



EQUIPMENT Operation Manual



Loctite[®] Hysol[®] 175
120 Volt Part Number 98035
230 Volt Part Number 98055

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1 Please Observe The Following

1.1 Emphasized Sections

Warning!

Refers to safety regulations and requires safety measures that protect the operator or other persons from injury.


Caution!

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

Notice:

Gives 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[®] 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.

1.3 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 270°F (130°C); it will return to its full operating temperature when operated.

Designed to comply with world wide 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: | 98035: 110-120 VAC 50/60Hz 98055: 230 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) |

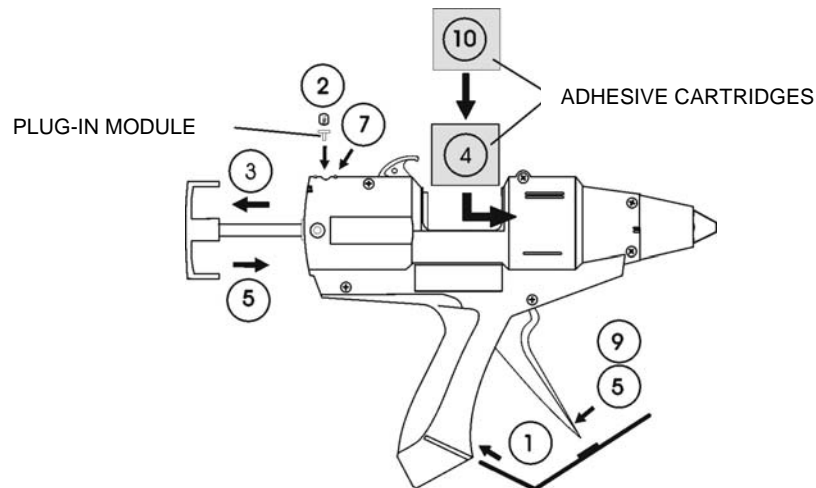
4 Installation



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 power supply:

1. Assemble 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 power supply.
7. Red “Power On” indicator light will illuminate.
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; air trapped in the heater housing needs to be evacuated.

5 Operation

Normal use:

- Assemble 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 stabilise.



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 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 ON NEXT PAGE.

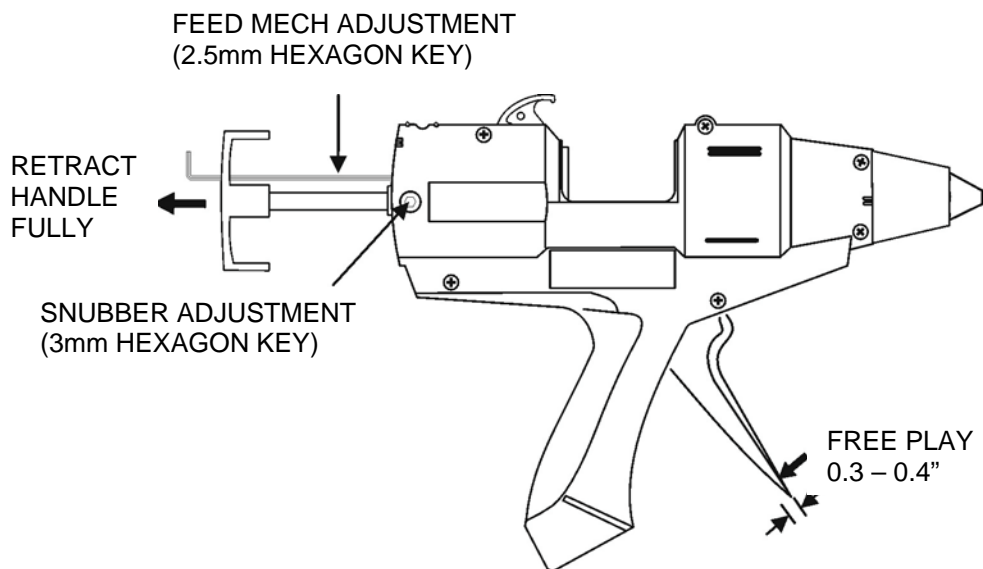
Do not over tighten, as this will make plunger retraction difficult and cause premature wear on the snubber pad.

