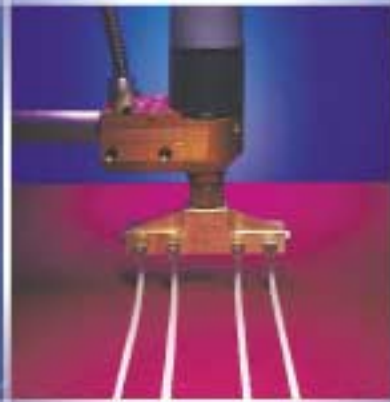


LOCTITE®

Loctite Industrial

Hysol® Hot Melt Adhesives & Equipment



Hot Melt Adhesives & Equipment

Loctite® Hysol® Hot Melt Adhesives and Dispensing Equipment A Complete Line of Hot Melt Solutions

Henkel Loctite has expanded its Loctite® Hysol® Hot Melt offerings to include a complete line of adhesives, hand held dispensers, and a new line of bulk Hot Melt equipment. Hot Melt adhesives offer many benefits - from open times ranging from seconds to minutes, eliminating the need for clamps or fixtures, to long-term durability and excellent resistance to moisture, chemicals, oils, and temperature extremes. Unlike many solvent and water-based adhesives, all Hysol® Hot Melt adhesives are non-toxic and 100% usable, reducing waste disposal and worker safety concerns.

The Right Size and Shape

Hot Melt adhesives are designed to fit commercially available hand held applicators and bulk systems. The various sizes and shapes of Hysol® Hot Melt adhesives are cast or extruded to exacting tolerances for smooth, reliable dispensing. All sizes and shapes of Hysol® Hot Melt formulations are available in bulk configurations for use with the new line of high performance bulk dispensers.

Whatever your application requires, there's a Loctite® Hysol® Hot Melt product to meet your specific performance requirements.



Hot Melt Adhesives

Loctite® Hysol® Hot Melt Adhesives were developed to bond a variety of substrates, including difficult-to-bond plastics. These adhesives can handle today's toughest applications in a broad range of industries. Hysol® Hot Melts are ideal for applications that require high-speed manufacturing, bonding versatility, very large gap filling, fast green strength, and minimal shrinkage. Hysol® products are solvent-free, environmentally friendly materials with no harmful VOCs.



EVA Based Adhesives

1X EVA Hysol®

Medium to fast setting, recommended for bonding paper, wood, fabric, and foam.

3X EVA Hysol®

Formulated for bonding sand molds and other porous substrates.

232 EVA Hysol®

Medium setting adhesive, with an open time of 15 seconds.

236 EVA Hysol®

Clear, toughened, flexible adhesive with superior wetting properties.

1942 EVA Hysol®

Medium setting, general purpose hot melt adhesive. Excellent adhesion to wood and many plastics.

0420 EVA Hysol® SprayPac®

Formulated for spray applications. Has an open time of 2 minutes when sprayed and 45 seconds when bead applied.

0430 EVA Hysol® SprayPac®

Formulated for spray applications. Suitable for bonding expanded polystyrene, polyethylene, and urethane foams. Can be used in applications where solvent-based aerosols are used.

0437 EVA Hysol® SprayPac®

Bulk material formulated to be spray applied to a wide variety of substrates.

0450 EVA Hysol® SprayPac®

Formulated for spray application. Well suited for use on expanded polystyrene or urethane foams.

0452 EVA Hysol® SprayPac®

Bulk material formulated to be spray applied to a wide variety of substrates. Excellent for bonding expanded polystyrene or urethane foams.

CoolMelt EVA Hysol®

Flexible material designed to be applied at low temperatures. Ideal for bonding heat sensitive parts.

QuikPac EVA Hysol®

Fast setting material with a 15 second open time.

SuperPac EVA Hysol®

A medium setting material, it is formulated to bond cardboard and foams.

WaxPac EVA Hysol®

Medium setting flexible material formulated to bond wax-coated substrates and withstand low temperatures.

Reactive Urethane Adhesives

3631 Hysol® Urethane

A toughened, high-strength adhesive for use on plastics. Flexible bond with an open time of 60 seconds.

3632 Hysol® Urethane

A high-strength, impact-resistant adhesive with a long work life of 180 seconds.

Polyolefin Based Adhesives

3650 Hysol® Polyolefin

A general purpose adhesive. Open time of 60-80 seconds.

3651 Hysol® Polyolefin

Ideal for polyethylene and polyolefin plastics. Long open time of 80-100 seconds.

Polyamide Based Adhesives

7460 Hysol® SprayPac® Polyamide

High heat resistance and fast set time. Suitable for bonding foams, fabric, and wood. Available in bead or spray.

7500 Hysol® SprayPac® Polyamide

Formulated for long open time and high output, for bonding surfaces up to 15 square feet. Available in bead or spray.

7809FR Hysol® Polyamide

Polyamide modified with fire retardant materials. It has a UL 94V-O flammability rating.

7811 Hysol® Polyamide

Exceptional high temperature resistance and impact at low temperatures.

7901 Hysol® Polyamide

Low viscosity polyamide used extensively for potting and encapsulating.

