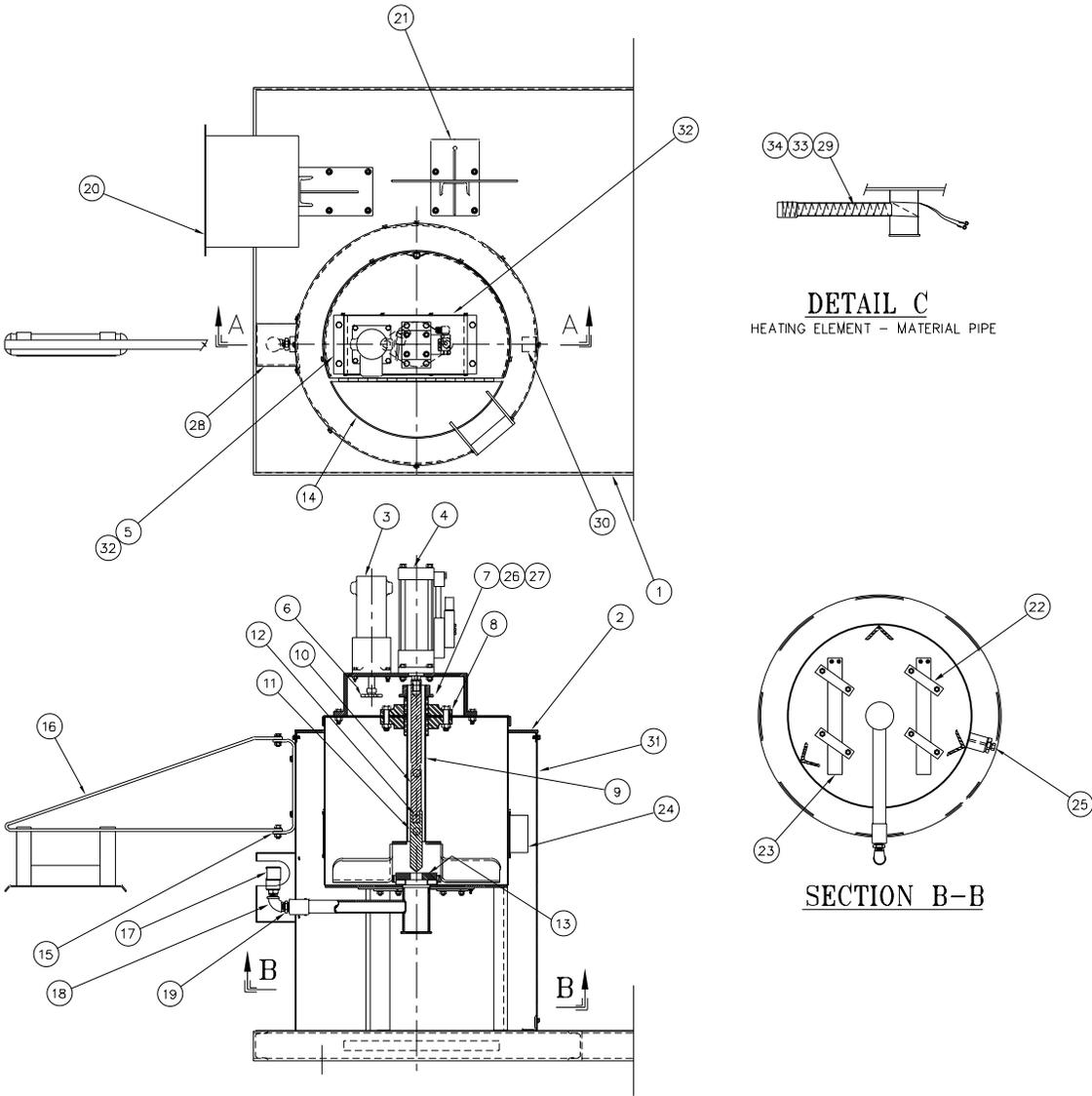
# BAX 100ES-TANK AND FRAME



## BAX 100ES-TANK AND FRAME

NUMBER	PART NUMBER	QTY	DESCRIPTION
1	55005	1	SKID FRAME ASSEMBLY
2	55125	1	MELTING TANK
3	55039	1	MOTOR, AGITATOR- 61 RPM
4	55104	1	AIR CYLINDER
5	55115	1	CYLINDER BRIDGE
6	55112	1	12T SPROCKET
7	55111	1	20T SPROCKET
8	50012	2	FLANGE BEARING
9	55110	1	AGITATOR
10	55119	1	PUMP ROD
11	50008	1	PUMP PISTON
12	29007	1	1/4 DIA. X 1-1/4 ROLL PIN
13	50007	1	PUMP PLATE
14	55126	1	MELTER LID
15	55012	1	BOOM SUPPORT BRACKET
16	55022	1	HOSE BOOM ASSEMBLY
17	55034	1	1/2" SWIVEL
18	28238	1	1/2" STREET ELBOW
19	28350	1	1" X 1/2" REDUCER BUSHING
20	55030	1	HOSE HANGER ASSEMBLY
21	55124	1	CONTROL BOX MOUNT
22	55127	4	HEATER CLAMP
23	50451	2	HEATER - 800 WATT
24	50223	1	HEATED BAND - 2500 WATT
25	28352	1	1" X 1/4 REDUCER BUSHING

