



LOCTITE® **EQUIPMENT**

OPERATION MANUAL

Hysol® 175 **P/N 98035**



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1. Please Observe the Following

1.1. Safety



Do not touch the nozzle or molten adhesive with bare skin as they are hot - the operating temperature of the Loctite® Hysol® 175 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.

1.2. Items supplied

Hot Melt Stick Dispenser
Plastic Stand
Manual
Plug-in Module 215°C

2. Description

The Loctite® Hysol® 175 Hotmelt Applicator contains a powerful 400W stainless steel cartridge heater which, in conjunction with its adjustable solid-state electronic controller, provides both a fast 5-minute warm-up, and accuracy in temperature control to within +/- 10°F (5°C) of the set temperature. Temperature adjustment is achieved by changing the plug-in module – the operator simply chooses the most appropriate module for the adhesive formulation to be used.

The advanced electronic controller provides an Auto Standby feature, allowing the tool to be left on for long periods of time without the adhesive overheating (however care should still be taken with soft formulations). If left unused for a while the tool will, after a variable time (depending on the ambient temperature), switch to its power-saving standby-mode, reducing the temperature of the tool to approximately 160°F (72°C); it will return to its full operating temperature when operated.

Designed to comply with worldwide safety standards, the Loctite® Hysol® 175 also features a totally enclosed heater housing, and is fitted with thermal fuse protection.

3. Technical Data

Dimensions (L x H x W):	approx. 12 1/4" x 9 5/8" x 2 11/16" (approx. 312 x 245 x 70 mm)
Total weight:	approx. 2.5 lbs. (1.15Kg)
Connection cable with main plug:	10 ft (3 m) long
Operating voltage:	110-120 VAC 50/60Hz
Power consumption	400W
Heating up time:	5 - 7 minutes
Operating temperature:	approx. 392°F (200°C) (dependent on Plug-in Module used)
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 ²)

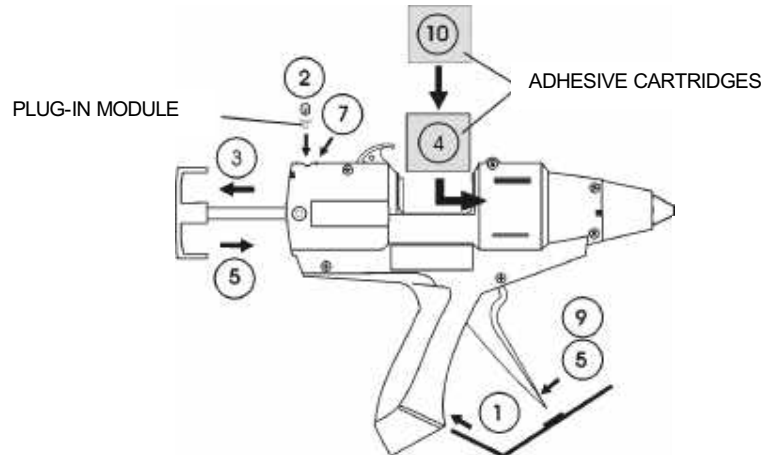
4. Installation



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.

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

1. Locate the enclosed stand into the grooves at the base of the handle.
2. Check that the Plug-In Module is the appropriate one for the adhesive to be used (refer to the Spares and Accessory lists at the end of this manual).
3. Pull handle back fully.
4. Drop adhesive cartridge into the breach of the tool and push fully forward.
5. Advance handle/plunger to rear of the adhesive cartridge by operating trigger.



6. Connect tool to main supply.
7. Red 'Power On' indicator light illuminates.
8. Allow tool to warm up for 5 minutes. Do not attempt to operate the tool until this time has elapsed.
9. Operate trigger to push the adhesive cartridge forward to the reloading point.
10. Pull handle back fully and load a second adhesive cartridge. Operate trigger to advance handle/plunger.



With a new tool it will be necessary to operate the trigger several times before adhesive can be extruded; this is because air trapped in the heater housing first needs to be evacuated.

5. Operation

Normal use:

- Fit the stand and place the tool in an upright position on a flat surface.
- Plug the tool into the power supply socket, and switch on the power.
- Wait 5 minutes for the tool to reach its normal operating temperature.
- Squeeze the trigger to advance the handle/plunger and extrude molten adhesive through the nozzle.
- To stop extruding adhesive simply release the trigger.



During use, the plunger will advance through the breach area of the barrel as the trigger is pulled. A point will be reached where the plunger no longer advances, but just moves back and forth. When this occurs the tool needs reloading with another adhesive cartridge.

