



USER MANUAL

COMBO605/606 and COMBO655/656



COMBO605

UNI-RAM CORPORATION • ONTARIO • CANADA

Revision 2011-07

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INTRODUCTION

Uni-ram holds many patents on designs used in its innovative products. Every machine is tested for compliance with Quality Assurance standards. Follow the instructions on preparation, use and operation to operate this machine safely and effectively. Ensure that this manual is readily available to the operator at all times. If you have any questions about the operation of this machine, contact:

North America:
Uni-ram Technical Service
1-800-417- 9133
Other Continents:
Contact Your Supplier

CAUTIONS AND WARNINGS

- The operator should wear protective clothing in accordance with local safety and environmental regulations, with a minimum of face goggles and gloves along with an apron and respirator if required.
- Always disconnect the power source before performing maintenance.
- **DO NOT SMOKE OR USE THIS EQUIPMENT NEAR A POTENTIAL SOURCE OF IGNITION SUCH AS SPARKS OR AN OPEN FLAME.** This unit must be located at least 6 feet (1.8 m) from all potential sources of ignition including electrical receptacles, switches, pilot lights, fixtures and contacts when installed in a non-hazardous locations.
- The ambient temperature must be between 5°C (41°F) to 35°C (95°F).
- **DO NOT RECYCLE NITROCELLULOSE WHICH IS EXTREMELY VOLATILE. IT AUTOMATICALLY IGNITES AT 135°C TO 166°C (275°F TO 330°F).** Do not install, operate or maintain this equipment where the auto ignition temperature of the solvent is lower than 250°C (482°F).
- Do not install, operate or maintain this equipment where the auto ignition temperature of the hazardous atmosphere(s) is lower than 250°C (482°F).
- Solvents that are recycled can be flammable. Establish and follow safe practices to store and handle solvents.
- Units must be installed by a qualified electrician and according to applicable laws.

LOCATION AND CONNECTION

This unit is certified for use in non-hazardous locations and hazardous locations

Class 1, Division 1 Group D and Class 1, Division 2, Group D.

- **Non-hazardous Location:**

If using a non-hazardous plug, the unit must be located outside of a hazardous location. In a non-hazardous location, we recommend that you use a receptacle located a minimum of 6 feet (185 cm) from the unit and a minimum of 30" (80 cm) from the floor. We also recommend that the unit be located at least 6 feet from any potential source of ignition such as electrical receptacles, switches, pilot lights, fixtures, contacts and similar equipment. To clarify the definition of an appropriate location, contact your local authority. This unit must be connected to the power supply only by a qualified electrician in accordance with the National Electrical Code.

- **Hazardous Location:**

In hazardous locations (Class 1, Division 1, Group D and Class 1, Division 2, Group D), the power cord must be connected to the main power supply by a qualified electrician, in accordance with the National Electrical Code. An explosion proof outlet (receptacle or hard wired) must also be used.

FEATURES AND SPECIFICATIONS

This unit combines into one cabinet the functions of a Uni-ram UG6000E or UG6000EH Automatic Spray Gun Cleaner and Uni-ram URS500 (120V) Solvent Recycler. All Uni-ram Solvent Recyclers feature rapid-start direct electric heating of solvent and a short cool-down time due to high-efficiency condensers and air cooling with a motor driven fan.

SAFETY FEATURES

- The Solvent Recycler component is certified under UL standard 2208 and CSA standards C22.2 No. 30 and No. 88 for use in non-hazardous locations as well as for use in hazardous locations Class 1, Division 1, Group D – T2C and Class 1, Division 2, Group D -T2C. The Gun Cleaner component (UG4000) is FM registered.
- Explosion proof construction (Recycler) and intrinsically safe electric circuitry.
- Computer controlled (Recycler) with many built-in safety programs including temperature control of all critical points including tank, condenser and fan motor.
- Self Diagnostic (Recycler) error messages are displayed on the Display Panel.
- Dual lid cover system (Recycler).
- Fume Vent (Gun Cleaner) for disposal of solvent fumes during gun cleaning.

RECYLER SPECIFICATIONS	
VOLTAGE(V)	120 (605&655) 240 (606&656)
CURRENT USAGE (A)	13.3
RECOMMENDED CIRCUIT AMPS	20
DISTILLATION TANK	ALUMINUM
DISTILLATION TANK CAPACITY	5 US GAL (20L)
CONSENER AND FITTINGS	COPPER
LID GASKET	NEOPRENE

UNIT SHIP WEIGHT	260 / 118 (LB / KG)
UNIT SHIP SIZE (INCL SKIDS)	40 X 17 X 42"

GUN CLEANER SPECIFICATIONS	
TANK SIZE	20 X 17 X 14.25"
AUTOMATIC WASH	YES
AUTOMATIC AIR FLUSH	YES
AUTOMATIC SOLVENT RINSE	YES
AUTOMATIC FUME VENTING	YES
FUME VENT CONTROL	YES
HOSE CLEANING	COMBO655 / 656
MANUAL RINSE WITH BRUSH	YES
BRUSH FLOW CONTROL	YES
CHOICE - MANUAL WASH SOLVENT	YES
GUNS CLEANED	2
NO. OF JETS	14
RINSE PUMP (METERING)	100 cc

PREPARATION AND SETUP

- Carefully inspect the shipping carton for any sign of transport damage.
- Carefully remove the unit from the shipping carton.
- Check the unit for damage. Report any transport damage immediately to the carrier and your vendor. Initiate a freight claim with the carrier. The manufacturer is not responsible for freight damage.
- A Liner Bag and Retainer Ring are already installed inside the distillation tank.
- Check the list of included parts. If any parts are missing, contact your supplier.
- Level the unit using the adjustable feet and install the two handles onto the front panel.
- Connect the ground wire at the back of the cabinet to an external grounded object.
- Attach a vent hose (not supplied) to the vent outlet on top of the machine. The duct system must not be under continuous vacuum. To stop or vary the rate of solvent venting from the tank upon opening, use the Vent Control Valve on the side of the unit.

CAUTION: USE ONLY GENUINE UNI-RAM LINER BAGS WHICH ARE 2 MIL THICK, LIGHT BLUE IN COLOUR WITH A SAWTOOTH EDGE AND A 3/16" WELD. THEY ARE SPECIALLY MANUFACTURED TO BE STRONG, HEAT RESISTANT AND CHEMICAL RESISTANT. USE OF A NON-UNI-RAM LINER BAG MAY VOID THE WARRANTY.

