

3M

Scotch-Weld™

PUR Easy 250 Adhesive Applicator

Technical Bulletin

September, 2014



Product Description 3M™ Scotch-Weld™ PUR Easy 250 Applicator is a self contained pneumatic applicator designed to dispense 1/10th gallon(300MI) cartridges of 3M™ PUR adhesives.

PURs are a family of one-component, moisture curing, urethane adhesives. These adhesives are applied warm and can bond a wide variety of substrates such as wood, fiber reinforced plastic (FRP) and many other plastics to themselves, to metal and to glass. See technical data sheets for additional information on 3M™ Scotch-Weld PUR adhesives.

- Features**
- Accepts 1/10th gallon (300MI) aluminum cartridges
 - Pneumatic dispensing (rated for 80 psi)
 - UL rated
 - Plastic disposable tip (supplied with 3M™ Scotch-Weld PUR adhesives)
 - (US)120 VAC 50/60Hz, 1.7A, 200W
 - 12 Month warranty

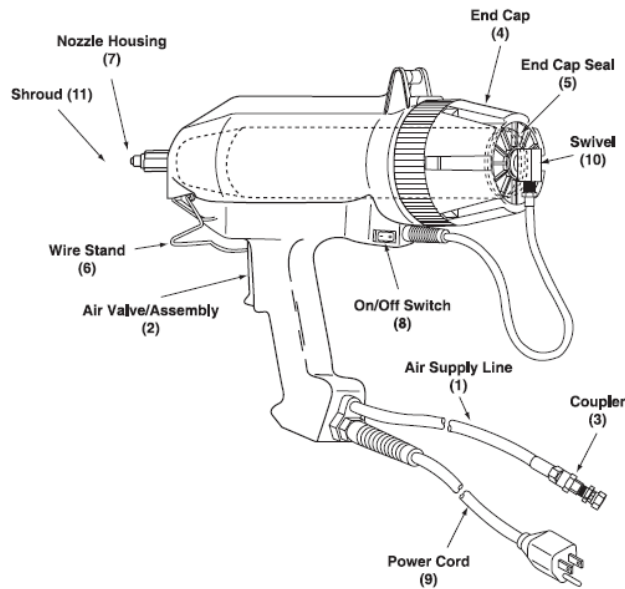
3M™ Scotch-Weld™ PUR Easy 250 Applicator	3M ID Number	Part No.
	62-9865-9930-6	51115-23563

3M™ Scotch-Weld™ PUR Easy 250 Applicator requirements	Electrical	120 VAC 50/60Hz 1.7 A, 200W	Applicator is equipped with a cord having an equipment-grounding conductor and grounding plug. Make sure applicator is connected to an outlet having the same configuration as the plug. Do not use an adapter.
	Air	Max 80 psi, 0.4 CFM	Connect to a filtered, regulated and dry air supply (see applicator User's manual for more information)
	Tool Weight	3.1 pounds* (1.45Kg)	Weight of applicator with electrical and airline, without cartridge.

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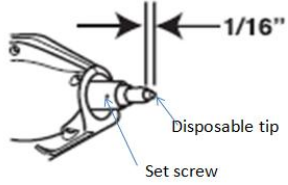
Repair/Replacement Parts






3M™ Scotch-Weld™ PUR Easy 250 Applicator








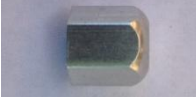
	Item #	Part Description	3M ID Number	Part No.	Comments
	1	Air supply line	62-9895-0005-3	21200-89479	
	2	Air Valve Trigger	62-9845-0009-0	48011-57410	See installation guide provided with Air Valve Trigger for installation information.
	3	Coupler Filter	62-9895-0001-2	21200-89475	
	4	End Cap	62-9895-0003-8	21200-89476	
	5	End Cap Seal	62-9895-0004-6	21200-89477	Seal is located inside of end cap. See installation guide provided with seal for installation information.
	6	Wire Stand	62-9895-0033-5	21200-89483	
	7	Nozzle Housing/shroud kit	62-9865-9950-4	51115-25783	Stk # also includes Item #11 nozzle shroud. (Replaces stk# 62-9845-0030-6)
	8	On/off Switch	62-9895-0024-4	21200-89482	See installation guide provided with on/off switch for installation information
	9	Power Cord	62-9895-0021-0	21200-89481	
	10	Swivel Connector	62-9845-9934-0	48011-58298	(Quick Dump valve old stk# 62-9895-0020-2) See installation guide provided with swivel connector for installation information.

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Repair/Replacement Parts <i>Continued</i>	Item #	Part Description	3M ID Number	Part No.	Comments
	11	Nozzle Shroud	62-9845-0029-8	48011-58320	3 shrouds per bag, 1 bag per case
	Not shown	Disposable plastic tip	78-8132-7930-0		Can only be order by 3M Sales Representative
Nozzle Shroud adjustment with Disposable Nozzle	Attached a disposable nozzle onto a 3M™ Scotch-Weld™ PUR Easy 250 or PUR Adhesive cartridge and load into the 3M™ Easy 250 applicator. With the cartridge loaded the tip of the disposable nozzle should extend past the shroud by approximately 1/16". If the tip of the disposable nozzle is not adjusted correctly loose set screw located on the side of the nozzle housing (see diagram below). Then adjust the shroud either in or out until the tip of the disposable nozzle is protruding approximately 1/16" beyond the shroud as shown. Tighten set screw to secure shroud.				

