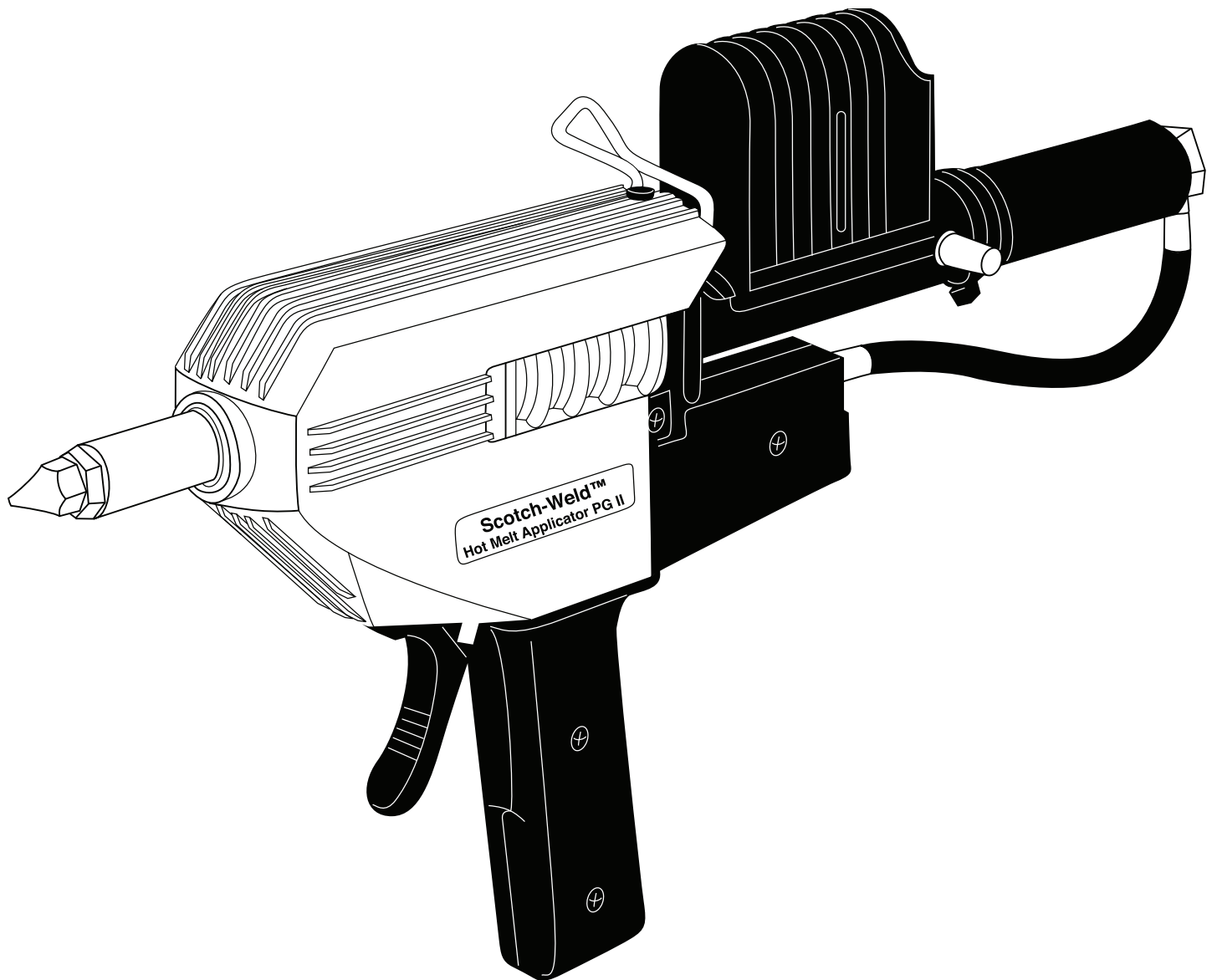


3M
Scotch-Weld™ Hot Melt Applicator PG II Owner's Manual
Manuel de l'utilisateur – Applicateur d'adhésif thermo-fusible PG II 3M™ Scotch-Weld™
Aplicador por fusión al calor de Scotch-Weld™ PG II de 3M™ Manual del usuario

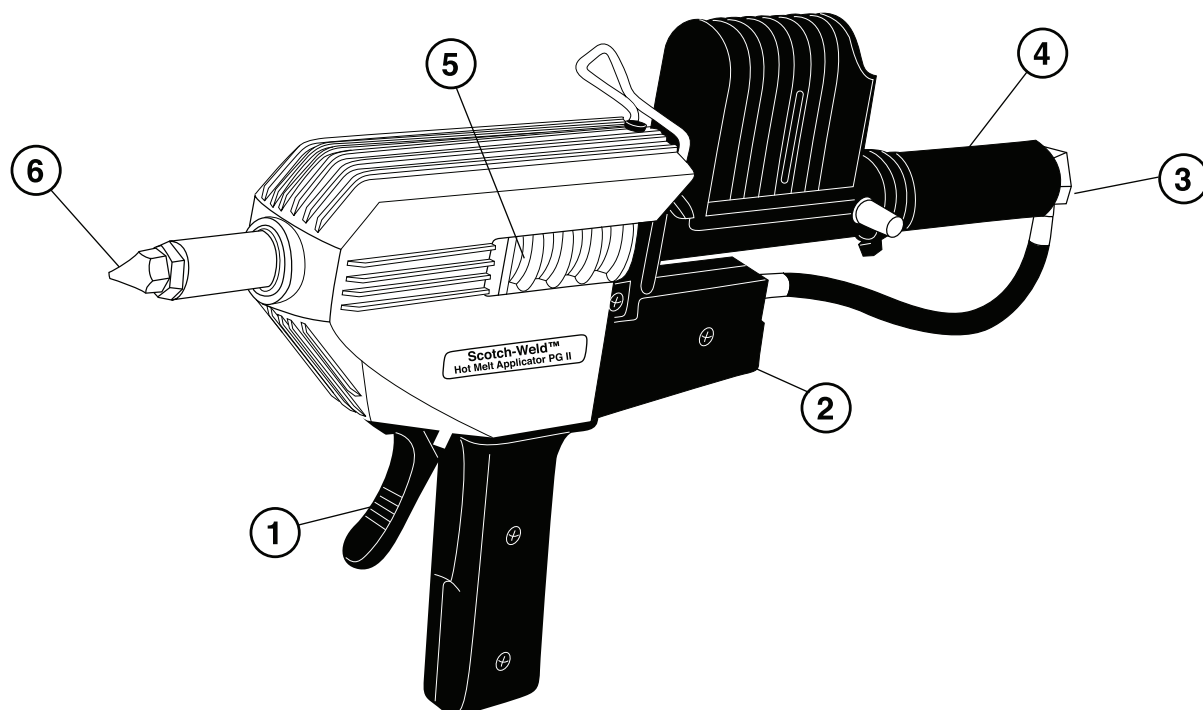


Use with 3M™ Scotch-Weld™ Hot Melt Adhesives
À utiliser avec les adhésifs thermo-fusibles 3M™ Scotch-Weld™
Úselo con adhesivos de fusión al calor Scotch-Weld™ de 3M™

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General Information



The 3M™ Scotch-Weld™ Hot Melt Applicator PG II is designed to be a simple, reliable tool for dispensing 3M™ Scotch-Weld™ Hot Melt Adhesive Sticks. It is self-contained and hand held, designed for multi-station or intermittent manual adhesive application.