INCLUDED PARTS

MANUAL	
LID GASKET	RECYCLER
LINER BAG, 2 SPARES	RECYCLER
TRIGGER CLAMP AND PLUG KIT (2)	GUN CLEANER
NOZZLE ADAPTORS (2 OPTIONAL, 1 INSTALLED) NOTE: ADAPTER #780-3530 IS INSTALLED FOR USE WITH DISPOSABLE CUP SYSTEM ONLY	GUN CLEANER

SOLVENT REQUIREMENTS (RECYCLER)

This unit recycles flammable solvents and combustible solvents. Flammable solvents include lacquer thinner, paint thinner, acetone and other paint diluents. Flammable Solvents have a flash point below 38.7°C (100°F). These solvents are commonly used in the industry as cleaning solvents or paint diluents.

Dirty solvent to be distilled must meet each requirement described below. The Material Safety Data Sheet (MSDS) provides data on the properties of the virgin solvent.

- 1) The BP (Boiling Point) of the dirty solvent must be less than 200°C (392°F). BP increases with greater contamination.
- 2) The auto-ignition temperature of the solvent to be distilled must be higher than 250°C (482°F) for safe operation. Do not recycle Nitrocellulose. The auto ignition temperature is 135°C (275°F).

Notes:

- Recycle recently contaminated solvent only. Standing solvent can become acidic over time.
- To avoid “FISH EYE” problems, do not recycle both paint diluents and parts washer solvent in the same unit.

Waste Residue

The waste residue of some paints will remain moist after recycling due to the composition of the paint itself. A dry waste residue is not guaranteed.

DEFINITIONS

Flash Point: The lowest temperature at which the vapor of a solvent can be made to ignite momentarily in air.
Auto-ignition temperature (often referred to as “ignition temperature” or “ignition point”): the temperature at which solvent ignites by itself.

PAIL SETUP AND CONNECTIONS



The unit comes with the pails installed and connected. If the pails need to be reconnected, use this picture as a guide. For safety, make sure the ground wires are connected.

OPERATION

SPRAY GUN CLEANING

PRE - CLEAN

- Disconnect the spray gun from the air hose. Pour paint from the cup (when present) into a 5 gallon pail (not supplied).
- Rinse cup with solvent and pour into the same 5 gallon pail for later disposal or recycling.

CLEANING SPRAY GUNS AND CUPS

- Loosen the air cap of the spray gun two full turns.
- Lock the trigger in the open position with the Trigger Lock Spring.
- Plug air inlet of spray gun with cap to prevent solvent from entering passage. Caps are supplied in the accessory kit.
- Place spray guns facing corner jets. Placement depends on type of spray gun. See pictures below. Place cups onto the low spray jets and cup holders.

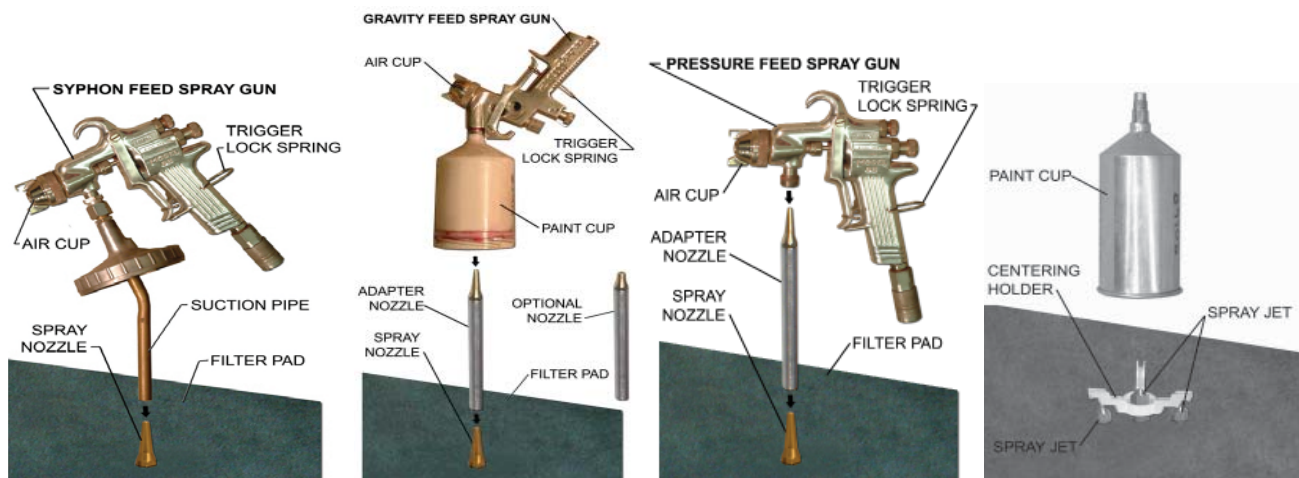
Note re: Gravity Feed Spray Guns: Some customers prefer to clean the cup separate from the spray gun.

- Close the lid and turn the "Auto Wash Timer" knob clockwise to start cleaning. The cleaning cycle takes about 60 seconds
- Push and hold the "Air Rinse" button for about 3 second to air-rinse the guns.
- Push and hold the "Clean Rinse" button for about 5 seconds to rinse guns with clean solvent. This will send a pre-set amount of clean solvent (100 cc) through the jets. Wait 30 seconds for the Rinse Pump to fully recharge before repeating.

The solvent flow per clean-rinse cycle is limited to 100 cc to minimize consumption. This quantity is usually sufficient to clean the inside passages of the spray guns.

USING THE MANUAL WASH and MANUAL RINSE FEATURES

- Open the lid and step on the foot left pedal. A dedicated pump delivers wash solvent through the brush.
- Open the lid and step on the right foot pedal. Clean solvent is delivered through the brush. Solvent flow through the rinse brush is limited to minimize clean solvent consumption.



HOSE CLEANING (COMBO655 / 656 ONLY)

- Models with this feature can be used to clean a paint feeder hose up to 100 feet (30 m) long. Connect the hose to the two fittings, one on the front and one on the right side. Rotate the “Mode Selector” handle to the horizontal position and turn the Timer knob clockwise to start the automatic cleaning cycle.
- To air-rinse the hose, push and hold the “Air Rinse” button.
- To rinse the hose with clean solvent, push and hold the “RINSE CYCLE CONTROL” button for about 5 seconds. This will use about 100 cc of clean solvent. Wait 30 seconds for the Rinse Pump to fully recharge before repeating.
- Disconnect the hose.

