



UFS Corporation

330 North 400 East
Valparaiso, IN 46383-9704 USA
PH: 219-464-2027 FAX: 219-464-8646
www.ufsc.com
email: service@ufsc.com

Service Reference

Topic: Converting a Flushable ME Cell to a Bare Electrode

Please read all the instructions listed below carefully to familiarize yourself with the project before attempting to perform any of the work or unpacking any further.

Required Materials

- Electrode Holder (call UFSc) or old Membrane Shell
- D.I. Water,
- 5 minute epoxy, or PVC shrink wrap

Required Tools

- Crescent wrench, Pliers, matt knife
- Saw Horses

Occasionally, a flushable Cell may need to be changed to a bare Electrode. Since the Electrodes in TECTRON™ Cells are usable without the Membrane Shells, TECTRON Cells can easily be converted from flushable to bare Electrodes. The Membrane Shells can be stored and re-used at a later time if desired.

1. Turn off the power to the system and lock out the DC rectifier with your own lock. Disconnect the Cell Cable Lead quick connect.
 2. Turn off ¼" supply valve and remove the supply tubing from the top of the flow indicator. Remove the Return tubing from the Overflow Nozzle and the Return Manifold. Pull the Electrode from the e-coat tank.
 3. After the Electrode has been removed, rinse it off using a D.I. water hose. Place the Electrode on the sawhorses. Working at the bottom of the Electrode, pull out the PVC C-ring with pliers. Grasp the black boot with pliers and pull the boot and the supply tubing out of the Electrode. If unable to reach the black boot, insert a small diameter pipe in the top of the Electrode and push the supply tubing and boot out. Save these parts for future needs. Brush on a thin layer of two-part epoxy on the portion of the Electrode pipe where the tab was welded to insulate, or use PVC shrink-wrap to cover the portion of the Electrode that was heated up during the welding of the Electrode Tab.
 4. Remove the Membrane Shell from the Tank. Refer to Bulletin 990134 for long-term storage instruction, if you have purchased a new Electrode Holder, skip to the next step. If you want to convert an old Membrane Shell into an Electrode Holder, remove the membrane Guard, if necessary. Use a sharp matt knife to cut away the outer wrap and membrane with a series of two circumferential cuts at the cap and collar and a longitudinal cut down the length of the membrane. Do not cut through the inner support tube. Finally drill a 12.7 (1/2") hole in the bottom center of the PVC cap to allow ED paint to drain.
 5. Cut off a portion of the bottom of the Electrode about 30 mm x 30 mm to form a bevel.
 6. Place the Electrode Holder (or modified Shell) in the same location as before and secure with two clamps.
 7. Place the Electrode into the holder in the tank.
 8. Reconnect the Electrical Cable Lead.
- For more information** See the original manual that came with the equipment or call UFSc at the phone number shown above.