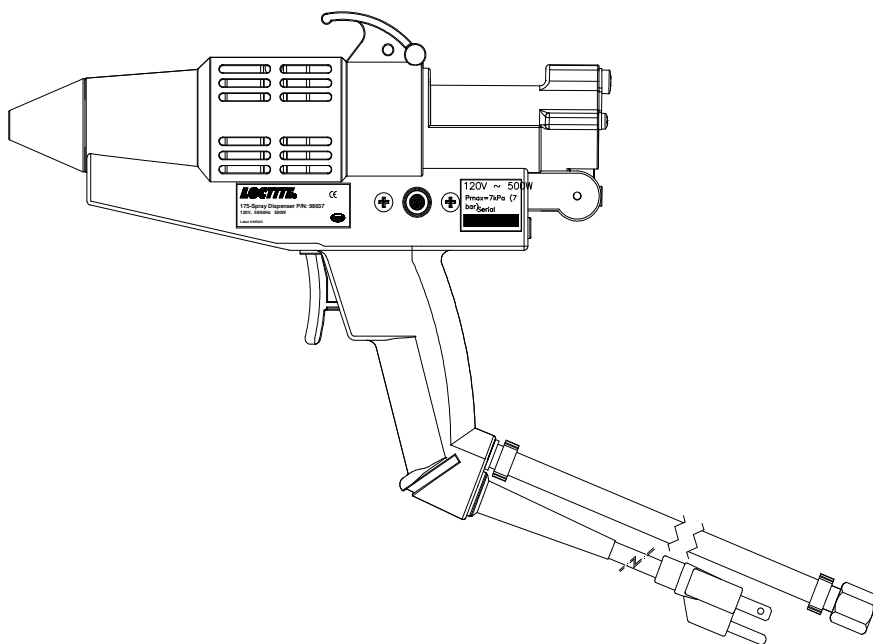




# EQUIPMENT

## Operation Manual

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### **Loctite® 175-Spray Dispenser**

**120 Volt Part No. 98037, 230 Volt Part No. 98057**

### **Loctite® 175-Spray-HT Dispenser**

**120 Volt Part No. 98041, 230 Volt Part No. 98059**

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# 1. Please Observe the Following

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## 1.1. Emphasized Sections



### Warning!

Refers to safety regulations and required 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:

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

## 1.2 Safety



**Do not touch the nozzle or molten adhesive with bare skin as they are hot - the operating temperature of the Loctite<sup>®</sup> 175-Spray and 175-Spray-HT dispensers is approximately 400°F (200°C). Protective gloves should always be worn. Careless handling can cause skin burns.** If molten adhesive comes into contact with the skin immerse the affected area immediately in plenty of cold water. Seek medical advice if necessary.

In addition to the safety instructions herein, any statutory regulations, local fire insurance regulations, or other generally valid “regulations for accident prevention” must be complied with when using this tool.

- Never use the tool if it is damaged in any way.
- Do not use this tool in damp rooms, outdoors while it is raining, or where there is high humidity.
- Do not use this tool in the vicinity of any heat-sensitive materials, or any flammable materials, liquids, or gases.
- Only use extension cables that meet the specification shown in “Technical data”.
- Never pull on the tool’s connecting cable.

## 1.3 Items supplied

### Loctite<sup>®</sup> 175-SPRAY

- Pneumatically-driven Hot Melt Cartridge Dispenser, fitted with 356°F (180°C) thermostat (suitable for standard spray hot melt adhesives)
- Plastic Stand
- Manual

### Loctite<sup>®</sup> 175-Spray-HT

- Pneumatically-driven Hot Melt Cartridge Dispenser, fitted with 383°F (195°C) thermostat (suitable for polyamide spray hot melt adhesives)
- Plastic Stand
- Manual

## 2 Description

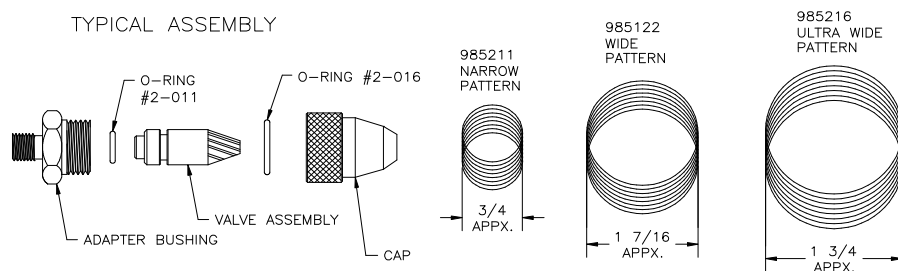
The Loctite® 175-Spray and 175-Spray-HT are the highest output, hand-held industrial spray hot melt dispensers available. With its two powerful 250W stainless steel cartridge heaters, they are capable of dispensing up to 9 lbs. of molten hot melt per hour, yet only take 5-7 minutes to warm up.