**FLOW CONTROLS (right side of unit)**

Two control levers on the right side of the unit allow the rinse solvent flow and the Brush solvent flow to be adjusted as needed. A third lever allows the Fume Vent to be turned OFF or ON.

SOLVENT RECYCLING

Wear protective clothing in accordance with local safety and environmental regulations. Use face goggles and gloves as a minimum. Use an apron and respirator if required.

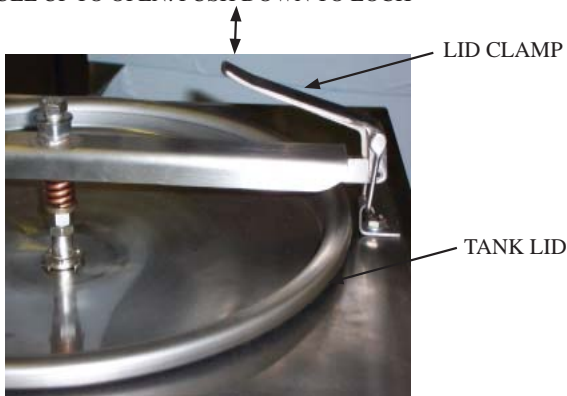
The unit is a self-contained gun cleaning / solvent recycling system designed to recycle the solvent used for cleaning guns. The unit can be used at any time to recycle used solvent either on an ongoing basis for separate storage or to replace the clean solvent used up during gun cleaning. The gun cleaner can be used while the recycler is in operation.

Recycling becomes necessary when the WASH PAIL (middle) becomes full or when the LOW LEVEL INDICATOR gauge indicates that the solvent level in the CLEAN SOLVENT PAIL is too low. At that point, the guns will no longer be cleaned properly. The level of solvent in the WASH PAIL should be checked regularly, especially during heavy use as this pail may fill up before the level in the CLEAN RINSE pail drops to the point where the LOW LEVEL INDICATOR gauge indicates that the level is too low. NOTE: the gauge only indicates the level correctly when the RINSE CYCLE CONTROL button is pushed.

1) Open the Tank Lid and Safety Cover

- Open the safety cover.
- Open the inner lid by releasing the Lid Clamp.
- Make sure that Tank is empty and that a Liner Bag is properly installed in the Tank.

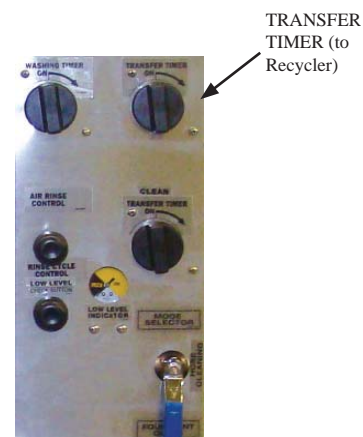
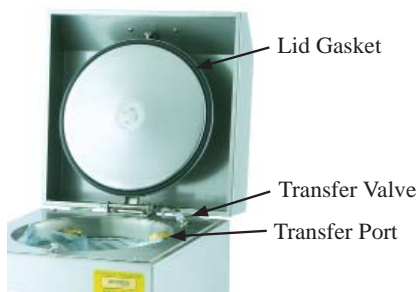
PULL UP TO OPEN. PUSH DOWN TO LOCK



2) Transfer Solvent TO the Recycler Tank

Verify that the solvent to be recycled complies with the requirements described in the section, Solvent Requirements.

- Open the Transfer Valve by turning the handle counter-clockwise 90°.
- Turn the Transfer Timer knob clockwise fully. Dirty solvent will flow from the Transfer Port into the Liner Bag and stop when the timer runs out.
- Close the Transfer Valve by turning the handle clockwise 90°.
- Close the tank Lid, lock down the Lid Clamp and close the Safety Cover.



- 3) Change temperature set point, as required. If the Temperature Set Point is satisfactory, skip this section.

Conditions to consider before starting Setup:

Minimize Temperature Set Point

After recycling there will be a small amount of solvent, about 1/8 US gal (500 ml), remaining in the distillation tank due to condensation. Select the lowest Temperature Set Point that recycles the solvent to this level.

Estimate Boiling Point

Add 45°C (81°F) to the boiling point of the pure solvent as shown on the MSDS (Material Safety Data Sheet) or another reliable source.

Recycle more often

The boiling point of the waste solvent mixture increases as it gets dirtier. To reduce the boiling point, recycle more often.

The display for the Control Panel is located at the top right corner of the base cabinet.

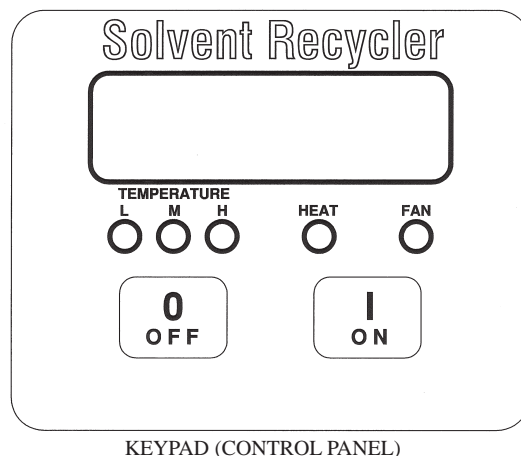
The LEDs for READY(L) and READY(H) on the control panel indicate the Temperature Set Point.

To Change the Temperature Set Point:

Make sure the “HEAT” and “FAN” lights are off. Press and hold the “OFF” button while pressing the “ON” button repeatedly to cycle through the 6 possible Set Points. If you go past the desired Set Point, continue to press the “ON” button until you cycle back to the missed Set Point.

TEMPERATURE SET POINTS	READY LIGHTS		
	L	M	H
90°C (194°F)	*		
115°C (239°F)	*	*	
140°C (284°F)		*	
165°C (329°F)		*	*
190°C (374°F)			*
200°C (392°F)	*	*	*

The Temperature Set Point is pre-set at the factory to 200°C (392°F) - all 3 lights are on.



4) Start Recycling

Press "ON" button. Distillation starts, "HEAT" and "FAN" lights come on. If you want to stop recycling press "OFF".

5) Finish Recycling CAUTION: DO NOT OPEN LID UNTIL COOLING IS COMPLETE

The clean recycled solvent is available for use when the heat lamp goes off. Recycling is complete and the the unit is ready for the next operation when "HEAT" and "FAN" lights are off.