- Pull the handle back fully.
- Insert a new adhesive cartridge.
- Operate the tool normally.

5.1. The Auto Standby Feature

With a tool as powerful as the Loctite® Hysol® 175 there would be a risk of adhesive 'meltdown' if it were left unused for too long at its normal operating temperature. To avoid this a special standby function is built into the temperature controller, lowering the temperature of the tool automatically after a period of inactivity. It should be noted, however, that this function is not time-dependent, but temperature-dependent i.e. the standby will activate at a point dependent on the ambient temperature and on the temperature of the tool itself. A yellow light will illuminate when the standby feature is active and the tool begins to cool down. If left long enough the tool's temperature will drop to approximately 270°F (130°C) and stabilize.



When the trigger is pulled to use the tool again the yellow light will extinguish, and the tool will begin to heat up to its normal operating temperature (IT MAY TAKE SEVERAL TRIGGER PULLS BEFORE THE LIGHT REMAINS EXTINGUISHED AFTER THE TRIGGER IS RELEASED). The adhesive may appear very viscous at this point, but will quickly thin as the temperature returns to normal.

When the tool is used for normal high output applications it is unlikely that the standby feature will operate.

5.2. Temperature adjustment

Temperature adjustment of the tool is achieved using a range of electronic Plug-In Modules with pre-set values. Simply select the required value (check that the Plug-In Module is the appropriate one for the adhesive to be used, referring to the Spares and Accessory lists at the end of this manual) and insert the module into the socket on top of the tool.

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.

- 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 immediately, quickly making any further adjustments. Hold the joint for 20 - 30 seconds to complete the bond.
- 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.
- Spots or blobs of adhesive are recommended for work pieces having a large surface area, or which are particularly long.
- Applying the adhesive in wavy lines is recommended for gluing textiles or similar materials.
- Foam materials, like polystyrene, can be easily bonded to other surfaces. However the adhesive must be applied to the other surfaces, not to the foam.
- Use only genuine Loctite® Hysol® adhesives to ensure reliable performance. Loctite® Hysol® adhesives are non-toxic and non-flammable.

7. Troubleshooting



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

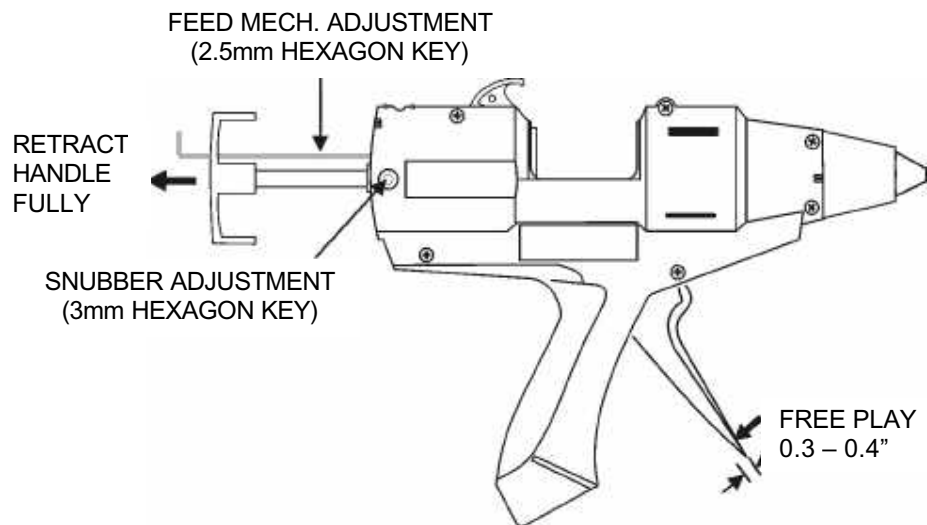
If the adhesive cartridge does not advance when the trigger is pulled, check that the tool is plugged into the main supply, switched on, and has had sufficient time to warm up. Otherwise carry out the 'Snubber Adjustment' as follows:

7.1. Snubber Adjustment



THIS IS FACTORY-SET BUT MAY REQUIRE MINOR ADJUSTMENT AFTER AN INITIAL BEDDING-IN PERIOD
The snubber is a spring-loaded friction pad, which rubs on the side of the feed bar, preventing its backward movement when the trigger is released. With the snubber correctly adjusted, the plunger should remain stationary when the trigger is released. If there is a backward movement, more snubber pressure is required. To increase pressure turn the adjustment screw clockwise using a 3mm hexagon key. Turn a quarter-turn each time and test. SEE DIAGRAM BELOW.

