Equipment Sourcebook
3rd edition

LOCTITE®

Henkel

Contents

Application & Dispensing Equipment

• Pressure-time systems

97125	97106	97108	97809	97124	97631

1x   1x   2x

97006	97003/97004	97008/97009	97102	97152	1x 1x	97153

97204

1x   2x   4x   2x

97118/97119	97115

1x   1x   1x

97111	97112/97116	97130	97121	98009/98013	97135/97136	97113/97114	97664/97676
97131							
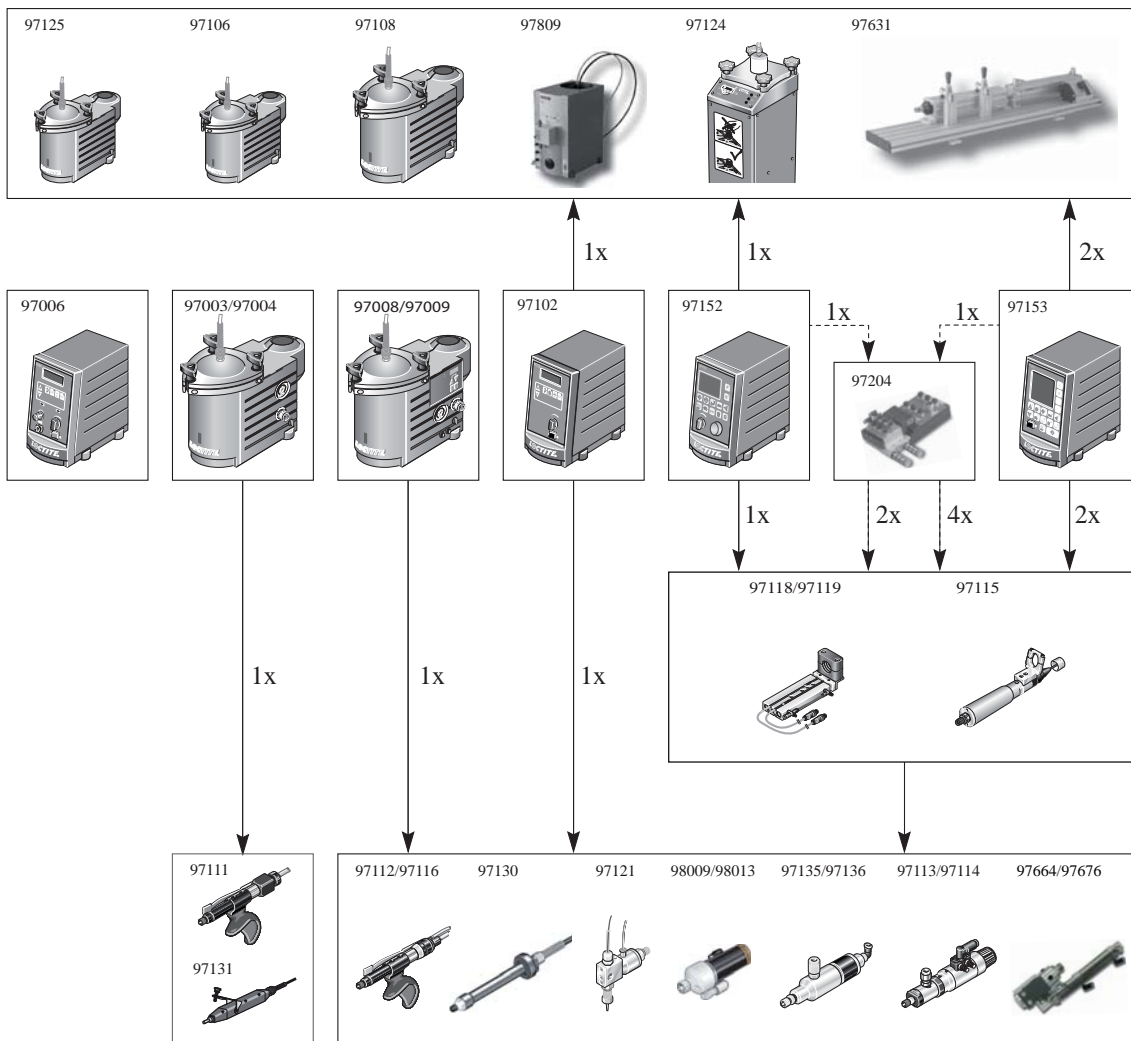
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• Volumetric dispensing systems

Single component			Two component
98548	97643	8953494	97640

Integrated Dispensing Systems

Loctite® Integrated Dispensing Systems are designed to offer the total package for fluid delivery. Every time you use a Loctite® adhesive product, these systems are ready for immediate operation and offer the manufacturing flexibility and reliability you're looking for. Selection of a Loctite® Integrated Dispensing System is based on the product being used, package size, and process requirements.

Product	All Purpose Syringe Dispensing System	Precision Syringe Dispensing System	Integrated Manual Dispenser 2 litres (0.7 bar)	Integrated Manual Dispenser 2 litres (7 bar)	Integrated Semi-Automatic Dispensing System	Integrated Semi-Automatic Dispensing System with Low Level Sensor
Item #	98666	97006	97003	97004	97008	97009
IDH No.	883976	88633	135546	135547	215844	215845
Package Size	10ml & 30ml	10ml & 30ml	250ml, 500g, 1 litre, 2kg	250ml, 500g, 1 litre, 2kg	250ml, 500g, 1 litre, 2kg	250ml, 500g, 1 litre, 2kg
Package Type	Cartridge	Cartridge	Bottle	Bottle	Bottle	Bottle
Pressure Range (bar)	0.25-7	0.1-7	0.05-0.7	0.3-7	0.3-7	0.1-4
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All Purpose Syringe Dispensing System

98666

This digital pneumatic dispensing system has been designed for dispensing repeatable amounts of fluids, e.g. resins, adhesives, oils, silicones, etc.

The system is easy to operate and achieves high repetition accuracy. The adjustable vacuum suck-back feature effectively prevents post-dispense dripping. The system is delivered ready for operation, including dispensing needles, cartridge, cartridge adapter, cartridge holder and foot switch.

Technical Specifications:

Power Supply	90-260 VAC; 47-63 Hz	Vacuum Range	0-1 bar (0-15 psi)
Air Input	2-12 bar (30-175 psi), filtered to a max. of 10µm	Dimensions (W x H x D):	145 x 175 x 160mm
Air Output	0.25-7 bar (2-100 psi)	Weight	2.0kg

Features:
- Digital timing control
- Non-volatile memory
- Timer setting range 0.01 to 99.99 sec
- Pressure range 0.25 to 7 bar
- Requires minimal bench space of 150 x 180 x 160mm
- Including cartridge adaptor 30cc/10cc, cartridge, needles, cartridge holder and foot switch

Precision Syringe Dispensing System

97006

The Precision Syringe Dispensing System has been designed for dispensing fluids and pastes directly from 10 or 30ml syringes. It allows precise deposits to be made and minimises air pressure fluctuation during the dispensing cycle. This system also contains an audible pressure alarm, anti-drip vacuum suck back and a stand-up design that ensures minimal foot print. It accurately dispenses adhesives or other fluids with viscosities ranging from medium to high consistency for a variety of assembly and repair applications. It delivers precise dots in a timed mode, or can be used for dispensing or potting in a continuous mode.

Typical Fluids Handled: Any fluid product packaged in a 10ml or 30ml syringe or suitable for decanting into empty syringes.

Technical Specifications:

Power Supply	90-260 VAC; 47-63 Hz	Vacuum Range	0-1 bar (0-15 psi)
Air Input	2-12 bar (30-175 psi), filtered to a maximum of 10µm	Dimensions (W x H x D):	145 x 230 x 260mm
Air Output	0.1-7 bar (1-100 psi)	Weight	3.0 kg

Features:
- Precision pressure regulator for precise application of small dots
- Digital display of the dispensing pressure
- Digital timer display, for precise timer settings, range 0.01-99.9 secs.
- Vacuum suck-back feature to prevent post-dispense dripping
- Requires minimal bench space
- Quick pressure setup feature
- Process monitoring for variation from set pressure
- Timed and continuous operating mode

Integrated Manual Dispenser 97003/97004

The Manual Dispenser Controller in combination with the Vari-Drop™ applicator (97131) has been designed for applying beads, for potting and for "by-eye" deposits. These dispensing systems are reliable, low cost pneumatic systems for dispensing fluids. Each system includes a 2 litre pressure reservoir that is designed for use with a hand-held applicator. These units have 0.05-0.7 bar (1-10 psi) (97003) or 0.3-7 bar (4-100 psi) (97004) pressure regulators, suitable for low viscosity (<1500mPas) and high viscosity (>1500mPas) fluids, respectively. The reservoirs accommodate all Loctite® bottles in 250ml, 500 g, 1 litre, and 2 kg packages.

Operation of this unit is easy. The operator will place a bottle of product in the reservoir and tighten the three handles on the lid. The unit is then pressurised to the appropriate setting for optimal flow control. The product is dispensed through a hand-held applicator. The amount dispensed can be set by adjusting the flow screw on the finger switch or adjusting pressure.

Typical Fluids Handled: Cyanoacrylate adhesives, light curable adhesives and anaerobic adhesives.

Features:
- Eliminates waste and reduces operator fatigue
- Easy to read pressure gauge
- Adjustable pressure regulator

Technical Specifications:

Air Input	max. 8 bar (116 psi), filtered to a maximum of 50µm	Max. distance from system to dispensing point	2m
Air Output	97003: 0.05-0.7 bar (1-10 psi) 97004: 0.3-7 bar (4-100 psi)	Dimensions (W x H x D):	360 x 335 x 235mm
		Weight	6.5kg

Selector Chart:

System	Viscosity Range (mPas)	Item #	IDH No.
Integrated Manual Dispenser	0-1500	97003	135546
	1000-10000	97004	135547
Hand-held applicator	0-1000	97131	194420
	500-5000	97111	88642

Integrated Semi-Automatic Dispensing System 97008/97009

The Integrated Semi-Automatic Dispensing System is a compact unit providing time-controlled dispensing when combined with an appropriate Loctite® dispensing valve. The system provides digital control of dispensing time within the range 0.1-99.9 seconds. The controller can be actuated by a footswitch or finger switch . It is also capable of operating in a continuous mode for bead dispensing applications. The reservoir accommodates Loctite® bottles in 250ml, 500g, 1 litre, and 2kg packages. The semi-automatic Dispensing System is required to be connected to an external electrical and pneumatic supply. Reservoir pressure and dispensing time can be set independently of each other. An uncovered bottle of Loctite® product is placed directly into the integrated reservoir, and the reservoir lid is clamped in place. The reservoir is then pressurised using clean, filtered dry air. Air within the reservoir will push down on the liquid in the bottle and force it through the product feedline to the dispensing valve. The amount of product dispensed is controlled by three main factors: The pressure in the reservoir, the length of time the dispensing valve remains open, and the dispensing needle size.

97009: The "empty" signal is indicated as blinking text "U" on the digital display of the controller. In addition it is signalled by an audible alarm.

Additional features: Voltage free output signals for empty and ready signalling. These can be connected to a higher ranking controller.

Features:
- Integrated design for simple setup and space economy.
- Precision pressure regulator (0.1-4 bar) for reliable dispensing, eliminating air pressure fluctuation (97009)
- Pressure displayed by pressure gauge 0-4 bar (97009) or 0-10 bar (97008) respectively
- Timer-controlled solenoid valve for air-actuated applicator
- Level sensor to give empty warning (97009)

Technical Specifications:

Power Supply	90-260 VAC; 47-63 Hz	Power Consumption	25W
Air Input	min. 5 bar (70 psi), max. 10 bar (145 psi), filtered to a maximum of 10 µm		
Air Output	97008: 0.3-7 bar (10-100 psi) 97009: 0.1-4 bar (3-60 psi)	Dimensions (W x H x D)	360 x 335 x 235mm
		Weight	7.5kg

Selector Chart:

System	Description	Item #	IDH No.
Integrated Semi-Automatic Dispensing System	without low level sensing	97008	215844
	with low level sensing	97009	215845

Accessories:	Item #	IDH No.
Foot Switch	97201	88653
Airline Filter / Regulator	97120	88649

See pages 18-23 for Dispense Valve selection.

Controllers and Reservoirs

Loctite® controllers and reservoirs can be combined with a range of Loctite® parts and accessories to create complete dispensing systems designed to meet your specific needs and processing methods.
Selection of Loctite® controllers and reservoirs is based on the product being used, the package type and size, and the overall process requirements.

Product	Semi-Automatic Controller	Automatic Controller	Multi Channel Automatic Controller	Solenoid Valve Module
Item #	97102	97152	97153	97204
IDH No.	135550	1275665	824499	142639
Pressure Range (bar)	0.1-7	0.1-7	0.1-6	2-8
Page	9	9	10	10

Product	0.5 litre Reservoir with analogue/digital low level sensor		2 litre Reservoir with analogue low level sensor	2 litre Bag Dispenser	Supply Pump	300ml Cartridge Pusher
Item #	Analogue 97106	Digital 97125	97108	97124	97809	97631
IDH No.	135554	215990	135555	360442	915111	854181
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Semi-Automatic Controller   97102

The Semi-Automatic Controller has been designed for precision programming of dispense time and dispense pressure setting; product is dispensed from a separately positioned container. Together with the digital pressure display, a digital timer ranging from 0.04 to 99.9 seconds allows the operator to make pin-point accurate deposits when applying a wide range of fluids from low to high viscosity.

