



## EQUIPMENT Operation Manual

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## Loctite<sup>®</sup> MM10 Dual Cartridge Dispensers

1633364 MM10 Dual Cartridge Dispenser 1:1 & 2:1 A Style Cartridges

1633365 MM10 Dual Cartridge Dispenser 1:1 & 2:1 B Style Cartridges

1633366 MM10 Dual Cartridge Dispenser 4:1 & 10:1 B Style Cartridges



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# 1 Please Observe The Following

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## 1.1 Emphasized Sections

### **Warning!**

Refers to safety regulations and requires safety measures that protect the operator or other persons from injury or danger to life.


### **Caution!**


Emphasizes what must be done or avoided so that the unit or other property is not damaged.

### **Notice:**


Gives recommendations for better handling of the unit during operation or adjustment as well as for service activities.


## 1.2 For Your Safety

 For safe and successful operation of the unit, read these instructions completely. If the instructions are not observed, the manufacturer can assume no responsibility.

 Make sure the Unit stands stable and secure.

 Use only original equipment replacement parts.

 Observe general safety regulations for the handling of chemicals such as Loctite® adhesives and sealants. Observe the manufacturer's instructions as stated in the Material Safety Data Sheet (MSDS).

 *While under warranty, the unit may be repaired only by an authorized Loctite® service representative.*

## 1.3 Unpacking and Inspection

Carefully unpack the Loctite® MM10 Dual Cartridge Dispenser and examine the items contained in the carton. Inspect the unit for any damage that might have occurred in transit. If such damage has occurred, notify the carrier immediately. Claims for damage must be made by the consignee to the carrier and should be reported to the manufacturer.

#### 1.4 Items supplied (one of the following dispensers)

Qty 1	1633364	MM10 Dual Cartridge Dispenser 1:1 & 2:1 A Style
	8903281	Manual
	8900729	Robot Screws
Qty 1	1633365	MM10 Dual Cartridge Dispenser 1:1 & 2:1 B Style
	8903281	Manual
	8900729	Robot Screws
Qty 1	1633366	MM10 Dual Cartridge Dispenser 10:1 B Style
	8903281	Manual
	8900729	Robot Screws

#### 1.5 Features

- Precision anti-drip dispense valve 1445944 / 100 Pack , 1444139 / 500 Pack (sold separately)
- Easy cartridge change over
- Light weight design able to be used on bench top robot systems
- Independent cartridge pressure and actuation functions to control adhesive flow rate
- Interchangeable cartridge pushers with common mounting tooling can accommodate 1:1, 2:1, 10:1 dual cartridges for both A and B style cartridges
- Fluid components designed for MMA and Epoxy adhesives, but can be used with any chemistry
- Dispenses adhesives up to 200,000 cPs

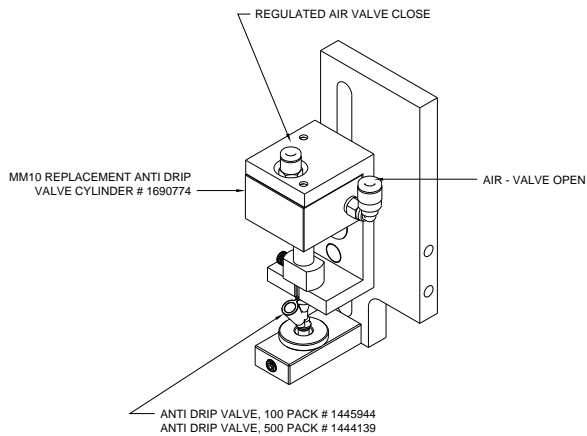
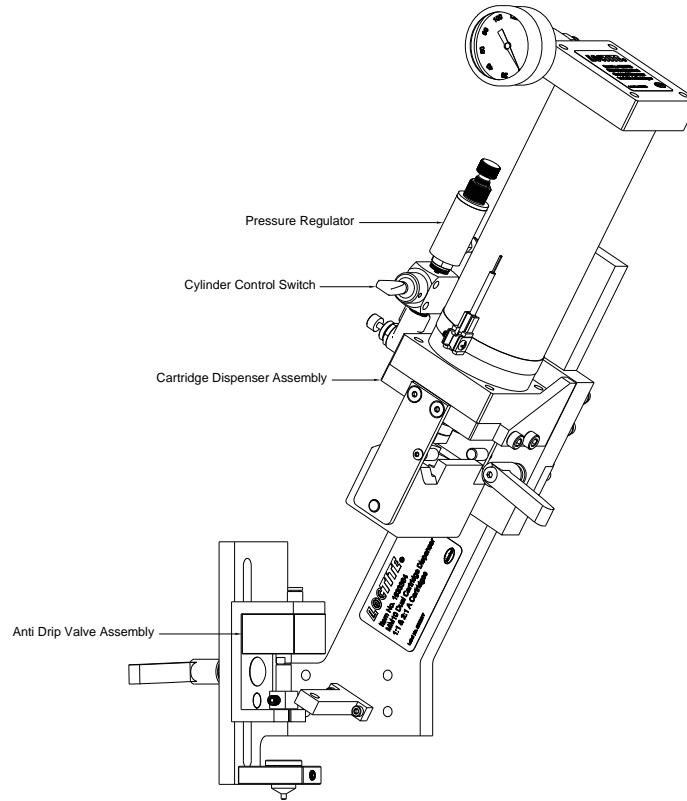
#### 1.6 Usage

