LOCTITE®

EQ RC42 Pneumatic Controller

IDH 3052849

Operating Manual



Henkel

Henkel Adhesive Technologies

The English language manual is the original master document. All other languages were translated from English.

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1 Please Observe the Following

The WEEE symbol on this equipment indicates that this product may not be treated as household waste. By ensuring that this product is disposed of correctly you will help prevent potentially negative consequences for the environment. For more information about where you can drop off your waste equipment for recycling, please contact your local city office, your waste disposal service or the Henkel customer service.

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.

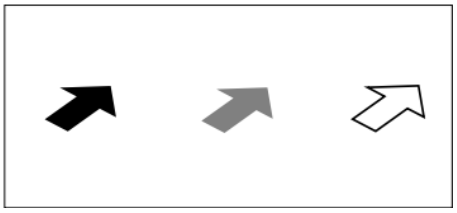
Caution!
Emphasizes what must be done or avoided so that the unit or other property is not damaged.

Notice:
A notice gives recommendations for better handling of the unit during operation or adjustment as well as for service activities.

The numbers printed in bold in the text refer to the corresponding position numbers in the illustration on page 3-4.

● The point emphasizes an instruction step.

Instruction steps in the illustrations are indicated with arrows.
When several instruction steps are indicated in an illustration, the shading of the arrow has the following meaning:



Black arrow = 1st step
Grey arrow = 2nd step
White arrow = 3rd step

1.2 For Your Safety

Follow all safety and warning instructions unconditionally during operation. The manufacturer cannot be held responsible if the instructions are not being followed. If you experience any malfunctions, problems or damage to the unit, contact your local Henkel equipment service immediately.

Please refer to the relevant Technical Data Sheet for the LOCTITE® product to be processed at https://www.henkel-adhesives.com or request the Technical Data Sheet and the Safety Data Sheet (in accordance with REACH Regulation (EC) No. 1907/2006) from your Henkel Technical Service.

INSTRUCTIONS given in these data sheets must be strictly followed!

Do not expose the connecting cable to heat, oil, or sharp edges.

Make sure the Unit stands stable and secure.

Use only original equipment replacement parts.

Damage to the power cord or the housing can result in contact with live electrical parts. Check the power cord and the unit before each use. If the power cord or the unit is damaged, do not operate!

Always disconnect the power supply before servicing the unit.

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

While under warranty, the unit must be repaired only by an authorized LOCTITE service representative.

1.3 Unpacking and Inspection

Carefully unpack the LOCTITE® EQ RC42 Pneumatic Controller and examine the items contained in the carton. Inspect the unit for any damage that might have occurred during transport. 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 Packing List

- EQ RC42 Pneumatic Controller (IDH 3052849) x 1
- Equipment Manual x 1
- Power Cord x 1
- Footswitch x 1

☞ As a result of technical development, the illustrations and descriptions in this operating manual can deviate from the actual unit delivered.

1.5 Features

- Precision air pressure regulator 0-6 bar (0-90psi).
- Keypad with LCD display.
- Capable of controlling up to two rotorspray systems or two valves.
- Pressure and dispense time display.
- Three optional working modes: Dispense, Rotor and Off.
- Dispensing modes: Continue and Timer.
- Stores up to 40 dispense programs.
- PLC Interface connections.

1.6 Field of Application (Intended use)

The LOCTITE® EQ RC42 Pneumatic Controller is a versatile, multi-function controller for actuating 1 or 2 dispensing valves as well as appropriate peripheral equipment such as rotorspray, reservoir, etc. Reservoir pressure is regulated by means of a precision regulator and measured by a digital transducer. All dispensing parameters and working mode can be programmed by the front panel keyboard. This controller can be integrated into fully automated assembly line operations by means of the PLC interface.

2 Description

2.1 Theory of Operation

The LOCTITE® EQ RC42 Pneumatic Controller is connected to an external pneumatic supply. A solenoid valve module and a precision pressure regulator are integrated into the unit, multipole interfaces allow easy connection to peripheral devices (valves, reservoirs, rotorspray or PLC). The control unit of the EQ RC42 Pneumatic Controller regulates the dispensing pressure and dispense time in order to dispense a repeatable volume of product. Up to 40 different dispense applications with different dispense parameters can be set and stored.

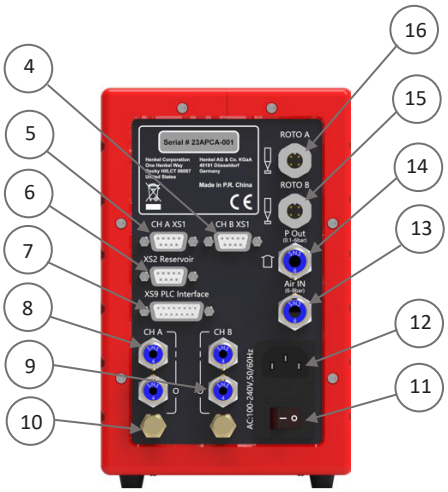
The controller provides various selection directories for controlling peripheral units to implement a multi-functional dispensing system. The system status overview is displayed on the screen. The keypad allows the user to easily change dispense time, pressure, and mode of operation settings, the working modes of the relevant channels (Dispense, Rotorspray or OFF) are switched on the LCD display.