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 2.5 mm hexagon key through the upper hole in feed bar handle and turn clockwise to decrease free play. SEE DIAGRAM BELOW.



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 (562-8483).

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 # | Spare Parts | Part # |
|--|--------|--|--------|
| Complete Nozzle Check Adapter Assembly | 985078 | U.S. Cordset Kit | 985226 |
| Nozzle Check Adapter Only (included with 985078) | 985088 | Qty 1 – Cordset, Item 17 | |
| | | Qty 1 – Cord Clamp, Item 16 | |
| | | Qty 2 – Screws, Item 42 | |
| Temperature Control 110/120V (Includes: PC Board, TCO, Micro Switch, Temp Sensor) | 985162 | Australian Cordset Kit | 985759 |
| | | Qty 1 – Cordset, Item 17 | |
| | | Qty 1 – Cord Clamp, Item 16 | |
| | | Qty 2 – Screws, Item 42 | |
| Temperature Control 230V (Includes: PC Board, TCO, Micro Switch, Temp Sensor) | 985755 | Trigger Kit | 985440 |
| | | Qty 1 – Trigger, Item 18 | |
| | | Qty 1 – Left Trigger Link, Item 19 | |
| | | Qty 1 – Right Trigger Link, Item 20 | |
| | | Qty 1 – Toggle, Item 21 | |
| | | Qty 1 – Lower Toggle Pin, Item 35 | |
| | | Qty 1 – Upper Toggle Pin, Item 36 | |
| | | Qty 1 – Trigger Link Pivot Pin, Item 37 | |
| | | Qty 1 – Trigger Pivot Pin, Item 38 | |
| | | Qty 2 – Retainer Ring, Item 39 | |
| | | Qty 4 – Retainer Ring, Item 40 | |
| | | Qty 1 – Torsion Spring, Item 50 | |
| Heater Assembly, 120V 400W | 985144 | | |
| Heater Assembly, 230V 400W | 985756 | | |
| Main Capacitor Assembly, 120V | 985178 | | |
| Main Capacitor Assembly, 230V | 985757 | | |
| Dispenser Stand | 985133 | | |
| Nozzle Shroud Kit – Qty 5 | 985223 | Snubber Kit | 985541 |
| | | Qty 2 – Snubber Assembly, Item 15 | |
| | | Qty 2 – Snubber Screw, Item 48 | |
| Handle Kit | 985224 | Label Kit for 98035 | 985870 |
| Qty 2 – Moulded Handles, Item 1 | | Qty 2 – Product I.D. Label | |
| Qty 9 – Casing Screws, Item 43 | | Qty 1 – Voltage & Serial Number Label | |
| Qty 1 – Handle Grip, Item 14 | | Qty 1 – Electrical Warning Label | |
| Qty 1 – Temperature Module Carrier, Item 33 | | | |
| Feed Bar Kit | | Label Kit for 98055 | 985871 |
| Qty 1 – Feed Bar Handle, Item 23 | 985220 | Qty 2 – Product I.D. Label | |
| Qty 1 – Feed Bar Handle Screw, Item 45 | | Qty 1 – Voltage & Serial Number Label | |
| Qty 1 – Feed Bar Sub-Assy., Item 24 | | Qty 1 – Electrical Warning Label | |
| Qty 1 – Rear Feed Bar Bushing, Item 22 | | | |
| Qty 1 – Feed Mechanism Sub-Assy, Item 25 | | O-Ring #2-222 Kit of 10, Item 7 | 985868 |
| Qty 1 – Pressure Plate, Item 28 | | | |
| Qty 1 – Feed Mechanism Spring, Item 29 | | Plug-In Modules | |
| Qty 1 – Front Feed Bar Bushing, Item 30 | | Plug-In Module 383°F (195°C) | 985164 |
| Qty 1 – Plunger, Item 31 | | (Recommended for standard EVA-based hotmelt adhesives) | |
| Qty 1 – Plunger Screw, Item 46 | | Plug-In Module 419°F (215°C) | 985134 |
| Qty 1 – Spacer Guard, Item 27 | | (Recommended for use with polyamides adhesives only) | |
| Qty 1 – Feed Mechanism Carrier, Item 26 | | Plug-In Module, Low Melt, 266°F (130°C) | 985865 |
| Qty 1 – Adjustment Screw, Item 44 | | Plug-In Module, 320°F (160°C) | 985866 |
| Heater Housing Kit | 985221 | Plug-In Module, 356°F (180°C) | 985867 |
| 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 | | | |
| Qty 1 – Ground Wire with Terminal, Item 41 | | | |
| Barrel Kit | 985222 | | |
| Qty 1 – Rear Barrel, Item 2 | | | |
| Qty 1 – PTFE Front Barrel, Item 3 | | | |
| Qty 1 – Barrel Support, Item 4 | | | |
| Qty 1 – PTC Sensor Assembly, Item 5 | | | |
| Qty 1 – Lock Ring, Item 6 | | | |

