Loctite® SD10 Digital Syringe Dispenser
Part Number 1514629
TABLE OF CONTENTS

1 Please observe the following ................................................................. 3
  1.1 Emphasized sections ................................................................. 3
  1.2 Items Supplied ................................................................. 3
  1.3 For your safety ................................................................. 4
  1.4 Usage ................................................................. 4

2 Description - Typical System Set-Up .............................................. 5
  2.1 Operating Elements ............................................................. 6
  2.2 Theory of Operation ........................................................... 6

3 Technical Data .................................................................................. 7
  3.1 Energy Requirements ............................................................ 7
    3.1.1 Electrical ................................................................. 7
    3.1.2 Pneumatics ............................................................... 7
  3.2 Connections and Dimensions .................................................. 7
  3.3 Other Data ............................................................................ 7

4 Installations ...................................................................................... 8
  4.1 Environmental Conditions ...................................................... 8
  4.2 Placement .............................................................................. 8

5 Dispensing ....................................................................................... 8
  5.1 Filling the Syringe ................................................................. 8
  5.2 Set Up .................................................................................. 9
    5.2.1 Purging Air from the Syringe .......................................... 9
    5.2.2 Manual Mode ............................................................... 9
    5.2.3 Programs .................................................................... 10
    5.2.4 Timer mode ................................................................. 10
    5.2.5 Cycle Mode ................................................................. 11

6 Cares and Maintenance .................................................................. 12
  6.1 Care .................................................................................. 12
  6.2 Maintenance ........................................................................ 12

7 Troubleshooting ............................................................................ 13

8 Replacement Parts and Accessories .............................................. 14

9 Warranty ....................................................................................... 15
1 Please observe the following

1.1 Emphasized sections

Danger!
Refers to safety regulations and required safety measures that protect the equipment, operator, or other persons from injury.

Caution!
Emphasizes what must be done or avoided so that the unit or other property shall not to be damaged.

Notice
Gives recommendations for better handling of the unit during operation or adjustment, as well as for service activities.

The numbers printed in bold in the text (xx) refer to the corresponding position numbers in the illustration in Section 2 & 2.1.

As a result of technical development, the illustrations and descriptions in this instruction manual can deviate in detail from the actual unit delivered.

1.2 Items Supplied

1 SD10 Digital Syringe Dispenser
1 Foot switch
1 User manual
1 Power Supply
1 Syringe Barrel Stand
1 30/55 cc Syringe Air Line Adapter
1 Syringe Test Kit
1.3 For your safety

For safe and successful operation of the unit, read these instructions completely. If the instructions are not observed, the manufacturer can assume no responsibility.

Damage to the power cord or the housing can result in live voltage.

- Check the power cord and the unit before each use. If the power cord or the unit is damaged, do not operate! Replace a damaged power cord with a new one.
- The unit may be opened and repaired only by an authorized Henkel service representative.

Improper handling of Loctite® brand products may be hazardous to one’s health!

- Observe general safety regulations for the handling of chemicals!
- Observe manufacturer’s instructions! Request a safety data sheet for the product used!
- Always wear goggles, when operating with pressurized air!

1.4 Usage

The Loctite® SD10 Digital Syringe Dispenser (1514629) is a self-contained dispenser system and suitable for the precise application of Loctite® brand products at manual workstations such as in workshops, laboratories and industrial installations. It is designed for a small volume applications of Loctite® brand anaerobic, UV curing and gel cyanoacrylate adhesives as well as Loctite® brand chipbonder® adhesives or soldering flux.
2 Description - Typical System Set-Up

Front Panel

Rear Panel

SD10 Digital Syringe Dispenser

For Service, Spare Parts, & Repairs
USA - (1) 860-571-5174
Germany - (49) 89-9268-0
Singapore - (65) 6266-0100
China - (86) 21-2891-8547
Visit: equipment.loctite.com