The Semi-Automatic Controller 97102 controls the dispensing pressure in the product reservoir and the pneumatic opening of the dispensing valve according to the selected dispensing time. The start signal for dispensing is provided by an external foot switch or finger switch. Error messages are shown on a digital display and are accompanied by an audible alarm. A voltage-free Ready signal is provided as long as no fault condition exists and when the dispensing cycle is completed.

Technical Specifications:

Power Supply	90-260 VAC; 47-63 Hz	Air Output	0.1-7 bar (1-100 psi)
Power Consumption	40W	Dimensions (W x H x D)	145 x 230 x 260mm
Air Input	2-12 bar (30-175 psi), filtered to a maximum of 10μm	Weight	2.8 kg

Features:
- Fitted with precision pressure regulator eliminating air pressure fluctuations
- Digital pressure readout with electronic monitoring
- Continuous or timed operation modes

Automatic Controller   97152

A versatile multi-functional controller for actuating 1-2 dispensing valves as well as appropriate peripheral equipment such as reservoir, advancing slide, rotor spray, online flow monitor, etc.

The process functions and data are laid out clearly on a graphic display. Settings can be made via the membrane keypad and the rotary selector switch.

The amount of product dispensed is determined by the pressure in the reservoir, the length of time the dispensing valve remains open and the nozzle size. Reservoir pressure is controlled via precision pressure regulator and monitored electronically. The dispensing parameters can be PIN secured against manipulation. The controller can be integrated into fully automated assembly line operations using its PLC interface, relieving the higher-ranking control system from the time-critical and resource intensive tasks related to dispensing control and monitoring. It is possible to query data records via a serial PC interface for documentation, maintenance or quality assurance, etc.

The system has an integrated pneumatic solenoid valve module for single channel operation. As an additional option, an external solenoid valve module 97204 may be connected to upgrade the unit for dual channel dispensing.

The controller can be used for evaluating data from either the pressure based or the calorimetric flow monitor. Error messages are shown on the display and, in the case of major faults, signalled with an audible alarm. In addition, fault and ready signals are provided as voltage-free electrical signals.

Technical Specifications:

Power Supply	90-260 VAC; 47-63 Hz	Dimensions (W x H x D)	145 x 230 x 260mm
Air Input	2-10 bar, filtered to max. 10μm	Air Output	0.1-7 bar
Power Consumption	60W	Weight	3.9kg

Features:
- 1-2 independent dispensing channels
- Integrated solenoid valve module
- Fitted with precision pressure regulator eliminating air pressure fluctuations
- Digital pressure readout with electronic monitoring
- PLC interface
- Graphic display for indication of dispensing parameters and pressure profile of the online flow monitor
- Online flow monitor signal evaluation

Multi Channel Automatic Controller 97153

A versatile multi-functional controller for actuating 1-4 dispensing valves as well as appropriate peripheral equipment such as reservoirs, advancing slides, rotorsprays, online flow monitors, etc. The process functions and data for all channels are laid out clearly on a large display. Settings can be made via the membrane keypad and the user interface.

The amount of product dispensed is determined both by the pressure in the reservoir and the length of time the dispensing valve remains open.

Reservoir pressure is electronically regulated and controlled by two integrated proportional valves, all dispensing parameters can be PIN secured against manipulation. The system can be integrated into fully automated assembly line operations using its PLC interface or an optional Profibus module, relieving the higher-ranking control system from the time-critical and resource intensive tasks related to dispensing control and monitoring.

It is possible to query data records via a serial PC interface for documentation, maintenance or quality assurance, etc. The system has an integrated pneumatic solenoid valve module. As an option, an external solenoid valve module 97204 may be connected to upgrade the unit.

The programme has various selection menus for controlling peripheral units within the scope of a multi-functional dispensing system. Error messages are shown on the digital display and, in some cases, signalled with an audible alarm. In addition, fault and ready signals are provided as voltage-free electrical signals.

Features 97153:
- 1-4 independent dispensing channels
- Integrated solenoid valve module
- Two electronic pressure regulators
- Controls two reservoirs with low level sensing
- PLC interface
- ProfiBus interface module available
- Large display for indication of dispensing parameters and pressure profile of the online flow monitor

Technical Specifications:

Power Supply	100-240 VAC; 47-63 Hz	Air Output	0.1-6 bar
Power Consumption	200W	Dimensions (W x H x D)	145 x 230 x 260mm
Air Input	2-10 bar, filtered to a maximum of 10µm	Weight	3.9kg

Solenoid Valve Module 97204

Electromagnetic valves are combined into a valve array with common air supply, eliminating complex pneumatic lines and making installation of the unit much easier. The four-channel Loctite® solenoid valve module brings pneumatic energy close to the dispensing valves and provides electrical connections for 2 rotorsprays and 2 advancing slides including limit switches.

Features 97204:
- 4 independent 5/2-way solenoid valves
- 2 electrical outputs for rotorsprays
- 4 electrical inputs for limit switches
- 1 central multipole connector to automatic controller 97152 or 97153

Technical Specifications:

Air Input	2-8 bar, filtered to a maximum of 10µm
Dimensions (W x H x D)	132 x 73 x 210mm
Weight	2.5kg

0.5 Litre Reservoir   97106/97125

This reservoir accommodates 250ml and 500g Loctite® bottles and is equipped with a pneumatic and electrical interface for connection to all Loctite® controllers. The integrated level sensor enhances the reliability of automated adhesive bonding processes.

Reservoir 97106:	
Integrated solenoid dump valve	Integrated Empty and Refill sensing with additional visual indication by LED

Reservoir 97125:
Integrated level sensor to give empty warning (digital)

Technical Specifications:			
Air Input	4-8 bar (60-116 psi), filtered to a maximum of 10µm	Weight	3.75kg
Dimensions (W x H x D)	170 x 255 x 315mm		

Selector Chart:	Item #	IDH No.
0.5 l Reservoir with "refill" and "empty" indication	97106	135554
0.5 l Reservoir with "empty" indication	97125	215990

Features:
- Prevents contamination, as product remains in its original package
- Reservoir lid holder with drip tray eliminates feed line contamination when changing product container
- Operational with semi-automatic and automatic controllers
- Product low level sensor to prevent air entrapment
- Pressure safety rupture disc

2 Litre Reservoir   97108

This reservoir accommodates up to 1 litre and 2kg Loctite® bottles and is equipped with a pneumatic connection and an electrical interface for setup with all Loctite® controllers. A bottle nesting basket for safely holding 250ml and 500g bottles is included in the supply package.

Technical Specifications:			
Air Input	4-8 bar (60-116 psi), filtered to a max. of 10µm	Dimensions (W x H x D)	205 x 335 x 360mm
		Weight	6.5kg

Selector Chart:	Item #	IDH No.
2 litre Reservoir with "refill" and "empty" indication	97108	135555

Features:
- Reservoir lid holder with drip tray eliminates feed line contamination when changing product container
- Operational with semi-automatic and automatic controllers
- Product low level sensor to prevent air entrapment
- Product low level display, offers good visual feedback to operator and provides signal for process control

Supply Pump

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97809

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The Supply Pump has been designed for bubble free delivery of low to medium viscosity anaerobic, UV and cyanoacrylate adhesives without fillers, as well as activators. It can be combined with controllers 97102, 97152 and 97153, or with VoluBrane Pump 97643.

The advantage of this system is that, unlike the pressure tanks, it will not directly pressurise the fluids; instead, a diaphragm pump feeds the product forward, reliably preventing entrapment of air bubbles. The original Loctite® bottle is placed into the reservoir, and the cap is replaced by a suitable adapter. The adapter must be ordered separately. The product pressure (regulated air) for operating the pump is set on the controller. The supply pump has a low level sensor for adhesive level monitoring.

Technical Specifications:

Air Input	2-7 bar (30-110 psi), filtered to max. 10µm	Weight	6.8kg
Dimensions (W x H x D)	170 x 305 x 270mm		

Accessories	Item #	IDH No.
Bottle adapter for 1 litre containers	8953293	1135959
Bottle adapter for 500ml containers	8953294	1135957
Bottle adapter for 250ml	8953295	1135956

Features:
- Product delivery via pneumatic diaphragm pump
- Operational with semi-automatic and automatic controllers
- Integrated low level sensor for adhesive level monitoring
- Prevents air entrapment during dispensing

2 Litre Bag Dispenser

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97124

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The Bag Dispenser 97124 is designed for anaerobic adhesives and sealants in Loctite® 2 litre package. It can be used preferably in conjunction with Controller 97152, but also with models 97153 or 97102, for supplying Loctite® products to a dispensing valve.

After loading a 2 litre bag into the reservoir, the seal of the bag is punctured using a piercing element. Then the reservoir is pressurised from a Loctite® Controller. The dispensing pressure in the reservoir (regulated air from the controller) squeezes the bag and feeds the product through the feedline to the dispensing valve. An integrated pneumatic cylinder presses a pusher plate against the bag in a controlled way. This action avoids twisting and crushing of the bag.

When the package is empty, a beep will sound, and an "EMPTY" message appears on the digital display of the controller. A red LED also lights up on the control panel of the reservoir. The reservoir is depressurised automatically by the controller 97152. The return travel of the piston is performed manually on the hand lever valve.

The bag is sealed to prevent intrusion of compressed air, this avoids bubbles in the product flow.

Technical Specifications:

Air Input	4-8 bar (60-116 psi), filtered to a maximum of 10µm	Dimensions (W x H x D)	185 x 689 x 230mm
		Weight	13kg

Features:
- The bag package is ideal for anaerobics because of its high oxygen permeability
- Clean operation without risk of contamination
- Product low level sensors for "refill" and "empty" signals
- Minimum of residue left in the bag
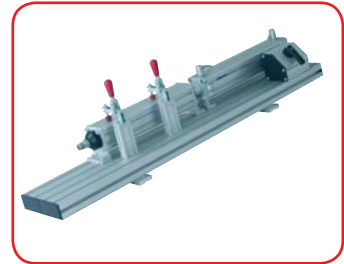- Minimum of packaging waste

300ml Cartridge Pusher 97631

The 300ml Cartridge Pusher has been designed for dispensing Loctite® adhesives from 300ml plastic cartridges. The Cartridge Pusher is used in combination with a suitable Loctite® controller (97102, 97152 or 97153) and dispensing valve (e.g. 97114).
A 300ml cartridge of a Loctite® adhesive is placed into the Cartridge Pusher and pressurised from a Loctite® controller. The piston of the pneumatic cylinder pushes the product out of the cartridge, through a product feed line and to the dispensing valve. The unit is therefore suitable for dispensing moisture curing adhesives. The Cartridge Pusher can be pressurised automatically when the controller 97152 is switched on and depressurised when the controller is switched off: An Empty signal is indicated by an LED lighting up and also appears as blinking text on the digital display of the controller.

Depending on the type of adhesive involved, a rotor pump and drive unit can be connected to the Cartridge Pusher. This is recommended for high viscosity and pasty materials. The complete assembly is operated via Loctite® controllers 97152 or 97153.

Features:
- Can be combined with Loctite® controller for dispensing high viscosity products
- Integral Forward/backward/off switch, allows operator to pre-set piston control setup.
- Clampshell design for easy and secure cartridge loading and unloading
- Reed switch for low level signalling

Technical Specifications: Optional: Can be upgraded with eccentric rotor pump for processing of high viscosity products			
Air Input	max. 4 bar (60 psi), filtered to a maximum of 30μm	Dimensions (W x H x D)	145 x 230 x 960mm
		Weight	11.6kg
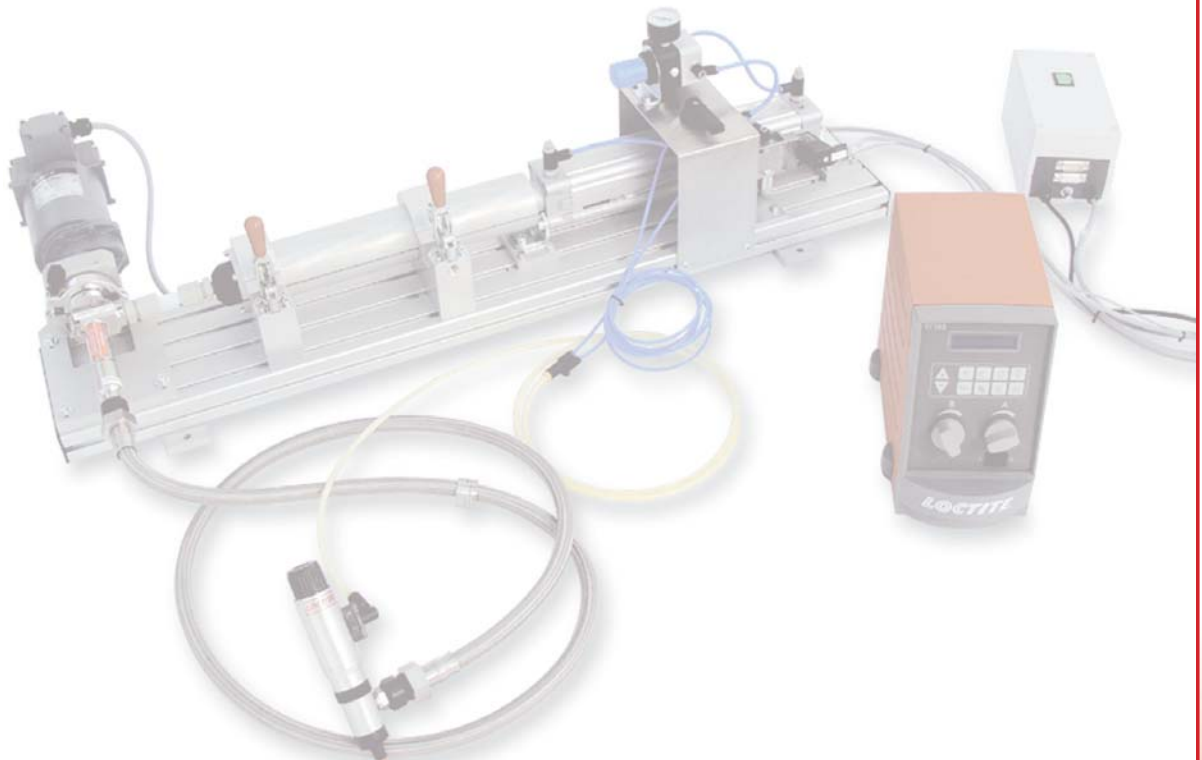
Application Equipment

Loctite® Application Equipment has been designed to complement dispensing equipment and support users by making adhesive application quick and easy. Further application systems, in addition to the items described, are available on request.