6) Transfer Clean Solvent

a) For models without the Solvent Transfer System: remove the pail and replace with an empty one.

b) For models with the Solvent Transfer System: turn the Transfer Timer knob clockwise fully. The clean solvent will flow out of the Solvent Receiving Pail into either a free-standing, external container or the Clean Solvent Pail of a Spray Gun Cleaner. The transfer will stop whwn the timer runs out.

7) Remove Debris:

Remove the Retainer Ring.

Slowly pull the Liner Bag containing the debris out of the distillation tank in a way that the Liner Bag does not break.

Dispose of the debris in accordance with local regulations.

NOTE: If the bag sticks to the bottom of the tank, turn the recycler on for 5 minutes to loosen the bag from the bottom of the tank, then lift the bag out while the bag is warm.

8) Clean Distillation Tank and Lid Surface

Distillation Tank:

Wipe and dry tank with a cloth.

Remove any remaining debris from the Distillation Tank using if necessary, plastic or wooden tools. Do not clean with abrasive or hard metal instruments that can damage the tank. The warranty does not cover such damage.

Note: There will be about 1/8 Gal (500 ml) of solvent remaining in the Distillation Tank after recycling due to condensation. This solvent, If left in the tank, can cause corrosion. Dirt and debris left in the tank can prevent full heat from reaching the dirty solvent during recycling.

Caution: Acidic or chlorinated solvents typically cause corrosion on an aluminum tank. It appears as black pitting spots on the tank. Excessive pitting leads to an unsafe condition of holes in the walls of the tank and solvent leakage. Inspect your tank after each batch. If there is excessive pitting, call a Service Technician and replace the tank with a corrosive resistant, stainless steel one.

Lid Surface:

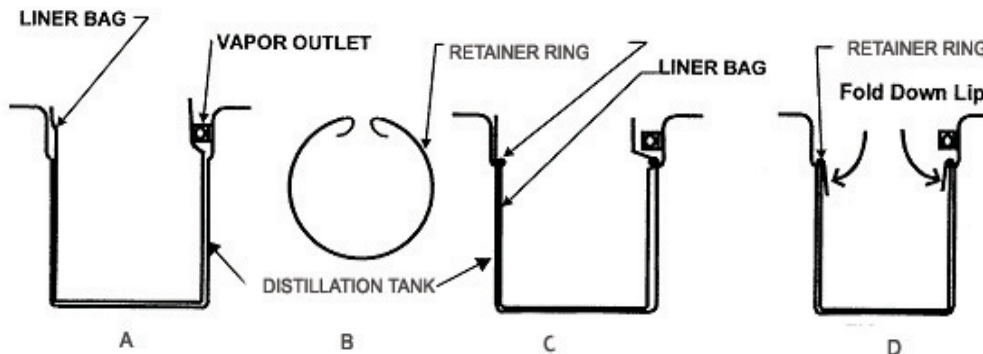
Use a cloth. Dry and clean the lid and the top of tank where the the Lid Gasket sits to extend the life of the Lid Gasket and prevent leakage. Avoid rotating the lid during cleaning. The lid gasket is a wear item.

9) Install new Liner Bag

Lift Recycler Safety Cover and Tank Lid fully; lids will stay in the open position.

- a) Install the Liner Bag so that the bottom of the Bag sits flat on the bottom of the Distillation Tank as shown.
- b) With thumb and index finger, squeeze the Retainer Ring and insert into inside of the Liner Bag. Let go and make sure it fits securely in the groove.
- d) Fold the flap of the liner bag over the retainer ring.

Caution: Ensure that the bag material does not block the Vapor Outlet.



NOTE: This is a schematic drawing only; not all components are exactly as shown.

10) Inspect Lid Gasket, Remove and Replace if necessary as required

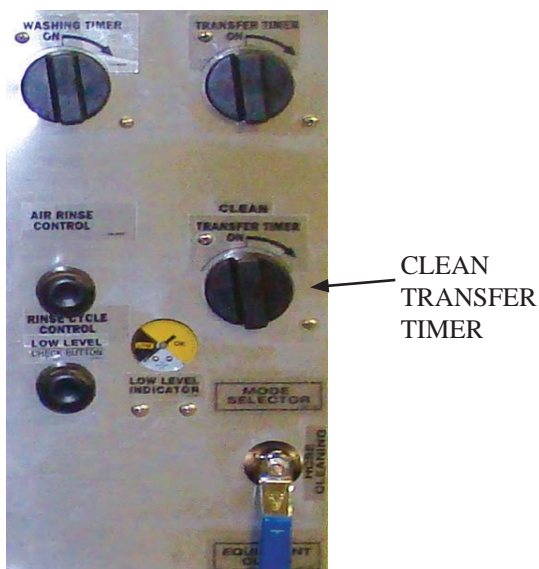
Inspect the Lid Gasket for shrinking, hardness and cuts. The Lid Gasket is a wear item as it is exposed to high temperature and solvent vapor during distillation. Damage to the lid gasket will cause solvent to leak.

To remove, open the Safety Cover and Tank Lid. Lift out the old gasket by hand and clean the cavity with a cloth. To Install, place the new gasket in the cavity, rub solvent or soapy water on the gasket to make insertion easier. Press the gasket firmly into the cavity all around.

Note: Keep a spare in stock. One extra is included with the unit.

11) Transfer Recycled Solvent back to the CLEAN RINSE PAIL.