For operation in line manufacturing or other automated workplace environments, the following messages can be analyzed by a higher ranking controller:

- the **Ready** signal,
- the **Refill** and **Empty** signals from the product reservoir,
- as well as all other **Fault** signals as a collective signal.

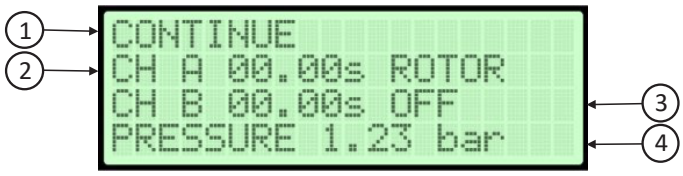
2.2 Overview (Front & Back of controller)





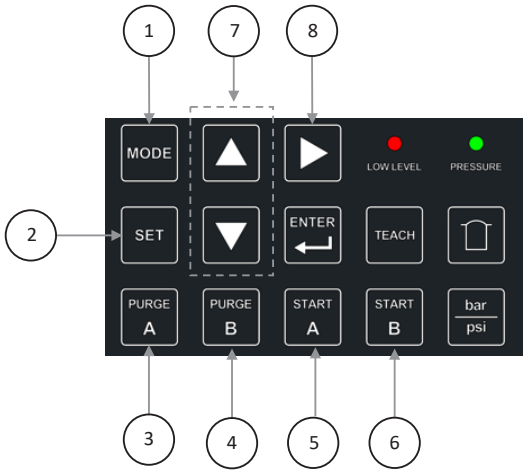
1. LCD Display
2. Operating Elements
3. Pressure Regulator
4. XS1 Start (Channel B)
5. XS1 Start (Channel A)
6. XS2 Reservoir
7. XS9 PLC Interface
8. Pneumatic Connection A
9. Pneumatic Connection B
10. Silencer
11. Power I/O Switch
12. Power Supply
13. Main Air Supply
14. Air Out to Reservoir
15. XS15 Connection: Rotor A
16. XS16 Connection: Rotor B

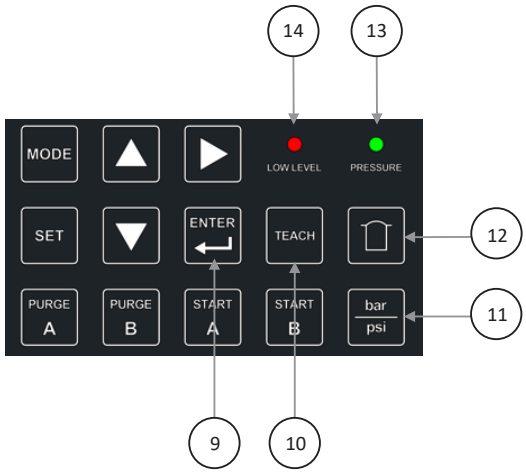
2.2.1 LCD Display



1 - Operation Mode
2 - Channel A working time and mode
3 - Channel B working time and mode
4 – Pressure output and Pressure Unit

2.2.2 Operating Elements

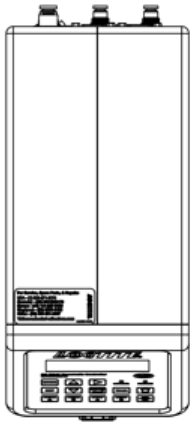


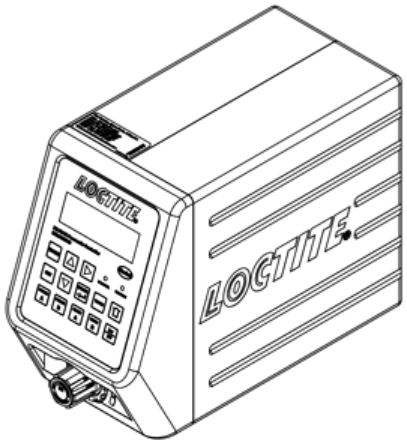


1. Changes dispensing modes.
2. Enables changing value/change cursor to next editable field.
3. Dispenses Channel A while depressed.
4. Dispenses Channel B while depressed.
5. Start a completed dispense cycle for Channel A.
6. Start a completed dispense cycle for Channel B.
7. Increase/decrease value.
8. Change cursor position (when set function enable).
9. Save the value.
10. Enables “Teach” mode.
11. Pressure Unit switch (Bar/PSI).
12. Reservoir pressurization/ depressurization.
13. Indicates low level status (LED “on” when the product bottle is empty).
14. Indicates reservoir status (LED “on” when the reservoir is pressurized).