Do not over tighten as this will make plunger retraction difficult and cause premature wear on the snubber pad.



7.2. Feed mechanism adjustment

THIS IS FACTORY SET AND SHOULD NOT REQUIRE ADJUSTMENT UNTIL THE TOOL HAS BEEN IN USE FOR SOME TIME.

This adjustment compensates for any wear or slackness in the trigger movement. Typically free play at the trigger tip should be 0.3 – 0.4" (8 - 10mm).



To re-set, insert a 2.5mm hexagon key through the upper hole in feed bar handle and turn clockwise to decrease free play. SEE DIAGRAM ABOVE.

If feed mechanism adjustment is set too tight plunger withdrawal will be very difficult.

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

8. Care and Maintenance

- When in use, do not lay the tool on its side - always place upright using the stand provided.
- 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.



Replace the nozzle if worn or damaged. **Only replace the nozzle while the tool is still warm. Disconnect the tool from the power supply before proceeding, and always use protective gloves.**

Unscrew the nozzle from the tool using either a 1/2" (13 mm) spanner, or the spanner-feature moulded into the dispenser stand. Fit the replacement nozzle, ensuring that it is securely tightened.

9. Accessories and Spare Parts

Spare Parts	Part Number
2-Part Nozzle Assembly - supplied with tool	985078
Nozzle Adapter	985088
Trigger	985148
Temperature Control 110/120V	985162
Heater Assembly 120V 400W	985144
Main Capacitor Assembly	985178
Dispenser Stand	985133
Nozzle Shroud Kit – Qty 5	985223
Feed Bar Assembly	985154
Handle Kit	985224
Qty 2 – Moulded Handles, Item 1	
Qty 9 – Casing Screws, Item 43	
Feed Bar Kit	985220
Qty 1 – Feed Bar Handle, Item 23	
Qty 1 – Feed Bar Handle Screw, Item 45	
Qty 1 – Feed Mechanism Toggle, Item 21	
Qty 1 – Snubber Assy., Item 15	
Qty 1 – Screw, Snubber, Item 48	
Heater Housing Kit	985221
Qty 1 – O-ring, Heater Housing, Item 7	
Qty 1 – Heater Housing, Item 8	
Qty 1 – Earth (Ground) Screw, Item 47	
Qty 1 – Helical Spring Lock Washer, Item 49	
Barrel Kit	985222
Qty 1 – Rear Barrel, Item 2	
Qty 1 – PTFE Front Barrel, Item 3	
U.S. Cordset Kit	985226
Qty 1 – Cordset, Item 17	
Qty 1 – Cord Clamp, Item 16	
Qty 2 – Screws, Item 42	
Plug-In Module	
Plug-In Module 383°F (195°C) (Recommended for standard EVA-based hotmelt adhesives)	985164
Plug-In Module 419° F (215° C) (Recommended for use with polyamides adhesives only)	985134

Accessories	Part Number
Nozzle 1-Hole Kit, Qty 5, 0.080" (2 mm) orifice	985225
Nozzle 2-Hole	985110
Nozzle 3-Hole	985111
Extension Nozzle 0.120" (3 mm)	985112
Needle Extension Nozzle 0.050" (1.3 mm)	985113
Spreader Extension Nozzle 0.250" (6 mm)	985114
'L' Nozzle, overlap carton sealing	985115
'T' Nozzle, center flap carton sealing	985116
(Note: the nozzle shroud cannot be re-fitted with some optional nozzles)	
Tool Hanger / Balancer	985243
Heavy-Duty Free-Standing Metal Stand	985087

10. Warranty

This applicator is guaranteed against faulty workmanship, materials and malfunction for a period of **12 months** from the date of purchase. This guarantee does not apply:

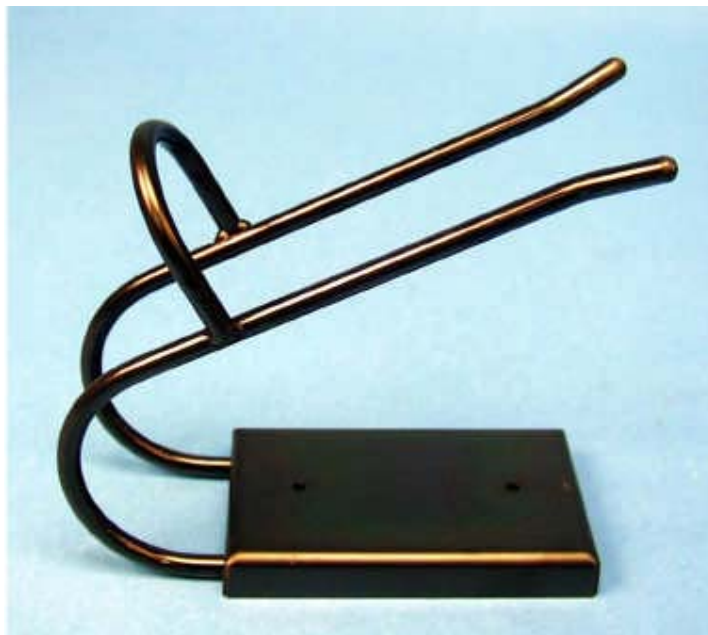
1. If the applicator has been dropped, damaged due to careless handling, or has not been used in accordance with the manufacturer's instructions.
2. If the applicator has been modified in any way.
3. If the applicator has been opened, or the electrical cable has been damaged or replaced.
4. If adhesive other than formulations supplied by the manufacturer of the applicator have been used.

The manufacturer undertakes to repair or replace at their discretion. The tool will be returned to the distributor or user freight prepaid.

Sellers and Manufacturer's only obligation shall be to replace such quantity of the product proved to be defective. Neither seller nor manufacturer shall be liable for any injury, loss or damage, direct or consequential, arising out of the use, or the inability to use, the product. User shall determine the suitability of the product for his intended use and the user assumes all risks and liability whatsoever in connection therewith.

11. Appendix

Pictures of available nozzles/accessories.