Product	Benchtop Robot Station	Advancing Slide	Rotorspray	Proximity Switch Unit
Item #	A broad range of benchtop robots are available.	97118/ 97119	97115	Z3205
IDH No.		142636/142637	135557	530015
Page	14/15/16	17	17	17

Benchtop Robots

Loctite precision dispensing robots offer industry leading performance and durability standards when integrated into adhesive dispensing processes. There is a comprehensive range of 3 and 4 axis precision robots and the innovative D-Series line that is designed specifically to suit adhesive dispensing requirements.

Precision Benchtop Robots   98282A/98302A

The Loctite® Precision Benchtop Robots are available in 3 or 4-axis configurations. In combination with tried and tested Loctite® dispensing equipment, they provide maximum flexibility for complex dispensing applications. Manually loaded, they allow users to repeatedly and reliably dispense dots, beads and potting deposits. Suitable valves and syringes can be easily connected to the robot. The simultaneous control over all axes provides for 3D linear and arc interpolations and allows for continuous path motion.

200 Series Benchtop Robot Station

Technical Specifications:

Power Supply	230 VAC	Max. portable weight	200 Series: Work surface 7kg, Tool head 3.5kg
Power Consumption	200W		300 & 400 Series: Work surface 11kg, Tool head 6kg
Robot type	3 axis robot 4 axis robot with additional rotational axis	Repeatability Accuracy	±0.01mm ±0,02°
Speed	0.1-500mm/s or 6-600°/s respectively (200 Series)	Operation Range (XYZR)	200 x 200 x 50 ±360° (200 Series)
	0.1-800mm/s or 6-600°/s respectively (300 Series)		300 x 320 x 100 ±360° (300 Series)
	0.1-800mm/s or 6-600°/s respectively (400 Series)		400 x 400 x 150 ±360° (400 Series)
Program Capacity	255 programs	External Interface	RS232-C
Data Memory Capacity	30000 points	Dimensions (W x H x D)	200 Series: 320 x 380 x 540mm
External I/O's	Input: 16 / Output: 16		300 Series: 560 x 530 x 650mm 400 Series: 590 x 630 x 800mm

Robot Configurations:

Description	Item #	IDH No.
200 mm x 200mm, 3 axis, 230V CE	98282A	on request
200 mm x 200mm, 4 axis, 230V CE	98286A	on request
300 mm x 320mm, 3 axis, 230V CE	98290A	on request
300 mm x 320mm, 4 axis, 230V CE	98294A	on request
400 mm x 400mm, 3 axis, 230V CE	98298A	on request
400 mm x 400mm, 4 axis, 230V CE	98302A	on request

Compact size:

Small, space saving footprint	Table axis protected from fluids
Powerful stepper motors	Control integrated into housing

Programming:

Powerful 32-bit processor	Simple and powerful programming language
Teach pendant with large display	Up to 250 programs

Interfaces:

16 outputs and 16 inputs	Controlling of Loctite® dispensing equipment	RS 232 C interface
Power: 230V		

Optional:

Safety enclosure (see page 47)		Software for programming

Additional brackets and fixtures available on request.

300 Series Benchtop Robot Station

400 Series Benchtop Robot Station

Features:
- Dispensing of dots, lines and circles (also in 3D)
- Repetition Accuracy ±0.01mm
- Continuous path (CP) control

D Series Robots

Loctite® D-Series Benchtop dispensing robots are designed with features that further simplify and automate adhesive dispensing processes. These systems, provide market leading, cost effective solutions, when integrated with a wide variety of dispensing systems.

Two alternative robots are available; the 300 x 300 and 400 x 400mm 3 axis systems.

Features:
- Independent dispense on/off purge control button on front panel
- Integrated solution – plug and play accessories.
- Software utility program compensates for positional offsets when dispense needle tips or barrels are changed.
- Teach Pendant program storage capabilities allows dispense program to be easily transferred from Robot to Robot.
- Over-speed error indicator prevents Robot from travelling too fast during the execution of the program.
- 100 programs, 4,000 points memory per program, compact flash card.
- Brush area function command allows the tip to "paint" a specifically designed area.
- No programming experience required.

Technical Specifications: 300 x 300mm Robot			
Number of Controllable Axes	3	Drive Method	3-phase stepping motor
Range of Operation	X axis: 300mm Y axis: 300mm Z axis: 100mm	I/O Signals	8 inputs / 8 outputs
Portable Weight	Work surface: 10kg Tool Head: 5kg	Teaching Method	Teach Pendant
Maximum Speed	PTP (X, Y): 600mm/s PTP (Z): 320mm/s	Program Capacity	100 programs
Repeatability Accuracy	X, Y, Z axis: ±0.01mm	Data Memory Capacity	4,000 points / program
Resolution	0.001mm	Dimensions (W x H x D)	485 x 600 x 500mm
CPU	32 bit	Weight	32kg
Display	Teach Pendant LCD	Power Source – auto switching	95-132 VAC 150w 180-250 VAC 150w
Control Method	Point to Point and Continuous Path	Working Environment	Temperature: 0-40°C Humidity: 20-90% RH

300 x 300mm Robot

Technical Specifications: 400 x 400mm Robot			
Number of Controllable Axes	3	Drive Method	3-phase stepping motor
Range of Operation	X axis: 400mm Y axis: 400mm Z axis: 100mm	I/O Signals	8 inputs / 8 outputs
Portable Weight	Work surface: 10kg Tool Head: 5kg	Teaching Method	Teach Pendant
Maximum Speed	PTP (X, Y): 600mm/s PTP (Z): 320mm/s	Program Capacity	100 programs
Repeatability Accuracy	X, Y, Z axis: ±0.01mm	Data Memory Capacity	4,000 points / program
Resolution	0.001mm	Dimensions (W x H x D)	585 x 600 x 600mm
CPU	32 bit	Weight	40kg
Display	Teach Pendant LCD	Power Source – auto switching	95-132 VAC 150w 180-250 VAC 150w
Control Method	Point to Point and Continuous Path	Working Environment	Temperature: 0-40°C Humidity: 20-90% RH

400 x 400mm Robot

Advancing Slide

The Advancing Slide System consists of a pneumatic double acting, dual piston cylinder. The mounting bracket eases precise positioning of either valves or rotorsprays. Additionally the system is equipped with 2 integrated limit switches that provide position sensing when connected to a controller.
The forward movement of the advancing slide is initiated by the start signal. The Loctite® Controller 97152 or 97153 controls the forward and backward movement of the advancing slide. The magnetic field of a permanent magnet located on both pistons of the pneumatic cylinder effects contactless actuation of the electrical proximity switches at their end positions, initiating the start of dispensing.

Technical Specifications:

Air Supply	min. 4 bar (60 psi), filtered to a maximum of 30µm	Dimensions (W x H x D)	97118: 80 x 65 x 30mm 97119: 150 x 65 x 30mm
Max. Stroke	97118: 50mm 97119: 100mm		

Features:
- Allows simple and precise positioning of valves and rotorsprays
- Air flow controls to adjust advance and retract speed
- Easy installation with Automatic Controllers 97152 or 97153
- Reed switch with 4-pin M12 circular connectors for sensing the two end positions

Rotorspray

With the Rotorspray 97115, low to medium viscosity Loctite® products can be applied to the interior cylindrical surfaces of workpieces. The Rotorspray is operated in combination with dispensing valves 98009, 97113 or 97135. Loctite® controllers 97152 or 97153 are used for synchronized control of these units. The special design of drive assembly and rotor housing ensures that the rotorspray is sealed to prevent contamination with adhesive.
Rotorspray 97115 is clamped in a fixture. The dispensing valve is clamped in the rotorspray fixture with the tip of the flexible dispensing needle pointing toward the inside of the wetting holes on the rotor disc. Loctite® controller 97152 or 97153 is used for switching the rotorspray ON and OFF and for opening the dispensing valve after the rotor reaches the rated speed. As long as the dispensing valve is open, product is dispensed through the wetting holes of the rotor disc by centrifugal force and uniformly distributed onto the interior cylindrical surface of the part. The rotorspray drive assembly is a spring-loaded design to prevent damage by collision.

Technical Specifications:

Power Supply	24 VDC	Adjustable Speed Range	4000-8000rpm
Power Consumption	10W, to 24W for short periods	Weight	600g
Dimensions (W x H x D) with standard rotor disc	ø 35/40 x 305 x 70mm		
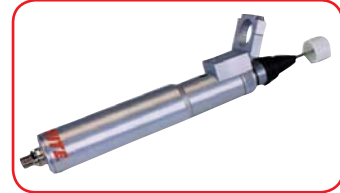
Features:
- Integrated error check, controlled speed and overload shut-off
- Status of rotorspray indicated by LED's
- High speed for large and small rotor discs
- Reduced risk of damage by collision due to spring-loaded design
- Short cycle time due to quick-stop capability

Proximity Switch Unit

The mounting stand with integrated initiator is a small device with a universal workpiece receptacle and a dispensing valve holding fixture. Equipped with an appropriate dispensing valve, it is a useful tool for coating small parts, e.g. screws, bolts, sleeves and bushes.
The operator positions the part to be coated manually in the workpiece receptacle. The initiator positioned behind detects the part and sends a start signal to the Loctite® controller to trigger the dispensing cycle. Dispensing valve holding fixture and workpiece receptacle are adjustable and can be adapted to various part configurations.
As an option this unit is also available with a capacitive initiator for detecting stainless steel and plastic parts.

Technical Specifications:

Power Supply	24 VDC	Dimensions (W x H x D)	100 x 185 x 150mm

Features:
- Universal tool to aid with adhesive application
- Adjustable position of dispensing valve
- Drip cup
- Rugged design

Valves - Hand-Held

Loctite® Hand-Held Dispensing Valves are designed for ergonomic operation and provide comfortable control for manual dispensing of fluids. All wetted parts of the hand-held valves are made of inert materials for universal compatibility with a wide range of fluids. Selection of a suitable Loctite® hand-held dispensing valve is based on the required control and actuation capabilities as well as the product being processed.

Product	Vari-Drop™ Applicator	Hand-Held Applicator		ErgoLoc Valve	Pinch Valve Applicator
Item #	97131/97132	97111	97112	97130	97121
IDH No.	194420/215996	88642	88643	444643	88650
Actuation	Manual	Manual	Pneumatic	Pneumatic	Pneumatic
Viscosity (m•Pas)	Low to medium	Medium to high	Medium to high	Low to medium, unfilled	Low to medium, unfilled
Dispensing capabilities	●	●	●	●	●
Recommended products	CA, UV, AN	UV, AN	UV, AN	CA, AN	CA, UV, AN
Suck-back	No	Yes	Yes	No	No
Start signal	Finger switch	Finger switch	Foot switch	Foot switch/ Finger switch	Foot switch/ Finger switch
Wetted parts	PTFE	POM, PTFE	POM, PTFE	PTFE	PTFE
Page	18	19	19	19	19

Legend: CA: Cyanoacrylates UV: UV and light curable products AN: Anaerobics/Acrylics
*POM Polyoxymethylene (Polyacetals) PTFE: Polytetrafluorethylene PE-UHMW: Ultra high molecular weight polyethylene

● High flow rate   ● Medium flow rate   • Low flow rate

Vari-Drop™ Applicator   97131/97132

The Loctite® Vari-Drop™ Applicator is a low cost, manually controlled hand-held valve. It has been designed for manual work stations. Stroke length can be adjusted to dispense beads and drops as required. The operator controls the amount of application.
Use the Vari-Drop™ Applicator to manually dispense a wide range of Loctite® products at a controlled rate of flow. The valve is capable of dispensing various sizes of beads and drops. The design is cost effective and user friendly. The operator controls the amount of application by holding down the finger switch.

Recommended products: Cyanoacrylates, acrylics, anaerobic and light curable adhesives, activators and primers.

Technical Specifications:					
Product feedline connection	1/4" tube	Dimensions (W x H x D)	20 x 36 x 165mm	Weight	40g

Features:
- Accepts a variety of dispensing needles
- Low cost
- Designed with UV resistant materials for light curable adhesives
- 97131 includes product feedline and reservoir fitting
- 97132 covers only the Applicator, e.g. for replacement

Hand-Held Applicator 97111/97112

Loctite® Hand-Held Applicator 97111 is suitable for dispensing Loctite® products in manual work stations. The operator controls the amount of application.
Loctite® Hand-Held Applicator 97112 is suitable for dispensing Loctite® products in semi-automatic processes.
This ergonomically designed applicator with pistol grip provides hand comfort and application control to eliminate hand fatigue and improve dispensing accuracy. The 97112 Applicator is actuated using a foot switch (97201) or an electrical finger switch (97236).
An air signal sent to this valve opens the pneumatic actuator, allowing adhesive to flow. It also incorporates an adjustable suck-back feature which prevents dripping or stringing. The Hand-Held Applicator is closed by spring return of the shut-off piston.