PROPERTIES CHART

PRODUCT	Item Number	Container	Color	Viscosity cP at Temperature °F	Tensile Strength (psi)	Open Time	Temperature Resistance ASTM D4498	% Elongation	Hardness (Shore A)	Key Specifications
EVA'S	1X	83357 Sample 5 lb. pellets 83358 40 lb. carton pellets 83359 Maxistick sample 7 oz. bag 83360 Maxistick 35 lb. carton 83362 PT stick 35 lb. carton 83363 Ministick 35 lb. carton 83364 Superstick sample 10" 5 oz. bag 83365 Superstick 10" 25 lb. carton 83366 Superstick 4" 25 lb. carton 83367 Polysht 12 oz. bag 83368 Polysht 35 lb. carton	Light yellow	2,000 350°	370	15 seconds	150°F	90	82	FDA CFR175.105
	3X	83369 Polysht sample 12 oz. bag 83370 Polysht 35 lb. carton	Amber	4,000 350°	580	60 seconds	135°F	300	86	FDA CFR175.105
	342	83255 Polysht 35 lb. carton	Cream	8,250 350°	800	5 seconds	166°F	60	95	FDA CFR175.105
	740	83260 Superstick sample 10" 5 oz. bag 83261 Superstick 10" 25 lb. carton 83262 Superstick 4" 25 lb. carton 83263 Polysht sample 12 oz. bag 83264 Polysht 35 lb. carton	Light yellow	9,000 350°	750	10 seconds	168°F	75	94	FDA CFR175.105
	O420 SprayPac®	83346 12 oz. sample bag 83347 Polysht 35 lb. carton	Cream	10,500 350°	-	2 minutes sprayed	153°F	-	-	-
	O430 SprayPac®	83348 Polysht 12 oz. sample bag 83349 Polysht 35 lb. carton	Cream	5,000 350°	280	3.5 minutes sprayed	170°F	-	75	-
	O430 SprayPac® Red	83350 Polysht 12 oz. sample bag 83351 Polysht 35 lb. carton	Pink	5,000 350°	280	3.5 minutes sprayed	170°F	-	75	-
	O437	83352 36 lb. carton bricks	Cream	5,200 350°	270	3.5 minutes sprayed	170°F	-	75	-
	O450 SprayPac®	83353 Polysht 12 oz. sample bag 83354 Polysht 35 lb. carton	Natural	4,500 350°	-	5-8 minutes	156°F	-	-	-
	O450 SprayPac® Red	83355 Polysht 12 oz. sample bag 83356 Polysht 35 lb. carton	Pink	4,500 350°	-	5-8 minutes	156°F	-	-	-
	O452	83257 21 lb. pucks 83677 36 lb. bricks	Natural	4,300 350°	-	5-8 minutes	156°F	-	-	-
	1942	83266 5 lb. sample bag pellets 83267 40 lb. carton pellets 83268 Maxistick sample 7 oz. bag 83269 Maxistick 35 lb. carton 83271 PT stick 35 lb. carton 83272 Mini stick 35 lb. carton 83273 Superstick sample 10" 5 oz. bag 83274 Superstick 10" 25 lb. carton 83275 Superstick 4" 25 lb. carton 83276 Polysht sample 12 oz. bag 83277 Polysht 35 lb. carton	Tan	5,000 350°	250	30 seconds	142°F	500	52	FDA CFR175.105
	6002	83280 PT stick sample 8 oz. bag 83283 Superstick 10" 25 lb. carton 83285 Polysht 35 lb. carton	Amber	3,500 350°	700	10 seconds	150°F	200	96	FDA CFR175.105
	CoolMelt	83393 CoolMelt maxistick sample 7 oz. bag 83394 CoolMelt maxistick 35 lb. carton	Off white	7,200 250°	195	15 seconds	140°F	800	-	FDA CFR175.105
	SuperPac	83402 Maxistick sample 7 oz. bag 83403 Maxistick 35 lb. carton 83404 Polysht sample 12 oz. bag 83405 Polysht 35 lb. carton	Light yellow	5,750 350°	280	30 seconds	144°F	200	-	FDA CFR175.105
	QuikPac	83395 QuikPak sample pellets 5 lb. bag 83397 Maxistick sample 7 oz. bag 83398 Maxistick 35 lb. carton 83399 Polysht sample 12 oz. bag 83400 Polysht 35 lb. carton	Light yellow	4,645 350°	-	15 seconds	174°F	-	-	FDA CFR175.105
	WaxPac	83408 Maxistick sample 7 oz. bag 83409 Maxistick 35 lb. carton 83410 Polysht sample 12 oz. bag 83411 Polysht 35 lb. carton	Light yellow	2,700 350°	730	30 seconds	150°F	-	-	FDA CFR175.105