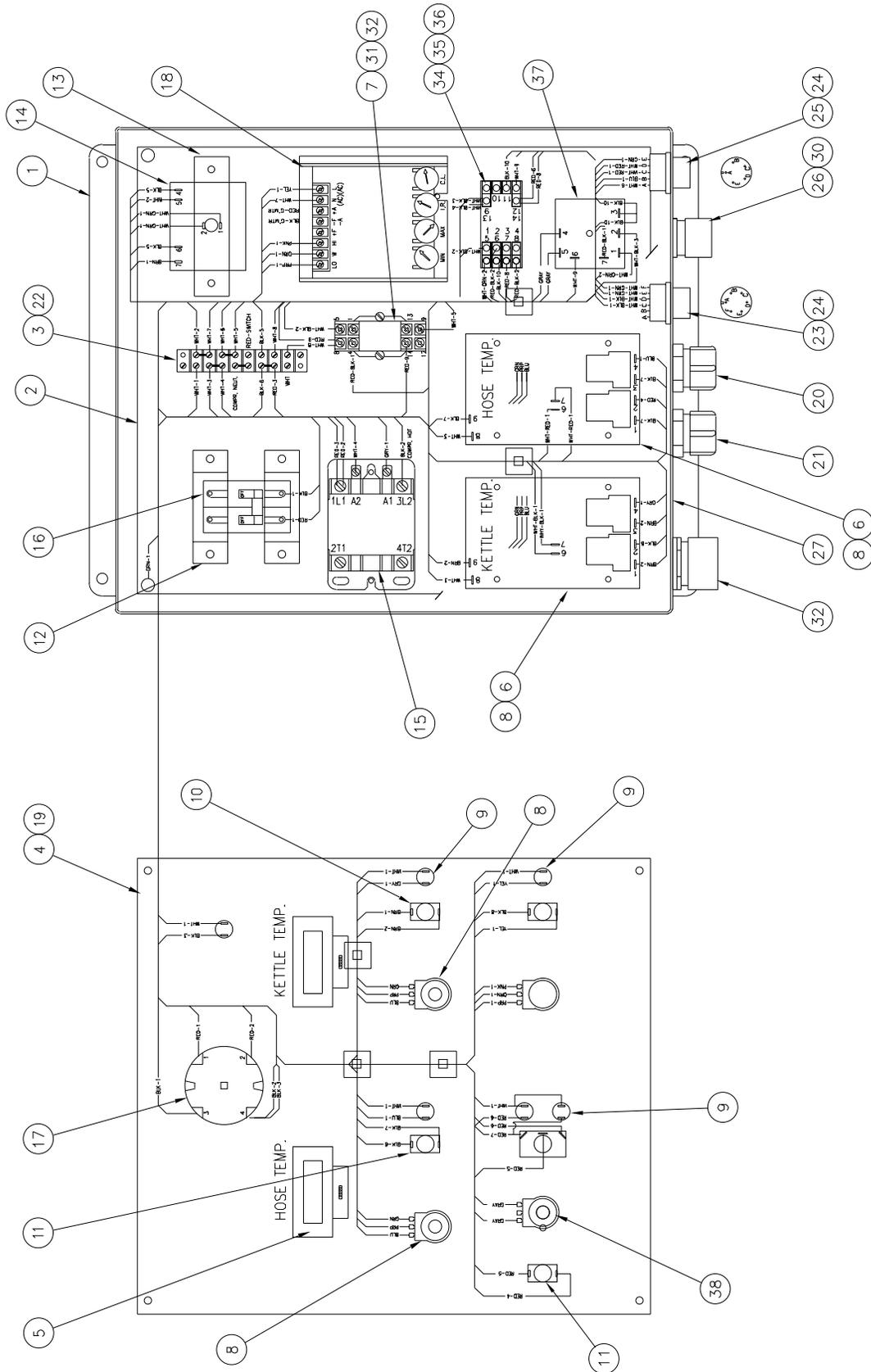
# BAX 100ES-TANK AND FRAME



## BAX 100ES-TANK AND FRAME

<b>NUMBER</b>	<b>PART NUMBER</b>	<b>QTY</b>	<b>DESCRIPTION</b>
26	50015	1	CHAIN, #40 - DRIVE
27	50436	1	CONNECTING LINK, #40
28	55011	1	HEAT GUARD
29	50279	1	HEATER CABLE - 260 WATT
30	50356	1	SKIN TAB
31	50361	1	OUTER SKIN
32	55116	2	CHAIN GUARD
33	50531	.2	ALUMINUM TAPE
34	50529	.2	FIBERGLASS TAPE