The 3M Scotch-Weld Hot Melt Applicator PG II uses electric heat to melt the adhesive, and air pressure to deliver the adhesive. Adhesive temperature is automatically maintained by a fixed thermostat on the heat block. The system is further protected by a thermal cutout (TCO), which acts as a thermal fuse.

When trigger (1) is pulled, the variable regulator (2) allows air pressure into rear of the Speedloader stick feed (3). Air pushes the piston (4), which advances adhesive stick through the applicator. As adhesive advances, it passes through hard plastic insulating sleeve (5) which acts as thermal barrier to keep molten adhesive and heat in forward portion of the applicator. The rest of the applicator stays cool.

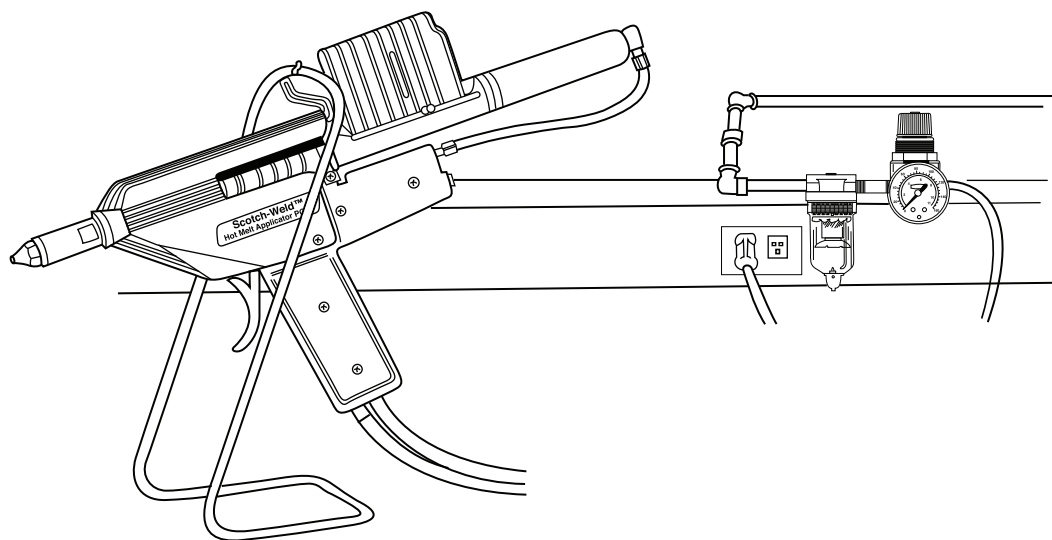
As adhesive advances into the heat block, it is melted and liquified. With pressure from the solid adhesive sticks and the piston, the liquid adhesive is forced out the tip of the applicator through the nozzle valve (6). When the trigger is released, air pressure is released from the rear of the loading chamber. Pressure on the molten adhesive in the front of the applicator is then also relieved. Spring tension in the nozzle valve retracts the valve, neatly cutting off the adhesive flow. The trigger of the 3M Scotch-Weld Hot Melt Applicator PG II can be feathered. The operator can pull the trigger back part way for a small amount of adhesive or pull the trigger back all the way for maximum flow.

The delivery rate of molten adhesive for the 3M Scotch-Weld Hot Melt Applicator PG II is seven pounds per hour with a product like 3M™ Scotch-Weld™ Hot Melt Adhesive 3738 utilizing the standard tip 9921. Adhesive flow rates will vary with the different adhesives in the line and the nozzle tip you choose.

READ INSTRUCTIONS THOROUGHLY BEFORE OPERATING OR PERFORMING ANY MAINTANCE ON 3M SCOTCH-WELD HOT MELT APPLICATOR PG II.

Set Up and Installation

Remove the 3M™ Scotch-Weld™ Hot Melt Applicator PG II from its shipper and inspect for obvious damage.



1. Connect Air and Electrical Service

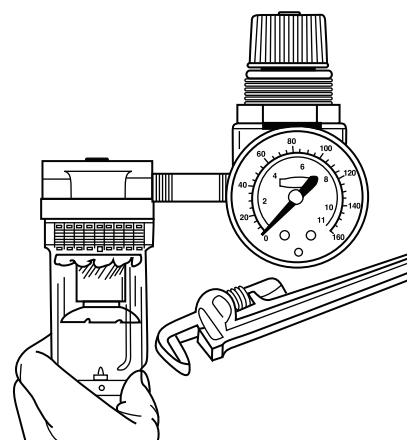
Select a work station where 120 VAC grounded receptacle and compressed air service are available. Electrical outlet should be as close to air supply as possible. **Filtered air regulated to 80 psi maximum is vital to trouble-free operation.** Connect air hose using two 1/2" open-end wrenches. Remove the steel swivel portion of the connector and insert the steel swivel into 1/8" female pipe thread air source. Insert and tighten the brass fitting into the swivel and snug up all fittings.

2. Install Air Filter and Regulator

An air filter and moisture trap must be installed at the applicator connection point of the air system. Install an air filter WATTS #602-2S Model M4 (or equivalent) at the air outlet or as close as possible to it. The hose connection at the end of the 3M Scotch-Weld Hot Melt Applicator PG II air hose is 1/8" standard male pipe fitting.

3. Install Bench Stand

Prior to start up in operation, set the bench stand on work surface so that tip of gun points away from work area when gun is not in use. When bench stand is in most desirable position, fasten permanently using the screws provided. (If portability of the bench stand is desired, simply attach the stand to a piece of scrap wood approximately 7" x 16" using either screws or by adhering the stand to the wood.)



Operation

Warm Up

Make certain that the 3M™ Scotch-Weld™ Hot Melt Applicator PG II is fully loaded with adhesive. Set the off/on switch to the “on” position, switch should light up, and set 3M Scotch-Weld Hot Melt Applicator PG II in the bench stand for 15 minutes. During this warm-up period you may note a slight dripping from the nozzle tip. This dripping is due to expansion of the adhesive during warm-up.

Loading

After warm-up, load applicator with the 3M™ Scotch-Weld™ Hot Melt Adhesive you'll be using on the job. To do this, fully retract the Speedloader piston by pulling one of the retract knobs located on either side of the loading chamber. Insert up to three 3M Scotch-Weld Hot Melt Adhesive Sticks into the chamber through the rear loading port. The applicator is now ready for operation.

As adhesive is extruded, the piston will move forward. This will be visually evident by the forward movement of the retract knobs. As the piston approaches the front of the chamber, a whistling sound will be heard. At this point the piston may be retracted and another adhesive stick will fall into place. Applicator is again ready for operation. Adhesive may be loaded into the chamber via the rear port at any time during operation thus saving time and increasing productivity.

If it is desired to remove adhesive once it is in the loading chamber, simply roll the applicator to one side and then point up. This will allow the adhesive to roll up and out of the chamber.

In order to keep the Speedloader stick feed operating at maximum efficiency, the chamber should be sprayed inside while the piston is in the full forward position with 3M™ Silicone Lubricant or equivalent once a week.

⚠ CAUTION:

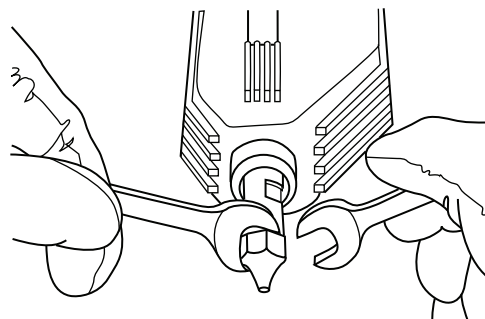
Never pull the trigger on the applicator unless there is adhesive in the loading chamber.

