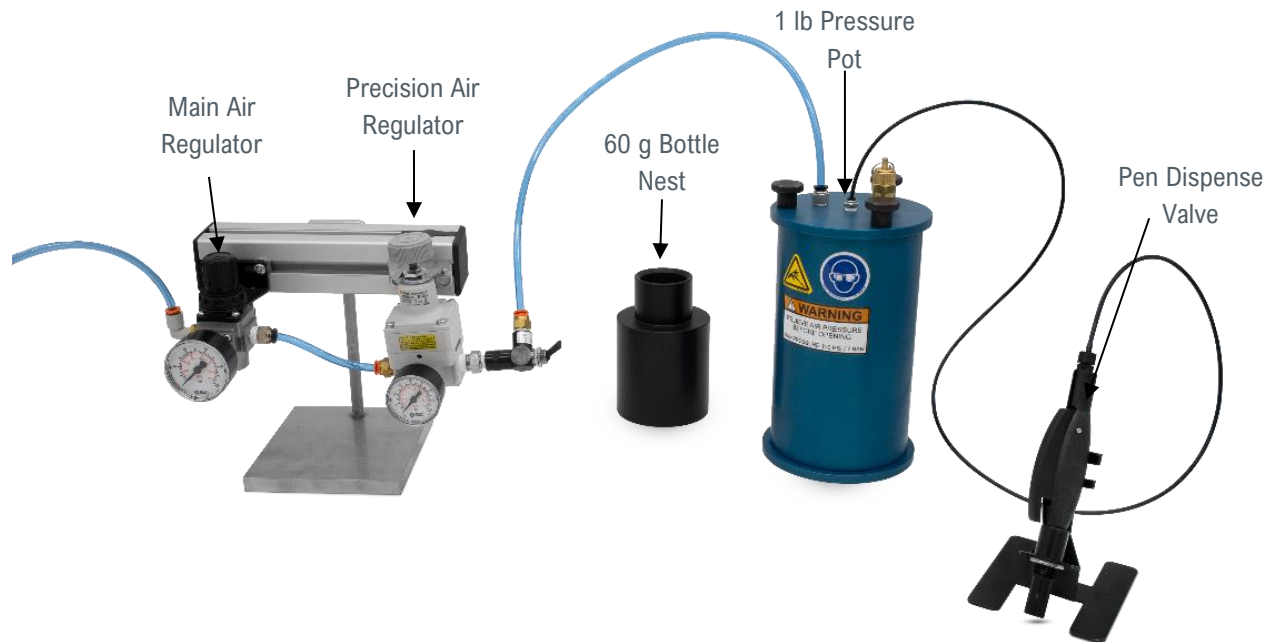




Dispensing Pen Kit for HLC™ Adhesives

Installation, Operation, and Maintenance Instructions



1. Remove the 1 lb Pressure Pot, Regulator Dispense Stand, and Pen Dispense Valve from their packaging and place them on a flat stable work surface.
2. Dymax recommends using an opaque, black material line in the Pen Dispense Valve to protect against UV light. To install the material line, use the following steps:
 - a. Loosen the pin on the side of the body of the pen valve using a 3/32" hex wrench. Once the threads are loose, fully remove the pin by pushing it through from the other side of the pen valve.
 - b. Remove the handle and spring, then remove the material line underneath.
 - c. Install the new material line, ensuring the male Luer fitting is on the material output side and the female Luer fitting is on the material input side.
 - d. Reinstall the spring, handle, and pin.
3. Remove the top cover assembly of the 1 lb Pressure Pot by unscrewing the three knob screws mounted on the cover.
4. Place an uncapped material container in the center of the tank. For 60 g containers place the 60 g Bottle Nest in the tank first, then seat the 60 g container in the top of the nest.

5. Cut the material line to the desired length, allowing enough length between the pressure pot and user to operate comfortably.
6. Run the material line through the push-through fitting on the cover and into the material container, ensuring the material line reaches the bottom of the container when the cover is reinstalled.

NOTE: *It is very important that the end of the tube in the material bottle is cut at an angle to ensure proper material flow.*

7. With the material line still in the container, reinstall the cover and firmly tighten the three knob screws.
8. Install the desired dispense tip on the Pen Dispense Valve.
9. Install the barbed male Luer fitting into the material line by firmly pressing it into the open end.
10. Connect the material line to the Pen Dispense Valve using the male Luer fitting.
11. Install an air line between the output of the main air regulator and the input of the precision air regulator using an appropriate length of the included ¼” tubing.
12. Install an air line between the output of the precision air regulator and the compressed air input on the cover of the 1 lb Pressure Pot. Ensure an appropriate length of the ¼” tubing is used to properly position the air regulators and pressure pot.
13. Verify the dump valve on the main air regulator is in the “EXH” position, then connect shop air to the main air regulator and set the regulator to 10 psi.
14. Move the dump valve to the “SUP” position and adjust the precision regulator to control the rate of material flow.

Note: *Recommended starting pressure on the precision regulator is 5 psi. Increment the pressure gradually to achieve desired flow rate.*

15. The set screw opposite the trigger handle on the Pen Dispense Valve determines how much the material line opens and can be used to further regulate the rate of material flow. Turn the set screw counterclockwise to increase the flow rate, and clockwise to decrease the flow rate.