Replacing Fluid Element

**Step 1.**
To prime pump, rotate Pump Priming Knob, 20 to 40 turns in the direction of the arrow until adhesive flows from bottle to Dispense Tip. Pump is now primed and ready to dispense.

**Step 5.**
Bottle is now properly installed.

**Step 2.**
Remove Cap and Nozzle from CA bottle and discard.

**Step 6.**
Remove Fluid Element Dispense Tube from holder.

**Step 3.**
Screw bottle into Fluid Element Cap by turning bottle. Tighten gently with pliers.

**Step 7.**
Pull gently on Fluid Element Dispense Tube to align it with the center of the rollers.

**Step 4.**
Align Fluid Element Cap so it will slide into Bottle Holder Tray.

**Step 8.**
Close Tube Slide and apply pressure to Tube Slide.

Loading and Priming

**Step 1.**
Ensure that the lower Fluid Element Dispense Tube is clean and dust free.

**Step 5.**
Bottle is now properly installed.

**Step 2.**
Remove Cap and Nozzle from CA bottle and discard.

**Step 6.**
Remove Fluid Element Dispense Tube from holder.

**Step 3.**
Screw bottle into Fluid Element Cap by turning bottle. Tighten gently with pliers.

**Step 7.**
Pull gently on Fluid Element Dispense Tube to align it with the center of the rollers.

**Step 4.**
Align Fluid Element Cap so it will slide into Bottle Holder Tray.

**Step 8.**
Close Tube Slide and apply pressure to Tube Slide.

Troubleshooting

<table>
<thead>
<tr>
<th>Malfunction</th>
<th>Possible Cause</th>
<th>Correction</th>
</tr>
</thead>
<tbody>
<tr>
<td>Fluid Element Tube is not correctly installed.</td>
<td>Repeat Fluid Element installation Steps 5-12. Try gently stretching dispense tip when installing Fluid Element Tube.</td>
<td></td>
</tr>
<tr>
<td>Dispense Tip is clogged.</td>
<td>Change Dispense Tip.</td>
<td>Use larger Dispense Tip.</td>
</tr>
<tr>
<td>Difficult to control drop dispensing.</td>
<td>Wrong dispense setting. Use a smaller dispense setting (see Setting Dispense Amount). Squeeze trigger slowly.</td>
<td></td>
</tr>
</tbody>
</table>

For more information, visit www.henkelna.com/industrial
To set dose amount, pull Trigger all the way back and hold, then:

- Press Stroke adjustment Knob in.
- Keeping hold of the Trigger, rotate Adjustment Knob to one of the six dose settings and release Trigger.
- Dispensing is achieved by squeezing and releasing Trigger.
- Best results are achieved by squeezing the Trigger and allowing a drop to form on the Dispense Tip. Once a drop is present, transfer the adhesive to the part to be bonded and release Trigger.

---

**Typical Dose Amounts**

<table>
<thead>
<tr>
<th>Adhesive Product</th>
<th>Max. Setting</th>
<th>Setting 5</th>
<th>Setting 4</th>
<th>Setting 3</th>
<th>Setting 2</th>
<th>Setting 1</th>
</tr>
</thead>
<tbody>
<tr>
<td>Loctite® 401™ 1500cP</td>
<td>6.5 mg</td>
<td>5.5 mg</td>
<td>4.5 mg</td>
<td>3.5 mg</td>
<td>2.5 mg</td>
<td>1.5 mg</td>
</tr>
<tr>
<td>Loctite® 401™ 1000cP</td>
<td>0.5 mg</td>
<td>0.5 mg</td>
<td>0.5 mg</td>
<td>0.5 mg</td>
<td>0.5 mg</td>
<td>0.5 mg</td>
</tr>
</tbody>
</table>