Loctite® MM10 Dual Cartridge Dispensers are designed to be used with Loctite® 50 ml dual cartridge packages. It can be used to dispense Epoxy and MMA adhesives or any adhesive packaged in Loctite® 50 ml dual cartridges. The MM10 Dual Cartridge Dispensers integrate onto all Loctite® Robotic systems or can be used as a stationary dispenser.

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## 2 Description

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1633364 MM10 Dual Cartridge Dispenser 1:1 & 2:1 A  
1633365 MM10 Dual Cartridge Dispenser 1:1 & 2:1 B  
1633366 MM10 Dual Cartridge Dispenser 4:1 & 10:1 B



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## 3 Technical Data

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Dimensions (L x H x W):

11" x 14.8" x 4.6"  
(297.0 mm x 376.0 mm x 118.0 mm)


Total weight:

5.3 lbs (2.4 kg.)

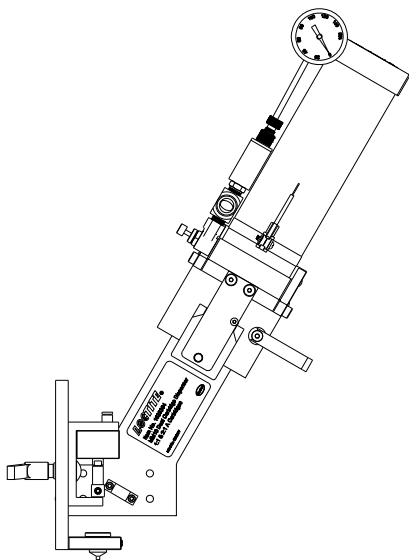
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## 4 Installation

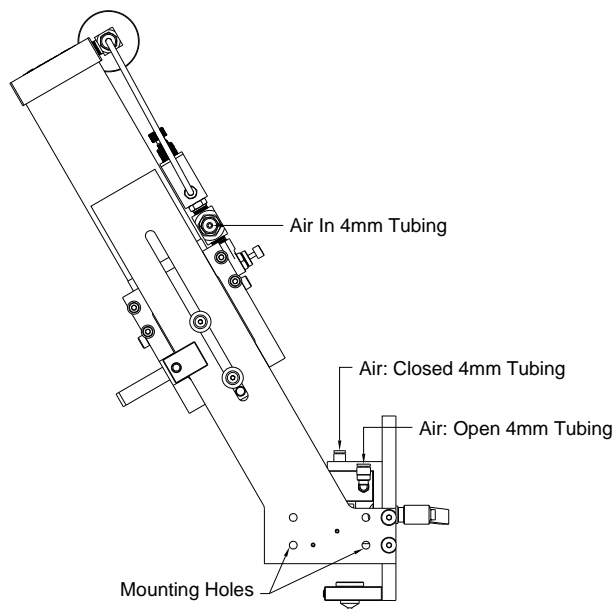
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 Before using the tool for the first time check it carefully for signs of external damage. If any shipping damage is found DO NOT USE THE TOOL - return it to your supplier immediately.