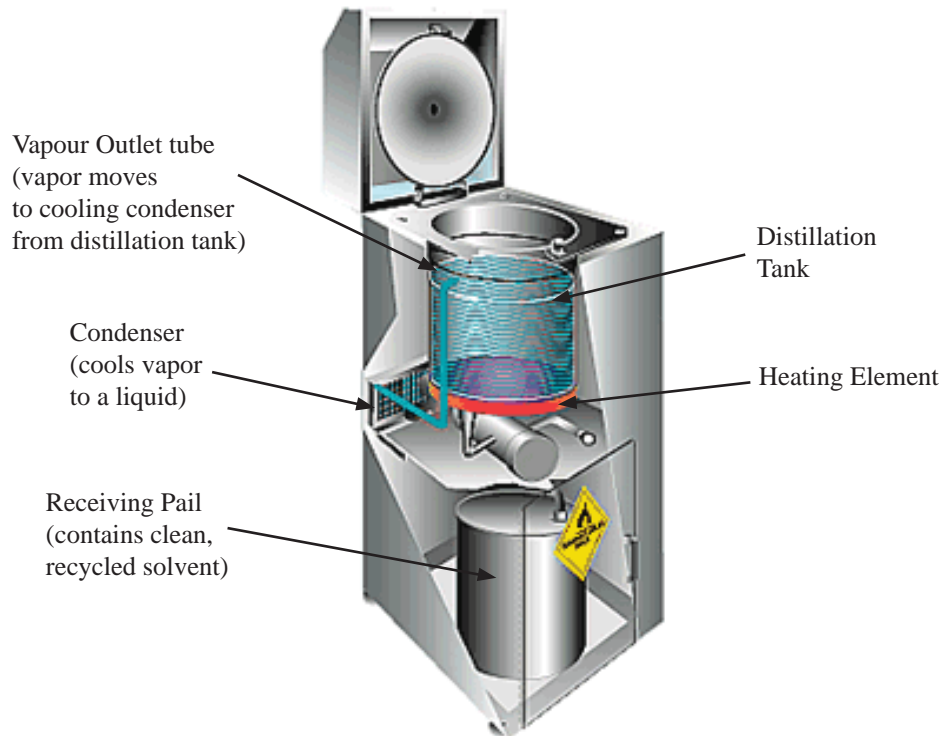
Turn the knob of the CLEAN TRANSFER TIMER (bottom right) fully.



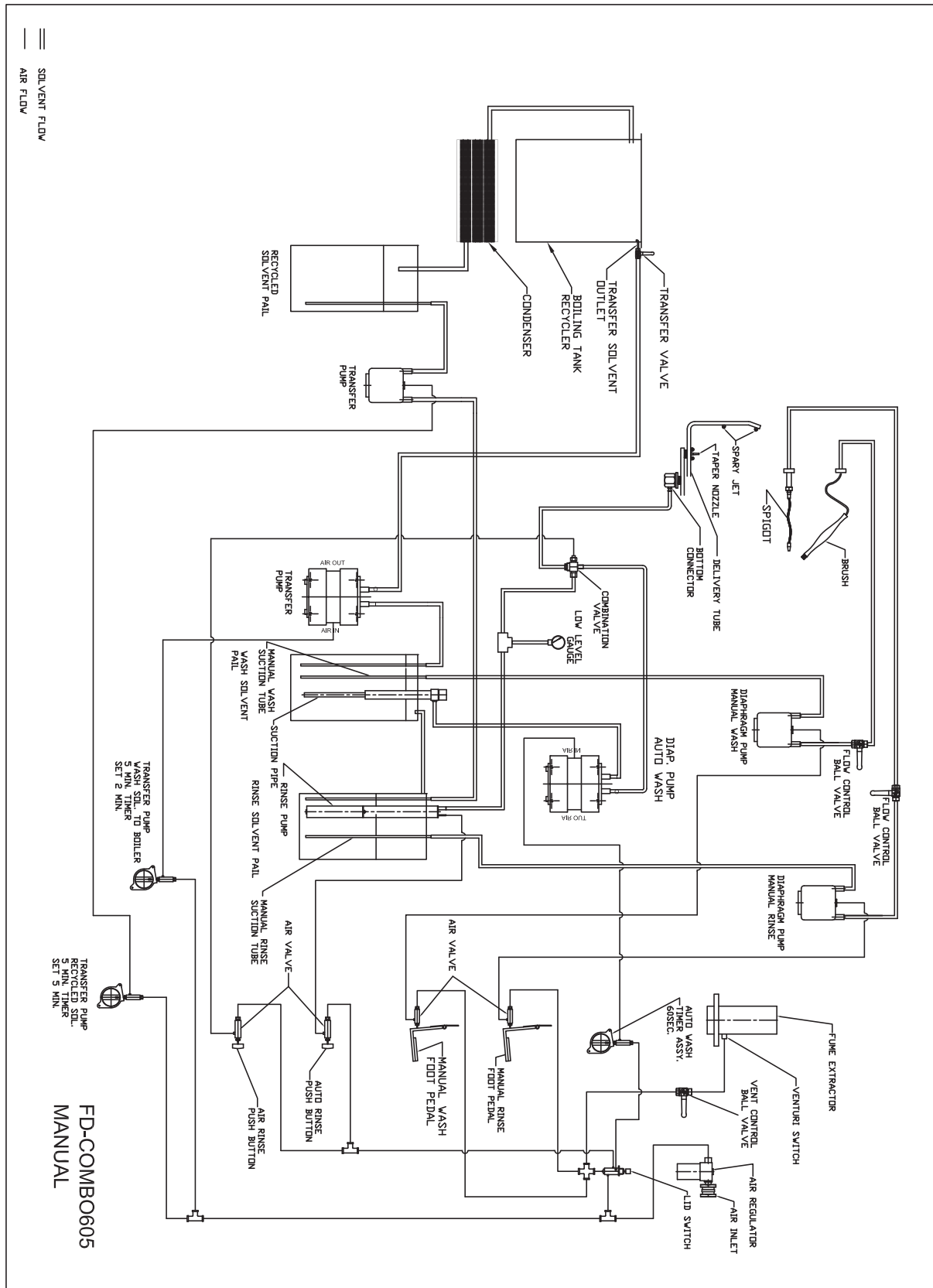
THEORY OF OPERATION - DISTILLATION PROCESS

Waste solvent consists of the original solvent plus liquid and solid materials picked up during use of the solvent. Recycling separates the original solvent from the waste materials. During the recycling process, the distillation tank fills with dirty solvent and the heating element heats the mixture. The solvent mixture boils and the vapour passes through a cooling condenser where purified, clean solvent, ready for use condenses out. Waste materials in the dirty solvent boil at a temperature substantially above the Temperature Set Point so they remain in the distillation tank for disposal.