9 Accessories and Spare Parts (continued)

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

10 Appendix

Available nozzles/accessories



| | | | | | | | | |
|---|-------------------------|-------------------------|----------------------------|-------------------------|---------------------------|-----------------------------|-----------------------------|---|
| 985225 1 Hole Standard 5 pack | 985110 2 Hole | 985111 3 Hole | 985112 Extension | 985113 Needle | 985114 Spreader | 985115 "L" Nozzle | 985116 "T" Nozzle | 985088 Nozzle Check Adapter |
|---|-------------------------|-------------------------|----------------------------|-------------------------|---------------------------|-----------------------------|-----------------------------|---|

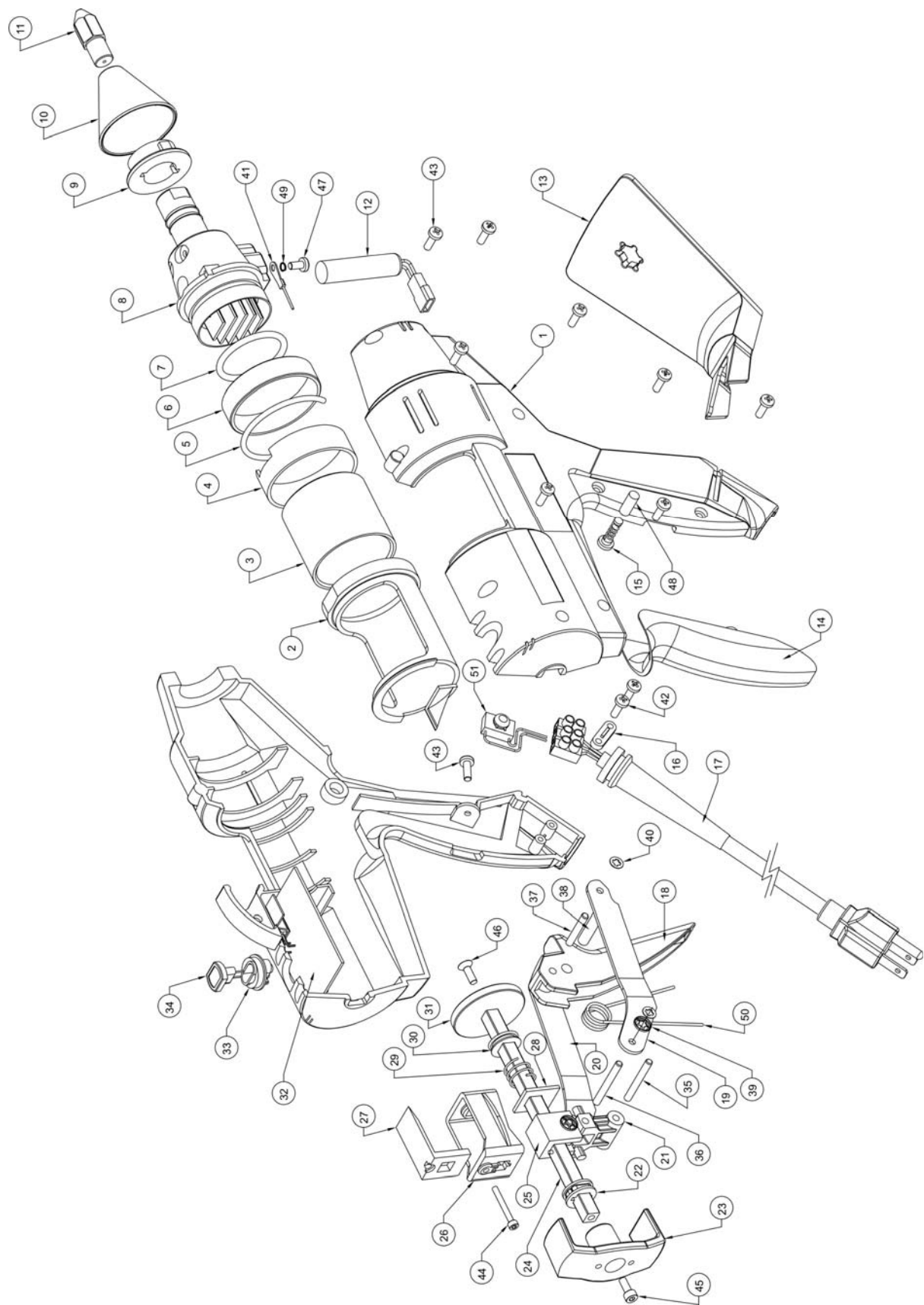


985087
Heavy Duty Free Standing
Metal Stand



985243
Tool Hanger/Balancer

11 Exploded Diagram



12 Parts List

| Item | Qty | Description | Rebuild Kits | Available Part No. |
|------|-----|---|---|--|
| 51 | 1 | Main Capacitor Assembly, 120V Main Capacitor Assembly, 230V | | 985178 985757 |
| 50 | 1 | Torsion Spring | Trigger Kit | 985540 |
| 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 | Feed Bar Kit | 985220 |
| 45 | 1 | Feed Bar Handle Screw | Feed Bar Kit | 985220 |
| 44 | 1 | Feed Mechanism Adjuster Screw | Feed Bar Kit | 985220 |
| 43 | 9 | Casing Screw | Handle Kit | 985224 |
| 42 | 2 | Screw | US Cord Set Kit Australia Cord Set Kit | 985226 985759 |
| 41 | 1 | Earth (Ground) Wire Assembly | Heater Housing Kit | 985221 |
| 40 | 1 | Retainer Ring | Trigger Kit | 985540 |
| 39 | 1 | Retainer Ring | Trigger Kit | 985540 |
| 38 | 1 | Trigger Pivot Pin | Trigger Kit | 985540 |
| 37 | 1 | Pivot Pin Trigger Link | Trigger Kit | 985540 |
| 36 | 1 | Upper Toggle Pin | Trigger Kit | 985540 |