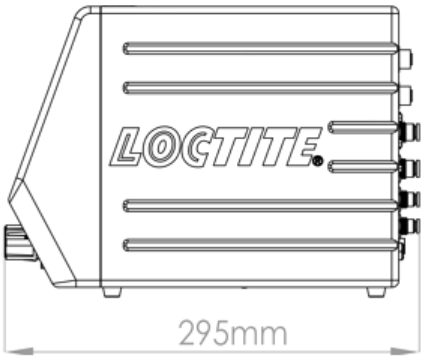
3 Technical Data

Dimensions (W x H x D):	130 x 207 x 295 mm
Total weight:	4.8 kg (10.6 lb)
Power Supply:	110-40 V AC 50/60 Hz
Internal control voltages:	24 V DC
Power consumption:	Approx. 100 Watts
Pneumatic Supply:	Min. 2 bar (29 PSI), max. 7 bar (125 PSI)
Air Quality:	Filtered 10 µm, oil-free, non-condensing. (If the required quality is not achieved, install a LOCTITE® filter regulator type 97120, order no. 478603 (US), 88649 (EU/Asia))
Operating Temperature:	+10 °C to +40 °C (+50 °F to +104 °F)
Storage Temperature:	- 10 °C to +60 °C (+14 °F to +140 °F)









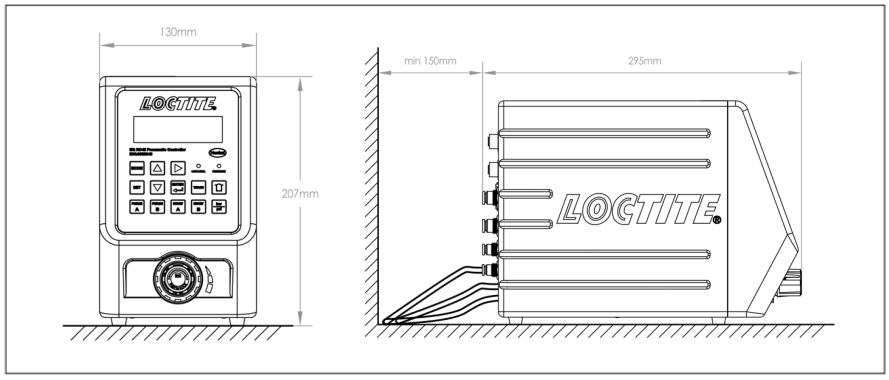
4 Installation

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

4.1 Environmental and Operating Conditions

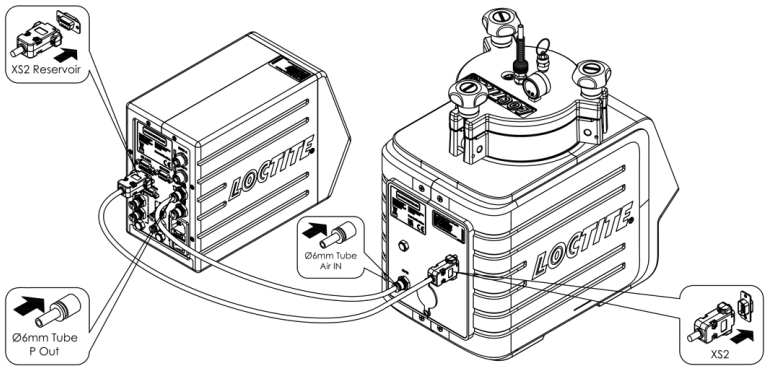
- No direct sunlight, no UV light.
- No condensing humidity.
- Avoid direct contact with water.
- Avoid kinking of air hoses.

4.2 Placement

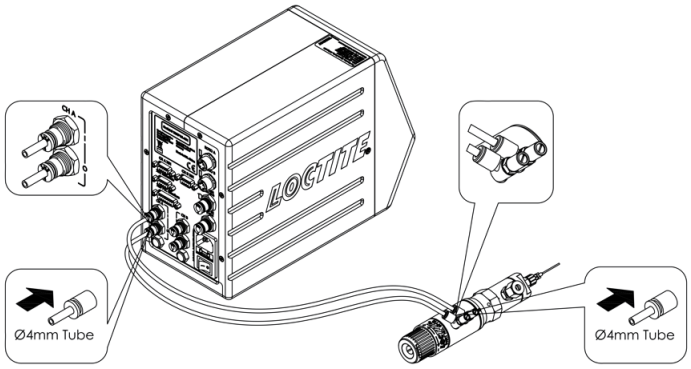


4.3 Connecting the Unit

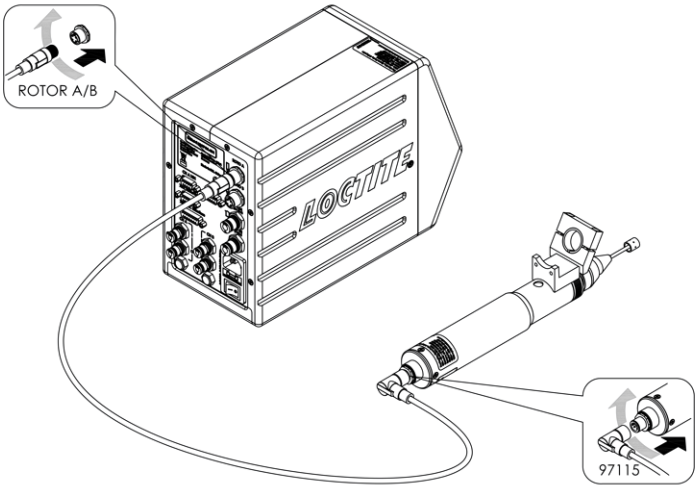
- Connect power cord to the power supply 12.
- Connect pneumatic hose to air supply 13.
- Connection of the Reservoir to the RC42 Pneumatic Controller.