Supported by a range of spray adhesive formulations, the Loctite® 175-Spray and 175-Spray-HT are suitable for most applications - they can even be used with heat sensitive substrates such as expanded polystyrene and other plastic foams. Also, the Loctite® 175-Spray and 175-Spray-HT systems are solvent-free and non-toxic, so there are none of the environmental problems often associated with other spray adhesive applicators.

Designed to comply with world wide safety standards, the Loctite® 175-Spray and 175-Spray-HT also feature a totally enclosed heater housing, and are fitted with thermal fuse protection.

## 3 Technical Data

Dimensions (L x H x W):	approx. 11 13/16" x 9 15/32" x 2 17/32" (Approx. 300 x 240 x 65 mm)
Total weight:	approx. 3 lbs. (1.4 Kg)
Connection cable with mains plug:	10 ft (3 m) long
Operating voltage:	98037/98041: 110-120 VAC 50/60Hz 98057/98059: 230 VAC 50/60Hz
Power consumption:	500W
Heating up time:	5-7 minutes
Operating temperature:	175-Spray approx. 356°F (180°C) 175-Spray-HT approx. 383°F (195°C)
Diameter of adhesive inlet:	1 11/16" (43 mm)
Extension cable:	max. 65ft (20 m) long
Wire cross section:	at least 16 a.w.g. (1.5 mm <sup>2</sup> )
Air Supply / Pneumatic	Minimum - 45 p.s.i. (3 bar) Maximum - 100 p.s.i. (7 bar)



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## 4 Installation

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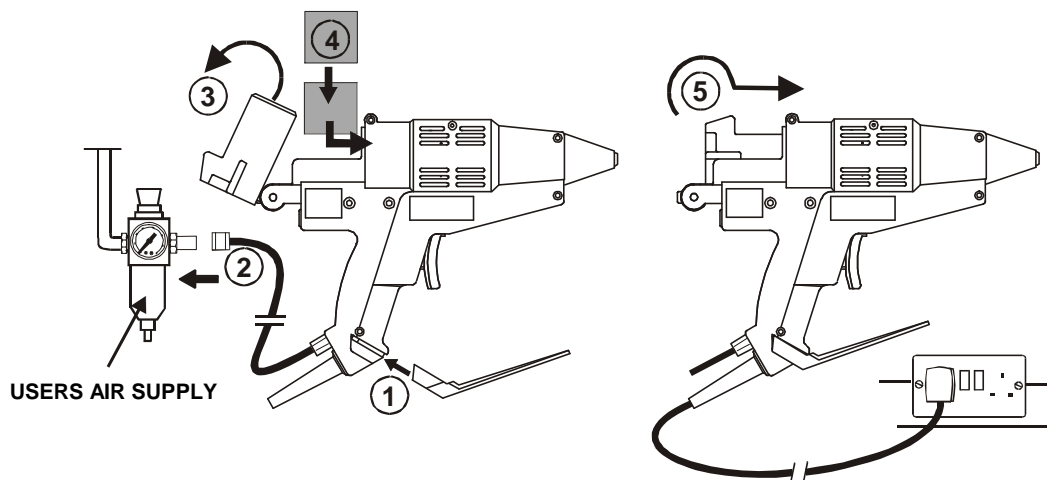


Before using the tool for the first time check it carefully for signs of external damage. If any transit damage is found DO NOT USE THE TOOL - return it to your supplier immediately.

**Steps 1 – 5 should be followed before connection to the main supply:**



1. Insert the dispenser stand into the grooves at the base of the handle. Stand dispenser on a flat surface.
2. Connect the air supply hose to a clean, dry and regulated air supply (use of a filter / regulator is recommended).
3. Pull piston back fully and rotate upwards.
4. Load two adhesive cartridges into the barrel of the tool and push fully forward.
5. Rotate the piston down and slide forward fully until it contacts the rear of the adhesive cartridge - it should engage about 5/16" (6-8mm) into the dispenser barrel.