Recommended products: Acrylics, anaerobic adhesives and light curable adhesives.

Features:
- Ergonomic design provides comfortable handling
- Suck-back feature to prevent post-dispense dripping

Technical Specifications:

Air Input (97112)	min. 4 bar (60 psi), filtered to a maximum of 10μm	Dimensions (W x H x D)	ø 28.5 x 162mm
Product feedline connection	1/4"	Weight	340g

ErgoLoc Valve 97130

The Loctite® ErgoLoc Valve provides excellent compatibility with a wide range of Loctite® products including cyanoacrylates. Valve body and stem are all PTFE lined to prevent premature curing. It is suitable for dispensing small drops and beads of low to medium viscosity products up to approx. 10,000 mPas (max. product pressure is 2 bar or 30 psi). The slim ergonomic design reduces hand fatigue.
Loctite® ErgoLoc Valve has been designed specifically for manual dispensing. Combined with a semi-automatic or automatic controller it is suitable for low to medium viscosity adhesives.

Recommended products: Low viscosity cyanoacrylates, acrylics, anaerobic adhesives, activators and primers.

Features:
- Forward closing – avoids air entrapment and potential premature curing of cyanoacrylates
- Stroke adjustment for fine-tuning dispense characteristics
- Quantity: 0.005g up to continuous bead

Technical Specifications:

Weight	140g	Dimensions (W x H x D)	ø 40 x 170mm
Air Input	4-7 bar (60-100 psi), filtered to a maximum of 10μm		

Accessories	Item #	IDH No.	Accessories	Item #	IDH No.
Finger switch	97293	531803	Product feedline	97972	142646

Pinch Valve Applicator 97121

The Pinch Valve Applicator provides excellent compatibility with all Loctite® products, in particular cyanoacrylates. It can dispense small drop sizes of low to medium viscosity products. This ergonomically designed applicator with pistol grip eliminates hand fatigue. Ease of feedline replacement offers customers a high degree of flexibility for changeover to a different product. The PTFE product feedline of the Pinch Valve is protected by an additional outer tubing. A single acting cylinder is used as actuator. The Pinch Valve Applicator is closed in idle position. The product feedline is closed and pinched off by the cylinder piston of the actuator assembly. The Pinch Valve Applicator can be mounted on the reservoir lid or be used as a stationary applicator unit.

Recommended products: Cyanoacrylates, acrylics, anaerobic and light curable adhesives, activators and primers.

Features:
- Easy assembly of the valve onto the reservoir lid
- Lightweight design achieves comfortable handling of the applicator pencil

Technical Specifications:

Air Input	min. 5 bar (72 psi), filtered to a maximum of 10μm	Weight	Valve: 240g Pistol grip: 100g
Dimensions (W x H x D)	Valve: 120 x 97 x 32mm Applicator pencil: ø 28.5 x 162mm		

Automatic Valves

Automatic Dispensing Valves are robust dispensing valves designed for precision delivery of adhesives or other fluids. Each valve is uniquely designed to meet different manufacturing needs. The valves can be easily combined with a Loctite® reservoir and a controller. Selection of an appropriate Loctite® dispensing valve is based on the chemistry and viscosity of the adhesive or fluid to be processed, and on the overall process requirements.

Product	Illustration	Item #	IDH No.	Viscosity (mPas)	Dispensing capabilities	Suck-back	Stroke adjust-ment	Wetted parts*	Page
Stationary Applicator Valve		97113	88644	Medium to high	●	Yes	Yes	POM & PTFE	21
		97114	88645		●				
Light Cure Disp. Valve/ Cyanoa-crylate Disp. Valve		98009	218280	Low	•	No	Yes	POM & PE-UHMW	21
		98013	318654		•				21
Diaphragm Valve		97135	215846	Low	●	No	No	PTFE	22
		97136	215848	Medium					
Shut-Off Valve		97664	315994	High	●	No	No	Stainless steel	22
		97676	529491	High	●	No	No	POM	

● High flow rate   ● Medium flow rate   • Low flow rate

*POM   Polyoxymethylene (Polyacetals)
PTFE   Polytetrafluorethylene
PE-UHMW   Ultra high molecular weight polyethylene

Stationary Applicator Valve | 97113/97114

The Stationary Applicator Valve is a robust dispensing valve designed for pressure-time applications. This valve is a modular design comprising a valve body and a pneumatic valve actuator, providing quick on-line serviceability. It also incorporates an adjustable suck-back feature which prevents dripping or stringing. The Stationary Applicator Valve 97113 is fitted with a $1/4$" tube fitting for viscosities up to 10,000 mPas; model 97114 is fitted with a $3/8$" tube fitting for higher viscosities.

The dispensing valve has a double-acting pneumatic actuator with spring assisted close. Separate adjustment of the two throttle valves achieves adjustable opening and closing speed for process control. These valves can be used in stationary mounted applications or in combination with an advancing slide.

Recommended products: Acrylics, anaerobic adhesives, gel-type cyanoacrylates and light curable adhesives

Technical Specifications:			
Weight	340g	Dimensions (W x H x D)	180 x 64 x 35mm
Product Pressure	max. 12.5 bar (180 psi)	Air Input	min. 4 bar (60 psi), filtered to a maximum of 10µm
Product Outlet	$1/4$"-26 UNF Luer-Lock output fitting		

Features:
- Robust, seal-less dispensing valve
- Modular design of product shutoff valve & valve actuator provides on-line serviceability
- Fail safe – spring assisted close
- Adjustable suck-back feature eliminates product dripping and stringing
- Double-acting cylinder allows adjustable opening and closing speed for process control

Light Cure / Cyanoacrylate Dispensing Valve | 98009/98013

The Loctite® Light Cure / Cyanoacrylate Dispensing Valve provides high-resolution stroke adjustment for accurate dispensing of small amounts of all low to medium viscosity adhesives. It is designed specifically for pressure-time applications and must be used in conjunction with a controller and product reservoir.

The dispensing valve has single acting, spring return, stroke control. Fine adjustment of flow rate is achieved by turning the flow control dial on top of the valve. The valve can be used in stationary mounted applications or in combination with an advancing slide.

Recommended products: 98009: Light curable adhesives, anaerobic retaining compounds, anaerobic threadlockers
98013 : Cyanoacrylate adhesives

Technical Specifications:	
Weight	130g
Max. Input Fluid Pressure	5 bar (70 psi)
Mounting Hole	(1) 10-32 UNF
Dimensions (W x H x D)	ø 78.5 x 30mm
Air Inlet Port	$1/4$" tube fitting
Air Input	5-6 bar (70-90 psi), filtered to a maximum of 10µm

Features:
- For applying miniature amounts
- Compact size and weight
- Stroke adjustment for fine-tuning dispense characteristics
- Fail safe – spring assisted close
- Diaphragm valve, no seals
- Bubble free, no-drip dispensing

Diaphragm Valve

97135/97136

In combination with a semi-automatic or automatic controller, Diaphragm Valves are suitable for dispensing all low (97135) to medium (97136) viscosity anaerobic and UV light curable adhesives. All wetted components inside the valve are PTFE to prevent premature curing. The valve has a simple design that facilitates cleaning, servicing and diaphragm replacement.

The opening of the diaphragm takes place by pressurising an internal single-acting cylinder. When in idle position, the valve is held closed by spring pressure. Sealing in idle position is achieved by an internal spring pushing a piston against the diaphragm, re-seating the diaphragm over the flow path. The diaphragm valve is not suitable for moisture sensitive products like CAs.

Recommended products: Acrylics, anaerobic adhesives and light curable adhesives

Technical Specifications:			
Air Input	min. 5-max. 7 bar (73-100 psi), filtered to a maximum of 10µm	Dimensions (W x H x D)	ø 32 x 127mm
Product Outlet	Luer-Lock output fitting	Weight	300g
Max. Product Pressure	4 bar (60 psi)		

Features:
- Modular design of valve body and valve actuator provides on-line serviceability
- Simple design, cost effective
- Easy to service

Shut-Off Valve

97664/97676

The Shut-Off Valve is used in combination with the Eccentric Rotor Pump 3RD8-L / 4RD6-L / 3RD12-L for dispensing Loctite silicones (97664) or anaerobic sealants (97676). It is opened and closed by a double acting cylinder and provides a clean cut-off of the fluid flow from the dispensing nozzle.

The valve is installed between eccentric rotor pump and dispensing needle. A pressure sensor can be screwed directly into the valve body for monitoring the amount of product dispensed.

Recommended products: High viscosity and pasty sealants

Technical Specifications:			
Max. Product Pressure	40 bar (580 psi)	Dimensions (W x H x D)	142 x 75 x 50mm
Air Inlet Port	min. 5 bar (73 psi), max. 10 bar (145 psi)	Air Quality	Filtered, oil-free, or filtered, oiled
Weight	600g	Dispensing Needle Connector	G 1/8

Features:
- Easy clean-up of product channel
- Non-drip opening and closing
- Self closing with spring return

Fluid Compatibility
Selector Chart for Loctite® Valves & Pumps

Product	Item #	IDH No.	Acrylics	Activators	Anaerobic Adhesives Gasketing Compounds	Cyanoacrylates	Silicones/ MS-Polymers	Single component Epoxies	Primers	UV- & light curable Adhesives
	97113/ 97114	88644/ 88645	●		●	●		●		●
	98009	21820		●	●				●	●
	98013	318654		●		●			●	
	97135/ 97136	215846/ 215848	●		●					●
	97664	315994					●			
	97676	529491			●					

Process Monitoring

The Loctite® Flow Monitor, when integrated with an appropriate dispensing system, ensures reliable process monitoring. This means that the Online Flow Monitor detects and evaluates malfunctions with respect to the quality and quantity of dispensing. These malfunctions may include air bubbles or pressure changes in the dispensing system, lost or clogged needles, or accidental needle-to-substrate contact.

Measuring Principle		Illustration	Item #	IDH No.
Pressure based	Preamplifier		97211	215992
	Dispensing valve		97138	1147046
Calorimetric	Preamplifier		97512	1126901
	Dispensing valve		97830	1122415
Fluorescence	Detector		98083E	664169

Theory of operation:

Two different measuring principles are used for online flow monitoring: The **pressure based** and the **calorimetric** method.

The **pressure based system** comprises a pressure sensor (with suitable pressure range), a Preamplifier and a Loctite® controller. The electronic evaluation system integrated into Loctite® controller 97152 or 97153, combined with Preamplifier 97211, measures the pressure profile by means of a pressure sensor built into the dispensing valve. This parameter is stored in the system and serves as a reference. The controller compares the pressure profile that has been measured to the previously stored reference pattern, based on four different factors; dispensing time, integral of pressure profile (equals the amount of product dispensed), length of the envelope curve for the pressure profile, and centre of gravity.

As long as the measured values are within a pre-defined tolerance range, the dispensing cycle is accepted, and the Ready signal is indicated on the controller. If the deviation is outside the tolerance range, the dispense cycle is rejected and signalled as an error. This message is indicated on the display of the controller and is made available as a signal to a higher-ranking controller.

Depending on the process environment conditions, appropriate tolerances can be adjusted to determine the optimum between a false alarm and a reliable error recognition.

The **calorimetric system** is similar with respect to system integration and signal processing but is based on a different measuring method. A miniaturised heating element placed in the product flow gets slightly heated, and the temperature difference in the flowing product is analysed. This system is recommended in particular for flow monitoring of small dispensed amounts at low pressure settings. The signal strength delivered by the pressure based method is too low for such applications and cannot be reliably processed.

Combined with a Loctite® controller, both systems are fail safe because no dispensing cycle will pass unchecked.

Preamplifier for Pressure Based Flow Monitoring   97211

The single-channel preamplifier is used for signal transmission between a dispensing valve with pressure sensor and a downstream Loctite® controller 97152 or 97153. The amplifying factor is adjusted depending on the viscosity of the product to be processed. The Online Flow Monitor is an ideal tool for quality assurance in automated manufacturing processes. In order to integrate such a monitoring system in the production process, a special dispensing valve with an integrated pressure sensor is required (see page 24).

Pressure based valve

Features:
• Adjustable amplifying factor with LED signal strength indication
• Power supply to pressure based sensor
• Single channel

Preamplifier for Calorimetric Flow Monitoring   97512

The two-channel preamplifier is used for signal transmission between the dispensing valve with calorimetric sensor (97830) and a downstream Loctite® controller 97152 or 97153. Set-up of the amplifying factor is not required; the valve itself provides permanent self-monitoring of the measuring circuit with status indication. The Online Flow Monitor is an ideal tool for quality assurance in automated manufacturing processes. The calorimetric measuring principle requires a minimum cycle time of 1.2 seconds.

Calorimetric valve

Features:
• LED signal strength indication
• Power supply to calorimetric sensor
• Two channel

Fluorescence Detector   98083E

The Loctite® Fluorescence Detector with lens is a robust monitoring unit that is designed for visual detection and monitoring of dispense processes utilising fluorescent adhesives. The integrated light source is a long lasting UV LED. The fluorescence detector is designed to be interfaced directly with a host PLC.