Application

Get a feel for your new 3M Scotch-Weld Hot Melt Applicator PG II. Start by applying small amounts of adhesive in puddles on a piece of scrap or paper. Try feathering the trigger. The 3M Scotch-Weld Hot Melt Applicator PG II is unique in this respect. Pull the trigger back slowly and note a small discharge of adhesive; pull the trigger back more and note increasing adhesive flow. When the trigger is fully depressed; you will get maximum flow. If more or less flow is desired, refer to page 17 of this manual. **Never operate the applicator without a nozzle tip. Doing so could seriously damage the nozzle valve.**

Changing Tips

The 3M Scotch-Weld Hot Melt Applicator PG II includes two different tips as standard equipment. Other tips, available from your Scotch-Weld Hot Melt Adhesive distributor, are shown on page 17 of this manual.



⚠ Caution:

Disconnect air and electrical power before servicing. Wear heat resistant gloves while working on tips.

Tips can be changed only when the applicator is hot. You will need a 5/8" and a 1/2" open-end wrench. Hold the nozzle valve hex firmly with the 5/8" wrench, while removing the nozzle tip with the 1/2" wrench. The accessory tip is mounted using the reverse procedure. Snug the tip lightly. **Over tightening could damage the valve assembly.**

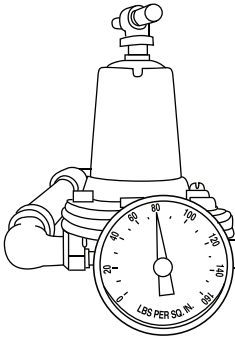
Preventive Maintenance

Before Operation

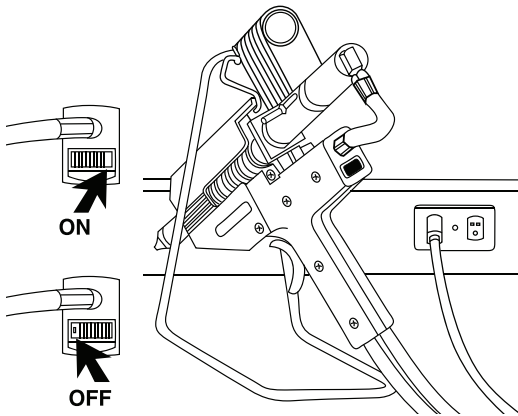
⚠ CAUTION:

Always remember the tip and valve are extremely hot.

1. Make sure filtered compressed air is available, regulated to a maximum of 80 psi or to a minimum of 50 psi. **DO NOT OPERATE 3M™ SCOTCH-WELD™ HOT MELT APPLICATOR PG II BELOW 40 PSI.** If low flow is experienced at 40 psi see page 8.



2. Make sure that the 3M Scotch-Weld Hot Melt Applicator PG II is plugged into 120 VAC and that the switch is in the “on” position. Switch should light up.



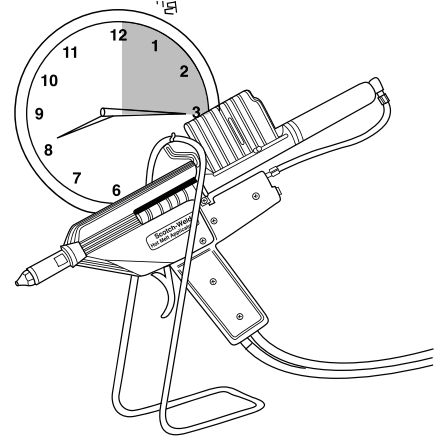
3. Inspect nozzle tip daily. Make sure tip is clean and clear of foreign matter. Using a coarse cloth, wipe off any accumulated adhesive or other foreign matter on the tip.



⚠ CAUTION:

Valve and nozzle tip are extremely hot. Wear heat resistant gloves when cleaning tip.

4. Be sure there is adhesive in the loading chamber.
5. Under normal conditions, allow at least 15 minutes for the applicator to warm up.

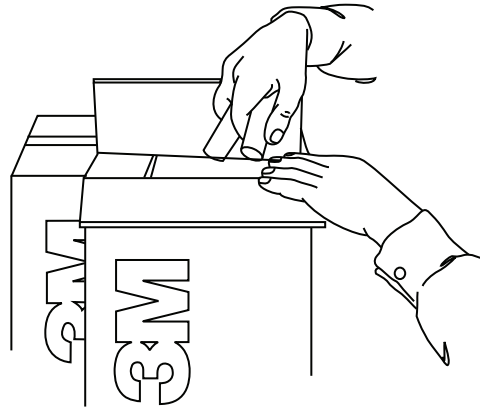
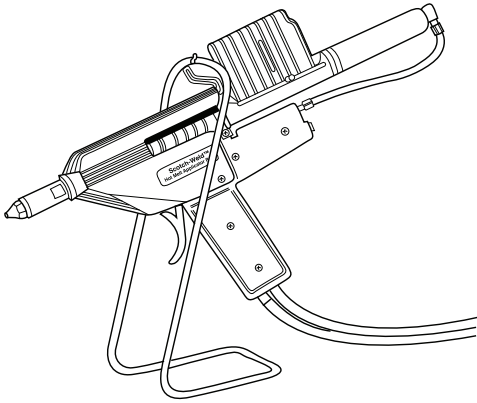


6. Under normal operations the in-line air filter should be removed and cleaned every six months. Simply remove the filter from the air supply line and blow compressed air through the filter in reverse of normal air flow to remove particular matter.
7. Periodically inspect the applicator to ensure that assembly is proper (i.e. watch for loose screws, worn pins, etc). See page 8-14 for Troubleshooting and Repair Procedures.

NOTE: Before shutting down the 3M Scotch-Weld Hot Melt Applicator PG II put the electrical switch in the “off” position. Continue using the applicator until approximately one adhesive stick has been consumed. If 3M Scotch-Weld Hot Melt Applicator PG II has not been in use but still on heat prior to shut down **WITHOUT EXTRUDING ADHESIVE, allow at least one hour for heat-up.**

Preventive Maintenance

During Operation



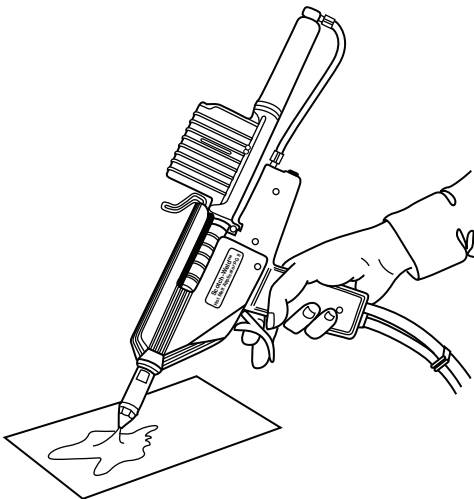
Always use the bench stand provided when 3M™ Scotch-Weld™ Hot Melt Applicator PG II is not in use. Do not lay the applicator on its side. This impedes cooling process and may cause plugging problems.

Open adhesive stick container only when necessary. Keep sticks clean and free from airborne contaminants.

After Operation

Before shutting down the 3M Scotch-Weld Hot Melt Applicator PG II put the electrical switch in the “off” position. Continue using the applicator until approximately one adhesive stick has been discharged. If 3M Scotch-Weld Hot Melt Applicator PG II has not been in use but still on heat prior to shut down **without extruding adhesive**, allow at least one hour for heat-up.

Lubricate inside loading cartridge with 3M™ Silicone Lubricant or equivalent once a week.