Label P/N: 988341
2.1 Operating Elements

1. Control panel
2. Adjustable air regulator
3. Digital air output/vacuum display
4. Suck back regulator
5. Air output for syringe air line adapter
6. Air input
7. XS-1, foot switch connector
8. Power switch
9. Power input (24VDC)
10. Foot switch
11. Power supply
12. Syringe air line adapter
13. Syringe end cap
14. Syringe piston
   The syringe piston ensures emptying of the syringe barrel and prevents air from permeating the product as well as preventing the product from running back out of the syringe barrel and into the control unit.
15. Syringe barrel
16. Luer lock tip cap
17. Dispense needle

2.2 Theory of Operation

The Loctite® SD10 Digital Syringe Dispenser (1514629) is connected to an external pneumatic supply. The control unit of the SD10 Digital Syringe Dispenser regulates the dispensing pressure and dispense time in order to dispense a repeatable volume of product. The built-in vacuum regulator prevents dripping of the product during pauses in dispensing.
3 Technical Data

3.1 Energy Requirements

3.1.1 Electrical
- Power supply: 110 – 240 VAC; 50 – 60 Hz
- Power consumption: Approx. 40 W
- Internal control voltages: 5 VDC; 24 VDC

3.1.2 Pneumatics
- Pneumatic supply: min. 2 bar (29 psi); max. 12 bar (174 psi)
- Quality: Filtered 10 μm, oil-free, non-condensing
- If the required quality is not achieved, install a Loctite® brand filter regulator.
- Accessory Order No. 985397
- Range of the Pressure regulator: 0.00 – 7.00 bar (0.00 – 100 psi)
- Pressure indicator: 0.00 – 7.00 bar (0.00 – 100 psi)

3.2 Connections and Dimensions
- Power connection: Cold appliance coupl. IEC 320 acc. to VDE 0625
- Pneumatic hose size: External dia. - 6 mm or 1/4"
- Dimensions W x H x D: 265mm W x 211mm D x 72mm H
  10.4" W x 8.3" D x 2.8" H

3.3 Other Data
- Protection level: IP 33
- Operating temperature: +10 °C to +40 °C (+50 °F to +104 °F)
- Storage temperature: -10 °C to +60 ºC (+14 °F to +140 °F)
- Weight: 3.0 kg (6.6 lbs)
- Continuous sound pressure level: < 65 dB(A)
4 Installations

4.1 Environmental Conditions

- No condensing humidity
- No splashing water

4.2 Placement

When the syringe piston is missing and the syringe is handled in an improper manner, the product can enter and contaminate the dispenser.

- Place the control unit in an elevated position above the syringe!
- Do not hold the syringe (15) in an elevated position above the dispenser or with the tip pointing upward!
- In work pauses, press the hose clamp closed on the syringe air line adapter!
- Hold the syringe correctly for uniform application of the product!
- When setting the vacuum, start with the vacuum in the full off position and increase slowly to ensure product is not sucked back into the unit.

5 Dispensing

5.1 Filling the Syringe

Improper handling of Loctite® brand products may be harmful to one’s health!

- Observe general safety regulations for the handling of chemicals!
- Observe manufacturer’s instructions! Request a material safety data sheet for the product used!
- Close the tip of the syringe with the luer lock tip cap.
- Hold the syringe at an angle to prevent air bubbles during filling.
- Slowly add product into the syringe.
- Insert the syringe piston into the syringe barrel.

Depending on the dispensing task, fill several syringes at the same time.

Store filled syringes with syringe piston, luer lock tip and syringe end caps in place.
5.2 Set Up

5.2.1 Purging Air from the Syringe

To avoid air bubbles during dispensing, the tip of the syringe must be purged of air.

- Hold the syringe over a container since product will flow out!
- Press the power switch to the position I (ON).
- Using the pressure regulator (2), set the dispensing pressure to 0.50 bar (approx. 7.00 psi). The set dispense pressure will show on the digital display.
- Press the button until the display reads MANUAL.
- Press and hold the button (or foot switch) until the product flows free of bubbles from the dispense needle.

If the product drips out of the dispense needle:
- Slowly turn the vacuum regulator (4) counter clockwise until the dripping stops.