PROPERTIES CHART

PRODUCT		Item Number	Container	Color	Viscosity cP at Temperature °F	Tensile Strength (psi)	Open Time	Temperature Resistance ASTM D4498	% Elongation	Hardness (Shore A)	Key Specifications
EVA'S	232	83237 83239 83241 83244 83245 83246 83247	5 lb. sample bag pellets 40 lb. carton pellets Maxistick 35 lb. carton Superstick 10" sample 5 oz. bag Superstick 10" 25 lb. carton Polyshot sample 12 oz. bag Polyshot 35 lb. carton	Clear	11,000 350°	-	15 seconds	153°F	-	88	FDA CFR175.105
	236	83251 83252	Superstick sample 10" 5 oz. bag Superstick 10" 25 lb. carton	Clear	8,500 350°	213	25 seconds	140°F	450	-	FDA CFR175.105
	740LV	83373 83374	40 lb. carton pellets Polyshot 35 lb. carton	Light yellow	3,500 350°	700	10 seconds	215°F	80	92	FDA CFR175.105
URETHANES	3631	31291 31279	300 ml cartridge 5 gallon pail	Off white	12,000 250°	1,800	60 seconds	*250°F	940	91	-
	3632	31289 31278	300 ml cartridge 5 gallon pail	Off white	15,000 250°	650	180 seconds	*250°F	1,000	85	-
POLYOLEFINS	3650	31297 31302	20 kg pellets 10 kg pellets	Light beige	2,900 355°	305	60-80 seconds	*176°F	43	87	-
	3651	31303	12 kg squares	Beige	10,000 355°	334	80-100 seconds	*266°F	790	55	-
POLYAMIDES	7460 SprayPac®	83308 83309 83369	Polyshot 25 lb. pail Polyshot 200 lb. drum Sample 13 oz. bag	Pale/ Amber	6,700 350°	-	30 seconds	210°F	-	-	None
	7500 SprayPac®	83312 83313	Polyshot sample 13 oz. bag Polyshot 25 lb. pail	Pale/ Amber	1,900 350°	-	2 minutes	200°F	-	-	None
	7803	83323	Polyshot 25 lb. pail	Amber	1,450 350°	380	20 seconds	248°F	-	-	None
	7804	83324 83325 83326 83327 83328 83329 83330	330 lb. drum pellets 5 lb. bag sample pellets 40 lb. carton pellets Superstick sample 10" 5 oz. bag Superstick 10" 32 lb. carton Polyshot sample 13 oz. bag Polyshot 25 lb. pail	Amber	7,500 350°	340	35 seconds	220°F	900	75	None
	7804FRM-HV	83381 83382 83383 83384 83386	5 lb. bag pellets 40 lb. carton pellets Superstick 10" sample 5 oz. bag Superstick 10" 30 lb. pail Polyshot sample 13 oz. bag	Off white	6,000 350°	2454	35 seconds	220°F	300	-	UL 94V-O
	7809FR	83388 83389 83390 83391 83675 83676	5 lb. bag sample pellets 40 lb. carton pellets Superstick sample 10" 13 oz. bag Polyshot 13 oz. bag Superstick 10" 32 lb. carton Polyshot 25 lb. pail	Amber	7,000 350°	363	35 seconds	240°F	373	85	UL 94V-O
	7810	83335 83336	Polyshot sample 13 oz. bag Polyshot 25 lb. pail	Amber	3,400 350°	300	30 seconds	215°F	800	-	None
	7811	83337 83338 83339 83340	5 lb. bag sample pellets 40 lb. carton pellets Polyshot sample 13 oz. bag Polyshot 25 lb. pail	Amber	6,400 400°	400	35 seconds	266°F	1,200	80	None
	7901	83341 83342 83343 83344	5 lb. bag sample pellets 40 lb. carton pellets Polyshot sample 13 oz. bag Polyshot 25 lb. pail	Amber	750 400°	260	35 seconds	300°F	80	95	None

*Creep Test.

HOT MELT STICK REFERENCE CHART

Description	Diameter	Length/Weight	Loctite® Hand Held Applicators by Item No.
Superstick	.50"	4"/11 g, 10"/27 g	98030, 98031, 98032, 98029
Maxistick	.75"	2.4"/14 g	98033, 98034
Polyshot	1.75"	1.5"/56 g	98035, 98036, 98040, 98037, 98041



Hand Held Applicators

Loctite® Hysol® Applicators are state of the art dispensing units designed for the application of hot melt adhesives. These units combine ergonomics, user-friendly design, and reliability. Selection of a Loctite® Hot Melt Applicator should be based on the type of hot melt being used, stick diameter, and process requirements.

98011 Loctite® Reactive Urethane Cartridge Dispenser

The Loctite® Reactive Urethane Cartridge Dispenser for 300 ml cartridges is used to manually dispense dots or beads of Hysol® Reactive Polyurethane Hot Melts.

With a fixed dispense temperature set at 250°F, this system includes a pressure-regulating stand with optional vertical application stand and foot switch for hands-free application. Using a cartridge keeps the product isolated from the reservoir to eliminate contamination. To minimize cartridge change over times, the Loctite® 98012 Cartridge Pre-heater is recommended. See the Hand Held Nozzles & Accessories Selector Chart.



98029 Hysol® 050-LITE Hot Melt Applicator

The Loctite® Hysol® 050-LITE hot melt applicator is a hand-held applicator used for dispensing 0.50" diameter EVA sticks. The

operating temperature of the unit is set at 200°C. This applicator weighs less than a pound, and is ideal for hobby, craft, and light duty industrial applications. A wire stand and nozzle are included.



98030/98031 Hysol® 050/Hysol 050-HT Hot Melt Applicator

The Loctite® Hysol® 050 and 050-HT Hot Melt Applicators are industrial grade, hand-held applicators used for dispensing 0.50" diameter sticks. The Hysol® 050 is set at 195°C for dispensing EVA hot melts and the Hysol® 050-HT is set at 215°C for dispensing polyamide hot melts.



98032 Hysol® 050-Gas Hot Melt Applicator

The Loctite® Hysol® 050-GAS Hot Melt Applicator is an industrial grade, hand-held, cordless system used for dispensing 0.50" diameter EVA sticks. There is no electrical utility requirement, as butane gas is used as the source of energy. The operating temperature of the unit is set at 195°C. Designed for use where the application of 0.50" diameter EVA hot melts is desired, this dispenser is ideally suited for outdoor and indoor applications, where access to electrical power is not practical.