Troubleshooting

Problem	Probable Cause (In order of priority)	Correction
Low or no adhesive flow	1. Hung adhesive stick	Turn on the 3M™ Scotch-Weld™ Hot Melt Applicator PG II and allow it to heat for at least 60 minutes. With incoming air at 80 psi extrude adhesive. If unsuccessful remove nozzle assembly and extrude one stick of adhesive. Readjust incoming air to 80 psi.
	2. Low air pressure	Check to see if there is sufficient air pressure. Test by setting pressure at 80 psi. Check in-line filter to insure that it is not plugged with contaminants. Disconnect in-line filter from air hose. Using a compressed air line, blow compressed air through the filter in the reverse flow position. If this does not increase air flow through the filter, swivel filter should be replaced.
	3. No electricity	Check to see that electrical service is live, and that lighted switch is in “on” position.
	4. Dirty nozzle valve assembly	Remove nozzle valve and clean. Run one adhesive stick out. Replace cleaned valve assembly.
	5. Regulator malfunction	Squeeze trigger and try to pull retract knobs. If they can be pulled back easily, install new regulator kit.
	6. Burned out heater(s)	With Volt/Ohm Meter, run electrical continuity check on each heater (see page 13 for procedure). If open circuit exists, install new heater kit.
	7. Jammed slugs	If the piston is retracted before reaching the point where the whistle is heard, a jam-up of the adhesive may occur. To free this, simply retract the piston fully and roll the applicator to one side so that the adhesive in the magazine will free itself. Now push the knobs forward until the adhesive stick still in the chamber is contacted by the piston. Roll the applicator back to its normal operating position and continue extruding adhesive until the whistle is heard or until the piston has traveled its full length as indicated by the orange retract knobs.
No heat	1. Blown thermal cutoff	Replace with new Thermostat/TCO kit. Refer to page 14, paragraph J.
Dripping Nozzle	1. Regulator malfunction	With finger off of trigger, attempt to retract piston. If piston is very difficult to pull back, air regulator may not be shutting off entirely. Replace regulator.
	2. Expanded adhesive stick	Extrude one adhesive stick.
	3. Worn nozzle valve	Replace with new nozzle valve assembly. Refer to page 12, paragraph C.

Troubleshooting

Repair Parts Kit

For ease and convenience in repair, 3M™ Scotch-Weld™ Hot Melt Applicator PG II repair part kits are available from your authorized 3M Scotch-Weld Hot Melt Adhesive distributor. When ordering part kits, provide the name and number of the repair part kit.

If necessary, part kits can also be ordered direct from the nearest 3M Sales Branch listed on the back cover.

Note: Depending upon the serial number on your 3M Scotch-Weld Hot Melt Applicator PG II, different part kits may be needed. Please check the Serial Number located on the heat block before ordering part kits.

Kit #	Repair Part Kit	# of Items/Kit	Kit #	Repair Part Kit	Items/Kit	Kit #	Repair Part Kit	Items/Kit
9200	Trigger Kit		9219	Switch Kit		9224	Miscellaneous Parts Kit	
	a. Trigger Pin	1		a. Switch Sub-Assembly	1		a. Heat Shield Screw, Top	1
	b. Trigger Assembly	1	9206	Hose Kit, Main			b. Heat Shield Screw, Side	2
9203	Heat Shield Kit			a. Hose Sub-Assembly	1		c. Heat Shield Screw	4
	a. Heat Shield	1		b. Cable Ties	5		d. Shim	2
9204	Regulator Kit		9220	Hose Kit			e. Electrical Connector Screw	9
	a. Regulator Assembly	1		a. Hose	1		f. Connector Strip	2
9205	Regulator Hose Sub-Assembly Kit			b. Elbow	1		g. Handle Screw	4
	a. Hose Assembly	1		c. Swivel Filter	1		h. Regulator Screw	3
9207	Power Cord Kit			d. Cable Ties	5		i. Ground Wire Screw	2
	a. Power Cord Assembly	1	9222	Heater Kit			j. Hinge Pin	3
	b. Cable Ties	5		a. 125 W Heater	4		k. Bail Screw	2
9209	Thermostat/TCO Kit			b. Machine Screw	8		l. Lock Washer for Bail	2
	a. Thermal Cutout Assembly	1		c. Cable Tie	1		m. Bail	2
	b. Machine Screw Large	1	9223	Valve Kit		9226	Dump Valve	
	c. Machine Screw Small	2		a. Nozzle Tip	1		a. Valve	1
	d. Thermostat Sub-Assembly	1		b. Valve Assembly	1	9260	Speedloader Hose Assembly	
9214	Low Temperature -350°F Thermostat/TCO Kit						a. Hose Assembly	1
	a. Thermal Cutout Assembly	1				9261	Scotch-Weld SL Magazine Extension Kit	
	b. Machine Screw Large	1					a. Magazine Extension	1
	c. Machine Screw Small	2				9987	Speedloader Assembly	
	d. Low Temperature Thermostat Sub-Assembly	1					a. Speedloader	1
9938	Hanger Kit						b. Hose	1
	a. Hanger	2					c. Pin	1
9221	Handle Kit						d. Bail	1
	a. Right Handle Sub-Assembly	1						
	b. Left- Handle Sub-Assembly	1						
	c. Machine Screw	4						
	d. Machine Screw	3						

Recommended Part Kits

Your 3M™ Scotch-Weld™ Hot Melt Applicator PG II has been engineered for durability and reliability. However, as with any electrical-mechanical device, parts will wear with use and require replacement for maximum performance. We have listed below certain part kits that you may want to have available in case the immediate need for replacement arises. All part

kits listed are available from your authorized 3M Scotch-Weld Hot Melt Adhesive distributor or from the nearest 3M Sales Branch location listed on back cover of this manual. **Please note the serial number of your 3M Scotch-Weld Hot Melt Applicator PG II before ordering part kits.**

Kit Number	Name	Stock Number	No. of Scotch-Weld Hot Melt Applicators in Use			
			2-5	6-10	11-15	16-20
9200	Trigger Kit	62-9200-6921-8	0	0	1	1
9203	Heat Shield Kit	62-9203-6901-4	0	1	1	2
9204	Regulator Kit	62-9204-6922-8	1	1	2	2
9207	Power Cord Kit	62-9207-6947-8	0	0	0	1
9209	Thermostat/TCO Kit	62-9209-6962-3	1	2	2	3
9219	Switch Kit	62-9219-2798-4	0	0	1	1
9220	Hose Kit	62-9220-2797-4	0	0	0	1
9221	Handle Kit	62-9221-2651-1	0	0	0	1
9222	Heater Kit	62-9222-6930-3	0	0	1	1
9223	Valve Kit	62-9223-6930-1	1	2	3	4
9226	Dump Valve Kit	62-9226-6990-8	0	0	1	1
9260	S/L Hose Assem. Kit	62-9260-2945-5	0	0	1	1

Repair Procedures

⚠ Caution

Prior to making any repairs on the applicator, make certain that the applicator is at room temperature and that both air and electrical service lines have been disconnected from their respective sources. Failure to disconnect the electrical power source could result in electrical shock. Heat shield must be in place before connecting applicator to electrical outlet.

Procedure	Part Kit
A.	Handle Kit
B.	Regulator Kit
C.	Valve Kit
D.	Hose Kit
E.	Power Cord Kit
F.	Switch Kit
G.	Trigger Kit
All of the above part kits repair procedures require "Handle and Heat Shield Disassembly".	
H.	Heat Shield Kit
I.	Heater Kit
J.	Thermostat/TCO Kit
All of the above part kits repair procedures require "Heat Shield Disassembly- procedure H".	