Do not continue turning after the dripping has stopped. When air is sucked in, the syringe must again be purged of air and curing of the product can occur! This can also cause the product to be sucked back into the unit and will damage it.

5.2.2 Manual Mode

This mode gives the operator full control of each dispense cycle.

- Press the button until the display reads MANUAL.
- Using the pressure regulator (2), set the dispensing pressure to 0.50 bar (approx. 7 psi).
- Press and hold the button (or foot switch) until the desired dispense quantity is achieved.
If the dispense quantity is achieved too slowly, increase the dispense pressure and check the dispense quantity again. Repeat this sequence until the desired dispense quantity is achieved in an acceptable amount of time.

### 5.2.3 Programs

This mode of operation is used for precise repeatable dispensing.

- Press the button until the LED above PROGRAM is lit.
- Press the button to setup the program number. The number on the display will flash. Press the button and the button to change numbers, press the button to move the cursor.
- Press the button to save the data.

You can set a program number to record dispense and interval time in Timer and Cycle mode. The program number can be 00-39.

For detailed operation please check chapters 5.2.4 and 5.2.5.

### 5.2.4 Timer mode

- Select a program number following the setup in section 5.2.3.
- Press the button until the LED above TIMER is lit.
- Press the button, to set the dispense time, followed by the button and the button to change numbers, and the button to move the cursor.
- Press the button to save the data.
- Press the button or foot switch to dispense.
Using the Teach Mode to set the dispense time.

- Press the \[ \text{MODE} \] button until the LED above TIMERR is lit.
- Press the \[ \text{TEACH} \] button until the light above it flashes.
- Pressure the \[ \text{button or foot switch for the desired amount of time.} \]
- Press the \[ \text{button to save the data.} \]
- Press the \[ \text{button or foot switch to dispense.} \]

5.2.5 Cycle Mode

After following the steps in 5.2.3 to set the dispense time, follow the steps below to set the delay between cycles.

- Press the \[ \text{MODE} \] button until the LED above CYCLE is lit.
- Press the \[ \text{button to setup the interval time. Press the \[ \text{button and the \[ \text{button to change numbers, and the \[ \text{button to move the cursor.} \]
- Press the \[ \text{button to save the setting.} \]
- Or press the \[ \text{button until the light above flashes.} \]
- Press the \[ \text{button or foot switch to set the dispense time.} \]
- Press the \[ \text{button to save the data.} \]
- Press the \[ \text{button or foot switch to dispense. The unit will run at the preset dispense and interval times.} \]
- Press the \[ \text{button or foot switch to stop the cycle.} \]
6 Cares and Maintenance

6.1 Care

- Occasionally the o-ring of the syringe adaptor (12) should be lubricated with silicone grease. This will prolong the life of the o-ring.
- Occasionally the o-ring inside the air output female connector (5), located on the front panel of the SD10, should be lubricated with silicone grease (Loctite 997569). This will prolong life and allow the air line adapter to easily fit into the connector without resistance. This is accomplished by lightly greasing the male plug on the syringe air line adapter (12) and inserting it into the female air output port on the front panel of the SD10.

⚠️ Clean hands after application of grease to assure surfaces to be bonded are clean. Otherwise bonding might fail.

Failure to properly handle cleaning agents may be hazardous to your health!
- Observe general safety regulations for the handling of chemicals!
- Observe manufacturer’s instructions! Request a material safety data sheet for the product used!

Recommended cleaning agents for:
- Anaerobic, UV curing, and Chipbonder® adhesives:
  There are currently no recommended solvents for removing cured Loctite® brand adhesives. Fluid adhesive residues can be removed with various solvents. ACETONE is well suited for this application.
- Cyanoacrylate adhesives:
  The best solvent is ACETONE for both cured and fluid cyanoacrylates.