98033/98034 Hysol® 075/Hysol® 075-LT Hot Melt Applicator

The Loctite® Hysol® 075 and 075-LT Hot Melt Applicators are industrial grade, hand-held applicators, and are the industry's price leaders where high volumes of 0.75" diameter hot melts are required. The Hysol® 075 is set at 182°C for dispensing standard EVA hot melts. The Hysol® 075-LT is set at 121°C for dispensing Coolmelt EVA sticks, to reduce the risk of operator burns over conventional applicators. It is ideally suited for applications requiring rapid dispensing where frequent re-loading is undesirable.



98035 Hysol® 175 Hot Melt Applicator

The Loctite® Hysol® 175 Hot Melt Applicator is an industrial grade, hand-held applicator. This applicator is designed for use where medium-to-high volume, manual application of Loctite® Hysol® 1.75" diameter EVA and Polyamide hot melts are desired. The applicator includes a plug-in thermostat at 195°C for EVA hot melts and a plug-in thermostat at 215°C for polyamide hot melts. It is ideally suited for applications requiring rapid dispensing where frequent re-loading is undesirable.



98036/98040 Hysol® 175-AIR/Hysol® 175-AIR-HT Hot Melt Applicators

The Loctite® Hysol® 175-AIR and 175-AIR-HT Hot Melt Applicators are industrial grade, hand-held pneumatic applicators used for dispensing Loctite® Hysol® 1.75" diameter EVA and Polyamide hot melt sticks, where medium-to-high volume, pneumatically powered applications are desired. The Hysol® 175-AIR is set at 195°C for dispensing EVA hot melts and the Hysol® 175-AIR-HT is set at 215°C for dispensing polyamide hot melts. They are ideally suited for applications requiring rapid hand held dispensing where frequent re-loading is undesirable.



98037/98041 Hysol® 175 SPRAY/Hysol® 175 SPRAY-HT Applicators

The Loctite® Hysol® 175-SPRAY and 175-SPRAY-HT Hot Melt Applicators are patented, industrial grade, hand-held pneumatic applicators used for spraying 1.75" diameter EVA and Polyamide spray sticks. These applicators are designed to rapidly cover a large area with a hot melt adhesive. They are commonly used to replace duct tape, staples, beads of adhesives, and other fastening techniques for large areas. The Hysol® 175-SPRAY is set at 180°C for dispensing EVA hot melts and the Hysol® 175-SPRAY-HT is set at 195°C for dispensing polyamide hot melts.



98038 Hysol® Wheelcoater

The Hysol® Wheelcoater is a bulk hot melt adhesive transfer machine used to apply a continuous film of hot melt adhesive to the surface of a part. The Wheelcoater is ideally suited for any application where a large, flat surface requires the rapid application of a hot melt adhesive. Typical examples are protective foam inserts for cardboard boxes and other packaging, wood/plastic panels, etc.



98042 Hot Melt Bench Mount Kit 98043 Hot Melt Pneumatic Timer

The Hot Melt Bench Mount Kit is used for converting the Hysol® 175-AIR or 175-AIR-HT applicator into a hands-free, bench-top dispenser. The Hot Melt Pneumatic Timer is used in conjunction with the Hot Melt Bench Mount Kit and Hysol® 175-AIR/AIR-HT applicator for "controlled" dot dispensing. These units are used for any hot melt application where holding an applicator is not desirable. This is especially relevant to applications where the part itself must be moved. Typical applications include: cardboard boxes and related packaging materials, wood and plastic panels, furniture components, etc.



Hand Held Applicators












	Hysol® Reactive Urethane Cartridge Dispenser	Hysol® 050-LITE	Hysol® 050/ Hysol® 050-HT	Hysol® 050-GAS	Hysol® 075/ Hysol® 075-LT	Hysol® 175
						
Item #	98011	98029	98030 / 98031	98032	98033/98034	98035
Page Ref.	19	19	20	20	21	21
Nominal Stick Diameter	N/A	0.50" (Supersticks)	0.50" (Supersticks)	0.50" (Supersticks)	0.75" (Maxisticks)	1.75" (Polyshot sticks)
Dispense Melt Rate (lbs./hr.)	>3	1.0	3.0 / 4.0	3.0	9.0/5.0	6.6
Applicator Adh. Capacity (lbs.)	300 ml	0.04	0.04	0.04	0.12	0.125
Heat Source	Electric	Electric	Electric	Butane	Electric	Electric
Dispense Power	Air	Manual	Manual	Manual	Manual	Manual
Dispense Temp. (°C)	121	200	195/215	195	182/121	195 & 215*
Hot Melt Chemistry	Reactive Urethane	EVA/ Polyolefin	EVA/ Polyamide/ Polyolefin	EVA/ Polyolefin	EVA/ EVA CoolMelt	EVA & Polyamide

	Hysol® 175-AIR	Hysol® 175-AIR HT	Hysol® 175-SPRAY	Hysol® 175-SPRAY HT	Hysol® Wheelcoater	Bench Mount Kit & Pneumatic Timer
						
