

# LOCTITE®

1001 Trout Brook Crossing  
Rocky Hill, CT 06067-3910  
Telephone: (860) 571-5100  
FAX: (860) 571-5465

## Instruction Sheet External Mix Assembly

Part # 1095801

North American Engineering Center, October 2007

### PRODUCT DESCRIPTION

The Loctite® External Mix Assembly is designed for ease of use when using two component externally mixed adhesive products. The design is such that it allows for easy positioning of valves to ensure proper alignment when using externally mixed adhesives. The Loctite® External Mix Assembly has an incorporated needle tip locator which aids in aligning dispensed product streams while reducing effects of minor impacts to tip alignment. Three pairs of bushings are included for use in the tip locator to accommodate 1" or 1½" 14, 15 and 16 gauge stainless steel dispense tips for further precision. 97113, 97114 or 986300 Loctite® Stationary Applicator Valves can be used with the Loctite® External Mix Assembly using the two included mounting fixtures.



### PRODUCT FEATURES

- Easy adjustment of tip locations using ¼" hex wrench.
- Two ¼" mounting holes for mounting in assembly station.
- Tip locator to ensure proper alignment of product streams.

### TECHNICAL DATA

- Weight: 3.0 lbs.
- Dimensions: 10.75" W X 8.38" H X 3.63" Deep

### USE INSTRUCTIONS

1. Mount Loctite® External Mix Assembly directly over the dispense area. The height of the product dispense points should be 6 to 12" above the substrate being dispensed on to facilitate good external mixing of adhesive components.
2. Install tip locator bracket using the two included hex bolts. The tip locator bracket should be mounted to the face of the Loctite® External Mix Assembly with the tip locator bracket extending in front of the Loctite® External Mix Assembly such that the tip locator bracket holes are on center with the Loctite® Stationary Applicator Valve mounting fixtures.
3. Install the 97113, 97114 or 986300 Loctite® Stationary Applicator Valves and connect one to part "A" and one to the part "B" feed lines. Refer to 97113, 97114 or 986300 manual for valve instructions. (97114 valves shown in photo)
4. Select appropriate bushings for use with the 1" or 1½" 14, 15 and 16 gauge stainless steel dispense tips selected and insert into tip locator bracket.
5. Install proper needle tip onto valves for bushing chosen.
6. Adjust tip locations using a ¼" hexagonal wrench to turn the valve positioning slides. Tips should be equally advanced and approximately 1/16" apart when measuring nearest needle tip points. This distance will need adjustment based on the throughput of the adhesive that is chosen via application dispense parameters.
7. Dispense adhesives and ensure that tip locations accommodate near immediate joining of dispense product streams. The dispensed product should helically fall to the part approximating a barber pole or candy cane pattern before falling onto the targeted part.



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NOT FOR PRODUCT SPECIFICATIONS

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