| 35 | 1 | Lower Toggle Pin | Trigger Kit | 985540 |
| 34 | 1 | Plug-In Module 195°C Plug-In Module 215°C Plug-In Module 130°C (Optional) Plug-In Module 160°C (Optional) Plug-In Module 180°C (Optional) | | 985164 985134 985865 985866 985867 |
| 33 | 1 | Module Carrier | Handle Kit | 985224 |
| 32 | 1 | Temperature Control, 110/120V Temperature Control, 230V | | 985162 985755 |
| 31 | 1 | Plunger | Feed Bar Kit | 985220 |
| 30 | 1 | Front Feed Bar Bushing | Feed Bar Kit | 985220 |
| 29 | 1 | Feed Mechanism Spring | Feed Bar Kit | 985220 |
| 28 | 1 | Pressure Plate | Feed Bar Kit | 985220 |
| 27 | 1 | Spacer Guard | Feed Bar Kit | 985220 |
| 26 | 1 | Feed Mechanism Carrier | Feed Bar Kit | 985220 |
| 25 | 1 | Feed Mechanism Sub-Assembly | Feed Bar Kit | 985220 |
| 24 | 1 | Feed Bar Sub-Assembly | Feed Bar Kit | 985220 |
| 23 | 1 | Feed Bar Handle | Feed Bar Kit | 985220 |
| 22 | 1 | Rear Feed Bar Bushing | Feed Bar Kit | 985220 |
| 21 | 1 | Toggle | Trigger Kit | 985540 |
| 20 | 1 | Right Trigger Link | Trigger Kit | 985540 |
| 19 | 1 | Left Trigger Link | Trigger Kit | 985540 |
| 18 | 1 | Trigger | Trigger Kit | 985540 |
| 17 | 1 | U.S. Cord Assembly Australia Cordset Assembly | US Cord Set Kit Australia Cord Set Kit | 985226 985579 |
| 16 | 1 | Cord Clamp | US Cord Set Kit Australia Cord Set Kit | 985226 985579 |
| 15 | 1 | Snubber Assembly | Snubber Kit | 985541 |
| 14 | 1 | Handle Grip | Handle Kit | 985224 |
| 13 | 1 | Dispenser Stand | | 985133 |
| 12 | 1 | Heater Assembly, 120V, 400W Heater Assembly, 230V, 400W | | 985144 985756 |
| 11 | 1 | Complete Nozzle/Check Adapter Assembly Nozzle Only, Pkg of 5 Check Adapter Only | | 985078 985225 985088 |
| 10 | 1 | Nozzle Shroud | Nozzle Shroud Kit, Qty. 5 | 985223 |
| 9 | 1 | Heater Housing Spacer | | 985143 |
| 8 | 1 | Heater Housing | Heater Housing Kit | 985221 |