6.2 Maintenance

The unit requires no special maintenance.
## 7 Troubleshooting

<table>
<thead>
<tr>
<th>Type of malfunction</th>
<th>Possible causes</th>
<th>Correction</th>
</tr>
</thead>
<tbody>
<tr>
<td>The digital display does not light.</td>
<td>– No power voltage present.</td>
<td>Check the power voltage.</td>
</tr>
<tr>
<td></td>
<td>– Power switch (8) is in position O (OFF).</td>
<td>Switch power switch (8) to position I (ON).</td>
</tr>
<tr>
<td></td>
<td>– Power fuse has failed.</td>
<td>Check/replace fuse.</td>
</tr>
<tr>
<td></td>
<td>– Control unit is defective.</td>
<td>Contact Henkel Equipment Service.</td>
</tr>
<tr>
<td>No change in the value on the digital display.</td>
<td>– No air pressure is present.</td>
<td>Check pneumatic supply.</td>
</tr>
<tr>
<td></td>
<td>– Control unit is defective.</td>
<td>Contact Henkel Equipment Service.</td>
</tr>
<tr>
<td>No product, too little or too much product.</td>
<td>– Dispense pressure is not set correctly.</td>
<td>Adjust dispense pressure setting.</td>
</tr>
<tr>
<td></td>
<td>– Pressure hose is not properly connected.</td>
<td>Connect air pressure hose correctly.</td>
</tr>
<tr>
<td></td>
<td>– Syringe (15) is not properly connected.</td>
<td>Attach syringe (15) correctly.</td>
</tr>
<tr>
<td></td>
<td>– Luer lock tip cap (16) is not removed.</td>
<td>Replace Luer lock tip cap (16) with a dispense needle (17).</td>
</tr>
<tr>
<td></td>
<td>– Dispensing needle (17) is clogged, too small or too large.</td>
<td>Replace dispense needle (17).</td>
</tr>
<tr>
<td></td>
<td>– Control unit is defective.</td>
<td>Contact Henkel Equipment Service.</td>
</tr>
<tr>
<td>Product drips.</td>
<td>– Vacuum regulator (4) is set too low.</td>
<td>Turn the vacuum regulator (4) counter clockwise until the dripping stops.</td>
</tr>
<tr>
<td>No start signal.</td>
<td>– Plug on the socket XS1: Start (7) is loose.</td>
<td>Switch the power switch (8) to the position O (OFF). Tighten the screws of the plug. Switch the power switch (8) to the position I (ON).</td>
</tr>
<tr>
<td></td>
<td>– Foot switch (10) is defect.</td>
<td>Replace the Foot switch (10)</td>
</tr>
<tr>
<td></td>
<td>– Control unit is defective.</td>
<td>Contact Henkel Equipment Service.</td>
</tr>
</tbody>
</table>
8 Replacement Parts and Accessories

<table>
<thead>
<tr>
<th>Description</th>
<th>Loctite Item No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>10 ml Clear Syringe Package</td>
<td>97207</td>
</tr>
<tr>
<td>30 ml Clear Syringe Package</td>
<td>97244</td>
</tr>
<tr>
<td>10 ml Air Line Adapters</td>
<td>97208*</td>
</tr>
<tr>
<td>30 ml Air Line Adapters</td>
<td>97245*</td>
</tr>
<tr>
<td>Foot Switch</td>
<td>97201</td>
</tr>
<tr>
<td>Filter Regulator</td>
<td>985397</td>
</tr>
</tbody>
</table>

*see section 6.1 (Care) of manual before inserting replacement air line adapters into the female connector (5) on the front panel of the SD10.
9 Warranty

WARRANTY

Henkel expressly warrants that all products referred to in this Instruction Manual for (1514629) Henkel SD10 Digital Syringe Dispenser (hereafter called "Products") shall be free from defects in materials and workmanship. Liability for Henkel shall be limited, as its option, to replacing those Products which are shown to be defective in either materials or workmanship or to credit 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 in writing within one month after discovery of the defect or after the time the defect should reasonably have been discovered and in any event, within (12) months after the delivery of the Products to the purchaser. This warranty does not apply to perishable items, such as (indicate items: fuses, filters, lights, etc.). 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, the use of products, parts or attachments which are not manufactured by Henkel, no claim shall be allowed.

No Products shall be returned to Henkel for any reason without prior written approval from Henkel. Products shall be returned freight prepaid, in accordance with instructions from Henkel.

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