Front View



Back View

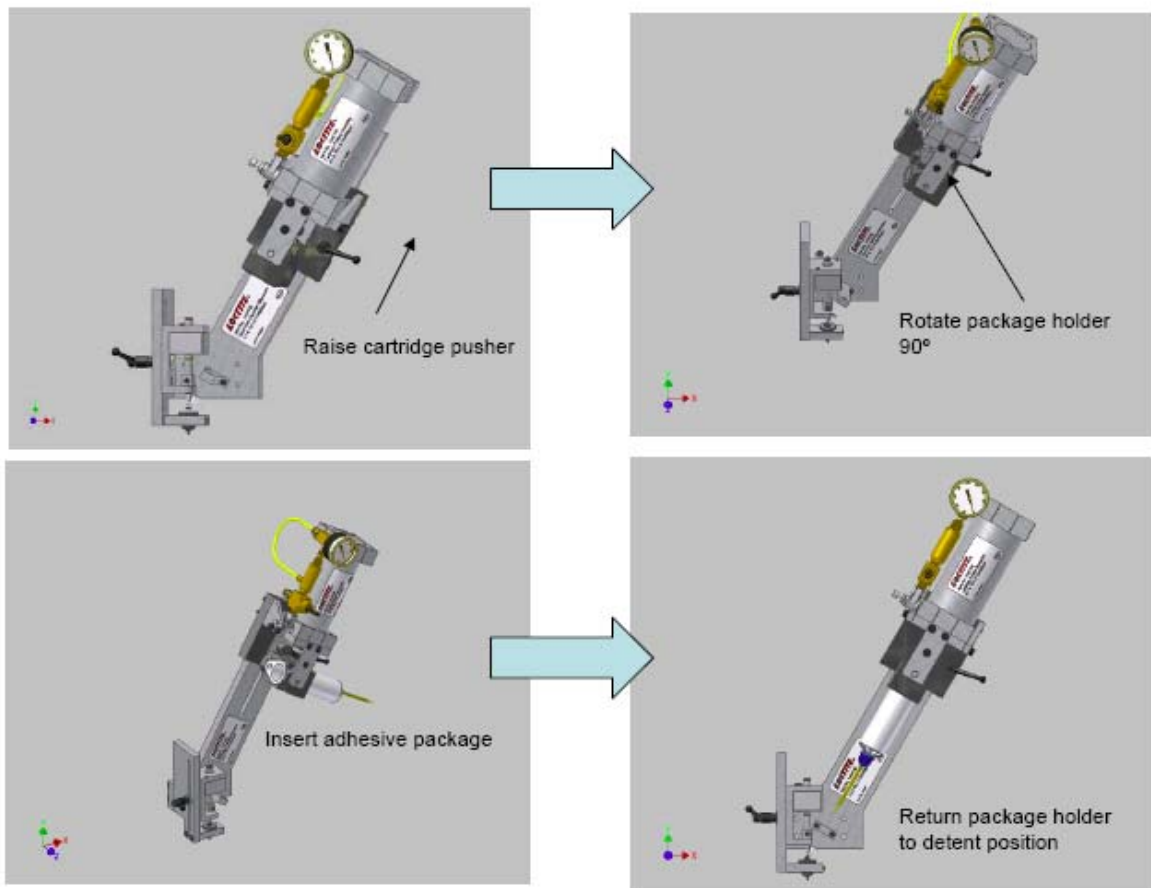


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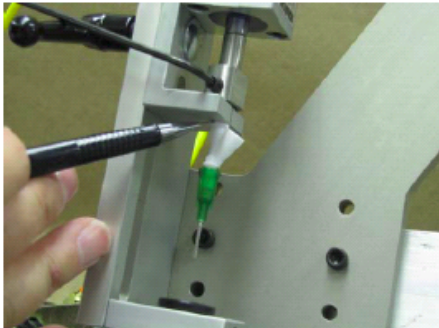
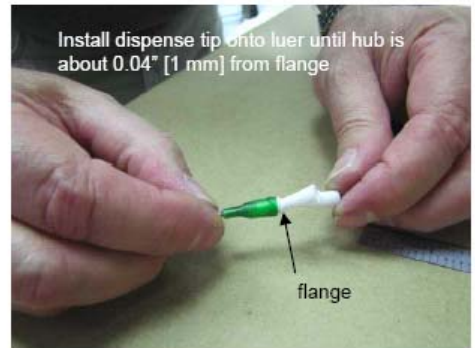
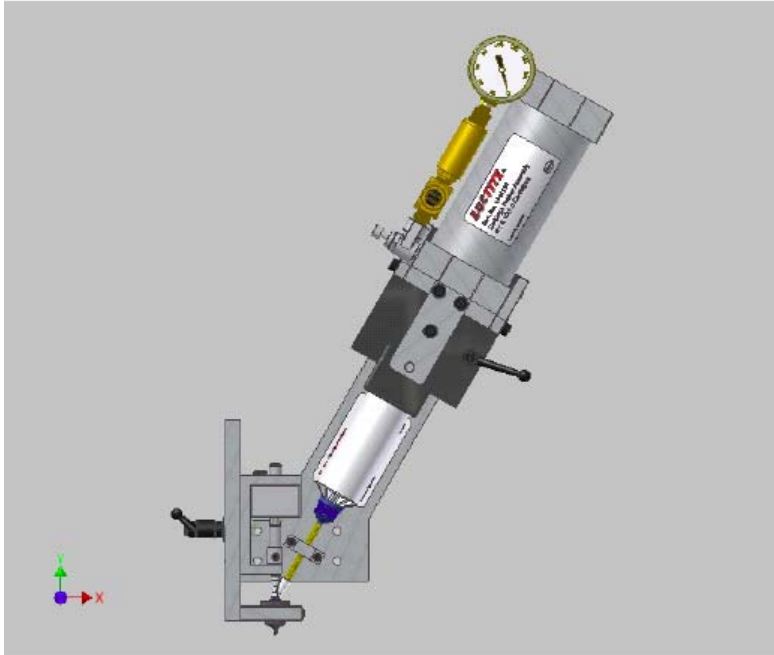
## 5 Operation

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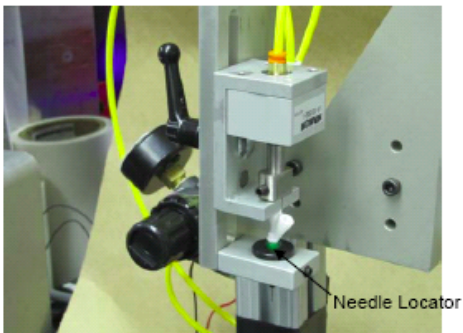
### 5.1 Loading the Adhesive Package



## 5.2 Anti Drip Valve Installation Procedure

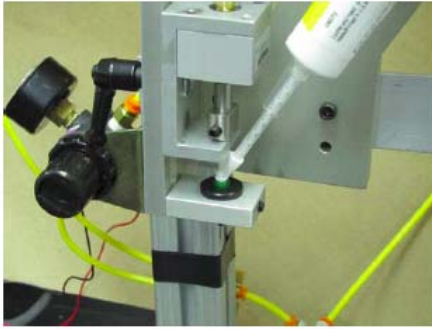


- Install valve into actuator bracket, insure that the flange is up against the bracket, **tighten set screw.**

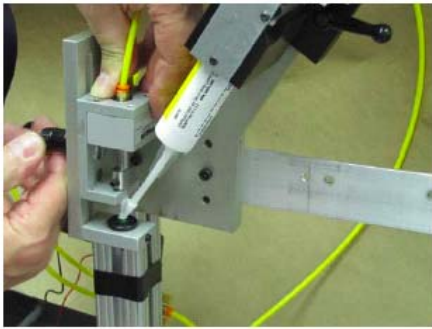


- Drop actuator bracket so that the dispense tip is positioned in the needle locator.  
**Do Not tighten actuator bracket**





- Insert mix nozzle into valve and **lock** ram cylinder.
- Energize product ram cylinder (40 PSI).
  - This action will force valve into needle hub.