Technical Specifications:					
Input Voltage	24 VDC	Output Capability	PNP/NPN selectable	Optimum working distance	9mm
Protection	IP 67	Size of light spot	5mm on the focal surface		

Fume Filtration

Loctite® Fume Filtration Systems are used for providing fume extraction at the workplace. The systems operate at a low noise level to safely remove harmful air-borne substances which often cannot be avoided in specific working processes. These filtration systems utilise activated carbon technology and have been designed specifically for adhesive processing workstations, making them a key element of environmental protection and health and safety at work measures.

Product	Air Filter Trolley, mobile	Air Filter System, stationary	Benchtop Suction Arm with hood	Hose with fitting
Illustration				
Item #	97612	97603	8991090	8991091
IDH No.	494964	527595	503370	529639

Air Filter Trolley, mobile   97612

Conveniently designed with large castor wheels and telescopic handle, the Air Filter trolley provides easy mobility for transportation to the required workstation. The trolley can be used for removing and filtering fumes, gases and unpleasant odours from work areas.

The fumes and vapours emitted are immediately captured by a transparent suction hood. Then they are cleaned by passing through an activated carbon filter. The purified air can be returned to the work area.

The combination of pre-filter and activated carbon ensures a very high efficiency in removing harmful/unhealthy gases, vapours and fumes. Activated carbon has a very large surface area and very small particles to ensure a long contact time between the polluted air and the adsorbent. The gases, vapours and fumes are efficiently absorbed.

Technical Specifications:					
Max. Vacuum	2800 Pa	Dimensions (W x H x D)	450 x 530 x 340mm	Max. Air Flow	170m^3/h
Power Consumption	150W	Constant Air Flow	80m^3/h at 1400 Pa	Weight	18kg
Power Supply	230V AC, 50 Hz	Noise Level	49 dB (A)		

Features:
- High impact ABS housing
- Resistant to chemicals and corrosion
- Adjustable discharge direction
- Adjustable flow rate
- Low noise level
- Compact design
- High performance fan, minimum energy consumption
- High capacity filter (can be recycled)
- Easy operation, servicing and filter replacement
- Long life brushless electric motor

Air Filter System, stationary   97603

The LAS 250 Air Exhaust and Filter Systems can be used for cleaning the air directly at the workstation. Harmful and unpleasant odours will be reliably removed. The system can serve up to two workstations due to its high filter performance.

The suction hose or the suction arm must be positioned close to the bonding station. The system exhausts the polluted air and blows out the purified air from the air outlet on the rear side of the unit. The combination of pre-filter and activated carbon ensures a very high efficiency in removing harmful unhealthy gases, vapours and fumes. Activated carbon has a very large surface area and very small particles to ensure a long contact time between the polluted air and the adsorbent. The gases, vapours and fumes are efficiently absorbed.

Technical Specifications:

Power Supply	230V AC, 50 Hz	Power Consumption	370W	Constant Air Flow	$250m^3$/h at 2200 Pa
Max. Air Flow	$450m^3$/h	Noise Level	52 dB (A)	Dimensions	370 x 780 x 500mm
Weight	approx. 40kg	Max. Vacuum	2600 Pa		

Features:
- Low noise level
- Adjustable flow rate
- High performance fan, minimum energy consumption
- High capacity filter (can be recycled)
- Easy operation, servicing and filter replacement
- Two options for exhausting polluted air: Suction arm with hood, or suction hose (must be ordered separately)
- Intake flange: 2 x suction hoses, diameter 50mm
- Long life brushless electric motor

Accessories for 97612/ 97603
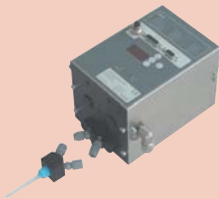
System	Item #	IDH No.
Benchtop Suction Arm, 3 joints, maximum range 950mm, including hood	8991090	503370
Y splitter (for connecting 2 hoses)	8991096	529643
Spare filter for Trolley 97612, replacement	97969	782862
Spare filter for LAS 250 97603, replacement	8991093	529641
Hose with fitting, 2 metre	8991091	529639
Filter for Trolley 97612, new	97968	267469
Filter for LAS 250 97603, new	8991092	529640
Suction hood transparent	8955065	1034999

Volumetric Dispensing Systems

Contrary to the pressure-time systems, operation of Loctite® Volumetric Dispensing Systems is based on the principle of volume change. They largely avoid variations in the amount of product dispensed due to variations in temperature and viscosity.

Product	Dual Rotor Pump Dispenser	Volumetric Rotor Dispenser	Benchtop Peristaltic Dispenser
Item #	97504	8953494	98548
IDH No.	614699	1197319	769914
Product Types	2-component epoxies	Low to medium viscosity anaerobics and UV acrylics	Low to medium viscosity Loctite® products
Page	29	29	30

Product	Volumetric Mix Dispenser	VoluBrane Pump	Eccentric Rotor Pumps
Item #	97640	97643/ 97643 PAS	97660/663/665/669
IDH No.	451896	831134/ 1388831	320229/315995 395210/452357
Product Types	2-component acrylics, 1:1 2-component epoxies, 1:1 2-component epoxies, 2:1	97643: Low to medium viscosity cyanoacrylates, acrylics & activators 97643 PAS: Low to medium viscosity anaerobics	1-component RTV Loctite® silicones, anaerobic gasketing compounds, 1-component Terostat MS polymers
Page	30	31	31

Dual Rotor Pump Dispenser 97504

The Dual Rotor Pump Dispenser is a volumetric system designed for dispensing two-part epoxy resins. It is suitable for processing low and high viscosity materials, provided that the ratio of viscosity part A/B is within the range of 1:1 to 10:1. The Pump has been designed for operating in a continuous mode for bead dispensing applications or for time-controlled potting applications in manual work stations.

Two separate servo drives allow continuous adjustment of mix ratios from 1:1 to 1:10. Abrasive products can be processed, provided that their qualification has been confirmed and that they do not tend to separate during storage in original containers. As the pumps are built directly into follower plates with wiper lips, they can also be used for feeding and dispensing thixotropic products which are not self-levelling. Interfaces allow the pump to be integrated into fully automated production environments.

The Dual Rotor Pump Dispenser has two eccentric rotor pumps powered by separate electric drives, a potentiometer for flow rate adjustment, and a hand-held pneumatic mix gun. Flow rate is adjusted using the potentiometer; mix ratio and dispense volume settings are made on the controller. The dispensing cycle is started by pressing the trigger of the mix gun. During the dispensing cycle, the two piston valves of the gun are open, and the pump motors are monitored electronically.

Technical Specifications:

Power Supply	230V AC, 50 Hz	Mixing system	static
Air Input	min. 4 - max. 6 bar (60-90 psi), must be filtered to a maximum of 10µm	Dimensions (W x H x D)	390 x 455 x 650mm
Container capacity	2 x 1kg Loctite® Hysol® original containers	Weight	approx. 18.0kg
Dispensing System	2 x Eccentric rotor pumps		

Features:
- Precision dispensing of two-component epoxies
- High repetition accuracy
- Suitable also for some abrasive and high viscosity materials

Volumetric Rotor Dispenser 8953494

The Loctite® Volumetric Dispenser is suitable for a wide range of flowable single component Loctite® anaerobics and UV acrylics. The Rotor Dispenser and its controller are perfectly tuned to work together. Menu navigation is easy and allows users to select either the amount of product dispensed (in ml) or the dispense rate (in ml/min).

The system ensures precise application of dots and of beads. It is characterized by a very high repetition accuracy, even in variable environmental conditions. Rotation can be reversed, which means that post-dispense dripping can be prevented by creating a specific suck-back effect. Product delivery is achieved by rotation of the stainless steel rotor with the self-sealing elastomeric stator. A maintenance free brushless DC motor is used to drive the system. The pump outlet has minimal dead space and is equipped with a Luer-Lock output fitting. The drive amplifier is built into the controller.

Technical Specifications:

Dimensions	Controller: 240 x 115 x 260mm Rotor dispenser: 220mm ø 35mm	Material Outlet	Luer-Lock fitting with O-ring
Weight	Controller: 1.3kg Rotor dispenser: 300g	Minimum Operating Pressure	0 bar, for self-levelling fluid
Motor	18-24V DC, incremental encoders, planetary gearing	Maximum Operating Pressure	6 bar inlet pressure, for non self-levelling fluid
Dispensing Accuracy*	<5%	Operating Conditions	+10°C to +40°C
Minimum Dispense Volume	0.004ml	Dispense volume, approx. per revolution	0.05ml
Flow rate*	0.05 to 6.0ml/min		

Selector Chart:		Item #	IDH No.
Controller		97150	1195937
Rotor Dispenser		97611	1196160

Features:
- Precision dispensing of anaerobics and UV acrylics
- Integrated pressure regulator on the rear for connection of an optional reservoir
- Membrane keypad with status LED
- Graphic LCD display
- Easy Menu using navigation wheel
- Interfaces for Loctite® product reservoir and higher-ranking control system

Benchtop Peristaltic Dispenser   98548

The peristaltic motion of the rotor provides volumetric dispensing of the material directly from a bottle or similar container and does not require the use of an air source. This dispenser completely empties the product container, eliminating waste and avoiding spilling. The Benchtop Peristaltic Dispenser provides precise volumetric dispensing of single component cyanoacrylates, UV and anaerobic adhesives, solvent-free activators and oils (up to a viscosity of approx. 5,000 mPas). The unit is designed mainly for manual work stations but can also be integrated into automatic production lines. A precise amount of product can be set and high repetition accuracy is ensured. Four feedline size options are available. Black tubing must be selected for UV-curable adhesives.

The Benchtop Peristaltic Dispenser is a volumetric system driven by a stepper motor. An electronic motor control unit with 9-pin I/O connector for an optional foot switch or communication with a PLC is integrated into the system. The unit provides digital dispense timing control, continuous flow rate adjustment and adjustment of suck-back.

Technical Specifications:

Power Supply	100-240 V AC, 50/60 Hz	Power Consumption	10W
Dimensions (W x H x D)	192 x 210 x 90mm	Weight, applicator assembly	approx. 3.0kg
Repetition Accuracy	±10%		

Selector Chart:

	Item #	IDH No.
Bottle stand for 20g/50ml Loctite® bottles	98501	756316
Controller	98548	769914

Features:
- Precision dispensing of low viscosity materials directly from the original bottle
- Does not require the use of an air source
- High repetition accuracy, unaffected by temperature variations
- Manual or time-controlled dispensing modes, variable dispensing rate and adjustable suck-back
- Range of clear and black feedline size options available
- Easy clean-up and product change-over

Volumetric Mix Dispenser   97640

The Mix Dispenser is suitable for precise volumetric application of 2-component acrylic and epoxy products (up to 50,000 mPas). It is a compact design for integration into automatic work stations and robotic applications. Mixing ratios of 1:1 and 2:1 are available. A very precise amount of product can be dispensed with very high repetition accuracy. The maximum dispensing volume is 10ml. Various types and sizes of mixers are available to suit different types of products and applications. Heater 97534 may be used for heating the dispensing head whenever high viscosity products are processed.

Synchronous dispensing is controlled by means of a DC drive with ball-screw transmission. Inlet and outlet valves are driven by pneumatic actuation. A control module with LED display, serial RS 232 and PLC interface are also integrated into the unit.

To prevent negative pressure and resulting entrapment of air bubbles, product pressure from a reservoir is applied to fill the product chambers simultaneously with product parts A and B. Dispensing volume and flow rate can be adjusted. A static mixer is connected for product mixing and dispensing.

Technical Specifications:

Power Supply	24 VDC	Power Consumption	84W
Air Input	min. 5-max. 8 bar (73-116 psi) required, filtered to a maximum of 10μm		
Dispensing System	Piston pump	Mixing System	static
Product Pressure	3 bar (44 psi) required	Repetition Accuracy	±3%
Dimensions (W x H x D)	152 x 190.5 x 140mm	Weight, applicator assembly	approx. 3.0kg

Static Mixer	Size	Item #	IDH No.	Static Mixer	Size	Item #	IDH No.
Blue (12 elements)	3.2mm	97285	697033	Green (16 elements)	6.5mm	97289	496665
Blue (16 elements)	3.2mm	97286	446903	Pink (20 elements)	5.4mm	97502	486497
Yellow (16 elements)	4.2mm	97287	446902	Green (20 elements)	6.5mm	97503	486499
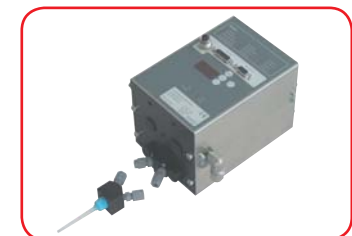
Features:
- Precision dispensing of 2-component acrylics and epoxies
- High repetition accuracy
- Numerous types and sizes of mixers available to suit different types of products and applications
- Tubing adapters for optimum separate assembly of mixing nozzle

Mixing ratio:	Item #	IDH No.
1:1	97640 (Acrylic)	451896
1:1	97061 (Epoxy)	727063
2:1	97062 (Epoxy)	727062

Approved Loctite® products:
Acrylics: 3250, 3252, 3255, 3271, 3292   Epoxies: 3421, 3422, 3430, 9455, 9466, 9483, 9489

VoluBrane Pump

The VoluBrane Pump is suitable for volumetric dispensing of drops of anaerobics, cyanoacrylates, UV acrylics, acrylics and activators up to 15,000mPas viscosity.