6. Connect tool to main supply.
7. Red 'Power On' indicator light will illuminate.
8. Allow the dispenser to thoroughly warm up for 10 minutes. Do not attempt to operate the dispenser until this time has elapsed.

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## 5 Operation

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### Normal use:

- Assemble the stand and place the dispenser in an upright position on a flat surface.
- Plug the dispenser into the power supply socket, and switch on the power. Wait 10 minutes for the dispenser to reach its normal operating temperature.
- Squeeze the trigger to advance the piston and extrude molten adhesive through the nozzle.
- To stop extruding adhesive simply release the trigger.



During use, the piston will advance into the barrel as the trigger is pulled. A point will be reached where the piston no longer advances, and the sound of air escaping can be heard - this indicates that the dispenser needs reloading.

- Release the trigger.
- Pull the piston back.
- Insert a new adhesive cartridge.
- Operate the tool normally.

## 5.1 Applying Adhesive - Spray Adjustment

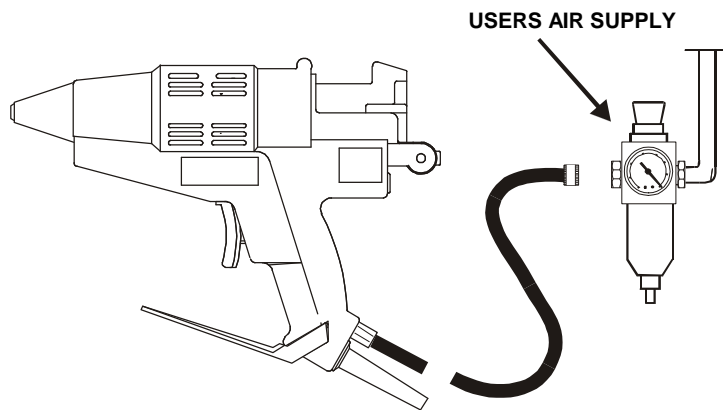
Turn the spray air adjustment control completely clockwise. Hold the dispenser facing away from you. Squeeze the trigger to extrude a bead of adhesive from the nozzle. While continuing to squeeze the trigger, rotate the spray air adjustment control slowly counter-clockwise; this changes the adhesive bead into an ever-finer spiral spray pattern. Continue to adjust the control until a suitable spray pattern is obtained to suit your application. To stop the adhesive flow, simply release the trigger.

## 5.2 Adhesive Flow Rate Adjustment

The flow rate of adhesive is dependent on the air pressure to the piston, and this is adjusted by varying the setting of the pressure regulator on the air supply to the dispenser.

The air pressure operating range for the dispenser is:

Minimum        45 p.s.i. (3 bar)  
Maximum        100 p.s.i. (7 bar)



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## 6 Application Hints

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As with all adhesives, performance depends on conditions of use. Suggestions or recommendations contained herein are for guidance only, since actual conditions of use are outside the supplier's control.

- Ensure that the surfaces to be bonded are dry, free from dust, grease, and loose particles.
- Apply adhesive to one surface only. Bring the two surfaces together as quickly as possible; the faster the bond is made, the greater the strength.
- A heavier spray pattern increases both working time and bond strength.
- When gluing dissimilar materials, apply the adhesive to the least heat conductive of the two.
- On materials that are cold to the touch, a better bond can be made by pre-warming them before applying adhesive.
- Surplus adhesive can be trimmed using a sharp knife once it has cooled. Should molten adhesive drip onto a smooth or polished surface, allow it to cool completely before removal.
- Spray adhesives can be applied directly to expanded polystyrene and other plastic foams.
- Use only genuine Loctite® Hysol® adhesives to ensure reliable performance. Loctite® Hysol® adhesives are non-toxic and non-flammable.

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## 7 Troubleshooting

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

### Glue “Backup” and “Meltdown”

“**Backup**” occurs when hot molten adhesive in the glue chamber is forced back between the barrel wall and the outside surface of the adhesive cartridge and piston. Once this adhesive cools, it may lock the adhesive cartridge in the barrel, preventing, or at least restricting, normal extrusion. By far the most likely cause of backup is allowing insufficient warm-up time before operating the tool (the molten glue in the glue chamber cannot escape forwards because the nozzle is blocked, due to being insufficiently warm). In the vast majority of cases the backup self-clears once the tool, having fully reached operating temperature, is operated again. For the rare occasions where the backup does not self-clear, turn the spray air adjuster fully clockwise; this will switch off the spray air, allowing the full pneumatic line pressure to be applied to the piston (the tool will operate as a bead tool).