- Push down on actuator bracket until bracket touches valve flange.
- Lock actuator bracket.
- The valve is ready to dispense

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## 6 Troubleshooting

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**⚠ Before proceeding with any repair or maintenance operation disconnect the tool from the main electricity and pneumatic supply.**

<b>Problem</b>	<b>Cause</b>	<b>Solution</b>
Anti Drip Valve Leaks	<ol style="list-style-type: none"> <li>1. Poppet is not attached to actuator</li> <li>2. Valve body is moving with poppet</li> <li>3. Poppet is not seated against the needle canular</li> </ol>	<ol style="list-style-type: none"> <li>1. Check set screw to insure poppet is attached to actuator</li> <li>2. Reposition actuator bracket to trap valve between both flanges</li> <li>3. Increase actuator air pressure to form seat in needle hub</li> </ol>
Mix Nozzle/ Valve Body Leaks	<ol style="list-style-type: none"> <li>1. Ram cylinder clamp is loose</li> <li>2. Cured product on nozzle tip</li> </ol>	<ol style="list-style-type: none"> <li>1. Tighten cylinder clamp</li> <li>2. Clean off nozzle tip</li> </ol>
Mix Nozzle/Cartridge Leaks	<ol style="list-style-type: none"> <li>1. Cartridge pressure is to high</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust pressure</li> </ol>
Flow rate, reduced over time	<ol style="list-style-type: none"> <li>1. Clogged needle</li> <li>2. Clogged mix nozzle</li> </ol>	<ol style="list-style-type: none"> <li>1. Change needle</li> <li>2. Change mix nozzle</li> </ol>

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## 7 Care and Maintenance

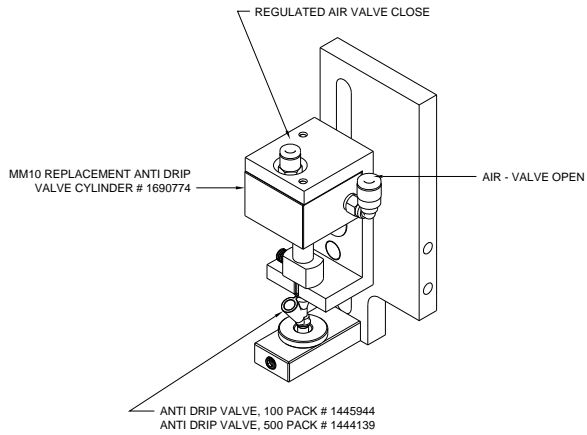
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Loctite® MM10 Dual Cartridge Dispensers are designed to be maintenance free.

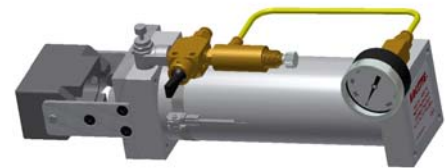
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## 8 Accessories and Spare Parts

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1690780 MM10 Replacement Dispenser 1:1 & 2:1 A  
1690777 MM10 Replacement Dispenser 1:1 & 2:1 B  
1690776 MM10 Replacement Dispenser 4:1 & 10:1 B



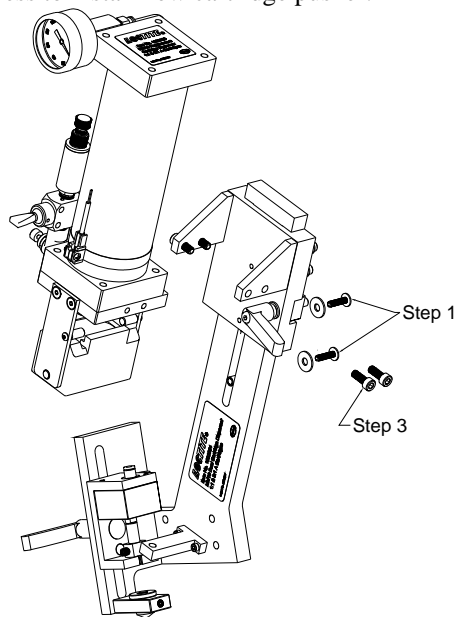
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## 9 Appendix

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### 9.1 Cartridge Pusher Assembly Replacement

1. Remove two (2) screws from back of Robot Mounting bracket.
2. Remove Cartridge Pusher Assembly and Cylinder Slider off Robot Mounting Bracket.
3. Remove four (4) screws on side gussets.
4. Reverse process to install new cartridge pusher.



