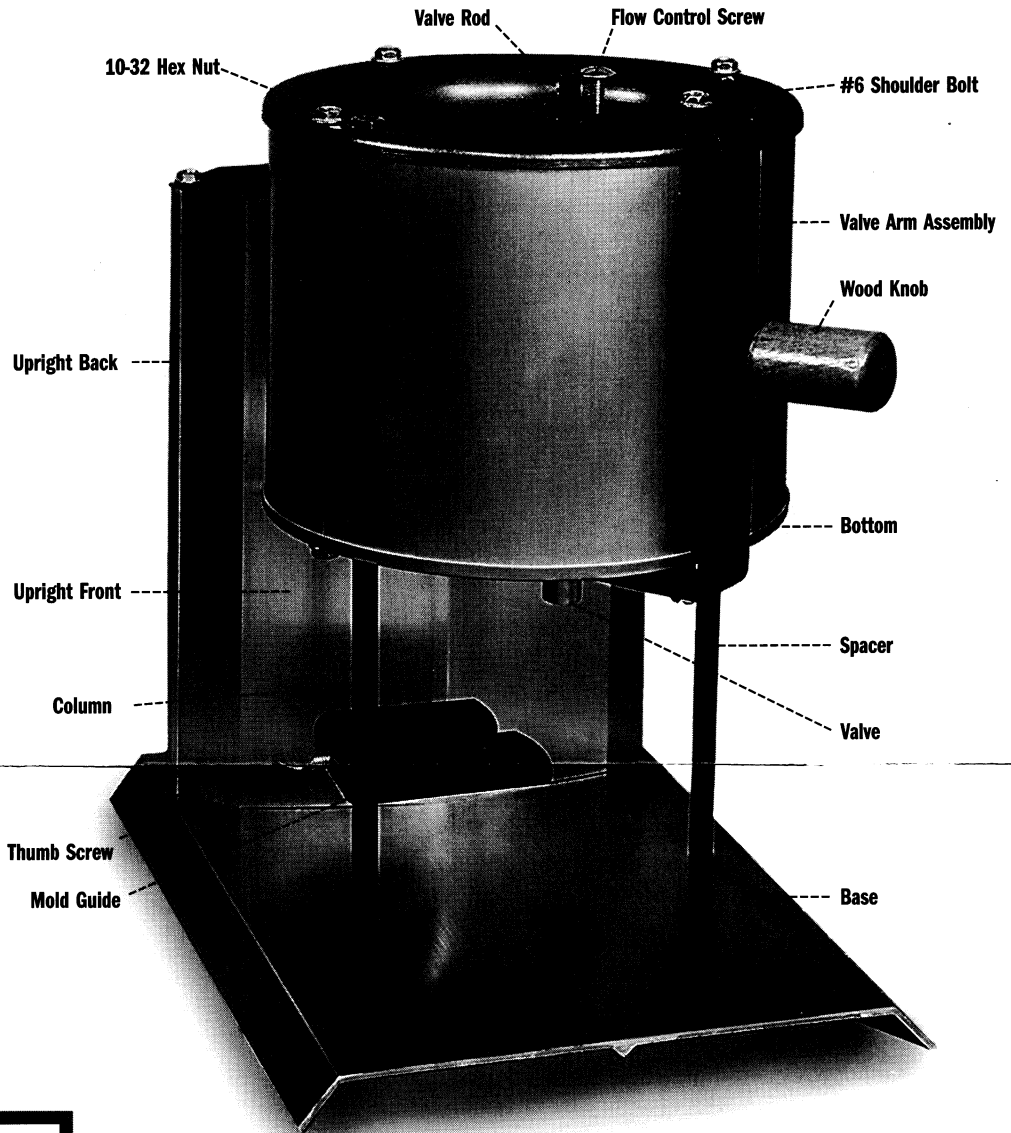


# LEE Pro 20 Series Melters

are the most advanced design melters made. The symmetrical reflective housing allows quick melting with low current requirements. The flow control valve is the easiest to adjust and features a valve rod that can be rotated 360 degrees for quick reseating.

PART #	ITEM	PRICE
EL3430	Column Medium	\$2.50
EL3439	Upright Med Rear	3.00
EL3444	#6 Shoulder Bolt	1.00
EL3453	Heater 110V Stand 20LB	9.00
FE1122	Screw 6 X 5/8 unslotted	0.34
EM1127	Cordset	\$2.00
FM1750	8-32 X 3/8 Slted Truss	0.50
EL3426	Valve Arm Assy	6.00
EL3428	Bottom	3.00
EL3433	Pot Housing Rear	5.00
EL3443	Valve Knob	2.00
EL3451	20 LB Pot Valve	3.50
EL3469	Instructions	1.00
EM1135	Thermostat Knob	1.00
FE1116	Full Nut 7/16 X 14	1.00
EL3438	Upright Med Front	3.00
EL3474	Pot 20 LB Standard	17.00
EL3403	Medium Spacer	2.00
EL3455	Name Plate Pro 20	2.00
EM1117	Bushing Cord 110V	0.50
EL3466	Thermostat 110V 20LB	5.00
FO1770	Pan HD 8-32 X 1/4	1.00
FE2030	10-32 Hex Nut	0.50
EL3427	Valve Rod	3.00
EL3432	Pot Housing Front	5.00
EL3434	Pot Housing Left	5.00
EL3445	Base	5.50
FE3464	7/16-20 valve nut	0.50
FE2753	Screw 8 X 1 type A	0.34
EM1129	Jumper 3 1/2 " 18 GA	1.00
EM1115	Heater Clamp	0.50
EL3465	Box For 90950	1.00
<b>Specific PRO 4-20 PARTS</b>		
EL3436	Upright Long Front	3.50
EL3447	Mold Guide	6.00
EL3454	Name Plate Pro 4-20	2.00
FE3470	Thumb Screw 10-32 X 3/8	1.50
EL3429	Melter Column Long	3.00
EL3437	Upright Long Rear	3.50
EL3471	Long Spacer	2.50
EL3480	Box for 90947	1.00



## Guarantee

Lee Products are guaranteed not to wear out or break from normal use for two full years or they will be repaired or replaced at no charge if returned to the factory. Any Lee product of current manufacture regardless of age or condition will be reconditioned to new, including a new guarantee, if returned to the factory with payment equal to half the current factory list price.