- Connection of one or two valves to the RC42 Pneumatic Controller.



- Connection of one or two rotorsprays to the RC42 Pneumatic Controller.



4.4 XS1 Start Signal Connection

The system auto detects when the footswitch(s) is connected to the system. When both channels are set in timed mode, the system automatically recognizes Channel A as master channel.

Operate two channels from a single start signal (Timed mode only)
Only XS1 Channel A (Master) Footswitch connected:
The footswitch can control both output of Channel A and Channel B and start at the same time.

Operate one channel from a single start signal (Timed/Continuous mode)
Only XS1 Channel B Footswitch connected (Timed mode):
The footswitch can only control the output of Channel B.
XS1 Channel A or XS1 Channel B Footswitch connected (Continuous mode)
The footswitch controls the output of selected Channel.

Operate two channels from two independent start signals (Timed/Continuous mode)
Both XS1 Channel A (Master) and XS1 Channel B Footswitch connected:
The footswitch will control their own channel and can be started at different times.

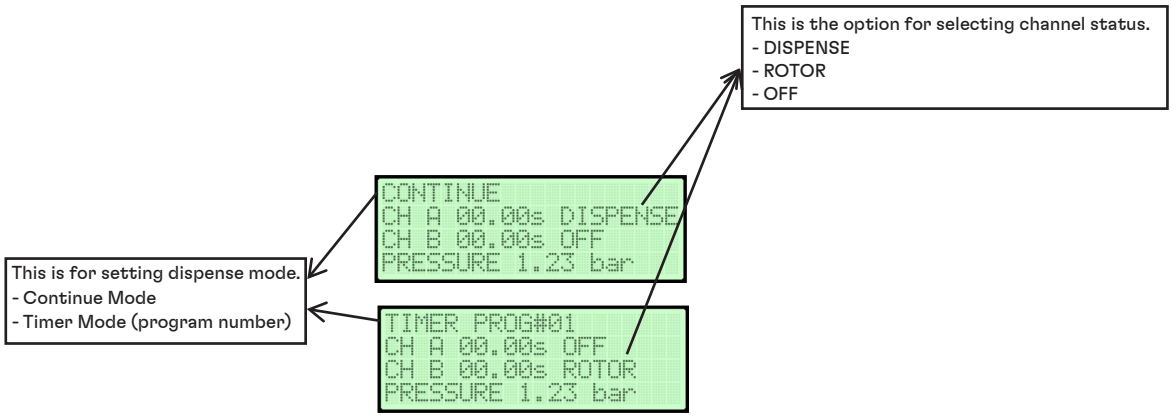
5 Operation

5.1 Start Up the System

! Observe the operating manual of the RC42 Pneumatic Controller used.

- Turn the “POWER” on (the position marked “I”) (11). The display (1) will turn on.
- If necessary, open the valve or regulator that controls the air inlet to supply pneumatic pressure to the system.

5.2 System Setup



This setting allows the operator pre-set different parameters and work modes for each channel under a specified program number.

1. Press MODE to select operation mode.

2. Press SET to set program number under timer mode, the number on the display will flash. Press ▲ or ▲ to change numbers, press ▶ to move the cursor.

3. Press SET again to switch from program number to Channel A setting.

4. Set dispense time and work mode (DISPENSE/ROTOR/OFF) for Channel A.

5. Press SET again to switch from Channel A to Channel B.

6. Set dispense time and work mode (DISPENSE/ROTOR/OFF) for Channel B.

7. After completed setting, press ENTER to save and exit.

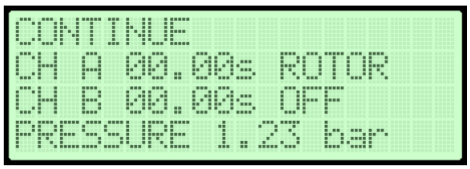
☞ **Notice:**

DISPENSE: Set the selected channel to work in dispensing mode.
ROTOR: Set the selected channel to work in rotorspray mode.
OFF: The selected channel is closed, and the corresponding solenoid valve and rotorspray cannot work.

