

## Hulon McCraw Waxing Procedure

It is essential that the ironer is at full working steam pressure, and has been run for a minimum of 15 minutes, with the fans either on or off. (See the section on the warm up period) Before the waxing procedure can be carried out.

This is to ensure that all the air and condensate has had time to be expelled from the ironer beds, and the calendar clothing has had time to dry out.

For the best results it is advisable to use an abrasive cloth. A good quality wax and a wax conditioning cloth.

The Procedure:

- 1) Remove any broken guide tapes from the roller and replace any missing tapes.
- 2) Turn the fans off
- 3) Set ironer speed at between 10 and 15 F.P.M.
- 4) Feed the abrasive cloth across the full width of the ironer. (This may take 3 passes).
- 5) Feed the wax conditioning cloth into the ironer. Be ready to stop the ironer when the flap is level with the feed bands.
- 6) Spread 1-2 handfuls of wax evenly under the wax flap and start the ironer.
- 7) It is advisable to stop the ironer for about 5 seconds, whilst the cloth is under the first roller. This is to ensure that the melted wax is deposited in a vital area, the first lip and bed.
- 8) Repeat this procedure across the full width of the ironer but only add ½ -1 handfuls of wax to the remaining passes.
- 9) Some laundries use an old cotton sheet to remove excess wax after this procedure.
- 10) Remember to switch the fans on prior to starting production.

N.B. Waxing should be carried out at least twice a day. (Well wax impregnated cloths or low production machines may not require any wax to be added to the mid-day procedures)

It is advisable to hang the conditioning cloth over a bar, alongside the ironer, in order for it to remain warm and supple, rather than fold it and store it in a cooler place.

Ironers designed with the fans to operate when the machine is switched on should be rewired to incorporate a separate fan on/off switch.

Failure to switch fans off during the waxing procedure will result in:

- a) Wax being sucked straight into the clothing causing premature discoloration and hardening.
- b) Clogged pores of calendar clothing, causing reduced permeability.
- c) Blocked fans, trunking and ducting, resulting in reduced drying capability.
- d) Re-deposit of wax from the calendar clothing onto the linen being fed through the ironer.
- e) Inadequate amount of wax actually left on the bed of the ironer.

Over-waxing will have a very similar effect as to the above items listed a), b), c) & d).