Heat Shield Disassembly Instructions

Disconnect Electrical and Compressed Air Service.

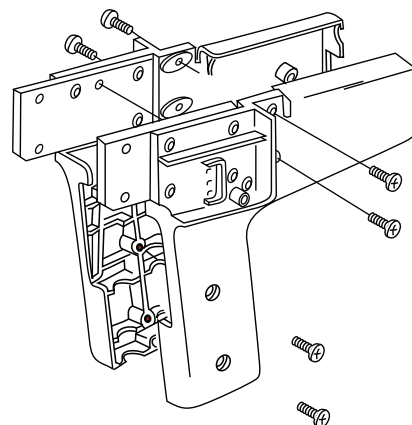
Remove the heat shield assembly by removing the two Phillips head screws from either side of the heat shield and the one Phillips head screw on the heat shield immediately above the loading chamber. Reassemble, following reverse procedure.

Handle Disassembly Instructions

With the nozzle of the applicator pointing away from you, remove the seven Phillips head cap screws in the handle. These screws are located in the left hand side of the handle grip, two in the pistol grip itself, two just forward of the wire terminal and three to the rear of the wire terminal. Remove the long screw on the bottom left of the flange immediately above the three screws located to the rear of the wire terminal. Without removing the wires from the wire terminals, lift the handle up and to the front of the applicator. This operation will allow for subsequent repair steps.

Handle Disassembly Instructions

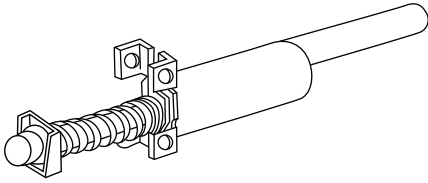
A. Handle Kit



Disconnect electrical and compressed air service.

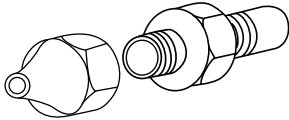
To replace applicator handles, first follow "Handle Disassembly Instructions." Next remove the electrical wiring from the terminal strip on the left handle, replacing them to the same terminals on the replacement. The right half of the handle is removed by removing the four Phillips head cap screws. Next remove the electrical wiring from the terminal strip and reassemble these to the replacement right half handle. Lift the switch out of its slot in the handle and replace it in the new handle. Replace the trigger and trigger pin at this time. Using reverse procedure, reassemble the right handle half, then the left. Be sure all the electrical wires are in place and are not being pinched.

B. Regulator Kit



Disconnect electrical and compressed air service. First follow “Handle Disassembly Instructions” then remove the two large Phillips head screws to the rear of the wire terminals on the right hand side of the handle. This allows the regulator assembly to swing free, connected only by the hose going from the brass rear of the regulator to the loading chamber assembly, and the main hose assembly. Remove the main hose by unscrewing the elbow fitting from the regulator. Use a 5/16” wrench to remove the loading chamber hose from the regulator. Reassemble with a new regulator using reverse procedure. Be sure hose fittings are quite snug. Check for air leaks by activating the regulator. Once this is done, reassemble the handle and heat shield.

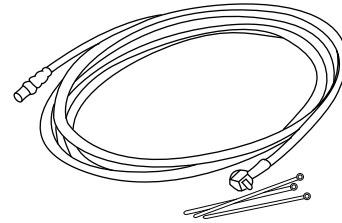
C. Valve Kit



3M™ Scotch-Weld™ Hot Melt Applicator PG II must be heated prior to repairing nozzle valve. CAUTION: WEAR SAFETY GOGGLES AND HEAT RESISTANT GLOVES. DISCONNECT AIR LINE BEFORE MAKING REPAIRS.

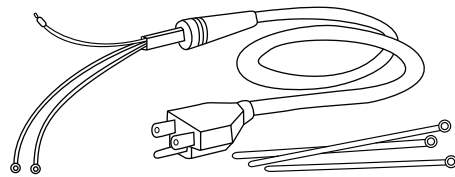
Nozzle valve assembly consists of the nozzle tip and the nozzle valve. Remove the old valve assembly using a 5/8” open-end wrench. Replace with new assembly. Gently snug up the valve assembly. With a 1/2” wrench, also snug up the new tip.

D. Hose Kit



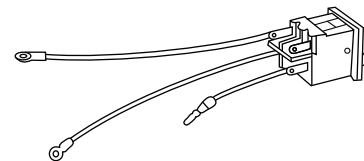
Disconnect electrical and compressed air service. Follow “Handle Disassembly Instructions,” page 11. Remove the main hose by unscrewing the elbow fitting from the air regulator. Cut the cable ties holding the power cord and hose assembly together. Remove the hose and reconnect the new hose using reverse procedure. Add new cable ties to the hose and power cord.

E. Power Cord Kit



Disconnect electrical and compressed air service. Follow “Handle Disassembly Instructions.” The power cord wire from the switch is removed from the bayonet connector. The black and white wires are removed from their respective terminals. Remember which wire came off which terminal for reassembly. Consult the electrical Wiring Arrangement on page 16. Reassembly is accomplished by reversing the above.

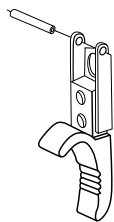
F. Switch Kit



Disconnect electrical and compressed air service. Follow “Handle Disassembly Instructions,” page 11. Lift the switch from the slot in the right half of the handle. The power lead can be unplugged from the power cord receptacle. The other wires terminating in ring lugs should be removed from their respective terminals, noting that the black lead is connected to the Thermal Cut Out Assembly and the white lead to the heaters. Install the new switch using reverse procedure.

Repair Procedures

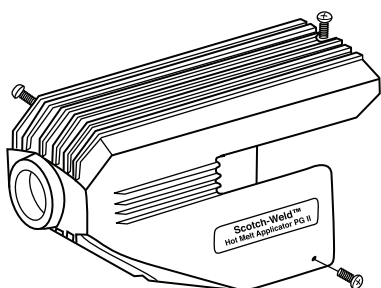
G. Trigger Kit



Disconnect electrical and compressed air service. Follow “Handle Disassembly Procedures”. Lift the trigger assembly off the trigger pin and replace. Reassemble following reverse procedure.

Heat Shield Disassembly Instructions

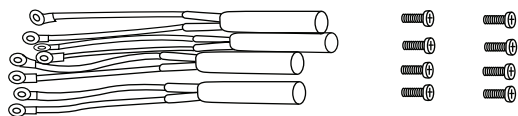
H. Heat Shield Kit



Disconnect electrical and compressed air service. Remove the heat shield assembly by removing the two Phillips head screws from either side of the heat shield and the one Phillips head screw on the heat shield immediately above the loading chamber. Reassemble, following reverse procedure.

I. Heater Kit

Disconnect electrical and compressed air service.



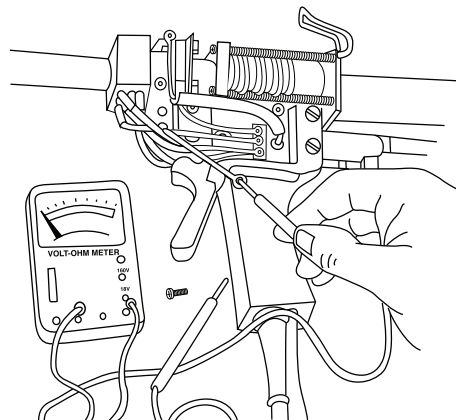
Follow “Heat Shield Disassembly,” per procedure H. All heater wires must be disconnected from their respective terminal strips. With a suitable drift punch, drive the old heaters out through the top of the heat block. All four heaters should be replaced making sure to reconnect the wires in the proper places. Refer to the “Wiring Arrangement” and “Electrical Control” diagrams, page 16. Be sure that heaters are bottomed out in the heat block. They should not stick out above the block more than 1/4”. It may be necessary to gently tap the heaters into place, but be careful not to crack the ceramic.