“**Meltdown**” occurs when the rear of the adhesive cartridge softens to the extent that it is not rigid enough to drive the cartridge forward without collapsing. As with backup, the molten adhesive can solidify, potentially locking the cartridge and / or piston into the barrel. Meltdown is caused by leaving the tool switched on for extended periods of time without operating it. It is recommended that, if the tool is to be left standing for forty minutes or more, it should be switched off and only switched back on when preparing to use it again.



The Loctite® 175-Spray and 175-Spray-HT tools are fitted with specially coated pistons which have non-stick characteristics far superior to any PTFE coating; this minimises the effect of any backup or meltdown, should it occur.

FOR ANY REPAIRS OR ADJUSTMENTS – OTHER THAN THOSE DETAILED IN THIS MANUAL – PLEASE CONTACT 1-800-LOCTITE (562-8483).

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## 8 Care and Maintenance

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Every attempt has been made to make this exceptionally powerful tool both reliable and trouble-free. However the following precautions should be noted:

- Make sure that the dispenser is up to temperature before attempting to operate.
- Do not leave the dispenser switched on for long periods without use. If the dispenser is not to be used for forty minutes or more, switch it off and restart when required.
- Keep the dispenser upright when not in use, never lay it on its side. Always use the stand provided, or the optional bench stand or suspension unit (see Accessory and Spare Parts Lists at the end of this manual).
- Do not use excessive force on the trigger. Ensure that the tool has fully warmed up before use.
- Keep the nozzle clean to prevent adhesive build-up. This is easily done by wiping the nozzle with clean paper or cloth while the nozzle is still warm.

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## 9 Accessories and Spare Parts

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Spare Parts	Part Number
Complete Nozzle Assembly – Wide Angle 2mm (supplied as standard), item 9	985122
Dispenser Stand, item 12	985069
Piston Support Assembly, item 25	985093
Thermostat Assembly, 180°C, 367°F (for 175-SPRAY), item 10	985123
Thermostat Assembly, 195°C, 383°F (for 175-SPRAY-HT), item 48	985079
Thermostat Assembly, 130°C, 266°F (optional) item 52	985979
Heater Assembly 120 Volts, item 11	985080
Heater Assembly 230 Volts, item 11	985761
PCB Assembly 120 Volts, item 15	985083
PCB Assembly 230 Volts, item 15	985762
Thermal Fuse, Spacer Assembly, item 7	985076
O-Ring #2-006 Kit of 10, item 28	985831
O-Ring #2-011 Kit of 10, item 49	985832
O-Ring #2-016 Kit of 10, item 50	985833
O-Ring #2-017 Kit of 10, item 51	985834
Heater Housing Split Ring Seal, Kit of 10, item 5	985836
Label Kit for 98037 Dispenser	985783
Label Kit for 98041 Dispenser	985795
Label Kit for 98057 Dispenser	985846
Label Kit for 98059 Dispenser	985847
Airline Assembly	985773
Qty 1 – Airline Assembly, 3 Meters, item 18	
Barrel Support Kit	985778
Qty 1 – Barrel Support, item 23	
Qty 2 – Flat Washer, item 44	
Qty 1 – Lock Washer, item 45	
Qty 1 – Shoulder Screw, item 34	
Qty 1 – Ground Wire, item 32	
Qty 1 – Lock Washer, item 42	
Qty 1 – Round Head Screw, item 40	
Heater Housing & Barrel Kit For 98037, 98041, 98057 & 98059	989941
Qty 1 – PTFE Barrel, item 2	
Qty 2 – Barrel Support Ring, item 3	
Qty 1 – Lock Ring, item 4	
Qty 1 – Heater Housing Split Ring Seal, item 5	
Qty 1 – Heater Housing, item 6	
Qty 1 – Fitting, item 30	
Qty 1 – Ground Screw, item 38	
Qty 1 – Lock Washer, item 42	
Qty 1 – Ground Wire, item 31	



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## 9 Accessories and Spare Parts (continued)

