



WAXMELTERS

Industrial Thermal Processing Equipment & Systems

WAXMELTERS EQUIPMENT DOCUMENTATION

DIP & CARVING TANK GUIDE

Controller Settings & Troubleshooting

Controller Basics

TC4S Settings

Troubleshooting

Support Form



EDITION

2019 content, 2026 layout

Formerly the "X-Treme Melters, WaxHand Machines, Candle Carving Tanks, & Dip Tanks Of All Kind Troubleshooting Guide". Content kept as published; model-specific notes flagged inside.

HOT TIPS FOR COOL CANDLES

Hello, dip & carving crew!

This is your WaxMelters Dip & Carving Tank guide: controller basics, advanced settings, troubleshooting and a support form, all in one place. The fun stops at the headings, every setting and step below is exactly as WaxMelters published it.

QUICK START

 The short version, copied word for word from the full sections inside.

SET TEMPERATURE WITH ARROW KEYS

From: Controller basics (2018 to 2019+ models)

- 1 Press ↑ or ↓ to raise or lower the temperature setting to the desired temperature and then it will blink and be set to that temperature.

CALIBRATING THE CONTROLLER:

From: Controller basics (2018 to 2019+ models)

- 1 Press and hold MODE until screen says PAR2
- 2 Press MODE until it displays IN-b
- 3 Press ↑ or ↓ to change setting. Press MODE to save

SCAN & WATCH



[WaxMelters Support Center](#)

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Tap any line to jump there. Every section is also a PDF bookmark.

01

TALK TO THE BRAIN

Controller basics (2018 to 2019+ models)

**LEGACY NOTE · ADDED BY WAXMELTERS 2026**

This guide was first published in 2019 for X-Treme Melters, WaxHand Machines, Candle Carving Tanks and Dip Tanks. The content below is kept as written. Items marked as model-specific (2018-2019+ MODELS ONLY, X-Treme / XX-Treme, TC4S and JOHNSON controls, ceramic fuses) may not match newer WaxMelters equipment. Confirm with WaxMelters Support before changing controller settings.

2018-2019+ MODELS ONLY



Control Box Will Have Exterior Similar To This Photo.

■ Set Temperature With Arrow Keys

- 1 Press ↑ or ↓ to raise or lower the temperature setting to the desired temperature and then it will blink and be set to that temperature.

■ To change F° to C° :

- 1 Press and hold MODE until screen displays PAR2
- 2 Press MODE until it displays UNIT
- 3 Press ↑ or ↓ to change setting, Press MODE to save

■ Calibrating the Controller:

- 1 Press and hold MODE until screen says PAR2
- 2 Press MODE until it displays IN-b
- 3 Press ↑ or ↓ to change setting. Press MODE to save



PRO MOVE · EXAMPLE

For Example, if Controller Temperature reads 180 F° and the actual melted material reads 170 F° then setting should be set to -10°.

■ Temperature Differential:

- 1 Press and hold MODE until screen says PAR1
- 2 Press MODE until it displays HYS
- 3 Press ↑ or ↓ to change setting. Press MODE to save

(Number= How many degrees the temperature drops on the controller before turning back on)

■ How to use this guide

Please review the applicable page(s) for your current challenge. This troubleshooting guide, along with your Instructions, addresses proper operation of the equipment and most of the solutions when a problem may arise.

If necessary, complete the applicable Advanced Troubleshooting Section in as much detail as possible and include a brief description of the problem and any steps that you have taken which have helped. Taking the time to answer these questions as completely as possible will expedite a resolution and prevent delays. Thank you.

02

TALK TO THE BRAIN

ADVANCED TEMPERATURE CONTROL SETTINGS (TC4S Controller)

■ For PAR1 Settings:

-Press and hold MODE until screen displays PAR1 Press MODE until it displays (setting name) Press Up or Down arrow to set each setting then press Mode to save

PAR-1 SETTINGS (SETTING NAME - SETTING VALUE)

AL-1	954
HYS	001

■ For PAR2 Settings:

-Press and hold MODE until screen displays PAR2 Press MODE until it displays (setting name) Press Up or Down arrow to set each setting then press Mode to save