To insure that heaters remain in place, gather all the

wires together approximately 1/2” below the heat block and tightly attach the cable tie provided with the kit.

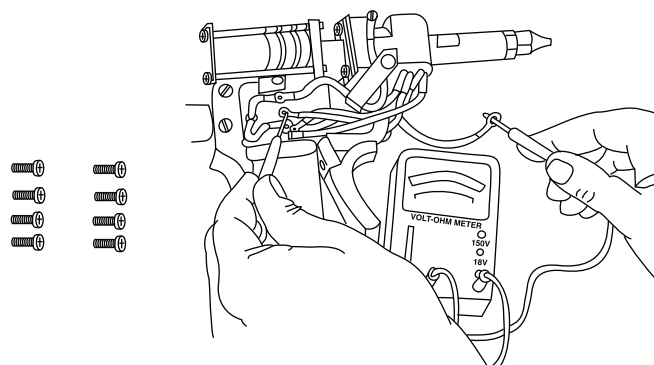
Heater Check-Out

Disconnect electrical and compressed air service.



Use Volt/Ohm Meter to check electrical continuity of each heater. If continuity exists, heater is okay. First remove heat shield. Heaters need not be removed from the block. Check in the following sequence: left front, right front, right rear, left rear. To start the check, remove only one wire from its connection on the terminal strip.

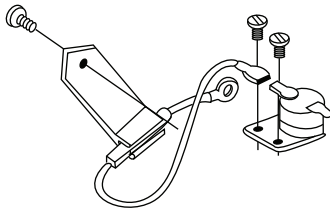
Place one probe from the meter on the connector of the



wire that has been removed, and with the other probe, touch the matching connector on opposite side of the applicator. If needle on Volt/Ohm Meter swings, heater is okay.

Reconnect wire that was removed first, and continue sequence. If one or more heaters are burned out, refer to Repair Procedure, pages 11-14.

J. Thermostat/TCO Kit



Disconnect electrical and compressed air service.

Remove the heat shield assembly by removing the two Phillips head screws from either side of the heat shield and the one Phillips head screw on the heat shield immediately above the loading chamber.

The thermostat and TCO are assembled as a unit and are replaced as such no matter which component has failed.

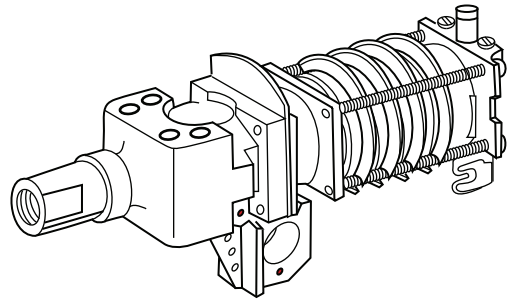
The Quick-Slide clips should be removed from the thermostat. Remove the two screws holding the thermostat, and pry the thermostat from the block.

Insert new thermostat. **Make sure the rear rim of the thermostat is slipped into the slot in the heat block before affixing screws.**

The thermal cutout assembly is then removed by disconnecting the Phillips head screw, holding the thermal cutout to the head block on the stand off strip. Remove the other end of the thermal cutout from the terminal strip with a small Phillips screwdriver.

Procedure is reversed to replace the thermal cutout.

K. Heat Block Kit

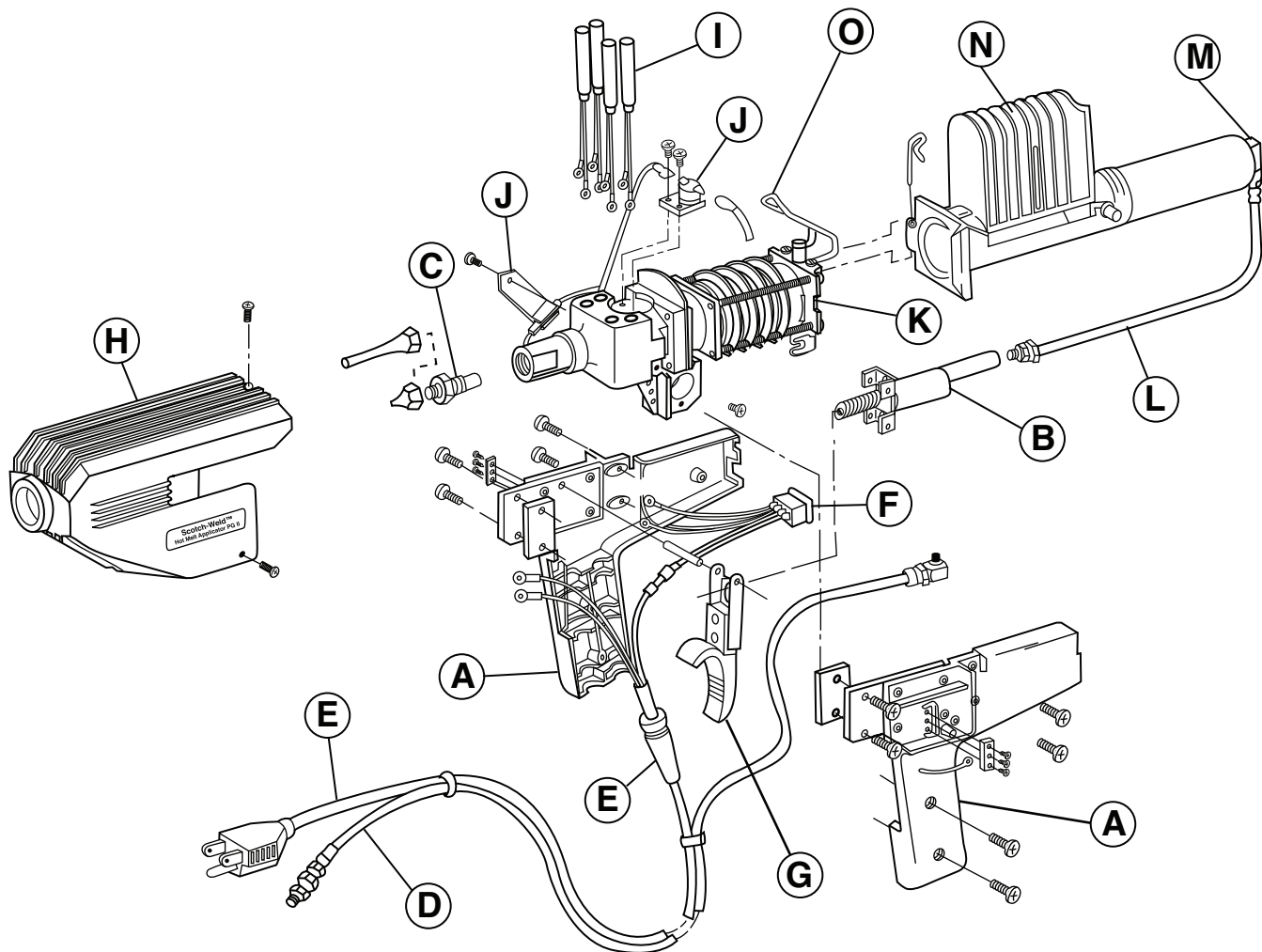


Disconnect electrical and compressed air service.

If the original heat block is broken or needs replacement, you may use the 3M factory refurbish program. Please contact your distributor for information on our PG II equipment refurbish program.