The VoluBrane Pump is self priming up to a viscosity of 500mPas. It is designed for integration into automated work stations and robotic applications. A precise amount of product can be set and high repetition accuracy is ensured. The maximum dispensing volume is 0.4 ml. The minimum dispensing volume is 0.004ml.

The volumetric VoluBrane Pump system comprises an air operated volumetric diaphragm pump, one electromagnetic dispense and one fill valve, electronic stroke adjustment, an electronic control system and a 4 pin I/O. Dispensing volume is adjusted on the thumb wheel and via display indication. It is monitored by electronic measurement of the diaphragm stroke.

During priming, the fill valve is opened, the dispensing valve is closed. The product chamber is filled by suction and, if required, also by the supply pressure of the material. Dispensing volume is mechanically adjustable. During the dispensing cycle, the fill valve is closed while the outlet valve is open. Dispensing is controlled by a pneumatic cylinder and the thumb wheel stroke adjustment.

Technical Specifications: Approved Loctite® products: on request			
Power Supply	24V DC	Air Input	min. 4-max. 8 bar (58-116 psi), filtered to a maximum of 10µm
Power Consumption	15W	Repetition Accuracy	< 3% (50-400µl); ±1µl (10-50µl)
Protection	IP 43		
Weight	approx. 1.0kg		
Dimensions (L x W x H)	280 x 52 x 107mm		

Accessories: 24V supply module (Item # 97843, IDH No. 1109319)
Approved Loctite® products on request.

Features:
- High accuracy of drop dispensing for a wide variety of Loctite® products
- High repetition accuracy
- Optional: control of a rotorspray

Eccentric Rotor Pumps

The Eccentric Rotor Pump is ideally suited for volumetric dispensing of materials ranging from anaerobic adhesives and sealants to very pasty silicones.

The direction of flow is reversible and the dispensed amount proportional to speed of rotation, i.e. the system allows for continuously variable adjustment of the dispensing rate via motor speed adjustment. The drive shaft is sealed by two double acting sealing rings made of UHMW-PE and PTFE; it is fitted with a barrier liquid connection.

Eccentric Rotor Pumps are positive displacement pumps providing volumetric dispensing and a nearly pulsation free flow of material.

Volume flow depends on the size of the pump and the number of revolutions. The pumps can be driven by either a digital AC servo drive or a DC drive. Pump and drive are fixed together with a mounting clamp for fast assembly and disassembly. As a rule, the pumps are operated with a shut-off valve at the product outlet as self-sealing capability will degrade over time.

Technical Specifications:			
Item #	97660	97663/97669	97665
Approved Loctite® products – silicones	5900, 5970	5083, 5699, 5900, 5910, 5960, 5970	
Approved Loctite® products – anaerobics	-	97669 only: 510, 518, 5203 5205, 5206, 5209	510, 518, 5203 5205,5206,5209
Maximum Inlet Pressure	20 bar dynamic, 30 bar static		
Dispensing rate for Loctite® 5900	3.0g/s at 20°C	0.6g/s at 20°C	0.3g/s at 20°C
	150rpm	150rpm	200rpm
	3mm nozzle	2mm nozzle	2mm nozzle
Dispensing rate for anaerobic gasketing compounds		97669 only: 0.5g/s at 20°C 150rpm 2mm nozzle	0.3 g/s at 20°C 200rpm 1.5mm nozzle
Stator Material	EPDM*	97663: EPDM*	VisChem**
		97669: VisChem**	

For more information on silicone and twin cartridge dispensing systems please refer to page 46.

Features:
- Ideal for volumetric dispensing of high viscosity products
- Continuously variable adjustment of the dispensed amount via drive motor speed
- All data relating to silicones refer to Loctite® 5900, extrusion rate acc. to TDS 20-80g/min

*EPDM suitable for silicones only

**VisChem is mainly suitable for anaerobic adhesives/sealants

Loctite® Hand-Held Applicators are ergonomically designed for hand delivery of Loctite® adhesives and fluids directly from their original package. Whether pneumatic or manual, each item is designed for easy, clean, hand-held dispensing of fluids, to reduce waste and operator contact. Selection of a Loctite® Hand-Held Applicator is based on the product type, package size, and process requirements.

Hand-Held Applicators for Single Component Dispensing

Product	30ml Manual Syringe Dispenser	Manual Dispensing Applicator for 50ml Cartridges	Peristaltic Hand Pump
Item #	98026	96005	97001/98414
IDH No.	476902	363544	88631/ 608966
Adhesive Components	1	1	1
Dispensing Capability	ALL	G,S	TL, RC
Viscosity Range	Low to high	Medium to high	Low to medium
Page	34	34	34

Product	300 ml Cartridge Dispenser			Hand-Held Dispensing Gun for PUR* 300ml Cartridges
Operation	Electrical	Manual	Pneumatic	Pneumatic
Item #	97046	167.65Y	97002	98011E
IDH No.	1047326	142240	88632	967646
Adhesive Components	1	1	1	1
Dispensing Capability	S, G	S, G	S, G	PUR
Viscosity Range	Medium to high	Medium to high	Medium to high	Medium to high
Page	35	35	35	-

ALL = all fluids in approved packages
TL = threadlockers
S = RTV sealants and adhesives
PUR = reactive PU hotmelt

M = two-component methacrylates
E = two-component epoxies
U = two-component urethanes

RC = retaining compounds
RR = Rapid Rubber repair urethane
G = gasketing compounds

Hand-Held Applicators for Two Component Dispensing

Product	50ml Dual Cartridge Applicator			2 x 300ml Dual Cartridge Applicator	900ml Dual Cartridge Applicator
Operation	Manual 1:1 / 2:1	Manual 10:1	Pneumatic	Pneumatic	Pneumatic
Item #	96001	1034026	97042	1911001	97048
IDH No.	267452	1034026	476898	88732	1175530
Adhesive Components	2	2	2	2	2
Dispensing Capability	E, U, M	M	E, U, M	U	E
Viscosity Range	High to pasty	High to pasty	High to pasty	High to pasty	Medium
Page	36	36	36	36	37

Product	200ml Dual Cartridge Applicator		400ml Dual Cartridge Applicator	
Operation	Manual	Pneumatic	Manual	Pneumatic
Item #	96003	983437	983438	983439
IDH No.	267453	218315	218312	218311
Adhesive Components	2	2	2	2
Dispensing Capability	E, U, M	E, U, M	E, U, M	E, U, M
Viscosity Range	High to pasty	High to pasty	High to pasty	High to pasty
Page	37	37	37	37

30ml Manual Syringe Dispenser   98026

The Loctite® 30ml Manual Syringe Dispenser is a hand-held, manually operated dispenser, for use with any product packaged in a standard 30ml syringe. This dispenser provides a convenient, cost-effective method to apply product.

• Pistol configuration for ease of application
• Ergonomic design minimizes operator fatigue

Typical Fluids Handled:
Any product package in a standard 30ml syringe

Features:
• Easy syringe loading
• Smooth dispensing

Manual Dispensing Applicator for 50ml Cartridges   96005

The Loctite® Manual Dispensing Applicator for 50ml Cartridges is a hand-held, manually operated dispenser for use with any product packaged in a standard 50ml cartridge. This dispenser provides a convenient, cost-effective method to apply product.

• Pistol configuration for ease of application
• Ergonomic design minimizes operator fatigue

Typical Fluids Handled:
Any product package in a standard 50ml cartridge.

Features:
• Easy cartridge loading
• Smooth dispensing

Peristaltic Hand Pump   97001/98414

The Loctite® Peristaltic Hand Pump is a volumetric bottle-top applicator that mounts easily on any Loctite® 50ml or 250ml bottle. It will not leak regardless of the orientation of the bottle, which minimizes waste and converts the product package into a portable dispenser for applications requiring small amounts. The Hand Pump applies adjustable amounts of Loctite® threadlockers and retaining compounds, viscosities up to approx. 30,000mPas. It requires no flushing, power or air source.

Typical Fluids Handled:
Low viscosity Loctite® threadlockers, Loctite® retaining compounds, Loctite® thread sealants.

Technical Specifications:	
Compatibility	98414: 50ml Loctite® anaerobic and UV adhesive bottles
	97001: 250ml Loctite® anaerobic and UV adhesive bottles
Dimensions	38 x 102 x 146mm, bottle stand 98414: 115 x 100 x 58mm

Features:
• Ideal for portable applications
• Accepts standard Loctite® dispensing needles

300ml Cartridge Dispenser (electric) 97046

The Loctite® 300ml Cartridge Applicator is an electric dispenser for applying products from 300ml cartridges. Designed to minimise operator fatigue in applications requiring portable dispensing – hassle-free cordless use. When the dispensing cycle is finished, the piston retracts automatically for pressure relief, to minimise run-on effect.

Technical Specifications:	
Weight	2800g

Accessories:
Spare battery Item #: 8952437, IDH No.: 1059469

Features:
• Powerful battery operated gun
• Gun is supplied with charging stand.

300ml Cartridge Manual Dispenser, Type STAKU 167.65 Y

The Loctite® 300ml Cartridge Gun is a manual dispenser for applying products from all 300ml standard cartridges. It is ideal for portable dispensing applications in manual work stations. The operator controls the amount dispensed by holding down the trigger.

Typical Fluids Handled:
Loctite® structural acrylic adhesives, Loctite® silicones, Loctite® anaerobic gasketing compounds, 1-component epoxy adhesives, MS polymers

Technical Specifications:	
Weight	630g

Features:
• Optimized load transfer
• Ergonomic design for comfortable and safe handling
• Glass fibre reinforced plastic housing for long-term reliability
• Rapid-loading system to make cartridge changes clean and easy

300ml Cartridge Pneumatic Dispenser 97002

The Loctite® 300ml Cartridge Applicator is a pneumatic dispenser for applying products from 300ml cartridges. Pneumatic pressurisation minimises operator fatigue. Flow rate is controlled via the integrated pressure regulator. The operator controls the amount dispensed by holding down the trigger.

Typical Fluids Handled:
Loctite® structural acrylic adhesives, Loctite® silicones/MS Polymers, Loctite® anaerobic gasketing compounds, 1-component epoxy adhesives.

Technical Specifications:			
Air Input	max. 8.5 bar (125 psi) with 300ml cartridge, max. 1.5 bar (22 psi) with 250ml tube, filtered to a maximum of 10µm		
Air Inlet Port	Thread diameter: R $1/4$ Pressure Hose: Female thread min. 6mm	Weight	800g

Features:
• Integrated pressure regulator
• Quick pressure relief to minimise run-on effect
• Use with 300ml cartridges

Hand-Held Applicators for Two Component Dispensing

50ml Dual Cartridge Manual Applicator, 1:1 / 2:1 — 96001

The Loctite® 50ml Dual Cartridge Applicator is a hand-held, manually operated dispenser. This dispenser provides a convenient, cost-effective method to apply product. It is used for 1:1 and 2:1 mix ratio products.

Typical Fluids Handled:
Loctite® 2-component epoxies and acrylics packaged in 50ml twin cartridges/syringes.

50ml Dual Cartridge Manual Applicator, 10:1 S cartridge design — 1034026

The Loctite® Dual Cartridge Manual Applicator is a hand held unit; it is made of impact resistant plastic and provides a convenient, cost-effective method to apply product.

Typical Fluid Handled:
Loctite® 3038 Polyolefin Bonder.

50ml Dual Cartridge Pneumatic Dispenser — 97042

The Loctite® 50ml Dual Cartridge Applicator is a hand-held, pneumatically operated dispenser. This dispenser provides a convenient, cost-effective method to apply product and eliminates hand fatigue. The dispensed amount is adjusted via the integrated pressure regulator. The applicator is available for 1:1 and 2:1 mix ratio products. A plunger adapter for processing 37ml dual cartridges is enclosed for quick and easy change-over.

Typical Fluids Handled:
Loctite® 2-component adhesives packaged in 50ml twin cartridges.

Technical Specifications:	
Air Input	max. 8 bar (125 psi), filtered to a maximum of 30μm

2 x 300ml Cartridge Pneumatic Dispenser — 1911001

The Loctite® 2 x 300ml Dual Cartridge Applicator is a hand-held dispenser. It allows parallel dispensing of the two parts of products Loctite® 3295 and 341, mixed in a ratio of 1:1 through a static mixer nozzle.
The pneumatic applicator has an integrated regulator for air pressure adjustment. Pressure is relieved automatically when the gun trigger is released, to minimise run-on effect.

Typical Fluids Handled:
Loctite® 3295 A/B, 341 A/B.

Technical Specifications:	
Air Input	max. 8 bar (125 psi), filtered to a maximum of 30 μm

900ml Dual Cartridge Pneumatic Dispenser 97048

The Spray Gun is used for air assisted application of Loctite® 7255 from 2:1 cartridges.
While the product is being mixed and extruded via a static mixer, a simultaneous flow of atomizing air is supplied; a spray nozzle is attached to produce a uniform spray pattern.

Technical Specifications:

Air Input	max. 8 bar (125 psi), filtered to a maximum of 30μm

Features:
• Control pressure separately adjustable for advancing cylinder and atomizing air.
• A hand lever valve is provided for turning the atomising air supply to the spray nozzle on and off.

200ml Dual Cartridge Manual Applicator 96003

The Loctite® 200ml Dual Cartridge Applicator is a hand-held, manually operated dispenser. This dispenser provides a convenient, cost-effective method to apply product. The applicator is suitable for 1:1 and 2:1 mix ratio products.

Typical Fluids Handled:
Loctite® 2-component adhesives packaged in 200ml twin cartridges.