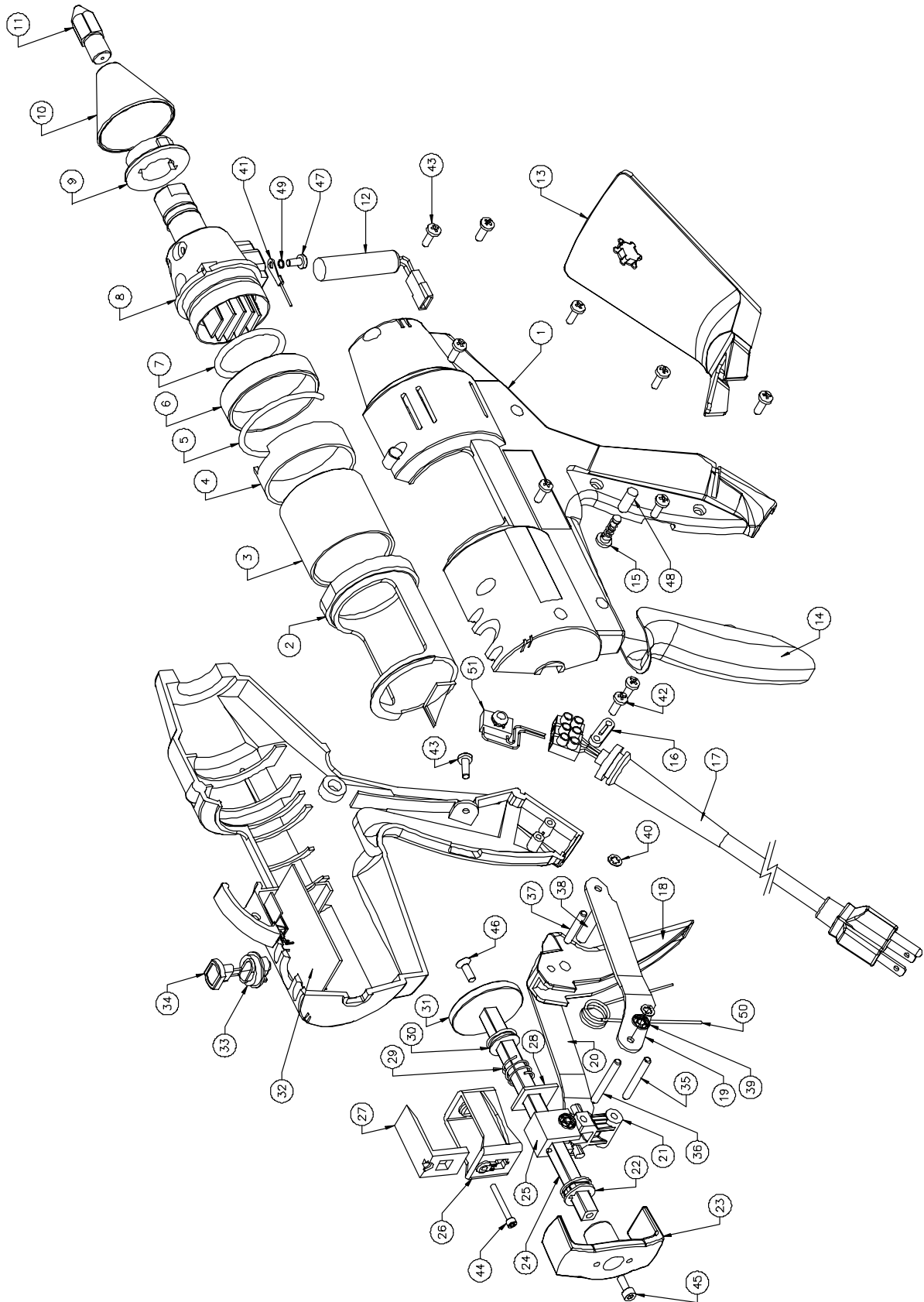


985087
HEAVY DUTY FREE-STANDING
METAL STAND



985243
TOOL HANGER / BALANCER

12. Exploded Diagram.



13. Parts List.

51	1	MAIN CAPACITOR ASSEMBLY		985178
50	1	TORSION SPRING		
49	1	HELICAL SPRING LOCK WASHER	HEATER HOUSING KIT	985221
48	1	SNUBBER SCREW	FEED BAR KIT	985220
47	1	EARTH (GROUND) SCREW	HEATER HOUSING KIT	985221
46	1	FEED BAR PLUNGER SCREW		
45	1	FEED BAR HANDLE SCREW	FEED BAR KIT	985220
44	1	FEED MECHANISM ADJUSTER SCREW		
43	9	CASING SCREW	HANDLE KIT	985224
42	2	SCREW	US CORD SET KIT	985226
41	1	EARTH (GROUND) WIRE ASSEMBLY		
40	1	RETAINER RING		
39	1	RETAINER RING		
38	1	TRIGGER PIVOT PIN		
37	1	PIVOT PIN TRIGGER LINK		
36	1	UPPER TOGGLE PIN		
35	1	LOWER TOGGLE PIN		
34	1	PLUG-IN MODULE 195°C		985164
33	1	MODULE CARRIER		
32	1	TEMPERATURE CONTROL, 110/120 VOLT		985162
31	1	PLUNGER		
30	1	FRONT FEED BAR BUSHING		
29	1	FEED MECHANISM SPRING		
28	1	PRESSURE PLATE		
27	1	SPACER GUARD		
26	1	FEED MECHANISM CARRIER		
25	1	FEED MECHANISM ASSEMBLY		
24	1	FEED BAR ASSEMBLY		985154
23	1	FEED BAR HANDLE	FEED BAR KIT	985220
22	1	REAR FEED BAR BUSHING		
21	1	TOGGLE	FEED BAR KIT	985220
20	1	RIGHT TRIGGER LINK		
19	1	LEFT TRIGGER LINK		
18	1	TRIGGER		985148
17	1	U.S. CORDSET ASSEMBLY	US CORD SET KIT	985226
16	1	CORD CLAMP	US CORD SET KIT	985226
15	1	SNUBBER ASSEMBLY	FEED BAR KIT	985220
14	1	HANDLE GRIP		
13	1	DISPENSER STAND		985133
12	1	HEATER ASSEMBLY. 120 VOLT, 400 WATT		985144
11	1	NOZZLE BODY ASSEMBLY		985078
10	1	NOZZLE SHROUD	NOZZLE SHROUD KIT, QTY 5	985223
9	1	HEATER HOUSING SPACER		
8	1	HEATER HOUSING	HEATER HOUSING KIT	985221
7	1	HEATER HOUSING O-RING	HEATER HOUSING KIT	985221
6	1	LOCK RING, ALUMINIUM		
5	1	PTC SENSOR ASSEMBLY		
4	1	BARREL SUPPORT		
3	1	PTFE SUPPORT	BARREL KIT	985222
2	1	REAR BARREL	BARREL KIT	985222
1	1	HANDLES, PAIR	HANDLE KIT	985224
ITEM	QTY.	DESCRIPTION	REBUILD KITS	AVAILABLE PART NO.

PARTS LIST