Parameter	Factory default	Parameter	Factory default
In-t	JIC	t	0200
Unit	F	AL-1	AN 1A
In-b	**	AL-2	AN 2A
ARuF	0001	AHYS	0001
L-Su	-22	LbAt	0000
H-Su	***	LbAS	008
a-Ft	HEAt	LbAb	002
C-nd	on of	dl -t	Stop
out	rLY	Ernu	0000
SSrñ	Stnd	LoC	oFF

PAR-2 Settings

■ In-b ** = this setting should be set as follows, if you have:

X-Treme, WaxHand, Depilatory, Dip Tank Melter:	0
Filling System (2014 or Prior Hose):	-20

Filling System with 2015 Hose:	0
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■ **H-Su *** = this setting should be set as follows, if you have:**

Waxhands/ Depilatory wax melters:	160
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Standard Melting Tanks and Filling Systems:	212
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X-Treme tanks:	300
----------------	-----

XX- Treme Tanks:	400
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Basic TROUBLESHOOTING



LEGACY NOTE · ADDED BY WAXMELTERS 2026

Page references inside this section (PAGE 4, page 8, pg. 3) point to page numbers in the original 2019 printed guide. Calibration is now in the Controller basics section and the full settings are in the Advanced Temperature Control Settings section. The original guide had no page 8.

■ Melting Tank Does Not Turn On (Red Power Button is off):

- Make sure the outlet works.
- Make sure the fuse has not been tripped: to reset fuse, flick the trip mechanism.
- Be sure button(s), fuse(s) and controller are free from materials, wax, dripping product, debris, etc.: accumulation of materials on these components will result in shorter life-span and can lead to blown/tripped fuses, button lights to go out or controller failure.

■ Melter Blowing/Tripping Fuses:

- Make sure no substances are leaking from the ball valve back into the Melter, which can happen if the Ball Valve is loose, there is no Teflon on the valve and/or the black gasket seal has been removed.
- Make sure no materials have dripped down the tank and onto the fuse, materials on or inside of the fuse can cause fuse to trip.
- Make sure your outlet is properly grounded and not overloaded; your melting tank should be the only appliance on the circuit.
- (2018 Models: Re-settable Fuses) Be sure fuse has not tripped (showing white front), If so-reset it.
- (Ceramic Fuse: Pre-2018) Be sure fuse cap is tight, and properly inserted, be sure fuse has not blown: also be sure nothing has dripped on/inside fuse holder. Ceramic fuses can be found at most local hardware stores such as Home Depot etc., in the microwave section, normally if you bring the blown fuse in with you, a store associate will be able to replace it for you.

■ Unit Heats Slowly or Unevenly or Does Not Heat At All - JOHNSON CONTROL:

- If this occurs the first few times or after a period of inactivity, there may be a Low MEGOHM Condition (heaters may absorb moisture from the environment) which prevents heater from operating at maximum efficiency until unit is used several times and moisture evaporated out.
- Make sure the GREEN light on the control comes on. If not, then the temperature needs to be set.
- Make sure the unit is not on an extension cord, power strip, or on a line with other appliances, etc.
- Make sure to set the unit to the melting and/or mixing point (whichever is higher) recommended by the manufacturer of your materials.

- If you are melting different kinds of materials and/or materials with different melting points, densities or other properties, make sure melt and mix the higher melt points first and to keep mixing so the denser materials do not sink to the bottom
- Make sure you keep the lid on while heating to reduce heat loss and more uniform heating.
- Make sure to double check the Advanced Temperature Control Settings.
- If the unit is dirty and/or has burned materials in it, try cleaning and scrubbing it (with scouring pad if needed) as you would a stainless steel pot since this will interfere with the sensors.
- If your room is cold or you are using the unit near an open door/window, a fan, humidifier, dehumidifier, air conditioner, etc, the unit may heat slower or take more time. You may have to raise the temperature of the unit to compensate for heat loss.

