



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

OPERATION MANUAL

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## **Hysol<sup>®</sup> 050-Gas**

### **P/N 98032**



## **LOCTITE**


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A  Company

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## Please Observe the Following

### **Safety**

**Do not touch the nozzle, the exhaust ports, or molten adhesive with bare skin as they are hot - the operating temperature of the Loctite® Hysol® 050-Gas is approximately 392°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 the vicinity of any heat-sensitive materials, or any flammable materials, liquids, or gases.
- When refilling, ensure that you switch off the tool before commencing, and that you keep away from sources of ignition.
- Ensure that the tool is held away from your face and body while igniting the gas.
- Always use the foldaway stand provided when resting the tool. Do not leave the tool on its side, as molten adhesive may flow back into the melt chamber, clogging the feed system.
- Do not leave the tool unattended while switched on.
- Do not expose to heat above 120°F (50°C), and avoid prolonged exposure to the sun.
- Do not try to open, puncture, or incinerate the gas tank.

BOND SEAL ASSEMBLE INSULATE REINFORCE ENCAPSULATE REPAIR FILL – *INSTANTLY*

Suitable for use with most materials. Just apply Loctite® Hysol® hotmelt to one surface then press parts together and the bond is made. Can be used for bonding: Wood, Paper, Cardboard, Foam, Chipboard, Hardboard, some Plastics, Rubber, Glass, thin Metals, Ceramics, Leather, Fabrics and many more.

The Loctite® Hysol® 050-Gas is simplicity itself. To operate just turn on the gas, press the ignition switch, and the gun will be ready for use in approximately 5 minutes. Glue sticks can be fed continuously through the back of the gun. Use only genuine Loctite® Hysol® adhesive sticks

### **Items supplied**

Hot Melt Stick Dispenser  
Manual

### **Technical Data**

Dimensions (L x H x W):	13 ¾" x 10 ½" x 3" (approx. 350 x 270 x 75 mm)
Total weight:	1.6 lbs. (approx. 750 g)
Heating up time:	4 - 7 min.
Operating temperature:	approx. 392°F (200°C)
Diameter of adhesive inlet:	1/2" (12 mm)
(Use only genuine Loctite® Hysol® adhesive sticks)	

## **USING THE Loctite® Hysol® 050-Gas**

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. Always use the foldaway stand provided (see figure 1 ⑥) when resting the tool.
3. Insert a Loctite® Hysol® adhesive stick into the rear of the tool. Push the stick forward until slight resistance is felt.

### **Normal use:**

**The Loctite® Hysol® 050-Gas is shipped without gas.**

- First fill the Loctite® Hysol® 050-Gas with butane gas (see figure 1 ①). We recommend the use of Braun, Calibri, Ronson, Rowenta, or other high-quality cigarette lighter fuel. When refilling, ensure that you switch off the tool before commencing, and that you keep away from sources of ignition.
- Load the tool with a Loctite® Hysol® adhesive stick (see figure 1 ②).
- Switch on the gas by rotating the 'gas on/off' switch counterclockwise to position 'I' (see figure 1 ③).
- Press the ignition button (see figure 1 ④) to ignite the gas. Gas ignition may be confirmed by the sound of the gas flow changing (to a mild 'roar'), or by a visible glow appearing in the 'Ignition View' window (see figure 1 ⑤) a few moments later. You may need to repeat pressing the ignition button to achieve ignition.

**Ensure that the tool is held away from your face and body while igniting the gas.**

**The glow in the ignition view window will disappear once the tool has reached temperature (the thermostat valve will close, shutting off the gas supply). It will only reappear once the tool has cooled sufficiently for the thermostat gas valve to open.**

- Allow at least 4 minutes for the tool to reach operational temperature (approx. 385°F/195°C).

**Always use the foldaway stand provided (see figure 1 ⑥) when resting the tool. Do not leave the tool on its side, as molten adhesive may flow back into the melt chamber, clogging the feed system. Do not leave the tool unattended while switched on.**

- Adhesive may now be extruded through the tool by simply pulling the trigger (see figure 1 ⑦). Adhesive flow is controlled by regulating the pressure applied to the trigger, and is stopped by simply releasing it.

### **Switching the Loctite® Hysol® 050-Gas off:**

- When work with the tool has been completed, switch off the gas by rotating the 'gas on/off' switch clockwise to position 'O' (see figure 1 ③).

**Allow the tool to stand for a few minutes before packing away, as it may operate one last time (even though the switch is in the 'off' position); this is due to the tool consuming any gas retained between the switch and the thermostat valve.**

Figure 1.



### PREVENTATIVE MAINTENANCE

- 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.
- Should “glue backup” or “meltback” accidentally occur (when molten adhesive becomes visible at the point where the glue stick enters the heater tube), 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, and then use the tool as normal.

## APPLICATION NOTES

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® adhesive sticks to ensure reliable performance. Loctite® Hysol® adhesive sticks are non-toxic and non-flammable.

## REPLACING THE NOZZLE

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

Remove the rubber safety cover from the nozzle. Unscrew the nozzle from the tool using a 1/2" (13mm) spanner. Fit the replacement nozzle, ensuring that it is securely tightened. Replace the rubber safety cover.

## SERVICING AND REPAIRS

The Loctite® Hysol® 050-Gas contain no user-serviceable parts. In order to avoid a hazard, any servicing or repairs, should only be carried out by the manufacturer, its service agent, or other similarly qualified person.

## GUARANTEE

The Loctite® Hysol® 050-Gas is guaranteed against faulty workmanship and materials for a period of **12 months** from the date of purchase. Within this warranty period the manufacturers undertake, at their discretion, to either repair or replace any tool proved to be defective (proof of purchase will be required for verification). This guarantee is invalidated if the tool is opened, or modified in any way, or if adhesive formulations other than those supplied by the tool's manufacturer are used. Warranty claims attributable to improper, or careless, use or handling, and to normal wear, are excluded from this guarantee.

The supplier's and manufacturers only obligation shall be to replace such tools that are proved to be defective. Neither supplier nor manufacturer shall be liable for any injury, loss or damage, direct or consequential, arising out of the use, or the inability to use, this tool. The user shall determine the suitability of this product for its intended use, and the user assumes all risks and liability whatsoever in connection therewith.

The manufacturer reserves the right to improve or modify this product without prior notice.

Optional nozzles:



**985225**  
1 HOLE

**985110**  
2 HOLE

**985111**  
3 HOLE

**985112**  
EXTENSION

**985113**  
NEEDLE

**985114**  
SPREADER

**985115**  
'L' NOZZLE

**985088**  
NOZZLE ADAPTOR