| 7 | 1 | Heater Housing O-Ring | Heater Housing Kit O-Ring Kit of 10 | 985221 985868 |
| 6 | 1 | Lock Ring, Aluminum | Barrel Kit | 985222 |
| 5 | 1 | PTC Sensor Assembly | Barrel Kit | 985222 |
| 4 | 1 | Barrel Support | Barrel Kit | 985222 |
| 3 | 1 | PTFE Support | Barrel Kit | 985222 |
| 2 | 1 | Rear Barrel | Barrel Kit | 985222 |
| 1 | 1 | Handles, Pair | Handle Kit | 985224 |

13 Warranty

Henkel Loctite expressly warrants that all products referred to in this Instruction Manual under Loctite® Hysol 175® Hotmelt Applicator (hereafter called "Products") shall be free from defects in materials and workmanship. Liability for Henkel Loctite shall be limited, as its option, to replacing those Products which are shown to be defective either in materials or workmanship or to credit to 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 to Loctite in writing within one month after discovery of the defect or after the time the defect should have reasonably have been discovered and in any event, within twelve months after the delivery of the Products to the purchaser. 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 Loctite, the use of products, parts or attachments which are not manufactured by Henkel Loctite, no claim shall be allowed.

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Loctite Industrial

Henkel Corporation

1001 Trout Brook Crossing
Rocky Hill, CT 06067-3910

Henkel Automotive

Technology Center
2455 Featherstone Road
Auburn Hills, Michigan 48326

Henkel Canada Corporation

2225 Meadowpine Boulevard
Mississauga, Ontario L5N 7P2

Henkel Ltda. Brazil

Av. Prof. Vernon Kriebel, 91
06690-11-Itapevi
Sao Paulo, Brazil

Henkel Capital, S.A. de C.V.

Calz. de la Viga, s/n, Fracc. Los Laureles
Loc. Tulpetlac, Ecatepec Edo. de Mexico
RFC: HCA000314-IC0

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