General Assembly

Please check serial number located on the heat block before ordering part kits.

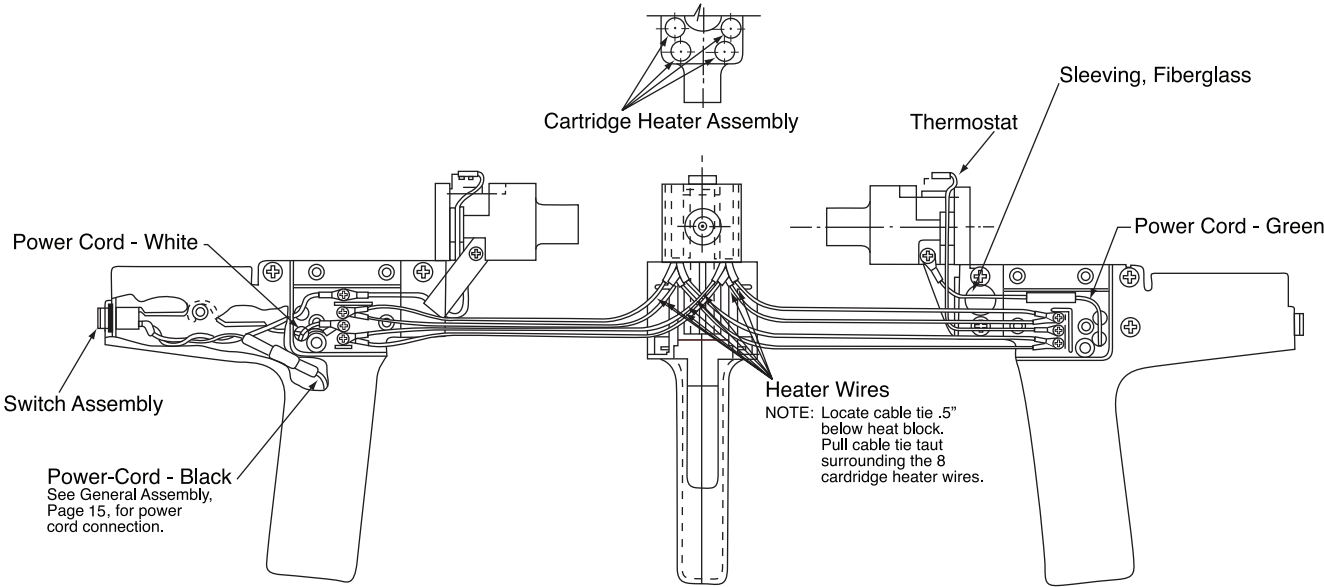


- A. 9221 Handle Kit
- B. 9204 Regulator Kit
- C. 9223 Valve Kit
- D. 9220 Hose Kit
- E. 9207 Power Cord Kit

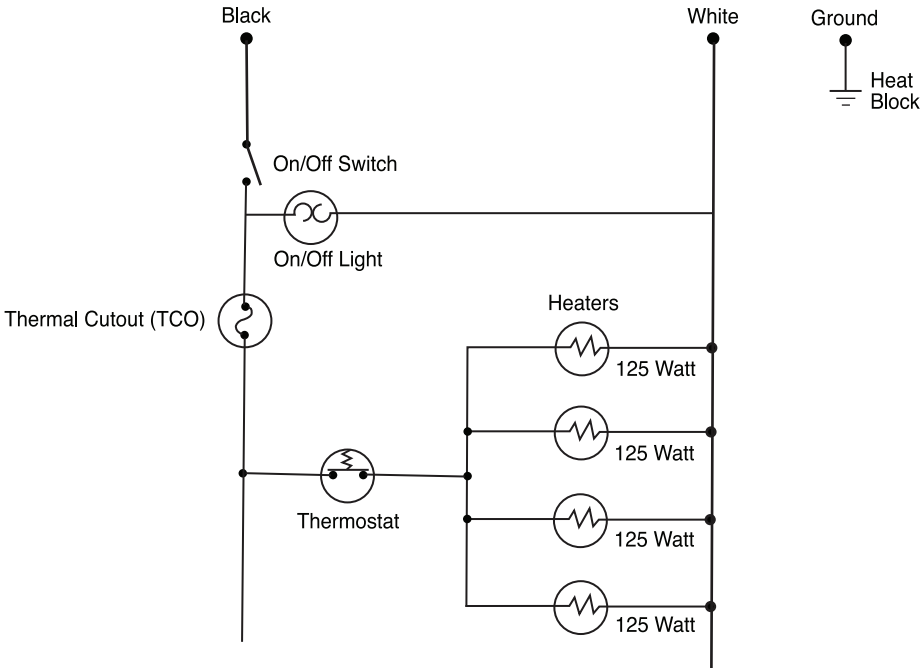
- F. 9219 Switch Kit
- G. 9200 Trigger Kit
- H. 9203 Heat Shield Kit
- I. 9222 Heater Kit
- J. 9209 Thermostat/TCO Kit
9214 Low Temperature -350°F
Thermostat/TCO Kit

- K. 9202 Heat Block Kit
- L. 9260 Speedloader Hose Assembly
- M. 9226 Dump Valve Kit
- N. 9987 Speedloader Chamber Assembly
- O. 9938 Hanger Kit

Electrical Control



Wiring Arrangement



Flow Control

Flow control of adhesive with your new 3M™ Scotch-Weld™ Hot Melt Applicator PG II is easy. An operator familiar with the control devices should be able to adjust the applicator for desired flow. To adjust adhesive flow, a combination of these control methods can be used.

The four control devices are:

1. Speed of 3M Scotch-Weld Hot Melt Applicator PG II movement.
2. The trigger.
3. The nozzle tip.
4. Air pressure.

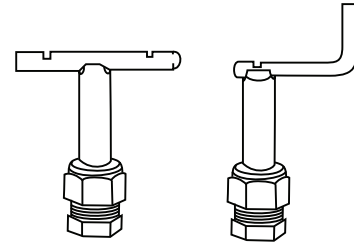
The trigger of the applicator is uniquely designed to allow for variable control. By pulling the trigger slowly to the rear, you can observe the start of adhesive flow. As you continue to pull the trigger rearward, increasing amounts of adhesive are dispensed.

Two nozzle tips were supplied with your 3M Scotch-Weld Hot Melt Applicator PG II: a .093" (9921) fluted tip and a .072" (9946) brass extension tip. The applicator was shipped with the .093" (9921) tip on the applicator. This tip will provide maximum flow for all 3M™ Scotch-Weld™ Hot Melt Adhesives except 3746 and 3783. The brass extension tip (9946) will allow for maximum **control** of all the adhesives and substantially eliminate initial surge. This is accomplished at a **decrease** in flow rate. Speed of movement is the preferred means to control flow. In the event that this is inappropriate for your operation, additional accessory tips are available.

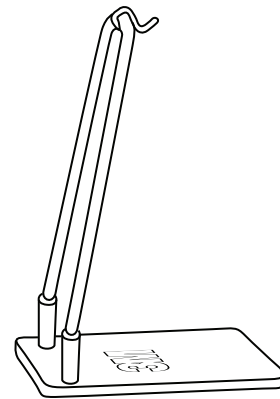
NOTE: DO NOT REDUCE AIR PRESSURE BELOW 40 PSI. If low adhesive flow occurs when operating at reduced air pressure, return to maximum (80 psi) and run at least one stick of adhesive through the applicator and then return to the lower pressure.