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Handle Kit 985228  
Qty 2 – Moulded handles, item 1  
Qty 6 – Casing Screws, item 37  
Qty 1 – Red Lens, item 29  
Qty 2 – Round Head Screw, item 39

Piston Sleeve Kit 985775  
Qty 1 – Piston, item 27  
Qty 1 – Piston Plate, item 24  
Qty 1 – Plan Head Screw, item 35  
Qty 2 – Round Head Screw, item 40

Piston Support Hardware Kit 985229  
Qty 1 – Washer, special with 4 holes, item 33  
Qty 1 – Pivot o-ring, item 28  
Qty 1 – Washer, flat nylon, item 43

Piston Support O-ring Kit, Qty 10 985234

Nozzle Shroud Kit, Qty 5 985235

Spray Air System Assembly Kit 985236  
Qty 1 - Spray Air System Assembly, item 22  
Qty 1 – Urethane Hose, item 20  
Qty 1 – Urethane Hose, item 19  
Qty 1 – PTFE Hose, item 21  
Qty 1 – Trigger Valve Assembly, item 14  
Qty 1 – Phillips Pan Head Screw, item 36  
Qty 1 – Trigger, item 13

U.S. Cord Set Assembly, 120 Volt 985231  
Qty 1 – Cordset, item 17  
Qty 1 – Clamp, item 18  
Qty 2 – Screws, item 41

Australia Cord Set Assembly, 230 Volt 985759  
Qty 1 – Cordset, item 17  
Qty 1 – Clamp, item 18  
Qty 2 – Screws, item 41

### Accessories

### Part Number

Complete Nozzle Assembly  
Ultra Wide Spray Pattern, 2mm Orifice 985216  
Standard Wide Spray Nozzle Assembly, 2mm Orifice 985122  
Narrow Spray Pattern Assembly, 1.5mm Orifice 985211

(For spray pattern definition see Section 3 – Technical Data)

Heavy-Duty Free-Standing Metal Stand 985087  
Tool Hanger / Balancer 985243  
Air Line Filter / Regulator / Gauge 985397

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## 10 Appendix

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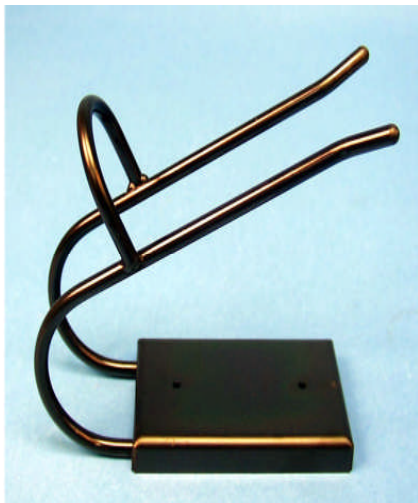
Available nozzles / accessories.