■ **Unit Heats Slowly or Unevenly or Does Not Heat At All- TC4 CONTROL:**

- If this occurs the first few times or after a period of inactivity, there may be a Low MEGOHM Condition (heaters may absorb moisture from the environment) which prevents heater from operating at maximum efficiency until unit is used several times and moisture evaporated out.
- Make sure the green "OUT" light on the control comes on. If not, then the temperature needs to be set.
- Make sure the unit is not on an extension cord, power strip, or on a line with other appliances, etc.
- Make sure you keep the lid on while heating to reduce heat loss and more uniform heating.
- Make sure the unit is properly calibrated as instructed on PAGE 4.
- If your room is cold or you are using the unit near an open door/window, a fan, humidifier, dehumidifier, air conditioner, etc, the unit may heat slower or take more time. You may have to raise the temperature of the unit to compensate for heat loss.

■ **Melter Overheating or Heating Too High- JOHNSON CONTROL**

- Be sure your "OFF" and "ON" settings are correctly set: "OFF" setting must always be set higher than "ON" setting. Try separating your settings by 2 degrees (ex. OFF= 175, ON = 173).
- If you would like to change the temperature setting, you must always change both "OFF" and "ON" settings.
- Try lowering the temperature setting since depending on your location, some calibration may be required. For example, the electric may be over 120v/240v, higher altitudes have lower boiling points, humidity in a room can influence temperature and so on.
- Try removing the lid and mixing your materials to better distribute the heat.
- If the unit is dirty and/or has burned materials in it, try cleaning and scrubbing it (with scouring pad if needed) as you would a stainless steel pot since this will interfere with the sensors.
- If you are melting different kinds of materials and/or materials with different melting points, densities or other properties, make sure melt and mix the higher melt points first and to keep mixing so the denser materials do not sink to the bottom.
- Make sure you are using at least enough material to fill 1/3 of the tank.

- Try adjusting your Digital Temperature Controller settings, especially the low range before heating re-initiates.

■ **Melter Overheating or Heating Too High- TC4 CONTROL**

- Check your controller settings, you can find the full controller settings on page 8. It is possible some setting(s) were reset or accidentally changed. Follow the guide and be sure all relevant settings match the guide. Not every setting in the guide will appear in your controller.
- Try lowering the temperature setting since depending on your location, some calibration may be required. For example, the electric may be over 120v/240v, higher altitudes have lower boiling points, humidity in a room can influence temperature and so on.
- Try removing the lid and mixing your materials to better disburse the heat.
- Make sure the unit is properly calibrated as instructed on PAGE 4.
- Make sure you are using at least enough material to fill the chambers 1/3 high.

■ **Melter Leaks**

- Your Melting Tank should not leak. Before leaving our facility, it is welded and then filled with water to make sure there are no leaks since leaks would damage the electrical equipment. Next, the electrical work is completed on the unit (while the outside of the unit is not yet sealed) and it is again filled with water to test it since if there are any problems, at this point, water is easy to dispose of. Next, it is tested with materials and the sensors are calibrated. Lastly, it is finally sealed. Hence, there is no way there could have been a leak before shipping the unit.
- Make sure to check that the Teflon tape on the Ball Valve is in place.
- Make sure the Ball Valve is connected tightly with a wrench.

■ **Ball Valve Clogged, No Material Pouring Out When Ball Valve Open:**

- Remove any extra attachments made to the ball valve, such as extra pipe, elbow, etc., this can lead to clogging, slow flow rate and even slower heat time.
- Melting tank temperature needs to be raised: the melting point of any particular product will rise if color, fragrance, etc. are added. Also, the listed melting point is normally lower than the actual temperature required to sufficiently liquefy the product for purposes of pouring.

04

HANDS-ON TIME

Multi-chamber TROUBLESHOOTING

- 1** If one chamber is found to be hotter or colder than others, be sure all chambers are correctly positioned: each chamber is labeled with a number, and each chamber position is also labeled in the tank with the same number. The labels are placed as to correspond to the chamber position and orientation of each chamber in that position (the label on the chamber should be 'face to face' with corresponding label in the tank). Example: chamber labeled "1", label will be found on one outside face of the removable chamber, on the inner wall of the tank you will also find a position labeled "1". When correctly positioned, the chamber labels should face each other directly (face-to-face).
- 2** If one chamber is found to be hotter or colder than others - Using an external thermometer (a standard dip thermometer should be used, not a laser) check the temperature of each chamber and record it, after this, take the average of all chambers together, and divide by the number of chambers total: this will give you the average temperature of all of the chambers together. Once you have this figure, compare it with what the controller is actually reading, and change your "In-b" setting accordingly (see pg. 3). For example: if the average temperature is 125f, and controller reads 130f, you will set your "In-b" setting to: "-5".