3M Scotch-Weld Hot Melt Applicator PG II Tips

Tip No.	Description
9913	2 Hole Spreader
9916	3 Hole Spreader
9917	3 Hole 1" Spreader
9921	.093" Fluted
9922	.063" Fluted
9726	"T" Tip
9940	.125" Fluted Tip
9946	.072" Brass Extension
9727	"L" Tip



9726 "T" tip for RSC carton closing and other uses.
9727 "L" tip for FOL carton closing and other uses.



9945 heavy-duty bench stand holds 3M Scotch-Weld Hot Melt Applicator PG II in proper position when gun is not in use.

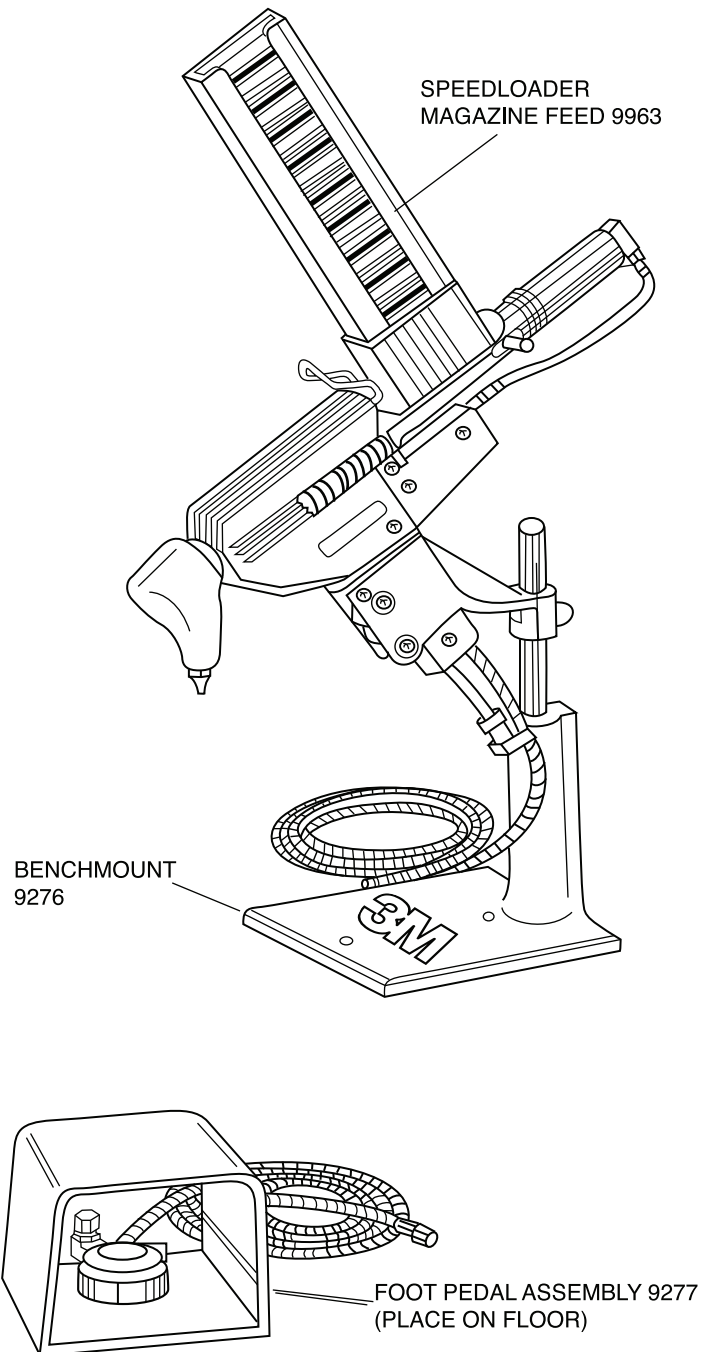
Bench Mount for 3M™ Scotch-Weld™ Hot Melt Applicator PG II

A special bench mount assembly is available which allows the 3M Scotch-Weld Hot Melt Applicator PG II to be mounted in a 45° position and operated with a foot pedal. It is adjustable to allow positioning of the nozzle tip from a minimum of 9 1/2" to a maximum of 15 1/2" from the bench top. A nozzle adapter that directs adhesive flow straight down is included in addition to the foot pedal unit.

Speedloader Magazine Feed for 3M Scotch-Weld Hot Melt Applicator PG II

The 3M Scotch-Weld Hot Melt Applicator PG II can be modified into a semi-automatic loading mode by the addition of the Speedloader Magazine Feed. By simply pushing a lever to the rear, the magazine feeds a new stick of adhesive into the melt chamber. Sticks won't jam. The magazine holds 12 3M™ Scotch-Weld™ Hot Melt Adhesive sticks, reduces the need for frequent reloading and helps increase production. It is ideal for hands-free benchtop applications in packaging and assembly.

Bench mounted 3M Scotch-Weld Hot Melt Applicator PG II with Speedloader Magazine Feed.



3M Repair Service

During warranty period

Contact your nearest 3M Sales Branch or 3M™ Scotch-Weld™ Hot Melt Adhesives distributor

After warranty period

The 3M™ Scotch-Weld™ Hot Melt Applicator PG II has been engineered to be durable and reliable. Recognizing that it will eventually need maintenance, we have made it easy to disassemble and repair. Step by step repair instructions are detailed in this manual, pages 3 through 19. Also provided are simple line drawings and exploded views.

Should your 3M Scotch-Weld Hot Melt Applicator PG II require repair, you can order repair part kits from your local 3M Scotch-Weld Hot Melt Adhesives distributor or from the nearest 3M Sales Branch listed on the back cover.

If you do not wish to make your own repair, check with your local distributor. Many of our 3M Scotch-Weld Hot Melt Adhesives distributors have in-house repair capability.

3M offers a “Refurbish Program”. Complete costs and details on 3M’s Refurbishing Program can be had by contacting your nearest 3M Branch Office.



RoHS compliant means that the product or part does not contain any of the substances in excess of the maximum concentration values in EU Directive 2002/95/EC, as amended by Commission Decision 2005/618/EC, unless the substance is in an application that is exempt under RoHS. Unless otherwise stated by 3M in writing, this information represents 3M’s knowledge and belief based on information provided by third party suppliers to 3M.

Important Notice: User is responsible for determining whether the 3M Scotch-Weld Hot Melt Applicator PG II is fit for a particular purpose and suitable for user’s method of application.

Warranty: 3M warrants for a period of 12 months from the date of use or purchase, whichever occurs first, that the 3M Scotch-Weld Hot Melt Applicator PG II will be free of defects in material and workmanship. 3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. This warranty does not cover routine maintenance, normal wear and tear, or damage resulting from accident, misuse, alteration, corrosion, lack of reasonable care, service performed by an unauthorized repair service, use of unauthorized replacement parts or accessories, installation, use, operation, or maintenance not in accordance with 3M recommended procedures, or use of adhesive cartridges not manufactured by 3M or not subject to 3M quality standards.

Limitation of Remedies: If the 3M Scotch-Weld Hot Melt Applicator PG II is proved to be defective within the warranty period stated above, THE EXCLUSIVE REMEDY, AT 3M’S OPTION, SHALL BE TO REFUND THE PURCHASE PRICE OF OR TO REPAIR OR REPLACE THE DEFECTIVE 3M APPLICATOR, provided that the defective applicator is, at 3M’s choice, returned immediately to 3M or an authorized service representative designated by 3M, or made available at user’s premises in a location suitable for servicing.

Limitation of Liability

3M shall not otherwise be liable for any losses or damages, whether direct, indirect, special, incidental or consequential, regardless of the legal or equitable theory asserted, including contract, negligence, warranty, or strict liability.