Item #	98036	98040	98037	98041	98038	98042/98043
Page Ref.	22	22	23	23	24	24
Nominal Stick Diameter	1.75" (Polyshot sticks)	1.75" (Polyshot sticks)	1.75" (SprayPac® Polyshot sticks)	1.75" (SprayPac® Polyshot sticks)	Bulk and Stick Form	N/A
Dispense Melt Rate (lbs./hr.)	8.8	8.8	8.0	8.0	N/A	N/A
Applicator Adh. Capacity (lbs.)	0.125	0.125	0.125	0.125	3	N/A
Heat Source	Electric	Electric	Electric	Electric	Electric	N/A
Dispense Power	Air	Air	Air	Air	Electric	N/A
Dispense Temp. (°C)	195	215	180	195	190	N/A
Hot Melt Chemistry	EVA	Polyamide	EVA Spray Adhesive	Polyamide Spray Adhesive	EVA Bulk/Sticks	EVA/ Polyamide

*The Hysol® 175 applicator (manual electric) is supplied with both temperature modules.

Hand Held Nozzles & Accessories Selector Chart

Product	Item #	Description	Used With
	985225	Standard 1-Hole Nozzle, 0.08" Diameter Cone Tip, 5 pk	98030, 98031, 98032, 98033, 98034, 98035, 98036, 98040
	985110	2-Hole Nozzle, .06" dia. x .39" spacing	98030, 98031, 98032, 98033, 98034, 98035, 98036, 98040
	985111	3-Hole Nozzle, .06" dia. x .20" spacing	98030, 98031, 98032, 98033, 98034, 98035, 98036, 98040
	985112	Diagonal Extension Nozzle, Tip = .14" dia. x 1.23" long	98030, 98031, 98032, 98033, 98034, 98035, 98036, 98040
	985113	Needle Extension Nozzle, Tip = .05" dia. x 1.32" long	98030, 98031, 98032, 98033, 98034, 98035, 98036, 98040
	985114	Spreader Extension Nozzle, Tip = (.09" x .25") sq. x 1.32" long	98030, 98031, 98032, 98033, 98034, 98035, 98036, 98040
	985115	L-Nozzle, .06" dia. x .85" offset	98033, 98034, 98035, 98036, 98040
	985116	T-Nozzle, .06" dia. x 1.5" spacing	98033, 98034, 98035, 98036, 98040
	985088	Standard Adapter/Check Valve for Nozzles	98030, 98031, 98032, 98035, 98036, 98040
	ANZ023N01	Standard Adapter/Check Valve/Jam Nut for Nozzles	98033, 98034
	985216	Ultra Wide Spray Nozzle, 1.5" - 6.0" dia. pattern	98037, 98041
	985211	Narrow Spray Nozzle, .05" - 1.25" dia. pattern	98037, 98041
	985122	Standard Wide Spray Nozzle, 1.25" - 5.0" dia. pattern	98037, 98041
	984999	Standard 1-Hole Nozzle, with Integral Check Valve, Tip = .10" dia. x .16" long	98029
	985002	Pencil Point Nozzle, with Integral Check Valve, Tip = .08" dia. x .24" long	98029
	985003	Precision Nozzle, with Integral Check Valve, Tip = .05" dia. x .20" long	98029
	985004	Extension Nozzle, with Integral Check Valve, Tip = .10" dia. x .50" long	98029
	985001	Spreader Nozzle, with Integral Check Valve, Tip = (0.08" x 0.25") sq. x 0.47" long	98029

Product	Item #	Description	Used With
	98012	Cartridge Pre-heater, holds (2) 300 ml cartridges	98011
	984261	Standard adapter for 300 ml Cartridges	98011
	984262	Standard 1-Hole Nozzle, 0.098" dia. cone tip, with integral check valve (Includes protective cap)	98011
	984272	Injection Needle Nozzle, with Integral Check Valve, Tip = .059" dia. x .197" long	98011
	984263	Adapter/Check Valve for Specialty Nozzles	98011
	984264	Needle Jet Nozzle, Tip = .051" dia. x 1.26" long (Requires 984263 adapter)	98011
	984265	Diagonal Extension Nozzle, Tip = .123" dia. x 1.276" long (Requires 984263 adapter)	98011
	984266	Flat Spreader Nozzle, Tip = (.084" x .177") sq. x 1.237 long (Requires 984263 adapter)	98011
	984267	2-Hole Nozzle, .06" dia. x .39" spacing (Requires 984263 adapter)	98011
	984268	3-Hole Nozzle, .06" dia. x .20" spacing (Requires 984263 adapter)	98011
	985243	Tool Hanger/Balancer	All Hot Melt Hand Held Applicators
	985397	Air Line Filter, Regulator, Gauge 0-150 psi	All Pneumatic Applicators
	985087	Heavy Duty Bench Top Metal Stand	98030, 98031, 98032, 98035, 98036, 98037, 98040, 98041

For custom hot melt dispense nozzles, contact the Loctite Special Equipment Group at 1-800-LOCTITE (562-8483).

Bulk Hot Melt Systems

Henkel Loctite introduces a line of Hysol® Bulk Hot Melt Dispensers offering high performance control and reliability for all of your hot melt dispensing needs. You can rely on Henkel Loctite to supply your performance hot melt adhesives as well as an array of standard high volume hot melt dispensing equipment. Henkel Loctite offers true one stop shopping for your complete adhesive solution.

All of the required system options are outlined in the following pages and are readily available for integration into your specific application. Tested and proven with all of the Loctite® hot melt products, these units offer complete customization to meet your specific process needs.