200ml Dual Cartridge Pneumatic Dispenser 983437

The Loctite® 200ml Dual Cartridge Pneumatic Applicator is a hand-held, pneumatically operated dispenser. This dispenser provides a convenient, cost-effective method to apply product and eliminates hand fatigue. The dispensing rate is adjusted via the integrated pressure regulator. The applicator is suitable for 1:1 and 2:1 mix ratio products.

Typical Fluids Handled:
Loctite® 2-component adhesives packaged in 200ml twin cartridges.

Technical Specifications:

Air Input	max. 8 bar (125 psi), filtered to a maximum of 30μm

400ml Dual Cartridge Manual Applicator 983438

The Loctite® 400ml Dual Cartridge Applicator is a hand-held, manually operated dispenser. This dispenser provides a convenient, cost-effective method to apply product. The applicator is suitable for 1:1 and 2:1 mix ratio products. A conversion kit for 4:1 ratio is available 984211 (IDH No. 478553).

Typical Fluids Handled:
Loctite® 2-component adhesives packaged in 400ml twin cartridges.
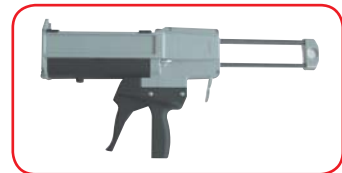
400ml Dual Cartridge Pneumatic Applicator 983439

The Loctite® 400ml Dual Cartridge Pneumatic Applicator is a hand-held, pneumatically operated dispenser.
This dispenser provides a convenient, cost-effective method to apply product and eliminates hand fatigue. The dispensing rate is adjusted via the integrated pressure regulator. The applicator is suitable for 1:1 and 2:1 mix ratio products. A conversion kit for 4:1 ratio is available 984210 (IDH No. 478552).

Typical Fluids Handled:
Loctite® 2-component adhesives packaged in 400ml twin cartridges.

Technical Specifications:

Air Input	max. 8 bar (125 psi), filtered to a maximum of 30μm

490ml version for 10:1 products 985249 (IDH No. 470572).

Disposable Dispensing Components - Accessories

Flexible Dispensing Tips. Dispensing Needle, Polypropylene (PPF), Helical Thread

Illustration/Example	Item #	IDH No.	Pack Size	Colour	Gauge	Inner Ø, mm
	97229	142640	50 pcs	Amber	15	1.37
	97230	142641	50 pcs	Green	18	0.84
	97231	142642	50 pcs	Pink	20	0.61
	97232	142643	50 pcs	Red	25	0.25

Tapered Dispensing Tips. Dispensing Needle, Polyethylene – Conical (PPC), Luer-Lock

Illustration/Example	Item #	IDH No.	Pack Size	Colour	Gauge	Inner Ø, mm
	97221	88660	50 pcs	Grey	16	1.19
	97222	88661	50 pcs	Green	18	0.84
	97223	88662	50 pcs	Pink	20	0.61
	97224	88663	50 pcs	Blue	22	0.41

High Precision Dispensing Tips. Dispensing Needle, Stainless Steel Standard (SSS), Luer-Lock

Illustration/Example	Item #	IDH No.	Pack Size	Colour	Gauge	Inner Ø, mm
	97225	88664	50 pcs	Amber	15	1.37
	97226	88665	50 pcs	Green	18	0.84
	97227	88666	50 pcs	Pink	20	0.61
	97228	88667	50 pcs	Red	25	0.25

Additional Dispensing Tips and Accessories

Illustration	Item #	IDH No.	Pack Size	Description
	98741	1146079	50 pcs	Dispensing Needle, Stainless Steel – PTFE-lined (SSTL), 25 Gauge (50 pack)
	97262	218288	2 each	Needle selection pack: 2 each of a variety of dispensing needles
	K1003100	88805	50 pcs	Formable Dispensing Tip, 21 Gauge / 0.5mm (50 pack)
	97248	218275	50 pcs	Luer Lock Tip Caps
	97233	88672	20 + 5 pcs	Luer-Lock® Adapter Kit, 20 Luer-Locks® and 5 adaptors

Additional Dispensing Tips and Accessories

Illustration	Item #	IDH No.	Pack Size	Description
	97207	88656	40 pcs	10ml Clear Syringe Barrel Kit
	97283	529462	40 pcs	10ml Amber Syringe Barrel Kit, for UV products
	97263	218287	40 pcs	10ml Black Syringe Barrel Kit, for UV and INDIGO® adhesives
	97208	88657	2 pcs	10ml Syringe airline adapter
	97244	88677	20 pcs	30ml Clear Syringe Barrel Kit
	97264	218286	20 pcs	30ml Black Syringe Barrel Kit, for UV and INDIGO® adhesives
	97245	88678	2 pcs	30ml Syringe airline adapter
	97290	397462	50 pcs	All plastic precision dispensing tip, 20 Gauge
	97511	530835	10 pcs	Tri-Nozzle – Helps eliminate bubbles in anaerobic gasket applications
	984569	1487440	10 pcs	Static Mixer for epoxy and PU in 50ml, SQ 5.3-24
	984570	1487439	10 pcs	Static Mixer for epoxy in 200 / 400ml, SQ 7.5-24
	1034575	1034575	10 pcs	Static Mixer MBX 6.5-20-S 10:1 for Loctite® 3038
	8953593	1248606	10 pcs	Spray mix nozzle for Loctite® 7255
	8953186	1104046	10 pcs	Static Mixer 4:1 / 10:1 for 400/490ml, MCX 08-18
	5289010	545996	10 pcs	Static Mixer 1:1 for acrylics in 50ml, MA 6.3-7
	98457	720174	10 pcs	Static Mixer 1:1 / 2:1 in 200/400ml, MC 8-24
	863585	367545	10 pcs	Static Mixer 1:1 for MS polymers in 410ml, MC 13-18
	8953187	1104047	10 pcs	Static Mixer 4:1 / 10:1 in 400/490ml, MCX 08-24
	8955989	1453183	10 pcs	Static Mixer for Loctite® 3090 MLX 2.5-16-5

Light Curing Equipment - UV Curing Systems

Loctite® light curing systems are state of the art, dependable units designed for fast and reliable curing of light curable adhesives. They are characterised by safety, user friendly design and reliability. To determine which cure system is right for the job is a matter of technical requirements and/or economic constraints. Light curable Loctite® adhesives are cured by UVA or UVV light. Acceleration of surface (tack free) cure can be achieved with UVC light.

	Product	Loctite® 7700 Hand-held LED Light Source	UV Spot Cure System, LED	UVA Wand System ECO	UVA/UVC Spot Cure System	
Spot Light Source						
	Item #	98794/98591	97079	97058	97057	97034
	IDH No.	1427232/806035	1473952	1076998	941764	331219
	Radiation Intensity	100mW/cm²*	8W/cm²*	15W/cm²*	15W/cm²*	5W/cm²*
	Power consumption [W]	<20	60	120	120	200
	Spectral wavelength (standard bulb)	395nm	365nm	310-500nm	310-500nm	250-440nm
	Optimum Spectral Output Range	UVV	UVA	UVA/UVV	UVA/UVV	UVA/UVC
	Page	41	41	41	42	42

 * Exact output measurement depends on the offset distance and on the type of meter used.
** Exact output measurement depends on the offset distance, the type of meter and the lamp used.

	Product	LED Flood Cure Systems	LED Line Array System	UVALOC 250 Hand lamp	UVALOC 400/ IndigoCure Lamp	UVALOC 1000 chamber / tunnel version	
Flood Light Source							
	Item #	97070/97071	97067/97068	97053	97039/63	97055	97056
	IDH No.	1427234/1427233	1484215/ on request	982317	525224/1278815	805741	838778
	Radiation intensity	200mW/cm²*	600mW/cm²	150mW/cm²*	80mW/cm²*	110mW/cm²**	
	Power consumption [W]	max. 350	150	250	400	1000	
	Spectral wavelength	375/405nm	365/405nm	350-480nm	300-450nm/ 400-500nm	200-550nm	
	Optimum Spectral Output Range	UVA/UVV	UVA/UVV	UVA/UVV	UVA/Indigo	UVA/UVC	
	Page	42	43	43	44	44	

 * Exact output measurement depends on the offset distance and on the type of meter used.
** Exact output measurement depends on the offset distance, the type of meter and the lamp used.

Loctite® 7700 Hand-held LED Light Source 395nm 98794/98591

The Loctite® 7700 light sources are used for curing light cure products that respond to UVV cold light. They both include a focussed LED light source.
The 98794 HD LED unit is designed for continuous use. It can be either hand-held or mounted in a fixed position. Initiation is via a foot switch (97201) which must be ordered separately.
The 98591 is designed for intermittent use and is started by pressing a finger switch. It is powered by a rechargeable battery.

UV Spot Cure System LED 365nm 97079/97079-4

This LED cure system is designed for curing Loctite® UV adhesives using UVA cold light at a wavelength in the range of 365 nm. The basic configuration is equipped with one LED head and one condenser lens. As an option the unit can be extended with 3 additional LED heads. The unit is designed for manual working stations and also for integration into automatic production lines. The radiation cycle can be started with the START button on the front panel, with a footswitch or via a PLC interface.

An optional sensor head is available for UV intensity measurement 8953856 (IDH No. 1305334).

Technical Specifications:

Power Supply	100-240V AC, 50/60 Hz	Weight	1.3kg
Power Consumption	max. 60VA	Dimensions (W x H x D):	80 x 125 x 140mm
Typical LED life	above 20,000 hours	Cure Area	ø 6mm
Operating Temperature Range	+5°C to +35°C		

Model:	Item #	IDH No.		Item #	IDH No.
1-channel, fully fitted	97079	1473952	4-channel, fully fitted	97079-4	on request

Features:
- LED life exceeds 20,000h
- Programmable intensity profile
- Locking key
- Connection for external emergency stop
- UVA intensity up to 8000mW/cm²
- Compact and space saving LED head design
- No warm-up required
- No thermal loading

UVA Wand System ECO 97058

This light source in combination with a liquid light guide is a simple, cost efficient spot light source for curing spots of Loctite® UV adhesives typically up to 12mm in diameter. It is particularly suitable for manual operation in small scale productions and lab applications. The integrated reflector lamp unit combines high radiation output with low energy consumption. For periodical monitoring of UVA radiation output it is highly recommended to use the UV Spot Radiometer (see page 45).
Spot curing systems 97057 or 97034 (with additional emission of UVC light for fast surface cure) should be preferred for fast processing cycles or where fully automated integration is required.

Technical Specifications:

Power Supply	230V AC, 50Hz	Spectrum	310-500 nm
Power Consumption	120W	Dimensions (L x W x H)	215 x 160 x 255mm
Lamp Type	120 watt ultra-high pressure mercury arc lamp	Weight	4.5kg

Features:
- High Intensity UVA and blue light source
- Choice of UV wands
- Adjustable exposure time up to 99.9s
- Bulb lifetime expectancy up to 3000h
- Integrated hour meter
- Ideal for manual workstations

UVA/UVC Spot Cure System

Loctite® UVA Spot Cure System 97057 is a high intensity spot curing system designed to emit UVA and visible (blue) light for extremely fast cure. Perfect for high-volume productions and short cycle times. System 97034 also emits UVC light for further acceleration of surface cure. The high intensity spot curing system is a lamp system for curing UV adhesives. The lamp's emission spectrum and radiation output were designed specifically to meet the requirements of UV-curable Loctite® adhesives and coating materials. A stepper motor drives the safety shutter. High reliability and very short exposure times are the special benefits of this design. The system offers capability for integrated continuous UV lamp intensity monitoring to improve the safety of production processes. The 97057 spot curing system is normally used to achieve high cure through depths and fast cure in applications that do not require a tack-free surface. Version 97034 should be selected where tack-free surfaces are needed. Light guides must be ordered separately.

Technical Specifications:

Power Supply	110-240 VAC ±10%, 50-60 Hz	Lamp Power Stabilisation	±3%
Power Consumption	180/380 VA	Dimensions (W x H x D)	340 x 160 x 310mm
Emission Spectrum	97057: 310-500nm/ 97034: 250-440nm	Weight	7.5kg
Lamp Type	97057: 120 watt ultra-high pressure mercury arc lamp 97034: 200 watt high pressure mercury arc lamp (DC)		

Selector Chart:

Light guide for 97057 & 97058	Item #	IDH No.	Accessories / Spare Parts	Item #	IDH No.	Light guide for 97034	Item #	IDH No.
UVA ø 5 x 1500mm	97323	376720	UVA lamp module for 97058	97317	951638	UVC ø 5 x 1000mm	97326	329278
UVA ø 8 x 1500mm	97324	298849	UVA lamp module for 97057	97317	951638	UVC ø 8 x 1000mm	97327	376721
UVA 2 x ø 3 x 1500mm	97318	951637	UVC lamp module for 97034	97322	354963	UVC 2 x ø 3 x 1000mm	97328	352194
UVA Light Guide Intensity Meter	7020	1406024	UV Protection Glasses	8953426	1175127			

Features:
- High intensity UVA and visible light source
- 97034 for additional high UVC intensity
- Choice of matching UV wands
- Variable time exposure controllable to 50ms
- Service life:
  97057: up to 3000 hrs
  97034: up to 1200 hrs
- Perfect for high-volume productions and short cycle times in automated processes.