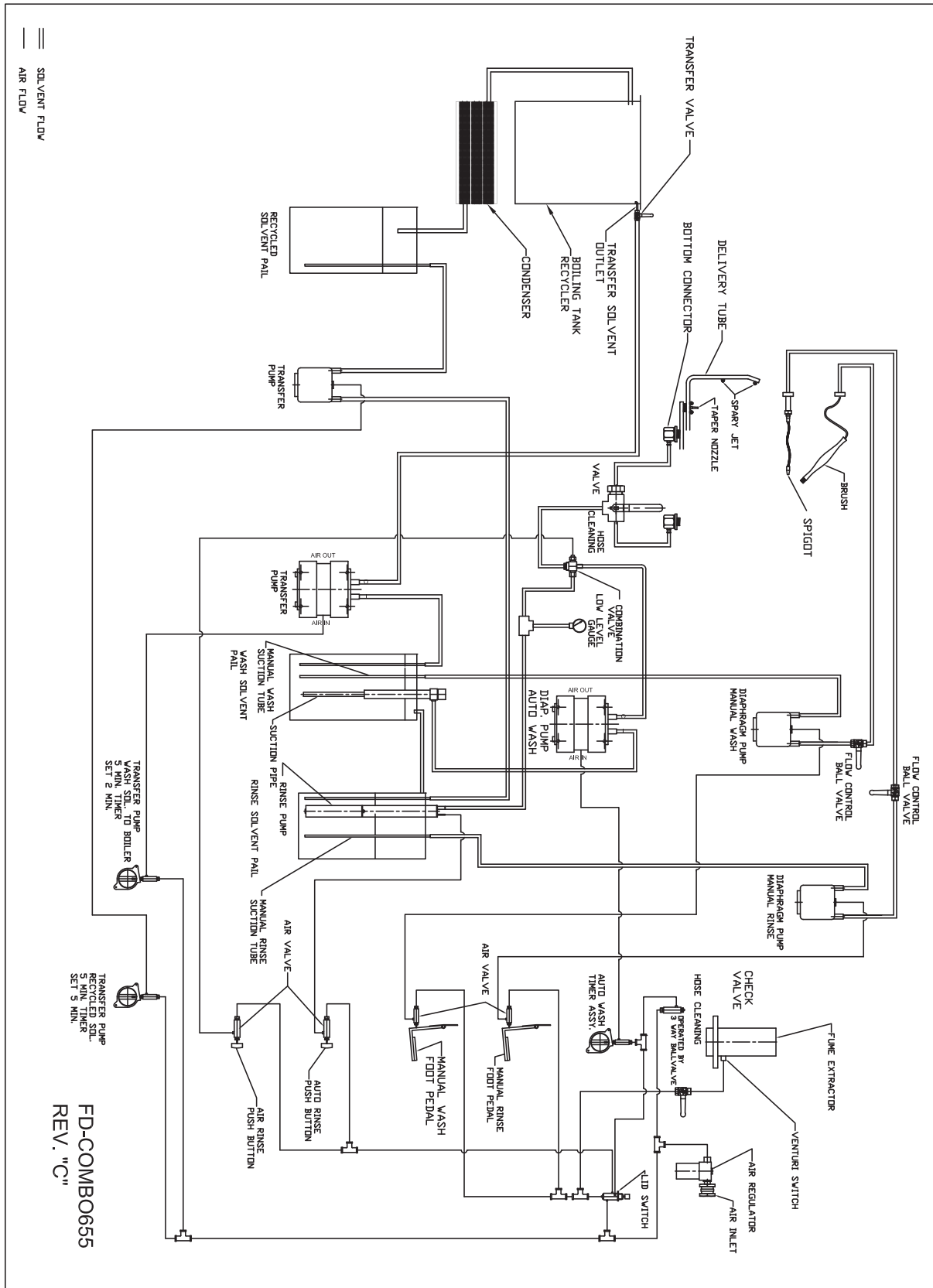
Solvent Recycling



FLOW DIAGRAM - COMBO605 / 606



FLOW DIAGRAM - COMBO655 / 656



TROUBLESHOOTING GUIDE

Carry out each action step until a solution is found. If the recommended actions do not solve the problem call Uni-ram Service in North America or contact a qualified Service Technician.

Caution: Disconnect the power supply before conducting maintenance or service.

PROBLEM	CAUSE	ACTION STEPS
Unit is plugged in, all the lights on the Panel are Off.	Power is not getting to the unit.	Reset breaker or replace fuse. If power is still not getting to the unit, call a Qualified Service Technician. Ensure that the unit is the only device on a circuit with sufficient capacity.
Unit is plugged in, "READY(L)" / "READY(H)" lights are On, Heat light fails to come on when "ON" button is pressed.	Power board or fuse not functioning.	Call Uni-ram Service
Recycled solvent is not clear	1) The solvent is reacting chemically.	1) Lower Temperature Set Point following Operating Procedure 4.
	2) The solvent flow path is dirty. One cause is overfilling the distillation tank.	2) To clean the path, follow Service Procedure 2 and then recycle 3 gal of clean solvent.
	3) Orange colour due to rust in receiving pail.	3) Place a jar under outlet tube and capture some solvent. If the solvent is clear, replace the pail with a non-corrosive one.
	4) Milky colour due to presence of water.	4) Eliminate source of water in solvent.
Dirty solvent remains in Distillation Tank after recycling Note: 1/8 Gal (500 ml) of recycled solvent is expected due to condensation.	1) Poor heat transfer due to dirt and debris left in the tank.	1) Clean the tank, replace the Liner Bag, recycle with pure solvent to test. If successful, the problem is due to a dirty tank, debris left in the tank or the solvent is too contaminated. Adjust accordingly. Follow Operating Procedures closely. If the level of contamination is too high, recycle more often.
	2) Boiling point of solvent is above Temperature Set Point.	2) Raise the Temperature Set Point and repeat the recycling operation. The Temperature Set Point should be the BP of pure solvent (as determined from the MSDS or other source) plus 45°C (113°F) to allow for contamination. If the boiling point is above the maximum Temperature Set Point for your model (200°C), dirty solvent cannot be recycled in this unit.
Liner Bag sticks		Turn unit on for 5 minutes and lift out bag while it is still warm.

PROBLEM	CAUSE	ACTION STEPS
Solvent vapor leaks from the Lid Gasket	1) Lid Gasket has excessive wear as indicated by cracks, shrinkage, hardness etc	1) Replace the Lid Gasket (See Operating Procedure 11).
	2) Solvent flow path is blocked.	2) Follow Service Procedure 2.
	3) Lid Tension not adequate	3) Follow Service Procedure 4.
	3) The Lid is not seated correctly.	3) Follow Service Procedure 5.
	4) The temperature SET-PT too high, resulting in excessively high solvent vapour pressure	4) Reduce the Temperature Set Point and repeat the recycling operation. If successful, continue to recycle using the lower Temperature Set Point.
Sections on Bag are brown and thin due to High Temperature	1) Use of inferior low temperature bag.	1) Use new genuine Uni-ram high temperature Liner Bag and recycle.
	2) Temperature Set Point is too high.	2) Reduce the Temperature Set Point and repeat the recycling operation. If successful, continue to recycle using the lower Temperature Set Point.
The computer appears to be operating erratically.	The computer may require re-booting.	Disconnect the power supply for 30 seconds. Restore power and operate unit.
Residue (puck) in Tank is too wet.	1) Not enough heat to vapourize the solvent.	1) Raise the Temperature Set Point
	2) Residue cannot be dried completely due to its composition.	2) None.