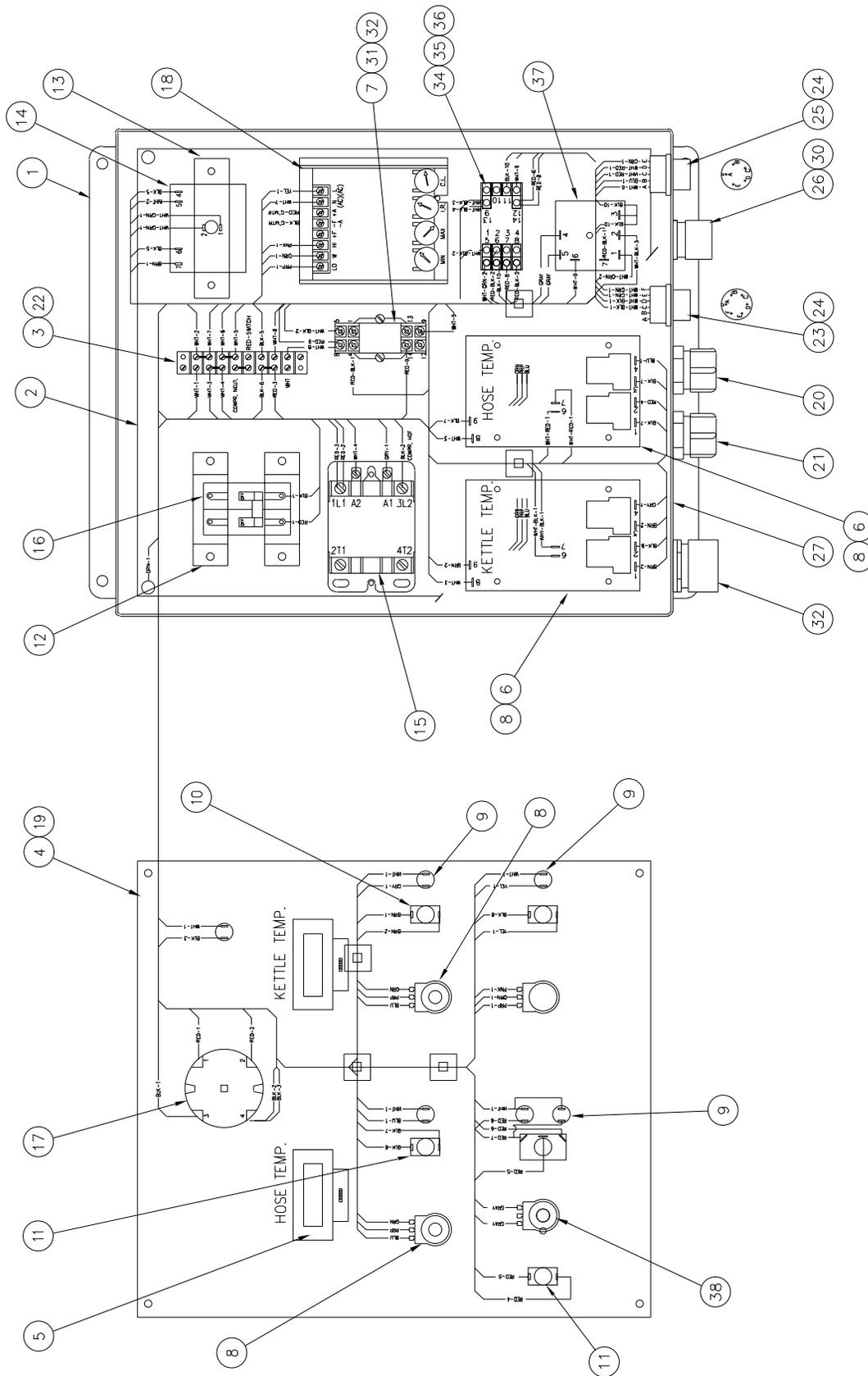
# BAX 100ES-CONTROL BOX ASSEMBLY



## BAX 100ES-CONTROL BOX ASSEMBLY

NUMBER	PART NUMBER	QTY	DESCRIPTION
1	55131	1	ENCLOSURE REWORK
2	55134	1	REAR PANEL
3	50250	1	TERMINAL STRIP
4	55133	1	FRONT PANEL
5	50251	2	LCD READOUT W/CABLE
6	51671	2	TEMPERATURE CONTROL, 200-400
7	51669	1	RELAY
8	50593	3	CONTROL KNOB
9	51658	6	PILOT LIGHT, 120VAC
10	50216	3	3 AMP CIRCUIT BREAKER
11	50217	1	15 AMP CIRCUIT BREAKER
12	50214	2	CIRCUIT BREAKER BRACKET
13	50381	1	OVERTEMP. DEVICE BRACKET
14	50255	1	TEMP CONTROL, 150-550
15	50231	1	MAGNETIC CONTACTOR
16	50224	1	40 AMP CIRCUIT BREAKER
17	50232	1	POWER SWITCH
18	50234	1	SPEED CONTROL MODULE
19	50287	1	FRONT PANEL DECAL
20	40449	2	1/2" CONDUIT CONNECTOR
21	50297	1	3/4" CORD CONNECTOR
22	50238	5	JUMPER
23	50517	1	6 PIN RECEPTACLE
24	50344	2	GASKET
25	50215	1	5 PIN RECEPTACLE