LED Flood Cure Systems

The LED Flood Cure System has been designed specifically for curing Loctite® UV adhesives using UVA or UVV light. It is a modular system comprising a high-intensity LED flood array, connecting cable and controller. The expected life is over 20,000 hours with proper handling. The unit is designed for manual working stations and also for integration into automatic production lines. The radiation cycle can be started with the START button on the front panel or with a footswitch (included in the supply package). The system can be operated in timed mode via the built-in timer, or in continuous mode via the footswitch, or via a customer-supplied PLC. The LED Flood Array consists of 144 individual LEDs.

Technical Specifications:

Cure Area	approx. 100 x 100mm @ 50mm distance	Dimensions (W x H x D) LED Array	104 x 130 x 152mm
Intensity	200mW/cm² at a 50mm distance	Power Supply	90-260 V AC, 47-63 Hz
Power Consumption	max. 350W	Dimensions (W x H x D) controller	310 x 135 x 365mm
Weight LED Array	approx. 1.8kg	Weight Controller	approx. 3.7kg

Selector Chart:

		IDH No.			IDH No.
97070	375nm LED System	1427234	97071	405nm LED System	1427233

Mounting stand available on request.

Features:
- High intensity: 190mW/cm²
- Typical life > 20,000h
- LED Arrays side by side stackable
- No warm-up or cool-down period required
- Maintenance free air cooling
- 144 individual LEDs
- Integrated temperature and fan monitoring

LED Line Array System

97067/97068

The LED Flood System is developed specially for curing of Loctite® UV-adhesives with UVA or UVV light. It is a modular system consisting of LED head, connection cable and controller. Up to 4 LED heads can be connected to one controller.

The system can be operated at manual working stations as well as within automated production lines. The compact design of the LED head makes it ideally suited to positioning above 'in-line' components on flow lines.

The radiation cycle can be started with the footswitch or via PLC. There are two operating modes; timer mode and continuous mode (via footswitch or PLC connection).

The LED head is equipped with 10 high power LED's and a lens for creating a high intensity curing line over the whole length of the array. The Line Array produces a cure area of 5 mm x 80 mm. The expected LED life is over 20,000 hours.

Technical Specifications:			
Cure Area	5 x 80mm	Dimensions (W x H x D) LED Array	80 x 114 x 23mm
Intensity	600mW/cm^2	Weight LED Array	0.3kg
Power Consumption	150W	Dimensions (W x H x D) Controller	150 x 223 x 260mm
Power Supply	90-260V AC, 47-63 Hz	Weight Controller	2.5kg

Selector Chart:		IDH No.			IDH No.
97067	LED Line System 365nm	1484215	97068	LED Line System 405nm	On request

Mounting stand available on request.

Features:
- Compact LED head design
- High intensity: 600mW/cm^2
- Up to four LED heads operated by a single controller
- No warm-up or cool-down period
- Minimal thermal load during curing
- Integrated temperature and fan monitoring

UVALOC 250 Hand Lamp

97053

The UV Hand Lamp 250W is a portable lamp module designed to emit high intensity ultraviolet light for curing Loctite® UV curable adhesives responding to UVA light. It contains a glass filter that will filter out UVC and UVB light to minimise any danger to operators. The lamp module is separated from the power supply unit for ease of handling. The mounting bracket on the lamp housing can be used for permanent assembly of the lamp module. An optional desktop stand is available.

Technical Specifications:			
Power Supply	230V AC ±10%, 50 Hz	Weight Controller	4kg
Power Consumption	250W	Dimensions Hand Lamp (H x W x D)	121 x 146 x 230mm
Weight Hand Lamp	2 kg	Dimensions Controller (H x W x D)	120 x 150 x 260mm

Optimum Accessories:	Item #	IDH No.		Item #	IDH No.
UV Protection Glasses	8953426	1175127	Pistol grip assembly	8953100	1121133

Adjustable mounting stand available on request.

Features:
- Low heat dichroidic reflector
- Hour meter
- Parabolic reflector for optimum illumination and minimal stray light
- Easy lamp replacement

UVALOC 400 / IndigoCure Lamp

97039/97063

The UVALOC 400 is suitable for UVA and UVV light curing Loctite® adhesives. Both versions are ideal for manual workstations, workshops and labs. They include a base with an integrated power unit and a lamp housing mounted to an adjustable post that enables lamp height to be set to suit the components. Available with optional UV protection enclosure. These light curing systems are designed for applications permitting manual loading. Exposure time depends on the application and must be controlled by the operator. Expected UV bulb life is approx. 1000 hours. The IndigoCure System 97063 has an additional special glass filter that completely blocks UV radiation.

Technical Specifications:

Power Supply	230VAC ±4%, 50 Hz	UV Lamp Warm-up Time	3 min.
Power Consumption	approx. 450W	Lamp lifetime	approx. 1000 hours
Intensity	80mW/cm^2	Lamp Type	400W High intensity metal halide bulb
Weight	11.5kg	Dimensions (W x H x D)	220 x 472 x 300mm
Emission Spectrum	97039: 300-450nm with standard bulb		97063: 400-500nm

Bulb Selector Chart:		Item #	IDH No.		Item #	IDH No.
UVA bulb 400W		97246	135562	Indigo bulb 400W	8953565	1284685

Features:
- 400 W Metal halide bulb
- Optimised to emit UVA light (97039) or Indigo light (97063)
- Typical curing area of 80 x 120mm
- Approx. 1000 hours of expected UV bulb life
- Adjustable lamp height
- Contains a glass filter to prevent exposure to UVB/UVC light

UVALOC 1000 chamber / tunnel version

97055/97056

UVALOC 1000 is a high-performance modular light curing system, designed for integration into automated production lines or used as a bench top system, for curing UV adhesives and sealants. Both systems have a parabolic reflector and a pneumatic shutter system. The controller module is programmable and includes a display. A drawer is provided in the lamp housing for replacement of the plug-in bulb.

Both systems are equipped with a standard 1000W medium pressure pure mercury vapour lamp for combined tack-free and in depth curing. Depending on the type of bulb selected, the expected service life is between 700 and 1200 hours. Optional bulbs are Gallium doped mercury lamps, designed to emit mainly light in the visible spectrum (380nm-780nm), and Fe-doped mercury lamps to emit high intensity UVA light (315nm-380nm). The pure mercury vapour bulb has higher UVC emission (210nm-280nm) for acceleration of surface cure, but less UVA for depth cure. A pneumatically operated shutter ensures that the UV bulb is effectively shielded during part loading or unloading, eliminating any danger to operators.

The chamber version (97055) has a fully interlocked access door that prevents opening during the UV exposure cycle. The door of the cure chamber is made of UV blocking, tinted polycarbonate to allow monitoring of the process during the exposure cycle.

The tunnel version is designed to be installed above an existing conveyor or workstation. It has a PLC interface to enable synchronisation of UV exposure, shutter opening and component conveyor operation.

Technical Specifications:

UV Emission Spectrum	200-550nm dependent on bulb type	Weight:	Controller 13kg
Dimensions (W x H x D):	Controller: 305 x 170 x 490mm		Cure chamber with lamp housing: approx. 12kg
	Cure chamber with lamp housing: 305 x 575 x 525mm	Dimensions (W x H x D):	Cure chamber internal dimensions: 235 x 307 x 350mm
Power Supply	230 VAC, 50Hz	Power Consumption	approx. 1200W
Pneumatic supply	4-6 bar (60-90psi)		

Selector Chart – UV Bulb	Item #	IDH No.
UVA bulb (Fe-doped)	97347	870097
UVC standard bulb (pure mercury)	97346	870098
UV Visible light bulb (Ga-doped)	97348	870096

Features:
- Repeatable and precise curing results due to adjustable opening times of the shutter
- Provides capability for tack-free cure of UV adhesives
- Effectively shielded UV lamp
- High degree of occupational safety
- Integrated UV monitoring system
- Emergency stop button

Accessories:

UV Protection Enclosure II   97307

The protection enclosure offers efficient protection of users from exposure to UVA, UVV and blue light. The tinted door drastically reduces the glare of the enclosed light source therefore improving both the comfort and safety of the operator. It is designed to suit the UVALOC 400 and can also be used with LED flood systems and spot cure systems.

Technical Specifications:				Item #	IDH No.
Weight	1.5kg	Dimensions (W x H x D)	450 x 284 x 360mm	97307	1280676

UV Safety Glasses – orange and grey   8953426/8953427

Two types of UV safety glasses are available with selection being dependent on the UV equipment and light wavelength.

Grey UV Safety Glasses
The grey UV safety glasses are recommended for general use with equipment that emits UV light within the UVA and UVC spectra. The bright light is absorbed by the grey lenses therefore improving comfort for the operator.

Technical Specifications for UV Protection Glasses, Grey:			
Visible Light Transmission	15%	UV Absorption	≥99.9% up to 400nm
IR Absorption	50%	Complies with	DIN EN 166, DIN EN 172

Orange UV Safety Glasses
The orange UV safety glasses are designed for use with light within the UVV spectra.
They enable parts being cured to be visually inspected during the curing process.
These are not recommended for use with UVA and UVC emitting UV equipment.

Technical Specifications for UV Protection Glasses, Orange:			
Visible Light Transmission	20%	UV Absorption	≥99.9% up to 400nm
IR Absorption	50%	Complies with	DIN EN 166, DIN EN 172

Selector Chart:	Item #	IDH No.			Item #	IDH No.
UV Protection Glasses, Grey	8953426	1175127		UV Protection Glasses, Orange	8953427	1175128

UV Spot Radiometer

UV intensity meter designed for light guide diameters 3mm, 5mm and 8mm. Spectral range 320-390nm (UVA).
Measuring range: 0-20W/cm^2. Power source: lithium batteries.

Measuring range:	Item #	IDH No.
UVA	7020	1406024

UV Meter   98727/98770

UV intensity meter designed for flood cure systems. The flat response curve makes this radiometer uniquely qualified to measure narrow band wavelengths of LED light curing devices. Power source: built-in rechargeable lithium batteries. Charger included.

Measuring range:	Item #	IDH No.		Item #	IDH No.
UVA + UVB	98787	1390323	Blue light (UVV)	98770	1265282

Custom Equipment Solutions

In addition to the large variety of Loctite® standard dispensing and curing equipment, Henkel also offers custom-built equipment solutions to suit specific customer needs. Henkel engineers work closely with customers to make sure that the correct selection of adhesive is achieved and the optimum process equipment is implemented into the production line. The Henkel total systems approach ensures optimal compatibility of Loctite® products with the customers' manufacturing processes. Our experience and the unique partnership between our customers, our local sales engineers and our application and equipment engineering staff guarantee the highest level of expertise in the field of adhesive applications.

Systems:

- Customised Silicone / MS Polymer Systems
- Customised Cartridge Systems
- UV Curing Systems
- Ready-to-use dispensing, curing and handling systems
- Robotic and X-Y-Z systems for dispensing adhesives and sealants

Silicone / MS Polymer System

This system is used for dispensing high viscosity Loctite® silicone or MS products from 20 litre / 25 kg open-top pails. Dispensing capability from other containers on request.

An air motor drives the extrusion pail pump. The product outlet pressure is regulated by controlling the motor air pressure. Product is conveyed from the pump through a reinforced, moisture impermeable high-pressure hose (maximum length 10m) to the fluid pressure regulator. This regulator brings the high delivery pressure down to the operating pressure required for dispensing, damping the pressure peaks that are created by the pail pump. The product, regulated to operating pressure, is conveyed through a high pressure feedline to an applicator valve or eccentric rotor pump.

Twin pail pumps, 200 litre pail pumps and heated pail pumps are also available.

Twin Pail Pumps   200 Litre Pail Pump

Twin Cartridge System for 300/850ml Cartridges

The systems are combined with a dispensing valve or an eccentric rotor pump for integration into assembly lines or other automated work stations.

The system is designed as a two channel dispenser, allowing only one channel to be activated at a time. Whenever channel 1 is empty, channel 2 will be automatically activated. At the same time, the changeover valve must be switched to the relevant channel. As an option the twin cartridge dispenser can be equipped with two ball valves for venting pressure from the feedlines. All electrical connectors are plugged into two (6-way) sensor interface boxes used for communication with a higher ranking controller. The system is available for 300ml cartridges and 850ml cartridges.

Typical Fluids Handled: Medium and high viscosity anaerobics.

Twin Cartridge System for Two-Component Epoxies

This system is based on a pneumatically operated extrusion cylinder, a static mixing tube and a controller (97006). To provide positive no-drip shut off, a Pinch Tube Valve (97141) attaches directly to the end of the mixer nozzle. For better stability the static mixer can be fitted with a support tube. This system is capable of dispensing Loctite® products from 50ml, 200ml and 400ml twin cartridges. The system is engineered to deliver the correct mixing ratio. An optional stand with mounting bracket is available for holding the cartridge system in place.

UV Conveyor System

The Loctite® UV conveyor combined with an electrodeless ultraviolet lamp provides a robust solution for UV curing.
The system includes a variable speed conveyor with a typical curing width of 100mm.
The lamp height and orientation are adjustable to suit the specific curing requirements.
The typical UV bulb life is 5,000 hours.

Fully guarded Robotic XYZ systems

Bespoke guarded enclosures are supplied to suit specific customer requirements. The systems are generally protected by light guards at the operator access position. The complete range of Loctite dispense equipment can be interfaced with the robots to provide a complete 'turn-key' solution.

Custom Equipment Solutions

Bespoke System Solutions

Henkel is not just a supplier of state-of-the-art dispensing systems, but can also design and build complete custom equipment solutions tailored to your specific needs and processing requirements.

These can include multi-axis robots and large XYZ systems, rotary indexing tables and fully automated systems, or combinations from standard modules and customised equipment.

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by IDH numbers

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