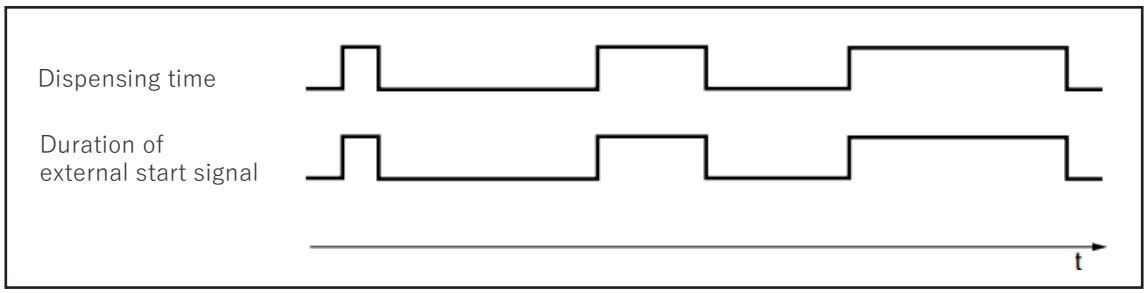
You can set a program number to record dispense time in Timer mode. The program number can be 00 – 39. For detailed operation for setting time please check chapters 5.3.2.

5.3 Setup Working Modes

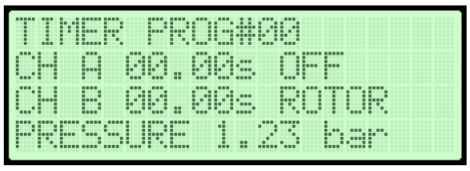
5.3.1 Continue Mode



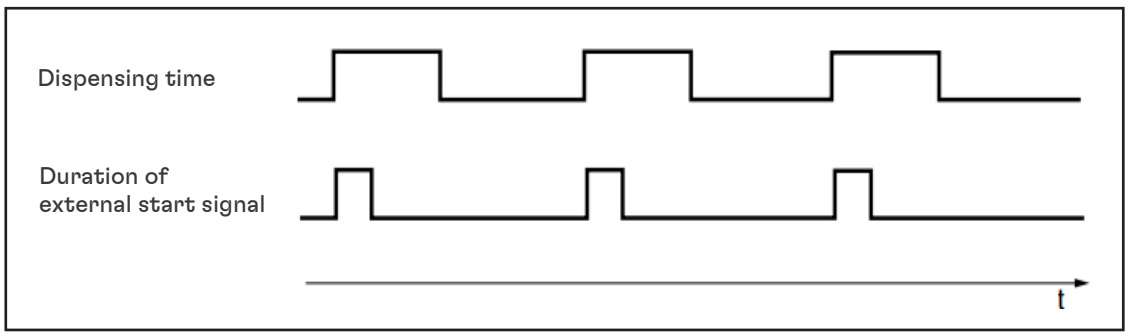
This mode of operation is used when different dispense times are necessary. The start signal must be present as long as dispensing is to continue. The dispensing time is controlled by the duration of the external start signal.



5.3.2 Timer Mode



This mode of operation is used for timed dispensing. Operator can setup the dispensing timer from 0 to 99.99s. The recommended minimum time increment is 0.1s.



How to set the dispensing time in Timer mode.

1. Press MODE to select Timer mode.
2. Press SET to set the dispense time for Channel A, the left most digit will start to flash.
3. Press ▲ or ▲ for numbering change on the flashing digit (0.01 – 99.99).
4. Press ▶ to move the flashing digit 1 digit to right.
5. Press SET again to switch from Channel A to Channel B.
6. Set dispense time for Channel B.
7. After completed setting, press ENTER to save and exit.

Using the Teach Mode to set the dispensing time in Timer mode.
1. Select Channel to set dispensing time.

2. Press [TEACH] to activate Teaching mode.

3. LED “Teach” will lights up indicating Teaching mode is activated.

4. Press foot switch to set the desired amount of dispense time.

5. Press [ENTER] to save the value and exit “Teach mode”.

5.4 Post-delay time setting



This setting allows the operator to set a delay time for after the dispense step of a rotorspray application. This will allow the rotor to continue to spin for the set delay time in order to spin off any residual product from the slinger disc. The delay time can be set from 0.1 to 9.9s.

1. Press [MODE] to select ROTORSPRAY DELAY.

2. Press [SET] to set post delay time for Channel A, the number on the display will flash. Press [▲] or [▲] to change numbers, press [▶] to move the cursor.

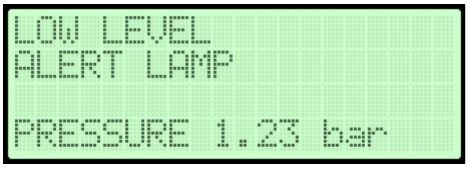
3. Press [SET] again to switch from Channel A to Channel B.

4. Set post delay time for Channel B.

5. After completed setting, press [ENTER] to save and exit.

☞ Different dispense times will result in different dispense cycle durations. Adding a post-delay time will add to the overall cycle time of the application.

5.5 Setting Low Level



1. Press [SET], the setting for Low Level mode start to flash.

2. Press [▲] for switching between “OFF”, “LAMP” and “LAMP + STOP”.

3. After completed setting, press [ENTER] to save and exit.

☞ **Notice:**

If the low level is not being used or not being used with a LOCTITE reservoir, the setting must be in the “OFF” mode or the controller will not operate.