**985211**  
NARROW SPRAY  
NOZZLE ASSEMBLY  
COLOR RED

**985122**  
STANDARD WIDE SPRAY  
NOZZLE ASSEMBLY  
COLOR YELLOW

**985216**  
ULTRA WIDE SPRAY  
NOZZLE ASSEMBLY  
COLOR BLUE



**985087**  
HEAVY DUTY FREE-  
STANDING METAL  
STAND

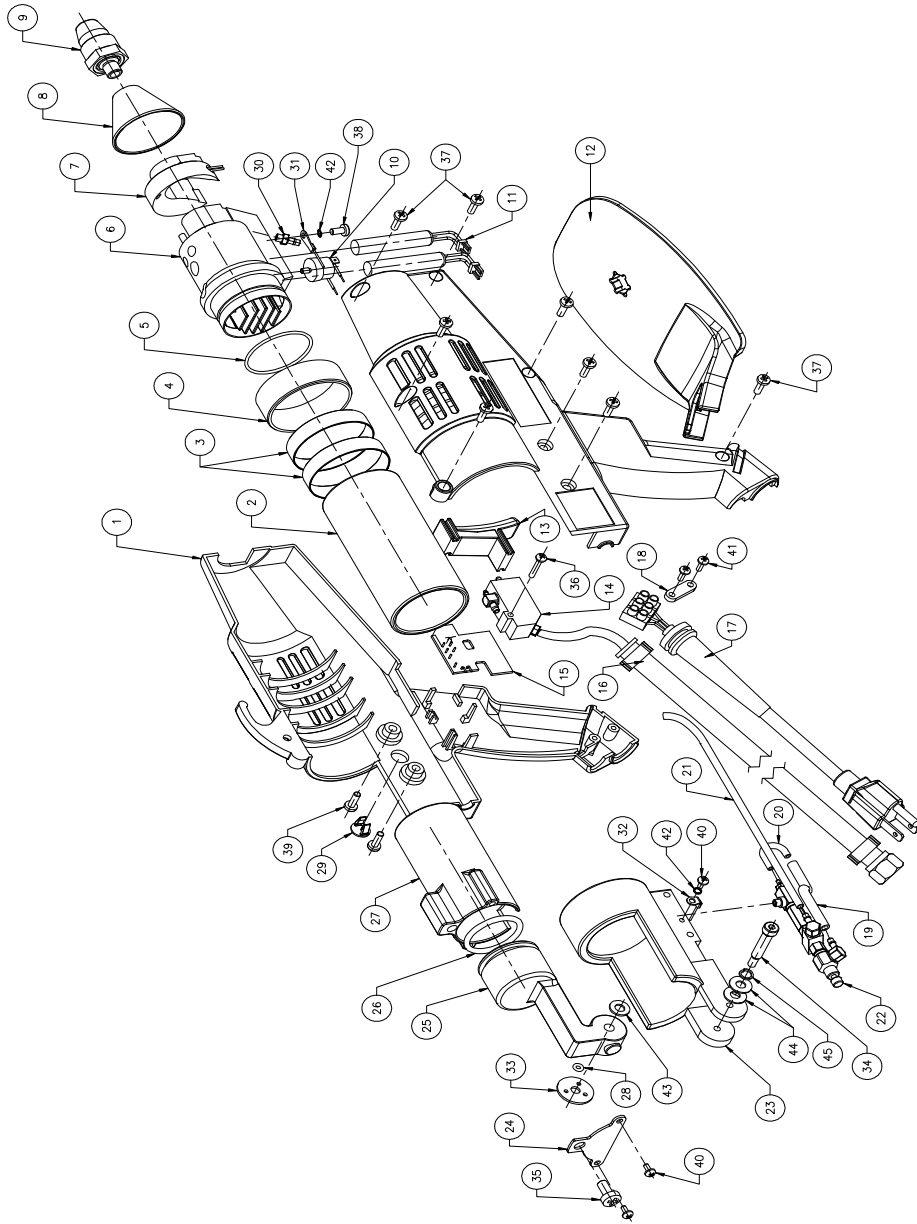


**985243**  
TOOL HANGER /  
BALANCER



**985397**  
AIRLINE FILTER  
REGULATOR  
GAUGE

# 11 Exploded Diagram



## 12 Parts List

ITEM	QTY.	DESCRIPTION	REBUILD KITS	AVAILABLE PART NO.
52	1	THERMOSTAT, 130°C, 266°F, (OPTION)		985979
51				
50				
49	1	O-RING #2-011, FOR NOZZLE ASSEMBLIES	O-RING #2-011 KIT OF 10	985832
48	1	THERMOSTAT, 195°C, 383°F, 175-SPRAY-HT		985079
45	1	HELICAL SPRING LOCK WASHER, 1/4", BLACK OXIDE	BARREL SUPPORT KIT	985778
44	2	WASHER, 1/4", FLAT, BRIGHT ZINC PLATE	BARREL SUPPORT KIT	985778
43	1	WASHER, FLAT, NYLON	PISTON SUPPORT HARDWARE KIT	985229
42	2	HELICAL SPRING LOCK WASHER	HEATER HOUSING & BARREL KIT BARREL SUPPORT KIT	989941 985778
41	2	PHILLIPS PAN HEAD SCREW, SELF TAPPING, #6-20 X 3/8, BRIGHT ZINC	US CORDSET KIT AUSTRALIA CORDSET KIT	985231 985769
40	3	PHILLIPS ROUND HEAD SCREW, #6-32 x 1/4 LONG	PISTON KIT BARREL SUPPORT KIT	985775 985778
39	4	PHILLIPS ROUND HEAD SCREW, #10-32 x 5/8 LONG, BLACK OXIDE	HANDLES & SCREWS KIT	985228
38	1	GROUND SCREW, 4BA x 1/2" LONG	HEATER HOUSING & BARREL KIT	989941
37	6	CASING SCREW, 12mm LONG SELF-TAPPING	HANDLES & SCREWS KIT PISTON SUPPORT HARDWARE KIT	985228 985229
36	1	PHILLIPS PAN HEAD SCREW, SELF TAPPING, #6-20 X 3/4, BRIGHT ZINC	TRIGGER VALVE KIT	985233
35	1	PHILLIPS PAN HEAD SCREW, 1/4-20 x 1/2 LONG, BLACK OXIDE	PISTON KIT	985775
34	1	SOCKET HEAD SHOULDER SCREW, 1/4" x 1"	BARREL SUPPORT KIT	985778
33	1	WASHER, SPECIAL WITH 4 HOLES	PISTON SUPPORT HARDWARE KIT	985229
32	1	BARREL SUPPORT GROUND WIRE ASSEMBLY	BARREL SUPPORT KIT	985778
31	1	HEATER HOUSING GROUND WIRE ASSEMBLY	HEATER HOUSING & BARREL KIT	989941
30	1	FITTING, BARBED	HEATER HOUSING & BARREL KIT	989941
29	1	RED LENS	HANDLES & SCREWS KIT	985228
28	1	O-RING #2-006	PISTON SUPPORT HARDWARE KIT O-RING #2-006 KIT OF 10	985229 985831
27	1	PISTON	PISTON KIT	985775