These units offer the following features:

- Compatible with all Loctite® hot melt products
- High volume extrusion, spray, or swirl options in all tank sizes
- Can be integrated with optional stand alone controllers or programmable logic controllers for various levels of automation and high process control
- Complete line of accessories

Tank Pump System available in 12, 14, or 34 lb. capacity. Available in 115VAC or 230VAC

Hand held and mountable applicators for process integration flexibility

Multiple zone temperature control to optimize product stability AND processibility

Automated or manual applicators available for extrusion, spray, or swirl pattern

Multiple dispense ports

PTFE lined stainless steel reinforced braided hoses, available in 4' through 24' lengths



The Loctite® Hysol® Bulk Hot Melt Systems come in three compact and economical sizes: 12, 14 and 34 pound tank capacity (expandable to up to 78 pounds with optional tank hopper). All units feature internal system diagnostics, which monitor the temperatures and system settings. These diagnostics automatically control the distribution of power, ensuring that the system reaches application temperature efficiently. This protects the pump from premature operation, resulting in safe, fast, and reliable operation for your production requirements.

Hysol® Bulk Hot Melt Systems accommodate all Loctite® Hysol® EVA, Polyamide and Polyolefin hot melt adhesives. All units share these performance features:

- PTFE coated reservoir reduces tank residue
- High surface area melt grid is integrated with tank walls to ensure fast and even heating, eliminating “hotspots” within the tank
- All system settings and system diagnostics are visible on front display for “at a glance” system status
- Gear pump for the most consistent product delivery pressure
- All systems are CE Certified



Bulk-12 System 98131/98132



- Single hose, applicator design
- Pressure adjustable, electric AC gear pump
- Three controllable temperature zones over seven fine tuned ranges
- Analog controls with high visibility LED indicator for temperature and diagnostic status
- Modular connections for hoses, controllers, timers, and other optional interfaces
- Integrated circuit breaker and safety features
- 115 and 230 VAC

Bulk-14 System 98133/98134



- Capable of two independent and fully customizable dispense lines
- Fully digital two-channel control display of temperature set points and diagnostic functions
- Variable speed DC gear pump with integrated flow control
- Five controllable temperature zones over six individual ranges for fine tuned temperature control
- User selectable standby mode automatically protects against overheating product
- 115 and 230 VAC

Bulk-34 System 98135



- Capable of up to four independent and fully customizable dispense lines
- Fully digital four-channel control display of temperature set points and diagnostic functions
- Variable speed DC gear pump with integrated flow control
- Nine controllable temperature zones over six individual ranges for fine tuned temperature control
- User selectable standby mode automatically protects against overheating product
- 230 VAC only



Hot Melt System selection begins with considering these important factors:

Q. At what rate do you need to deliver material?

A. Larger units provide higher dispense rates.

Q. How many dispense points?

A. Larger units can accommodate up to four dispense hoses.

Q. How long are the hoses for your application?

A. Higher powered units can accommodate longer hose lengths.

Once these are identified for your application, consult the chart below for the specific performance features for each bulk melt unit.

Hysol® Bulk-12 System
115 VAC

Hysol® Bulk-12 System
230 VAC

Hysol® Bulk-14 System
115 VAC

Hysol® Bulk-14 System
230 VAC

Hysol® Bulk-34 System
230 VAC

					
Item Number	98131	98132	98133	98134	98135
Max Dispense Rate #/hr (kg/hr)	28 (12.7)	28 (12.7)	70 (31.7)	70 (31.7)	100 (45.3)
Max Number of Hoses	1	1	2	2	4
Max Length of all Hoses	16'	24'	32'	48'	72'
Standard Tank Capacity lbs. (kg)	12 (5.4)	12 (5.4)	14 (6.4)	14 (6.4)	34 (15.4)
Optional Expanded Capacity lbs. (kg) with Hopper Upgrade	–	–	40 (18.2)	40 (18.2)	78 (35.4)
Max Melt Rate #/hr (kg/hr)	12 (5.4)	12 (5.4)	28 (12.7)	28 (12.7)	75 (34.1)
Max Temp Setting for Tank °F (°C)	395 (202)	395 (202)	395 (202)	395 (202)	395 (202)
Max Dispense Temperature °F (°C)	410 (210)	410 (210)	425 (218)	425 (218)	425 (218)
Temperature Control Zones	3	3	5	5	9
Controls	analog	analog	digital	digital	digital
Available Dispense Patterns	Extrude Swirl Spray Fan Spray Cone Spray	Extrude Swirl Spray Fan Spray Cone Spray	Extrude Swirl Spray Fan Spray Cone Spray	Extrude Swirl Spray Fan Spray Cone Spray	Extrude Swirl Spray Fan Spray Cone Spray
Compatible Loctite® Hysol Adhesives	EVA, Polyamide, Polyolefin	EVA, Polyamide, Polyolefin	EVA, Polyamide, Polyolefin	EVA, Polyamide, Polyolefin	EVA, Polyamide, Polyolefin
Pump Pressure	0-300 psi	0-300 psi	0-300 psi	0-300 psi	0-300 psi
Dimensions, inch (cm) L x W x H (with open lid)	15.5 x 10.5 x 20 (40 x 27 x 50)	15.5 x 10.5 x 20 (40 x 27 x 50)	20.1 x 12.1 x 23 (51.25 x 31x 58.5)	20.1 x 12.1 x 23 (51.25 x 31x 58.5)	22 x 14.25 x 27.5 (56 x 36.25 x 70)
Weight Empty, lbs. (kg)	41 (18.6)	41 (18.6)	51 (23.2)	51 (23.2)	86 (39.0)
System Power Consumption (Watts)	1700	2780	2220	3860	6600
Melt Tank Power Consumption (Watts)	900	1700	900	1700	3400

Bulk System Applicators

In any adhesive application, the accuracy of your dispense equipment can define the level of success of the process. Henkel Loctite offers three accurate and convenient styles of dispense heads to suit any process requirement. Whichever dispense head you choose for your application, it must match the voltage of the melt unit. The 2-hand and mounted styles also come in multiple coil voltages (24 VDC, 115 VAC, and 230 VAC) to match external control systems if employed.