OFF: Only signal output from XS9
LAMP: Signal output from XS9 + LED Light on control panel
LAMP + STOP: Signal output from XS9 + LED Light on control panel + System Stop

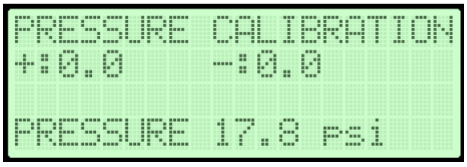
5.6 Pressure Calibration

LOCTITE® EQ RC42 Pneumatic Controller is already calibrated for pressure during the manufacturing process. LOCTITE® EQ RC42 Pneumatic Controller is only required to be calibrated if the set pressure differs from the measured pressure. To be sure the displayed value of the unit is exact, calibration must be accomplished accurately.
Pressure calibration must be done in **PSI**.

Notice:

To calibrate, an external and calibrated digital Pressure gauge is needed (not supplied with the LOCTITE® EQ RC42 Pneumatic Controller).

5.6.1 PRESSURE CALIBRATION PROCESS



Before Calibration,

- Disconnect external air pressure supply of the controller and switch OFF.
- Turn the pressure regulator (3) of the controller clockwise until it stops.
- Connect an external calibrated pressure gauge to Air Output (14) of controller.
- Turn on air source and power on the controller.

For the pressure calibration, follow the steps as below.

- Press button ▲ and ▶ together to open the pressure calibration setting page.
- Turn the pressure regulator (3) exactly to 58 psi (4 bar).
- Verify the pressure value on the external pressure digital gauge.
- If value differ, press SET to set offset value, press ▲ or ▲ to change numbers, press ▶ to move the cursor.
- Press SET to switch between “+” and “-“ offset fields.
- Press ENTER ↵ to store the value and exit the offset value setting.
- Press button ▲ and ▲ together to exit Pressure Calibration screen.

6 Application Hints

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.

6.1 Shutdown for Longer Periods of Non-use

- Switch the power switch (11) to the position O (OFF).
- Disconnect power cord from line voltage.
- Switch off external pneumatic supply.

6.2 Returning to Operation after Longer Periods of Non-use

- Reconnect the external pneumatic supply to the controller.
- Check the installation according to Chapter 4.
- Return to operation according to Section 5.1. ~5.4.

6.3 Selecting Dispensing Needle

- Straight Stainless-steel needles are recommended for products with low to medium viscosity or when precise dispense placement is critical to the application. Not recommended for anaerobic adhesives.
- Conical needles are recommended for general purpose dispensing and ideal for medium to high viscosity products.
- Flexible dispense needles are recommended for rotorspray application.
- PTFE-lined stainless steel needles especially for fast curing products.

6.4 Micro dot Application

- For very small quantities, it is recommended to use “Time” mode and to touch transfer adhesive by touching the dispense needle to the surface of the part.

6.5 Best practices for dispensing

- The best accuracy is achieved with a low pressure and a longer dispense time. Due to application constraints, a longer dispense time may not be possible. Therefore, a compromise between pressure and time may need to be reached in order to suit the application.
- Start with a low pressure (0.1 bar for low viscosity, no more than 0.5 bar for high viscosity products) and medium time. Increase pressure or time to achieve desired quantity.

7 Troubleshooting

⚠ Before proceeding with any repair or maintenance operation, disconnect the EQ RC42 Pneumatic Controller from the main electricity supply.

Malfunction	Possible Cause	Corrective
The LCD display does not power on.	Power switch (11) is in position O (OFF).	Switch power switch to position I (ON).
	Power cord is defective.	Replace power cord.
	Power fuse is defective.	Check/replace mains fuse.
	Control unit is defective.	Contact Henkel Equipment Service.
No change in the pressure value on the LCD display.	No air pressure present.	Check pneumatic supply.
	Pressure regulator (3) defective.	Replace regulator.
	Product reservoir not actuated or defective.	Check reservoir pressurization button (12).
	Control unit is defective.	Contact Henkel Equipment Service.
No start signal.	Automatic reservoir empty. (The empty level signal indicator is on.)	Refill automatic reservoir.
	XS2 cable connection is loose or not connected.	Check the cable connection. (If the low level is not being used or not being used with a LOCTITE reservoir, the setting must be in the “OFF” mode.)
	XS1/XS9 cable connection is not secure.	Switch OFF. Tighten the screws of the plug. Switch ON.
	Footswitch defective.	Replace the Footswitch.
No product, too little or too much product.	Dispensing pressure not set correctly.	Adjust dispensing pressure setting.
	Air hose not properly connected.	Connect air pressure hose correctly.
	Dispensing needle clogged, too small or too large.	Replace dispensing needle.
	Dispensing valve not correctly connected.	Check dispense valve.
	Product reservoir manually depressurized or defective.	Check product reservoir.
	Control unit is defective.	Contact Henkel Equipment Service.
No reaction from the buttons.	Button is defective.	Contact Henkel Equipment Service.

