



## Product Description Sheet

### Loctite® CL15 UV Wand System

Part # 1661548

North American Engineering Center

#### PRODUCT DESCRIPTION

The Loctite® CL15 UV Wand System is a high output, 100 Watt, mercury arc, spot curing system. The system accepts universal AC input power, (90-260 VAC, 50/60Hz). The system can be operated in either timed, manual, or cycle mode. The Loctite® CL15 is PLC compatible, allowing it to be easily integrated into automated production systems.

#### PRODUCT FEATURES

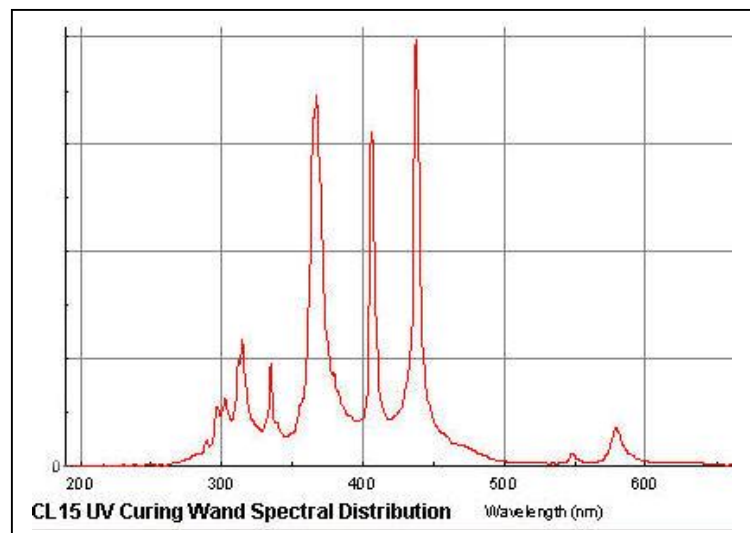
- Powerful mercury arc lamp provides up to 15W/cmsq.\*
- Manual, timed, or cycle shutter operation
- Complete cycle control - settable parameters include:
  - UV exposure time, (shutter open)
  - Dwell time, (shutter closed)
  - Number of cycles, (continuous cycling)
- "Lamp On" is indicated by relay contact output
- Can be operated from an external PLC
- Small footprint and light-weight, (7 ½ lb)
- Shutter is operated by a reliable rotary solenoid
- Lamp is disabled if the enclosure lid is removed
- Light guide interlock safety switch prevents accidental UV exposure if the light guide is not installed
- Internal dichroic mirror minimizes the transmission of heat caused by "waste energy", while allowing critical UV light to pass



\*Output with a new lamp installed and measured with a Loctite® 7020 Spot Radiometer, item #1406024

#### Technical Data

- Dimensions: 12.5" wide x 9.75" deep x 5.5" high
- Weight: 7 lbs
- Auto-ranging Power Supply:
  - 90 to 260 VAC; 50 to 60 Hz.
- Output: Up to 15W/cm<sup>2</sup> UV output.



 Excellence is our Passion

Henkel Americas  
1-800-LOCTITE  
www.equipment.loctite.com

Henkel Europe  
+49.89.320800.1800  
www.henkel.com/industrial

Henkel Asia Pacific  
+86.21.2891.8863  
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**THEORY of OPERATION**

When the unit is switched on the curing lamp will come on within several seconds. A period of approximately 90 seconds is required for the lamp to reach full power. At that point, an internal relay will change state, making a closure across pins 3 and 4 of the footswitch connector, (located on the rear panel of the unit). This signal is meant to provide confirmation to a PLC that the curing lamp is on and ready.

Curing takes place when the shutter is opened, allowing UV light to be directed from the end of the liquid filled light guide to the adhesive. The curing parameters, (UV irradiance and exposure time) must be determined before use. The UV irradiance, (the strength of the UV light), at the adhesive surface can be varied by adjusting the distance of the light guide from the bond. The UV exposure time required to complete the curing process depends primarily on the UV irradiance and the properties of the adhesive product.

**Loctite® CL15 UV Wand System Includes:**

- Curing unit
- Operation Manual
- AC Power Cord
- High Pressure mercury arc lamp
- Ultraviolet Protection Glasses
- Foot Switch



**Loctite® Accessories (not included):**

- Lightguides (see below)
- 7020 Spot Radiometer, P/N 1406024



**Recommended Spare Parts**

- UV Safety Glasses; P/N/ 97210
- Replacement lamp module; P/N 1664246
- Foot Switch, P/N 97201



**Loctite® UV Light Guide Options:**

Description	Dimensions	Item Numbers			
		Single Pole	2 Pole	3 Pole	4 Pole
Standard	3 mm diameter x 1000 mm long	N/A	983684	98596	98597
	5 mm diameter x 1000 mm long	983677	N/A	N/A	N/A
	5 mm diameter x 1500 mm long	951681	N/A	N/A	N/A

**Recommendations**

UV cure rate is dependent on lamp intensity, distance from the light source, depth of cure needed or bondline gap and the light transmittance of the substrate through which the radiation must pass. Henkel Corporation recommends that you test all adhesive applications under simulated or actual end use conditions to ensure the adhesive meets or exceeds all required product specifications. Refer to the Loctite® Light Cure Product Selector Guide and product Technical Data Sheets for curing specifications and performance.



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