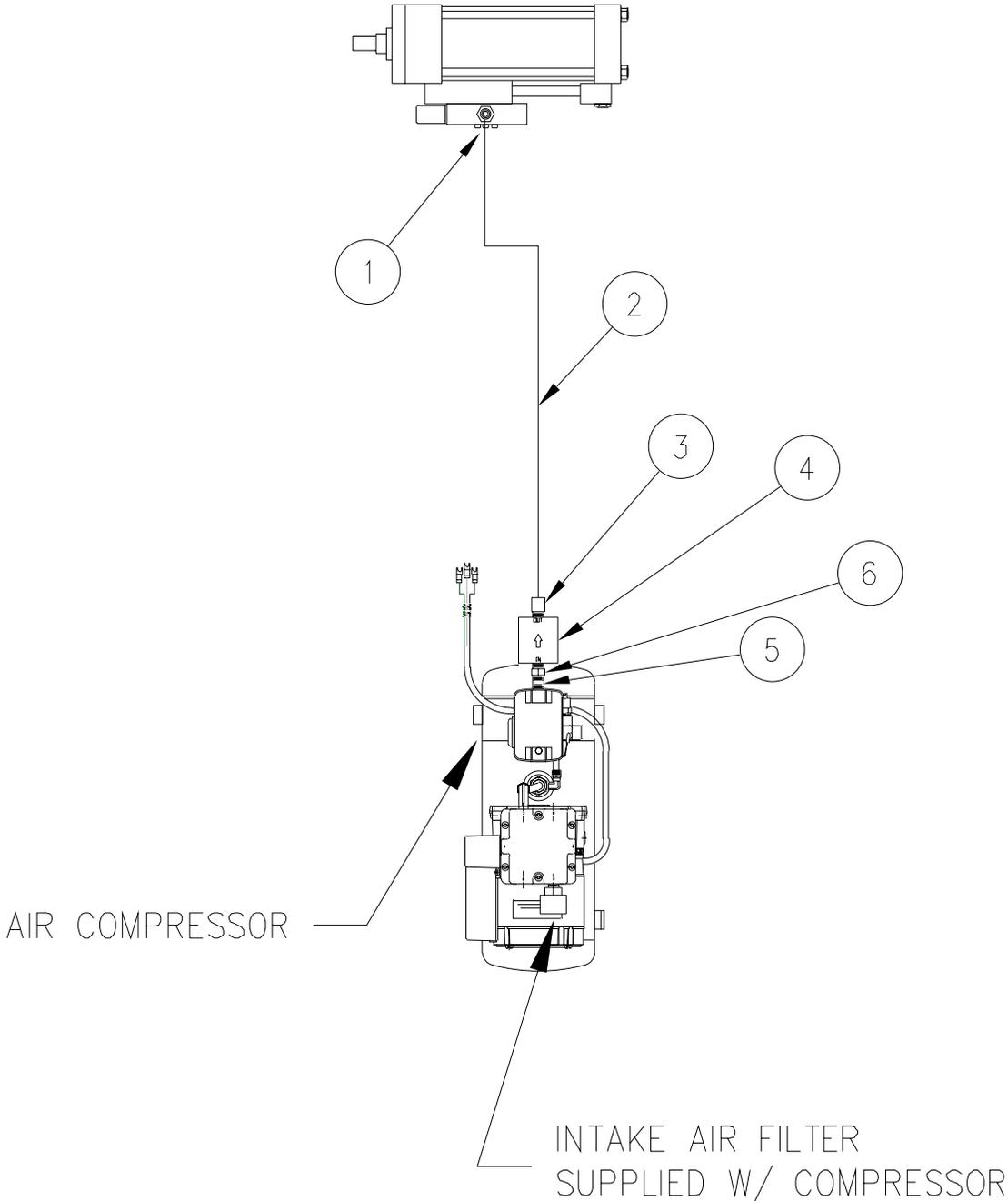
# BAX 100ES-CONTROL BOX ASSEMBLY



## BAX 100ES-CONTROL BOX ASSEMBLY

NUMBER	PART NUMBER	QTY	DESCRIPTION
26	51064	1	CORD CONNECTOR "WHITE"
27	24270	1	7/8" PLUG
28	25268	2	CLAMP (NOT SHOWN)
29	55136	4	STAND-OFF (NOT SHOWN)
30	50280	1	1/2 CONDUIT NUT
31	51662	1	BASE, RELAY
32	51663	1	HOLD-DOWN SPRING
33	51684	2	36" RIBBON CABLE
34	55167	1	4PDT 120VAC RELAY
35	55168	1	RELAY BASE
36	55169	1	HOLD DOWN SPRING (4PDT)
37	55166	1	CUBE TIMER 120VAC
38	55372	1	POTENTIOMETER

# BAX 100ES - AIR PIPING DIAGRAM



## BAX 100ES - AIR PIPING DIAGRAM

<b>NUMBER</b>	<b>PART NUMBER</b>	<b>QTY</b>	<b>DESCRIPTION</b>
1	28342	2	3/8 NPT X 1/4 REDUCER BUSHING
2	28203	2	ELBOW HOSE ADAPTER
3	29586	9FT	HOSE, 1/4" I.D.
4	55113	1	AIR FILTER
5	28012	1	1/4 X 1-1/2 PIPE NIPPLE
6	28342	1	3/8 X 1/4 REDUCER BUSHING





©Copyright 2014 by Crafico, Inc.