



# **LOCTITE**<sup>®</sup> **EQUIPMENT**

OPERATION MANUAL

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## **Hysol<sup>®</sup> 050-LITE** **P/N 98029**



## **LOCTITE**


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A  Company

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## ***Please Observe the Following***

### ***Safety***

- **Do not touch the nozzle or molten adhesive with bare skin as they are hot - the operating temperature of the Loctite<sup>®</sup> Hysol<sup>®</sup> 050-LITE 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.
- 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.

### ***Items supplied***

Hot Melt Stick Dispenser  
Wire Stand  
Manual

### ***Description***

The Loctite<sup>®</sup> Hysol<sup>®</sup> 050-LITE Hotmelt Applicator contains a new technology self-regulating heater, providing accuracy in temperature control and excellent reliability. The tool operates on any voltage from 100 - 240 VAC, and can be used within 7 minutes of being switched on. For total safety the heater housing is totally enclosed, and the applicator is electrically double-insulated.

### ***Technical Data***

Dimensions (L x H x W):	8" x 6 9/16" x 1 5/16" (approx. 210 x 170 x 36 mm)
Total weight:	3/4 lbs. (approx. 360 g)
Connection cable with mains plug:	78" long (1.8 m)
Operating voltage: (electronic voltage control)	100 to 240 VAC 50/60Hz
Heating up time:	5 - 7 min.
Operating temperature:	approx. 400°F (200°C)
Diameter of adhesive inlet:	1/2" (12 mm)
Extension cable:	max. 65 ft long (20 m)
Wire cross section:	at least 16 a.w.g. (1.5 mm <sup>2</sup> )

### ***Power consumption***

Heating up phase:	approx. 500 W
Rest period:	approx. 20 W
Operating phase:	approx. 45W

### ***Installation***

Before using the tool for the first time:

1. 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.
2. Attach the enclosed stand to the tool by locating the hooks on its legs into the holes on either side of the casing. When correctly assembled the stand should pivot, snapping into two possible positions.
3. Insert a Loctite<sup>®</sup> Hysol<sup>®</sup> glue stick into the rear of the tool. Push the stick forward until slight resistance is felt.

## Operation

Normal use:

- Fold down 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 - 7 minutes for the tool to reach its normal operating temperature.
- Squeeze the trigger to advance the glue stick and extrude molten adhesive through the nozzle.
- To stop extruding adhesive simply release the trigger.

When adhesive can no longer be extruded from the tool, it is time to reload another glue stick.

Once the gluing task is completed place the tool in an upright position on a flat surface (always use the stand when resting the tool). Ensure that the nozzle cannot cause any damage to surrounding materials. Switch off the power, and allow the tool to fully cool down before packing it away. Never wrap the power lead around a tool that has not fully cooled. Any unused glue stick can remain in the tool; it will be fully reusable when heated up again.

## 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 workpieces 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<sup>®</sup> Hysol<sup>®</sup> adhesive sticks to ensure reliable performance. Loctite<sup>®</sup> Hysol<sup>®</sup> adhesive sticks are non-toxic and non-flammable.

## Troubleshooting

If the stick does not advance when the trigger is pulled, check that the tool is plugged into the mains supply and switched on. Else ensure that the tool has had sufficient time to warm up, and that "glue backup" or "meltback" has not occurred (where molten adhesive becomes visible at the point where the glue stick enters the heater tube) – see *Care and Maintenance*.

## 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 whilst the nozzle is still warm.
- Should glue "backup" or "meltback" accidentally occur, switch off the tool and allow the adhesive to cool. Gently pull away this excess adhesive, reconnect the power, and allow the tool to warm up again. Now squeeze the trigger two or three times to advance the glue stick, then use the tool as normal.

Replace the nozzle if worn or damaged. **Only replace the nozzle whilst 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 a 1/2" (13 mm) spanner. Fit the replacement nozzle, ensuring that it is securely tightened.

## Accessories and Spare Parts

Spare Parts	Part Number
Standard Nozzle 0.100" (2.5 mm) - supplied with tool	984999
Wire Stand	984914
Manual	984913

Accessories	Part Number
Extension Nozzle 0.100" (2.5 mm)	985004
Spreader Nozzle 0.250" X 0.080" (6.4 mm X 2 mm)	985001
Pencil-point Nozzle 0.080" (2 mm)	985002
Precision Nozzle 0.050" (1.3 mm)	985003
Silicone Rubber Safety Cap (for use with 984999, 985004 and 985002)	985005



985004      985001      985002      985003      985005

## 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.

Seller's 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.