ERROR CONDITION CODES

The computer constantly monitors the unit as it operates.

AN ERROR CONDITION IS INDICATED BY FLASHING "READY" LIGHTS.

NOTE: On later models of the URS500, due to a change in software, the heater light may flash during normal operation. For all error conditions except for an error code "22" condition, the Heater light would be off.

To determine the error type, count the flashes of READY (L) before READY (H) flashes, then count the number of flashes for READY (H). For example, two flashes from READY (L) and then one by READY (H) indicates error code 21. Look up the Error Code on the Chart below. Press the "OFF" button to stop the error code and press the "ON" button to resume operation after the error condition has been corrected. If the error persists, call for service.

ERROR CODE	Flashing LED Lights		Description	Action Required
	READY (L)	READY (H)		
11	1 TIME	1 TIME	Open circuit - defective tank thermocouple	Contact Uni-Ram Service
12	1 TIME	2 TIMES	Open circuit - defective condenser thermocouple	Contact Uni-Ram Service
13	1 TIME	3 TIMES	Computer malfunction	Replace computer circuit board
21	2 TIMES	1 TIME	Open Heater Circuit - defective component; heater element, thermostat, wire conductor, blown fuse. A defective thermostat or wire terminal is the most likely cause.	Contact Uni-Ram Service
22	2 TIMES	2 TIMES	Defective heater triac; Heater is still "ON"	Disconnect the power supply immediately. Contact Uni-Ram Service
23	2 TIMES	3 TIMES	Condenser is overheating or thermostat is faulty.	Clean dirty Condenser following Service Procedure 1. If Thermostat is faulty contact Uni-ram Service
24	2 TIMES	4 TIMES	If code 23 condition lasts over 10 minutes, this code will show and operation is terminated.	1) Clean dirty Condenser. See Service Procedure 1. 2) Position the unit to provide 6 inches (15cm) all around the unit. 3) Check Cooling Fan or Fan Motor.
31	3 TIMES	1 TIME	a) Boiling did not occur within 45 minutes. Tank is either empty or there is excessive debris in liner bag or tank is dirty.	a) Clean Distillation Tank following Operating Procedure 7, replace liner bag, following Operating Procedure 9.
			b) Set-up point is too low.	b) Increase temperature set point following Operating Procedure 4 and recycle with virgin solvent
			c) Boiling point of solvent is above maximum set point.	c) Solvent cannot be recycled.

ERROR CODE	Flashing LED Lights		Description	Action Required
	READY (L)	READY (H)		
32	3 TIMES	2 TIMES	Micro Controller has been reset due to power interruption or drop in voltage during the recycling operation.	Press "OFF" and then "ON" buttons to resume operation. Disconnect power at the source for about 30 seconds. Usually nothing is wrong with the unit.
33	3 TIMES	3 TIMES	a) Recycling did not finish in 6 hours due to power interruption or excessive debris in Liner Bag	a) Clean Distillation Tank following Operating Procedure 7, replace Liner Bag, following Operating Procedure 9,
			b) Temperature Set Point is too low for the solvent.	b) increase Temperature Set Point following Operating Procedure 4 and recycle with virgin solvent
			c) Boiling point of solvent is above maximim set point.	c) Solvent cannot be recycled.

SERVICE PROCEDURES

1) CLEAN CONDENSER

Using a brush attachment, vacuum the condenser at the back of the unit.

2) CLEAR BLOCKED SOLVENT FLOW PATH

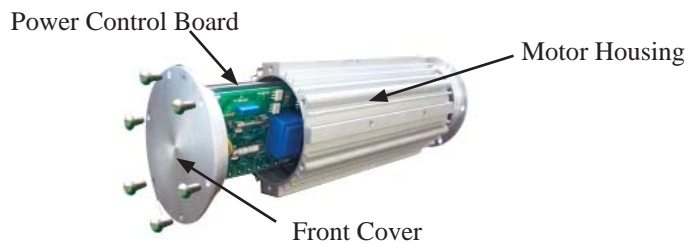
CAUTION: WEAR SAFETY GOGGLES.

A blockage in the solvent flow path (Vapour Outlet - Condenser - Solvent Outlet Tube) can cause solvent to leak. To determine the location of the blockage, first check the Solvent Outlet Tube and the Vapour Outlet Fitting for visible signs of blockage or damage. If the problem is not in either of these locations, the Condenser is probably blocked. To clear the condenser, pour some clean solvent into the Vapour Outlet and check if it comes out of the Solvent Outlet Tube. If the blockage persists, blow air at about 30 PSI (2 kg/cm²) into the Vapour Outlet. If the air comes out of the Solvent Outlet Tube, the blockage has been cleared. If not, call for service.

3) REPLACE FUSES

Fuses are located on the Power Control Board inside the Motor Housing.

- Disconnect power supply.
- Remove the Guard Screen by unscrewing two metal screws to get access to the Motor Housing



- Unscrew the 6 screws from the Front Cover and pull it gently from the motor housing to expose the fuses. Note: Care should be taken not to pull the Front Cover too far as some wires may disconnect.
- There are two fuses for the URS500 Type Solvent Recycler (COMBO605/655) and four fuses for the URS600 Type Solvent Recycler (COMBO606/656).

URS500 Type:

Fuses F1: 250 V 20.0 A 314 (Fast type) for Heater
Fuses F2: 250 V 2.0 A 312 (Slow type) for Fan Motor

URS600 Type:

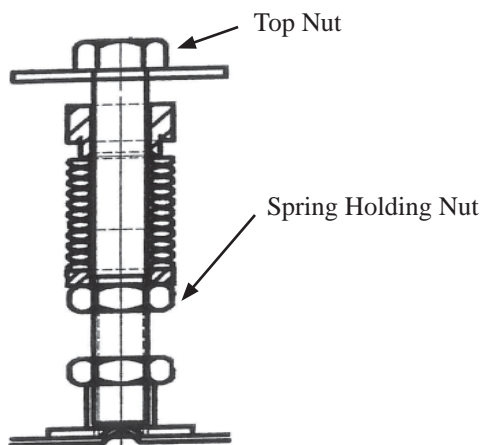
There are two each of F1 and F2 fuses.