8 Care and Maintenance

8.1 Care and Maintenance

- The unit requires no special care and maintenance.

Notice: Clean hands after application of grease to ensure surfaces to be bonded are clean.

8.2 Cleaning

If cleaning agents are not properly handled, damage to health can result!
- Observe general safety regulations for the handling of chemicals!
- Observe manufacturer's instructions! Request a safety data sheet for the product used!

Recommended cleaning agent: Isopropanol (IPA).

Notice: Acetone will damage the plastic housing and paint of the equipment.

9 Accessories and Spare Parts

Item	Description	IDH#
Spare Parts		
1	Foot Switch	88653
2	Silicone Grease, 6 Gram Tube	88722
Accessories		
1	LOCTITE Air Filter, Regulator, Gauge (Mechanical version) - US	478603
	LOCTITE Air Filter, Regulator, Gauge (Mechanical version) – EU/Asia	88649

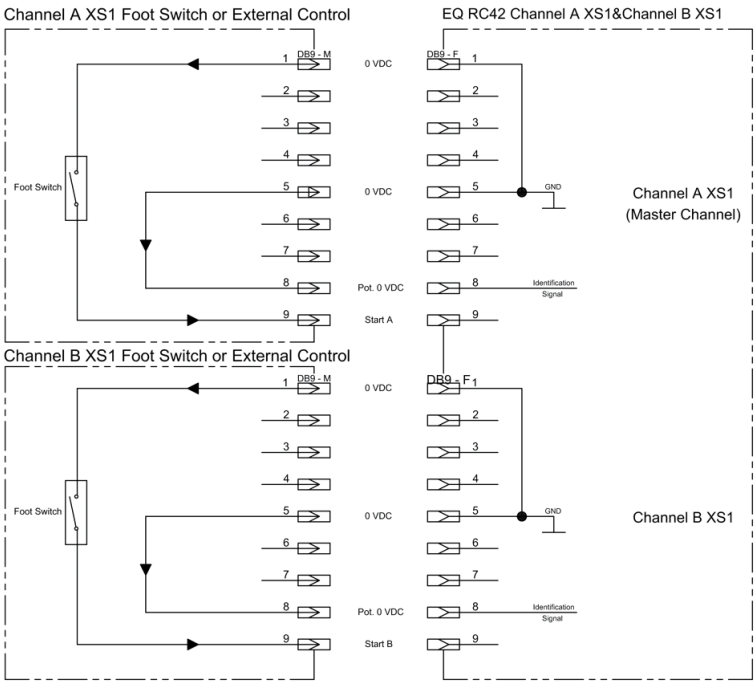
10 Diagrams

10.1 XS1 Start

XS1 Start via Footswitch, or external control.

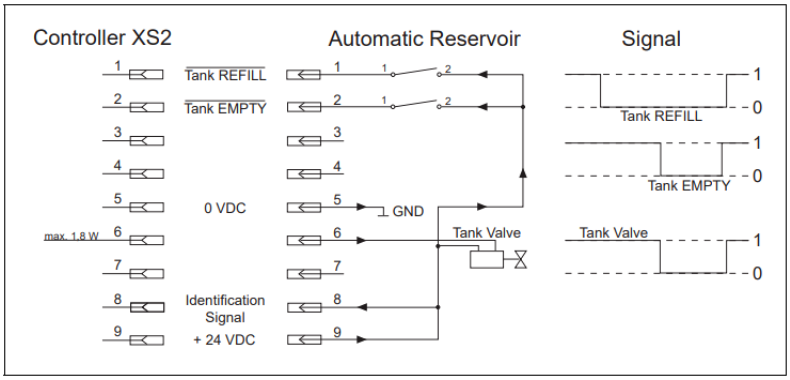
Warning!

Never connect external voltage on pin1 or pin9!