Date purchased \_\_\_\_\_

## Caution:

Be extremely careful not to get any water into the molten lead. Even a small drop will explode into steam and violently spatter hot lead.

Wear safety glasses while using.

Use only in areas of adequate ventilation. Air flow sufficient to carry away the smoke of an extinguished match is considered adequate.

Keep food and drink out of the work area. Wash hands before eating or smoking.

Do not melt pewter or high tin alloys as they are corrosive to the pot liner.

If the pot is allowed to cool full of metal the spout will likely drip during heat up. Be sure to place a ingot mold under spout to catch drips.

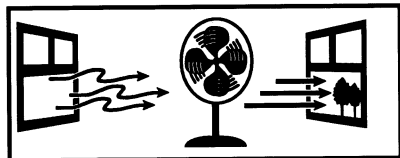
# LEE

LEE PRECISION, INC. 4275 HIGHWAY U HARTFORD WISCONSIN 53027



**WARNING: Melting lead and casting lead objects will expose you and others in the area to lead, which is known to cause birth defects, other reproductive harm and cancer.**

**Reducing Exposure** Lead contamination in the air, in dust, and on your skin is invisible. **Keep children and pregnant women away** during use and until clean up is complete. Risk can be reduced—but not eliminated—with strong ventilation; washing hands immediately after use of these products before eating or smoking; and careful cleaning of surfaces and floors with disposable wipes, after lead dust has had a chance to settle. Use a lead-specific cleaner with EDTA, or a high-phosphate detergent (like most detergents sold for electric dishwashers) and bag wipes for disposal.



Use strong ventilation

### Set Up

Screw wood knob onto valve arm stud.

Place the melter on a stable work bench or table. Do not place in a draft or allow a fan to blow directly on the pot.

Route the power cord so it will not be tripped over or pulled by a child.

Place a Ingot mold or small metal can under the pour spout during warm up.

Fill the pot with desired casting alloy.

Set mold guide for proper height and rotate mold guide forward or backward for proper right to left alignment. [NOTE: this feature available only on Pro 4 series]. Best results with bottom pour pots are obtained by holding the mold away and slightly off center of the pour spout.

Set heat control to **high** and plug in.

### Directions

It will take about 20–30 minutes to heat 20 lbs. of metal to 600 degrees; line voltage greatly affects melt time. After the metal is melted adjust heat setting to desired position. The markings are reference numbers only and do not indicate temperature. The high setting will stabilize at approximately 900° Fahrenheit and the low about 450°. Cast at the lowest temperature that will give good fill out. 650°F is a good starting point.

With an ingot mold placed under the pour spout lift the pour knob and observe the flow. Rotate the flow control screw clockwise to decrease flow. As the metal is consumed you will need to rotate the flow control screw counterclockwise to maintain a uniform flow. Do not rotate the screw too far counterclockwise as continuous flow will occur.

As the valve spout ages it may corrode or accumulate debris. Should your valve begin to drip rotate the valve rod with a screwdriver this will force out any debris or corrosion from between the valve rod and seat. The metal should be fluxed when ever more metal is added to the pot. A small piece of wax about the size of a pea works well as a flux, be prepared for a flame when the wax is added to the pot. Stir the metal vigorously and scrape the sides and bottom of the pot to dislodge impurities, which will float and can be skimmed off and discarded properly.

### Tips

Leaving a thin layer of oxidized metal on the surface will cause no harm when using the melter as a bottom pour pot and will slow further oxidation of your metal. Flux and skim only after adding more metal to the pot.

Before storing your melter for extended periods spray all steel parts with a silicon spray or a rust inhibitor like WD40.

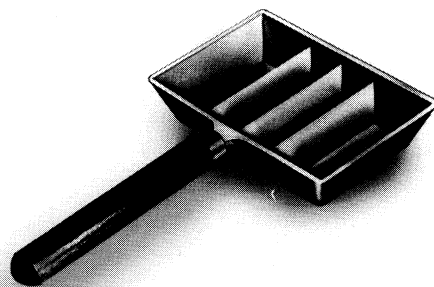
Store your melter with about an inch of metal in the bottom. It speeds the next melt and reduces the likelihood of carrying surface contamination through the valve.

### Trouble Shooting

Should the valve not pour when the knob is raised, it's most likely caused by the heat being set too low or flow control screw rotated too far clockwise. If you're sure the heat is set high enough and flow control is open, the spout is likely plugged with sediment. With the melter at operating temperature hold a straightened paper clip with a pliers and feed the wire up the spout opening to force out the obstruction.

Should the valve drip, simply rotate the valve rod with a screwdriver. If this does not cure the drip check the valve linkage for binding due to corrosion or damage. The moving points of the valve linkage should be lubed with a high temperature anti-seize lubricant, like Permatex #133 or equivalent, found at any automotive or well-stocked hardware store.

**Don't risk handling molten metal in a makeshift container.**  
**Use the Lee Ingot Mold to cast 1/2 and 1-pound ingots.**  
**Perfect for remelting and alloying. Wood handle stays cool.**  
**Aluminum construction is lightweight and rustproof.**



Part #90029

Send your name and address for a complete catalog

**LEE**

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