3M™ Scotch-Weld™ PUR Accessories	Part Description	3M ID Number	Part No.	Comments
	3M™ Scotch-Weld™ PUR Easy 250 Cartridge Preheater	62-9865-9930-6	51115-23564	Used to preheat up to 4-1/10 gallon cartridges at a time.
	3M™ Hot Melt Applicator Foot Pedal Assembly 9277	62-9277-9930-4	21200-82278	Can be used with Benchmount bracket assembly for hands free operation of 3M™ Scotch-Weld™ Easy 250 applicator
	3M™ Scotch-Weld™ Polyurethane Reactive Adhesive Benchmount Bracket Assembly	62-9895-9950-1	21200-30086	Comes with Bracket only does not include stand shown in picture. Allows for hands free operation when used with foot pedal assembly
	Main Nozzle	62-9895-0018-6	21200-89515	Not for use with disposable plastic nozzle. Does not include valve, tip or tip cap.
	Main Nozzle Assembly	62-9895-0019-4	21200-89514	Not for use with disposable plastic nozzle. Includes valve, tip(0.090") and tip cap.

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3M™ Scotch-Weld™ PUR Accessories <i>Continued</i>	Part Description	3M ID Number	Part No.	Comments
	Valve	62-9773-0012-8	21200-83730	Use with main nozzle assembly 62-9895-0018-6 or 62-9895-0019-4. See installation guide provided with valve for installation information.
	Low Flow tip -0.062" orifice	62-9895-0016-0	21200-89472	3 tips per bag, 1 bag per case. Use with main nozzle assembly 62-9895-0018-6 or 62-9895-0019-4.
	Extension tip - 0.072" orifice	62-9895-0015-2	21200-89471	3 tips per bag, 1 bag per case. Use with main nozzle assembly 62-9895-0018-6 or 62-9895-0019-4.
	Tip - 0.090" orifice	62-9773-0013-6	21200-87191	3 tips per bag, 1 bag per case. Use with main nozzle assembly 62-9895-0018-6 or 62-9895-0019-4.
	High Flow tip – 0.125" orifice	62-9895-0017-8	21200-89473	3 tips per bag, 1 bag per case. Use with main nozzle assembly 62-9895-0018-6 or 62-9895-0019-4.
	Tip Cap	62-9773-0014-4	21200-87194	3 caps per bag, 1 bag per case. Use with main nozzle assembly 62-9895-0018-6 or 62-9895-0019-4.

3M™ Scotch-Weld™ PUR Adhesives for use in 3M™ Scotch-Weld™ Easy 250 applicator	PURs - Easy 250 (yellow labels)	PURs (Purple labels)
	EZ250015	TE015
	EZ250030	TE030
	EZ250060	TE031/TE031 Black
	EZ250120	TE040/TE040 Black
	EZ250150	TE100/TE100 Black
	EZ250200	TE200
		TS115HGS
	TS230White/TS230 Black	

Available Package Sizes 3M™ Scotch-Weld™ PUR adhesives	1/10 gallon cartridge ^{1,2}	2 Kilo bag ³	5 gallon pail	55 gallon drum
	10 fluid ounces/295ml	2 Kgs(4.4 pounds)	36 pounds (16.3 Kgs)	400 pounds (181.4 Kgs)
	Thread size for nozzle M15 X 1.5	Slug OD. – 5.0" (127 mm)	Pail ID. – 11.25" (285.8mm) Pail Ht. – 13.5" (343 mm)	Drum ID. – 23.6" (600.5 mm) Drum Ht. – 34.8" (883.9 mm)
1- Packed 5 -1/10 gallon cartridges per case. 2-10 disposable plastic nozzles are supplied with each case of adhesive. 3-Packed 6 -2kg bags per case.				

Approximate Coverage per container (Linear ft per container based on 1/8" dia. Bead size)	1/10 gallon cartridge	2 Kilo bag	5 gallon pail	55 gallon drum
	250' (76.2m)	1650' (502.9m)	13,500' (4114.8m)	170,200' (51876.9m)

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Adhesive Warm - up	1/10 gallon Cartridges: Should be heated for a minimum of 45 minutes in either the 3M™ Pre-heater (US - Pn.23564) or Easy 250 PUR Adhesive Applicator (US - Pn. 23563). The PUR can be held at dispensing temperature for up to 16 hours* (total time in pre-heater and applicator). Refer to the 3M™ Polyurethane Reactive (PUR) Easy 250 Adhesive Applicator User's Manual for complete information on applicator requirements, cartridge loading, and adhesive application.
	*Note: It is recommended that adhesive heated longer than this total time be discarded and fresh adhesive introduced.

Adhesive Application	After heating adhesive to 250°F (121°C) ¹ , apply an adequate amount of 3M™ Scotch-Weld™ PUR Adhesive to one of the substrates to be bonded. Adhesive should only be applied to clean, dry surfaces. (See surface preparation below for additional information) For the best results apply the PUR only on substrates that are at ambient/room temperature prior to adhesive application. Join the substrates within the recommended open time and hold/fixture the bonded part until the adhesive has adequately set. Do not move or adjust surfaces after contact has been made, as inferior bond strength will result.
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¹-Dispensing temperature should never exceed 275°F (135°C)

Precautionary Information Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577 or (651) 737-6501.

Technical Information The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

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