- Remove the fuses from the board and, using a meter, test each one and replace as needed.
- Carefully push the Power Control Board back into the Motor Housing.
- Ensure that the wire to the computer board is secure.
- Re-install the Front Cover using all 6 screws..
- Install the Guard Screen using two metal screws.
- Close the Door and re-connect the power supply.

4) INCREASE LID TENSION (BY ADJUSTING SPRING BOLT)

CAUTION:

SHOULD BE DONE ONLY AS A LAST RESORT - FIRST CHECK FOR A WORN LID GASKET, A BLOCKAGE IN THE SOLVENT FLOW PATH, LOOSE HINGE OR CROSS BAR BOLTS OR A SET POINT THAT IS TOO HIGH FOR THE SOLVENT BEING RECYCLED.

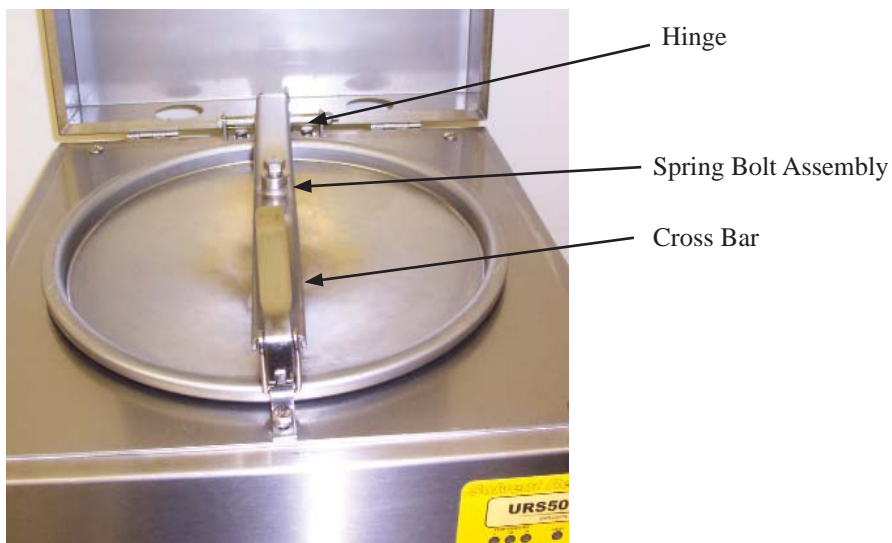


This procedure tightens the Lid by increasing the tension on the spring attached to the Lid Bar Spring Bolt Assembly. The Lid and Bolt Assembly is carefully designed as a Safety Pressure Relief system to prevent a dangerous build up of pressure inside the closed tank. Do not adjust the Spring Holding Nut by more than 2 full turns maximum. If 2 full turns do not solve the problem, call for service.

- While holding the top nut with a wrench, turn the nut below the spring no more than a 1/2 turn at a time. Turn in a counter-clockwise direction (as you look down on it).
- After each 1/2 turn, operate the unit normally and check for leaks.

5) REPOSITION LID and TIGHTEN HINGE AND CROSS BAR BOLTS

The Hinge bolts can loosen over time, causing the lid to shift off center. This can lead to an inadequate seal and leaking around the Gasket. Loosen the bolts, reposition the lid and re-tighten the bolts.



6) RECOMMENDED 6-MONTH MAINTENANCE

- Vacuum the condenser (see Service Procedure 1).
- Clean the solvent flow path by recycling 3 Gal of clean solvent.
- Inspect Distillation Tank for debris, pitting and/or other damage.
- Inspect Lid Gasket for wear or damage (see Operating Procedure 11).

REPLACEMENT PARTS

DESCRIPTION	PART NO.
Lid Gasket, Standard (Neoprene)	770-2150N
Liner Bag, Pkg of 10	LB900C-10
Trigger Clamp and Plug Kit, Pkg of 2	140-2340
Nozzle Adapter, Push On, Conventional Systems Only	110-430
Nozzle Adapter, Push On, Disposable and Conventional Systems	110-430PPS
Nozzle Adapter, Disposable Cup Systems Only	780-3530
Retainer Ring	770-9110

Full Product Warranty

These Uni-ram products have been engineered and manufactured to high performance standards. Each unit has been subjected to detailed factory testing before shipment.

This product comes with a one-year full warranty from the date of purchase. Uni-ram Corporation reserves the right to repair or replace the unit, free of charge, to the original purchaser if a part is found to be defective in material or workmanship as determined by factory service personnel. The items listed below under "Conditions of Warranty" as consumables are not covered.

Uni-ram reserves the right to direct the customer to ship the unit collect to the Uni-ram factory or to an approved Service Center for repair using the Uni-ram Return Goods Procedure or to repair the unit on-site. To prevent damage in transport, the purchaser must ship the unit in the original packaging or use alternate adequate packaging. All units must be shipped clean and free of solvent.

Conditions of Warranty:

As Uni-ram Corporation has no control over the working conditions or circumstances under which the purchaser stores, handles or uses the product, Uni-ram makes no warranty or claim, either expressed or implied with respect to this product's fitness for any purpose or the result to be obtained from its use. This condition applies to the sale of all products and no representative or distributor of Uni-ram Corporation has the authority to waive or change these conditions.

This warranty applies only to the original purchaser and does not apply if the unit has been misused, overloaded, neglected, altered or used for any purpose other than those specified in the operating and installation instructions. Deterioration due to normal wear is not covered by this warranty. Damage due to accident, transportation, fire, floods or acts of God is also not covered. Units whose serial numbers have been altered or removed are not covered. The warranty is invalid if unauthorized abrasives are used in this unit. Unauthorized attempts at self-repair or alterations by the owner also invalidate this warranty. Interior or exterior finishes are not covered by this warranty.

Consumable Items are not covered by this warranty.

This warranty replaces all other warranties expressed or implied by statute or otherwise.

To make a claim, call Uni-ram Service at 1-800-417-9133 and quote the serial number of the unit.

USE ONLY GENUINE UNI-RAM LINER BAGS WHICH ARE 2 MIL THICK, LIGHT BLUE IN COLOUR WITH A SAWTOOTH EDGE AND A 3/16" WELD.

THEY ARE SPECIALLY MANUFACTURED TO BE STRONG, HEAT RESISTANT AND CHEMICAL RESISTANT.

USE OF A NON-UNI-RAM LINER BAG MAY VOID THE WARRANTY.