- 1) Hysol® Hand Held Applicator
 - Convenient, durable, fully insulated, and customizable
 - Available in top or bottom inlet applicators
- 2) Hysol® Mounted Applicator (for automatic or fixed position dispense)
 - Excellent design for automated applications
 - Electrically controlled
 - Compact design is easily mounted to a robot or incorporated into a workcell or fixture
- 3) Hysol® 2-Hand Applicator
 - Electrically controlled for precision dispense
 - Vertical design allows direct positioning over the part


	Description	Item Number	Compatible with these Melt Units	Melt Unit Voltage	Control Coil Voltage
	Hysol® Hand Held Bottom Inlet Applicator	98138	98131, 98133	115 VAC	-
		98139	98132, 98134, 98135	230 VAC	-
	Hysol® Hand Held Top Inlet Applicator	98136	98131, 98133	115 VAC	-
		98137	98132, 98134, 98135	230 VAC	-
	Hysol® Mounted Applicator	98146	98131, 98133	115 VAC	24 VDC
		98147	98131, 98133	115 VAC	115 VAC
		98145	98132, 98134, 98135	230 VAC	24 VDC
		98149	98132, 98134, 98135	230 VAC	115 VAC
		98148	98132, 98134, 98135	230 VAC	230 VAC
	Hysol® 2-Hand Applicator*	98143	98131, 98133	115 VAC	24 VDC
		98140	98131, 98133	115 VAC	115 VAC
		98144	98132, 98134, 98135	230 VAC	24 VDC
		98142	98132, 98134, 98135	230 VAC	115 VAC
		98141	98132, 98134, 98135	230 VAC	230 VAC

* All of the Hysol 2-Hand Applicators require a separate applicator control cord and either an extrude or spray control module. Select between single button (only requires one hand to actuate) or two button (requires two hands to actuate) to control the unit.

2-Hand Applicator Cord, 1 Switch	986884
2-Hand Applicator Cord, 2 Switch	986885

Extrusion Hoses


Choose between 115 and 230 VAC to match your melt unit, then select the required length of hose.

		4 foot	6 foot	8 foot	10 foot	12 foot	16 foot	18 foot	24 foot
	115 VAC	986337	986339	986341	986343	986345	986347	986349*	986351*
	230 VAC	986338	986340	986342	986344	986346	986348	986350	986352

*Not available for Bulk-12 115 VAC System (98131).


Extrusion Controller

For 2-Hand Applicator only. This unit allows the integration of the melt tank pump function and 2-Hand Applicator activation in a single control unit. Choose from 115 and 230 VAC to match your melt unit.

	115 VAC	986886
	230 VAC	987525

Spray Hoses

Choose between 115 and 230 VAC to match your melt unit, then select the required length of hose.


		4 foot	6 foot	8 foot	10 foot	12 foot	16 foot	18 foot	24 foot
	115 VAC	986353	986355	986357	986359	986361	986363	986365*	986367*
	230 VAC	986354	986356	986358	986360	986362	986364	986366	986368

*Not available for Bulk-12 115 VAC System (98131).


Spray Controllers

Hysol® controllers utilize the latest in microprocessor technology to handle a multitude of adhesive patterns. A controller and appropriate nozzle are required for spray or swirl dispensing. Refer to the accessories page for a complete line of nozzle assemblies to meet your dispensing requirements.

Spray Controller

	115 VAC	98161
	230 VAC	98162

2-Hand Applicator Spray Controller

	115 VAC	986887
	230 VAC	987526

Timers and Output Cords

Loctite® Hysol® Timers provide timed dispense control for all Loctite® Hysol® automatic bulk hot melt systems. Timers can be used in either 115 or 230 VAC systems.

Two Event Timer 98158 Four Event Timer 98159

The Two and Four Event Timers contain independently selectable output channels that control 24 VDC or AC line voltage applicators. They feature separate high and low speed ranges to control delay and length of pattern.

The Four Event Timer has an added "stitch" mode pattern application. These modular units can be used with foot switch, proximity or optical sensors.



Timer Output Cord Selection*

Two or Four Event Timer	Bulk-12 System	Bulk-14 System	Bulk-34 System
With 24 VDC Output	986890	986743	986747
With Line Voltage Output	986744	986745	986746

*Output voltage cord selection is determined by the applicator control coil voltage selected.