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## **10 WARRANTY**

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Henkel expressly warrants that all products referred to in this Instruction Manual for (Loctite® MM10 Dual Cartridge Dispensers; Item Numbers 1633364, 1633365, 1633366 (hereafter called “Products”)) shall be free from defects in materials and workmanship. Liability for Henkel shall be limited, as its option, to replacing those Products which are shown to be defective in either materials or workmanship or to credit the purchaser the amount of the purchase price thereof (plus freight and insurance charges paid therefore by the user). The purchaser’s sole and exclusive remedy for breach of warranty shall be such replacement or credit.

A claim of defect in materials or workmanship in any Products shall be allowed only when it is submitted in writing within one month after discovery of the defect or after the time the defect should reasonably have been discovered and in any event, within (12) months after the delivery of the Products to the purchaser. This warranty does not apply to perishable item. No such claim shall be allowed in respect of products which have been neglected or improperly stored, transported, handled, installed, connected, operated, used or maintained. In the event of unauthorized modification of the Products including, where products, parts or attachments for use in connection with the Products are available from Henkel, the use of products, parts or attachments which are not manufactured by Henkel, no claim shall be allowed.

No Products shall be returned to Henkel for any reason without prior written approval from Henkel. Products shall be returned freight prepaid, in accordance with instructions from Henkel.

**NO WARRANTY IS EXTENDED TO ANY EQUIPMENT WHICH HAS BEEN ALTERED, MISUSED, NEGLECTED, OR DAMAGED BY ACCIDENT.**

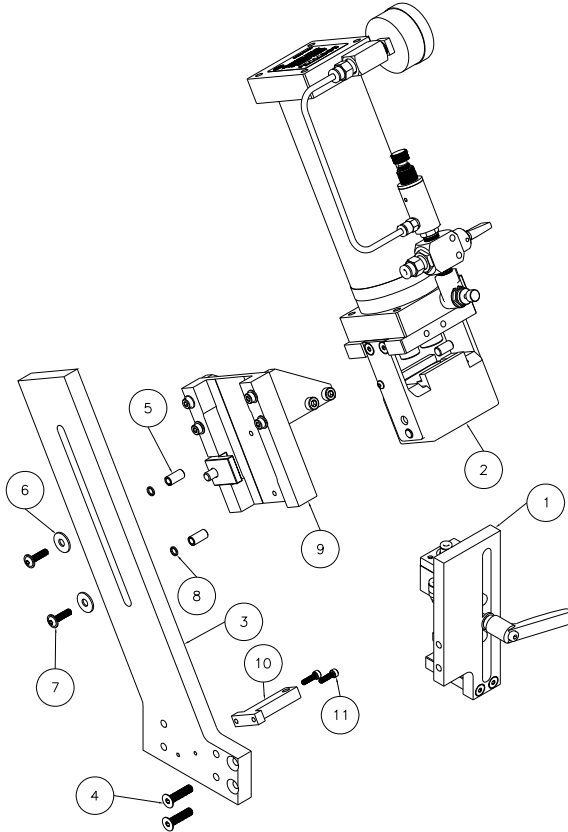
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## 11 Exploded Diagram



11	2	SOCKET HEAD CAP SCREW M3 X 12	8902317
10	1	STATIC MIXER SUPPORT	8902316
9	1	CYLINDER SLIDER ASSEMBLY	8903293
8	2	STANDOFF SHIM	8902290
7	2	FLANGED BUTTON HEAD SOCKET SCREW M4 X 16	8902249
6	2	THRUST WASHER, NYLON	8902248
5	2	ROUND STANDOFFS	8902247
4	2	FLAT HEAD SOCKET SCREW M5 X 22	8902246
3	1	ROBOT MOUNTING BRACKET	8902245
2	1	PACKAGE HOLDER ASSEMBLY 1:1 & 2:1D	8903287
1	1	SHUT OFF VALVE ASSEMBLY	8903288
ITEM	QTY.	DESCRIPTION	PART NUMBER
PARTS LIST			

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