PRODUCT DESCRIPTION
The Loctite® 50 ml Dual Cartridge Dispenser provides highly accurate control for applying drops or small beads of 2-part adhesives with 1:1, 2:1, or 10:1 mix ratios for both A-System and B-System 50 ml style cartridges. This 50 ml Dual Cartridge Dispenser can be used as a stationary dispenser or can be integrated into any Loctite® Precision Adhesive Dispensing Robot system.

PRODUCT FEATURES
- Interchangeable cartridge pushers with common mounting tooling can accommodate 1:1, 2:1, or 10:1 dual cartridges for both A-System and B-System 50 ml cartridges.
- Independent cartridge pressure and actuation functions to control adhesive flow rate.
- Fluid components designed for MMA and Epoxy adhesives, but can be used with any chemistry.
- Accepts precision anti-drip dispense valve 1444139 (sold separately).
- Easy cartridge change-over.
- Light-weight design; able to be used on any Loctite® Precision Adhesive Dispensing Robot system.
- Dispenses adhesives up to 200,000 cPs viscosity.
- Can be used as a stationary dispenser with the use of a Loctite® Single Function Controller, item 97101

Technical Data
- Dimensions: 11" W x 5" D x 15" H (297 mm x 376 mm x 118 mm)
- Weight: 5.3 lbs. (2.5 kg.)

Loctite® Dual Cartridge Dispensing System Total Solution
The Loctite® 50 ml Dual Cartridge Dispenser when used in conjunction with any Loctite® Precision Adhesive Dispensing Robot system provides a total processing solution for applying small beads or drops. The Dispenser mounts easily to the Robot and can be programmed for any 3-axis application. The Loctite® D-Series Bench-top Robots are available in four different sizes depending on the application requirements. The two tables below will help select the right system and all the related components.
**Loctite® 50ml Dual Cartridge Dispensers**

**Item No. 1444133 & 1444135**

**Step One:** Select the D Series Robot with the dispense area that is appropriate for the application.

<table>
<thead>
<tr>
<th>Dispense Area</th>
<th>Description</th>
<th>Item Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>200x200mm</td>
<td>LOCTITE® 200 D-Series Dispensing Robot 24 VDC</td>
<td>1597107</td>
</tr>
<tr>
<td>300x300mm</td>
<td>LOCTITE® 300 D-Series Dispensing Robot 24 VDC</td>
<td>1452395</td>
</tr>
<tr>
<td>400x400mm</td>
<td>LOCTITE® 400 D-Series Dispensing Robot 24 VDC</td>
<td>1452396</td>
</tr>
<tr>
<td>400x400mm</td>
<td>LOCTITE® 500 D-Series Dispensing Robot 24 VDC</td>
<td>1578317</td>
</tr>
</tbody>
</table>

The Robot accessories that will be needed are common to D Series Robot Systems. They are:
- Loctite® Solenoid Valve Module; item # 988000
- Loctite® Teach Pendant; item # 1328356
- Loctite® Interface cable; item # 1329222
- Note: General Purpose Benchtop Robots are also available.

**Step Two:** Select the Dispenser based on adhesive ratio:

<table>
<thead>
<tr>
<th>Adhesive</th>
<th>Ratio</th>
<th>Cartridge Style</th>
<th>Dispenser</th>
</tr>
</thead>
<tbody>
<tr>
<td>H/HF 8600</td>
<td>2:1</td>
<td>A</td>
<td>1444135</td>
</tr>
<tr>
<td>H 8700</td>
<td>2:1</td>
<td>A</td>
<td>1444135</td>
</tr>
<tr>
<td>H/HF 8000</td>
<td>10:1</td>
<td>B</td>
<td>1444133</td>
</tr>
<tr>
<td>H/HF 8025</td>
<td>10:1</td>
<td>B</td>
<td>1444133</td>
</tr>
<tr>
<td>H 8010</td>
<td>10:1</td>
<td>B</td>
<td>1444133</td>
</tr>
<tr>
<td>H 8500</td>
<td>10:1</td>
<td>B</td>
<td>1444133</td>
</tr>
</tbody>
</table>

This is a small representation of Henkel two part Adhesives. If an adhesive is not shown please contact a local Henkel office to get assistance in selecting the right Dispenser. Cartridge types are subject to change so before ordering a Dispenser, please consult your local Henkel Sales Representative or Distributor.

**Step Three:** Order Loctite® Anti Drip valve # 1444139 (500 pack) or # 1445944 (100 pack).
Step Four: Select the proper static mix nozzle to match the style of the cartridge.

“A-System” Style 1:1 & 2:1 mix ratio
Item # 1334299 (100 pk.)

“B-System” Style
10:1 Mix Ratio - Item # 1329200 (100 pk.)
1:1 & 2:1 Mix Ratio - Item # 1440017 (100 pk.)

Step Five: Select the proper dispense needle tip to meet production requirements.

Note: photo on right shows Anti Drip Valve with ¼” stainless steel dispense tip needle attached.

Order Information:

- Item # 1444133 .... Loctite® 50ml Dual Cartridge Dispenser for 10:1 cartridges.
- Item # 1444135 .... Loctite® 50ml Dual Cartridge Dispenser for 1:1 and 2:1 cartridges.
- Item # 1444139 .... Loctite® Anti Drip Valve (500 pack)
- Item # 1445944 .... Loctite® Anti Drip Valve (100 pack)
Spare Parts

- Item # 1444136 ….Replacement Loctite® Cartridge Pusher Assembly for 10:1 cartridges.
- Item # 1444138 ….Replacement Loctite® Cartridge Pusher Assembly for 1:1 and 2:1 cartridges.
- Item # 1444140 ….Replacement Loctite® Advancing On / Off Air Cylinder
- Item # 1334299 ….Static Mix Nozzle for “A” Style cartridges with 1:1 and 2:1 mix ratio. Sold in (100 pk.)
- Item # 1329200 ….Static Mix Nozzle for “B” Style cartridges with 10:1 mix ratio. Sold in (100 pk.)
- Item # 1440017 ….Static Mix Nozzle for “B” Style cartridges with 1:1 and 2:1 mix ratio. Sold in (100 pk.)
- Dispense Needle Tips ….. Determined by process requirements.

Note
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