26	1	O-RING #2-219	O-RING #2-219 KIT OF 10	985234
25	1	PISTON SUPPORT ASSEMBLY		985093
24	1	PISTON PLATE	PISTON KIT	985775
23	1	BARREL SUPPORT	BARREL SUPPORT KIT	985778
22	1	SPRAY AIR SYSTEM ASSEMBLY	SPRAY AIR SYSTEM KIT	985236
21	1	PTFE TUBING, 195mm LONG	SPRAY AIR SYSTEM KIT	985236
20	1	URETHANE TUBING, 50mm LONG	TRIGGER VALVE KIT SPRAY AIR SYSTEM KIT	985233 985236
19	1	URETHANE TUBING, 75mm LONG	TRIGGER VALVE KIT SPRAY AIR SYSTEM KIT	985233 985236
18	1	CORDSET CLAMP	US CORDSET KIT AUSTRALIA CORDSET KIT	985231 985759
17	1	U.S. CORDSET ASSEMBLY, 3M	US CORDSET KIT AUSTRALIA CORDSET KIT	985231 985759
16	1	AIRLINE ASSEMBLY, 3M	AIRLINE ASSEMBLY, 3M	985773
15	1	CONNECTOR & LIGHT PCB ASSEMBLY, 120 VOLT CONNECTOR & LIGHT PCB ASSEMBLY, 230 VOLT		985083 985762
14	1	TRIGGER VALVE ASSEMBLY	TRIGGER VALVE KIT	985233
13	1	TRIGGER	TRIGGER VALVE KIT	985233
12	1	DISPENSER STAND		985069
11	2	HEATER ASSEMBLY, 120 VOLT, 250 WATT HEATER ASSEMBLY, 230 VOLT, 250 WATT		985080 985761
10	1	THERMOSTAT, 180°C, 356°F, 175-SPRAY		985123
9	1	WIDE SPRAY NOZZLE ASSEMBLY, 2mm		985122
8	1	NOZZLE SHROUD	NOZZLE SHROUD KIT OF 5	985235
7	1	THERMAL FUSE & SPACER ASSEMBLY		985076
6	1	HEATER HOUSING, 175 SPRAY	HEATER HOUSING & BARREL KIT	989941
5	1	HEATER HOUSING SPLIT RING SEAL	HEATER HOUSING & BARREL KIT SPLIT RING SEAL, KIT OF 10	989941 985836
4	1	LOCK RING, ALUMINIUM	HEATER HOUSING & BARREL KIT	989941
3	2	BARREL SUPPORT RING	HEATER HOUSING & BARREL KIT	989941
2	1	BARREL, PTFE	HEATER HOUSING & BARREL KIT	989941
1	1	HANDLES, PAIR	HANDLES & SCREWS KIT	985228

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## 13 Warranty

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Henkel expressly warrants that all products referred to in this Instruction Manual for the Loctite® 175-Spray and Loctite® 175-Spray-HT Hot Melt Dispensers (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 items, such as fuses, etc. 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, OR IF THE SYSTEM USED TO DISPENSE ANY MATERIAL OTHER THAN HENKEL PRODUCTS.

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