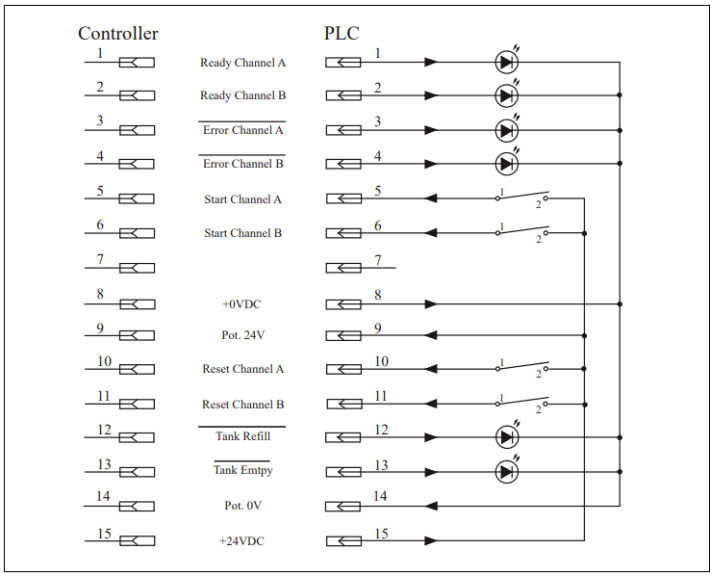
10.2 XS2 Product Reservoir

XS2 LOCTITE Reservoir with low level sensor

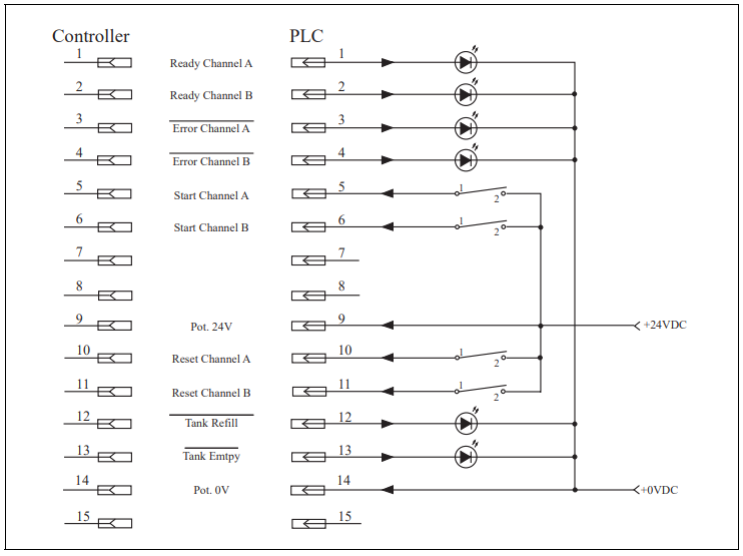


10.3 XS9 PLC Connection

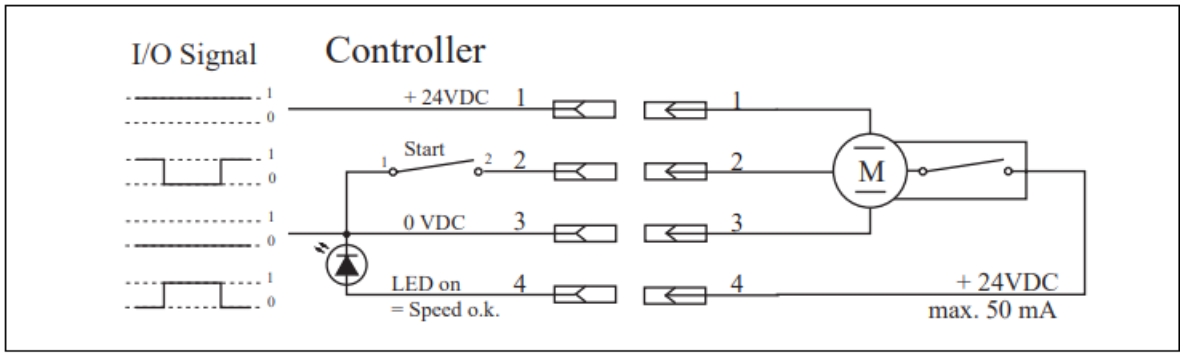
XS9 PLC internal 24VDC power supply



XS9 PLC external 24VDC power supply



10.4 XS15/XS16 Rotor Unit



11 Warranty

Henkel expressly warrants that all products referred to in this Instruction Manual for LOCTITE® EQ RC42 Pneumatic Controller (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 therefor 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, filters, lights, 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.

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12 Declaration of Conformity

CE	EU Declaration of Conformity	
The English language Declaration of Conformity is the original master document. All other languages have been translated from English.		
Designation of the unit:		EQ RC42 Pneumatic Controller
Unit number:		Order no. (IDH): 3052849
Manufacturer:		Henkel AG & Co. KGaA Henkelstraße 67 40589 Düsseldorf Germany
Importer for the United Kingdom:		Henkel Ltd. Wood Lane End Hemel Hempstead Herts HP2 4RQ United Kingdom
This declaration of conformity is issued under the sole responsibility of the manufacturer. The object of the declaration described above is in conformity with the relevant Union harmonisation legislation:		
Applicable EC regulations		Applicable harmonised standards
Directive 2014/35/EU (OJ L 96, 29.3.2014)	Low Voltage	EN IEC 62368-1:2024+A11:2024
Directive 2014/30/EU (OJ L 96, 29.3.2014)	EMC	EN 55032:2015+A11:2020, EN 55035:2017+A11:2020, EN IEC 61000-3-2:2019+A2:2024, EN 61000-3-3:2013+A2:2021
Directive 2011/65/EU (OJ L 174, 1.7.2011)	RoHS 2	EN IEC 63000:2018
Place and date of issue: Düsseldorf, 2025-04-09		Signed for and on behalf of Henkel AG & Co. KGaA: Michael Brunner Business Development Manager Equipment

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Manual P/N: 9060244, Rev A, Date: 2024-08-18

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