05

GOOD TO KNOW

Advanced Troubleshooting: If Applicable, Please Complete & Return This Page:



PRO MOVE · SEND IT TO US

Call (888) 929-6358 or email it to Support@Waxmelters.com

Company: _____

Contact Name: _____

Contact #: _____

Melting Tank Size: _____

Approximate Purchase Date or Order #: _____

■ Unit Is Not Turning On And/Or Blowing/Tripping Fuses

- 1 Did you check the power cord and try another outlet. Y / N
- 2 Is the fuse cap in securely with the same amp “fast blow” heated rated ceramic fuse? Y / N
- 3 (2018 Models & Newer) Is the Re-Settable Fuse “tripped” (showing white front?) Y / N If so, flip the re-settable fuse back to its original state (showing black front), and be sure it is free of materials, dust, debris etc. which may have dripped/gathered on it.
- 4 Does the power button come on first and after a 5-10 second delay it blows/trips the fuse? Y / N
- 5 Did any material potentially enter the unit through the top, a side seam or valve area? Y / N

■ Unit Does Not Heat, Heats Slowly And/or Unevenly

- 1 Do you feel any heat when you touch the bottom of the tank or valve? Y / N You may need to remove a chamber (Waxhand & Candle Carving Tanks)
- 2 Does the Green “OUT” light come on the control? Y / N
- 3 When the Green “OUT” light comes on, do you hear TWO “CLICK” noises? Y / N
- 4 Have you tried raising the temperature to compensate for heat loss and other electrical/ environmental factors (low altitude, humidity, etc...) which may require calibration? Y / N

- 5 Did you burn any material or notice discoloration inside the tank? Y / N If so, did you try scrubbing it clean (like a stainless steel pan) since the sensors will be unable to work. Y / N
- 6 Are you keeping the lid on and mixing your materials? Y / N
- 7 Did unit suddenly stop heating? Y / N
- 8 Did it progressively heat slower and then stop? Y / N Have you had any power surges, outages or roaming blackouts in your area? Y / N
- 9 Was the unit operated without material or very little material? Y / N
- 10 If you unit has chambers, is each bin must be inside the correctly numbered chamber and the # on each bin must face/be against the outside # on the chamber? Y / N
- 11 Controller Calibration (SO) is set to _____ & (ASD) is set to _____
(See Pg. 3 of this guide).
- 12 What is the brand and brand name of your material? _____ Melt point? _____
_____ Melter Temperature Settings(OFF/ON)? _____ / _____
_____ How Long Does it Take? _____ If using preheated material from another tank, the preheated Temperature is _____.

■ Unit Overheating And/Or Heating Too High

- 1 Did you try lowering the temperature? Y / N Sometimes, depending on your location, some calibration may be required. If you are at a higher altitude, the boiling points of substances are generally lower and may require you to lower your temperature. Y / N
- 2 Is the unit/each chamber at least 1/3 full? Y / N
- 3 Did you burn any material or notice discoloration inside the tank? If so, did you try scrubbing it clean (like a stainless steel pan) since the sensors will be unable to work. Y / N
- 4 Did you try removing the lid and mixing the materials? Y / N
- 5 Did you make sure your OFF and ON settings are correctly set? (OFF should always be set higher than ON, at all times.: Example: OFF=175, ON=173) Y / N
- 6 Try setting the OFF and ON settings closer together, such as 3-5 degrees apart (Example: OFF=175, ON=170). Y / N

■ **Please Provide A Brief Description & Any Steps That Have Helped:**



Need more help?

If you require additional assistance, please take photos of the tank, its power supply, and buttons/fuses/control: forward the photos along with the above page to: support@waxmelters.com

Or alternatively you can call: (888) 929-6358



TIP · PLEASE NOTE

Please answer these questions accurately to expedite a resolution and prevent delays. Thank you. Call (888) 929-6358 or email it to Support@Waxmelters.com



NEED A HAND? WE HAVE GOT YOU.

(888) WAX-MELTERS | (888) 929-6358

support@waxmelters.com · waxmelters.com/support



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