Bulk System Accessories Selector Chart



Item #	Product
986634	Bulk-14 Hopper Upgrade to 40# Capacity
986635	Bulk-34 Hopper Upgrade to 78# Capacity
986636	Bulk Units Floor Stand
986331	Universal Mount Bracket Kit
986693	Feed Line Adapter, 45 Degree
986694	Feed Line Adapter, 90 Degree
986637	Hose Cradle
986638	Tension Balancer
986639	Hose Cradle & Tension Balancer



Item #	Product
986723	Proximity Sensor Assembly
986724	Optical Sensor Assembly
986725	Sensor Cord Extension, 10 Feet
98160	Foot Switch Assembly
986891	Bulk-12/14 External PLC Interface Cable
986892	Bulk-34 External PLC Interface Cable
984363	Bulk-12 Applicator hanger arm kit
984347	Bulk-14 & 34 Applicator hanger arm kit
987834	Bulk-14 Dual External PLC Interface Cable

	Item #	Description
	986369	Extrusion Nozzle 1/2", 0.020 Dia.
	986373	Extrusion Nozzle 1/2", 0.030 Dia.
	986377	Extrusion Nozzle 1/2", 0.040 Dia.
	986381	Extrusion Nozzle 1/2", 0.050 Dia.
	986385	Extrusion Nozzle 1/2", 0.060 Dia.
	986389	Extrusion Nozzle 1/2", 0.070 Dia.
	986393	Extrusion Nozzle 1/2", 0.080 Dia.
	986370	Extrusion Nozzle 1", 0.020 Dia.
	986374	Extrusion Nozzle 1", 0.030 Dia.
	986378	Extrusion Nozzle 1", 0.040 Dia.
	986382	Extrusion Nozzle 1", 0.050 Dia.
	986386	Extrusion Nozzle 1", 0.060 Dia.
	986390	Extrusion Nozzle 1", 0.070 Dia.
	986394	Extrusion Nozzle 1", 0.080 Dia.
	986398	Extrusion Nozzle 1", 0.090 Dia.
	986371	Extrusion Nozzle 2", 0.020 Dia.
	986375	Extrusion Nozzle 2", 0.030 Dia.
	986379	Extrusion Nozzle 2", 0.040 Dia.
	986383	Extrusion Nozzle 2", 0.050 Dia.
	986387	Extrusion Nozzle 2", 0.060 Dia.
	986391	Extrusion Nozzle 2", 0.070 Dia.
	986395	Extrusion Nozzle 2", 0.080 Dia.
	986399	Extrusion Nozzle 2", 0.090 Dia.
	986372	Extrusion Nozzle 3", 0.020 Dia.
	986376	Extrusion Nozzle 3", 0.030 Dia.
	986380	Extrusion Nozzle 3", 0.040 Dia.
	986384	Extrusion Nozzle 3", 0.050 Dia.
	986388	Extrusion Nozzle 3", 0.060 Dia.
	986392	Extrusion Nozzle 3", 0.070 Dia.
	986396	Extrusion Nozzle 3", 0.080 Dia.
	986400	Extrusion Nozzle 3", 0.090 Dia.
	986695	Extrusion Button Nozzle 0.012 Dia.
	986696	Extrusion Button Nozzle 0.015 Dia.
	986697	Extrusion Button Nozzle 0.025 Dia.
	986698	Extrusion Button Nozzle 0.030 Dia.
986699	Extrusion Button Nozzle 0.040 Dia.	
986700	Extrusion Button Nozzle 0.050 Dia.	
986701	Extrusion Button Nozzle 0.060 Dia.	
986702	Extrusion Button Nozzle 0.070 Dia.	
986703	Extrusion Button Nozzle 0.080 Dia.	
986704	Extrusion Button Nozzle 0.090 Dia.	

	Item #	Description
	986888	Swirl Sub Assembly
	986803	Swirl Nozzle, .030 Dia.
	986804	Swirl Nozzle, .045 Dia.
	986805	Swirl Nozzle, .060 Dia.
	986806	Swirl Nozzle, .080 Dia.
	986889	Spray Sub Assembly With Fan Air Cap
	987017	Spray Sub Assembly With Cone Air Cap
	986807	Spray Nozzle & O-Ring, .020 Dia.
	986808	Spray Nozzle & O-Ring, .030 Dia.
	986809	Spray Nozzle & O-Ring, .040 Dia.
	986810	Spray Nozzle & O-Ring, .050 Dia.
	983791	T-Bar Nozzle, 2x1
	986792	T-Bar Nozzle, 2x2
	983793	T-Bar Nozzle, 2x3
	986797	Y-Bar Nozzle, 2x1
	986798	Y-Bar Nozzle, 2x2
	986783	Direction Nozzle, .010 Dia., 2 Pack
	986784	Direction Nozzle, .020 Dia., 2 Pack
	986785	Direction Nozzle, .030 Dia., 2 Pack
	986786	Direction Nozzle, .040 Dia., 2 Pack
	986736	Direction Nozzle Assembly, .010 Dia., 2 Pack
	986738	Direction Nozzle Assembly, .020 Dia., 2 Pack
	986740	Direction Nozzle Assembly, .030 Dia., 2 Pack
	986742	Direction Nozzle Assembly, .040 Dia., 2 Pack
	986730	Direction Nozzle Screw, 5 Pack
	986727	Direction Nozzle O-Ring, 10 Pack
	986733	Blank Screw Assembly, 5 Pack

Additional Equipment Resources

In addition to our standard line of equipment, Henkel Loctite offers a number of resources to support your dispensing and light curing needs, including custom equipment systems, equipment rental programs, and engineering services. Simply contact us at 1-800-LOCTITE (562-8483) or visit www.equipment.loctite.com

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1068/LT-3768