

LOCTITE®

2331226 EQ CL36 LED Cure Chamber

Operating Manual



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1 Please Observe the Following

1.1 Emphasized Sections

Warning!

Refers to safety regulations and requires safety measures that protect the operator or other persons from injury or danger to life.


Caution!


Emphasizes what must be done or avoided so that the unit or other property is not damaged.

Notice:

A notice gives recommendations for better handling of the unit during operation or adjustment as well as for service activities.

1.2 For Your Safety


 For safe and successful operation of the unit, read these instructions completely. If the instructions are not observed, the manufacturer can assume no responsibility.


 Do not expose the connecting cable to heat, oil, or sharp edges.


 Do not bypass interlock any time.


 Make sure the Unit stands stable and secure.

 Use only original equipment replacement parts.

 Always wear UV glasses when operating the chamber.

 Always disconnect the power supply before servicing the unit.

 Observe general safety regulations for the handling of chemicals such as Loctite® adhesives and sealants. Observe the manufacturer's instructions as stated in the Safety Data Sheet.

 While under warranty, the unit may be repaired only by an authorized Loctite service representative.

1.3 Unpacking and Inspection

Carefully unpack the Loctite® CL36 LED Cure Chamber and examine the items contained in the carton. Inspect the unit for any damage that might have occurred in transit. If such damage has occurred, notify the carrier immediately. Claims for damage must be made by the consignee to the carrier and should be reported to the manufacturer.

1.4 Items supplied

- 1.4.1 CL36 LED Cure Chamber
- 1.4.2 Equipment Manual
- 1.4.3 Power Cord

1.5 Features

- 1.5.1 Variable light intensity
- 1.5.2 Two 200mm x 200mm LED flood lights, top and side
- 1.5.3 Rotary table with 2kg payload
- 1.5.4 Touch screen user interface with color display
- 1.5.5 Accepts part sizes up to 300mm x 300mm x 255mm
- 1.5.6 Independently adjustable digital timers for top and side LED floods
- 1.5.7 Uniform intensity throughout chamber volume
- 1.5.8 Universal power supply

1.6 Usage

The Loctite® CL36 LED Curing Chamber is an all-new, state-of-the-art UV curing station that's been specifically designed and engineered for printed parts with Loctite resin.

Providing a reliable and professional post-curing solution, the Form Cure has 405 nm UV light from multi-directional UV LEDs and a rotating turntable ensure complete penetration, while a constant heat source bakes parts to achieve the most desirable finish for all engineering resins.

2 Description

The Loctite® CL36 LED Curing Chamber a high-performance LED system for curing UV adhesive. The chamber is a closed system. It is used for applications permitting manual loading of the cure chamber.

The chamber offers 405nm LED. There are 2 pcs of 200x200 mm LED floods in one chamber, one on top and one on side. With a rotary table, the chamber can cure all sides of parts in one time.

Variable intensity capability allows adjustment of the light intensity based on the application and resin type, resulting in optimal cured performance of the resin. Adjustable from 10-100% in 1% increments.

Large 200 x 200mm top and side LED flood lights allow for a wide range of part sizes. LED floods provide instant on/off and do not emit infrared emissions, which can cause part warpage. LED life ~ 20,000 hours

The chamber equips touch screen, which offers friendly UI.

3 Technical Data

Overall Dimensions, L x H x W (mm)	471.05 x 372 x 573
Cure Chamber Dimensions, L x H x W (mm)	304 x 300 x 255
Weight, lbs. (kg)	110 (50kg)
Power Supply	110-240VAC 50/60Hz
LED Wavelength	405nm
Maximum Intensity	205mW/cm ² @40mm WD
Recommended Operating Temperature	+10 ° C to +40 ° C (+50 ° F to +104 ° F)

4 Installation

! Before using the equipment for the first time check it carefully for signs of external damage. If any shipping damage is found DO NOT USE THE EQUIPMENT – return it to your supplier immediately.

4.1 Environmental and Operating Conditions

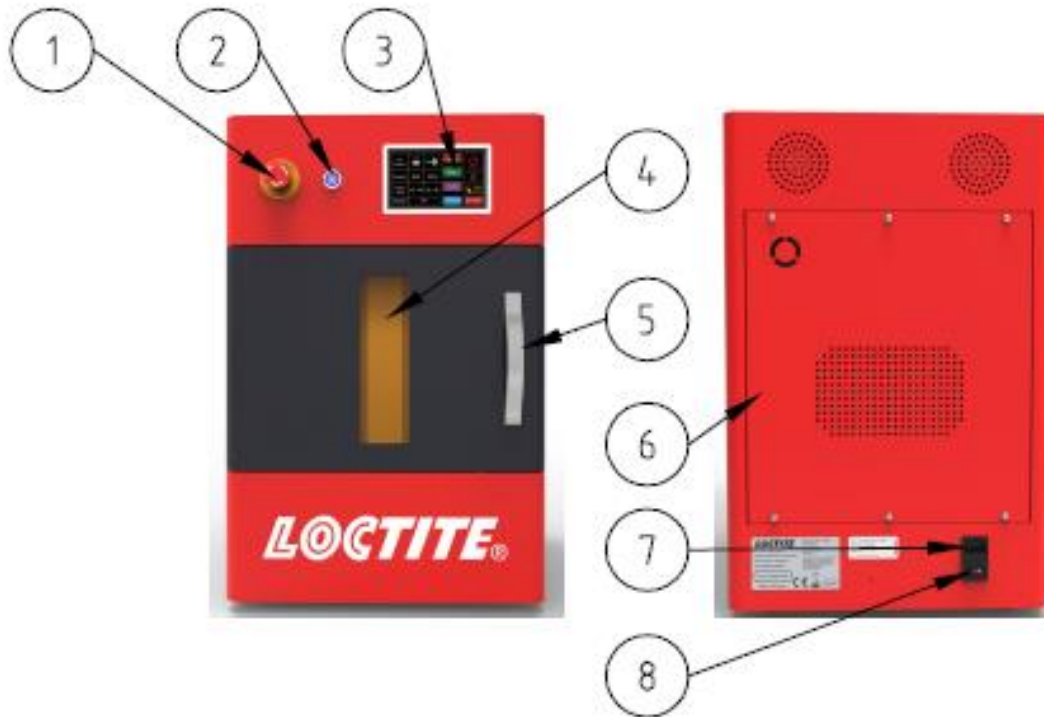
- The equipment should be installed in a dry, well ventilated and dust-free place.
- To ensure proper ventilation, install the unit at a distance of at least 100 – 150 mm from a wall or neighboring object.


4.2 Connecting the Unit

Make sure to provide a stable power supply of nominal 110~240 V AC 50/60 Hz.

5 Setup

5.1 Overview



1. EMO Button
2. ON/OFF Switch
3. Operation Panel
4. Observation Screen
5. Door Handel
6. Rear Side Panel
7. Power Inlet
8. Power Switch
9. Side LED Flood
10. Top LED Flood
11. Door Switch
 Do not press door switch any time.
12. Rotary Table

5.2 Electrical Connection

Plug the AC power cord into NO. 7 Power Inlet, which located in rear side of chamber.

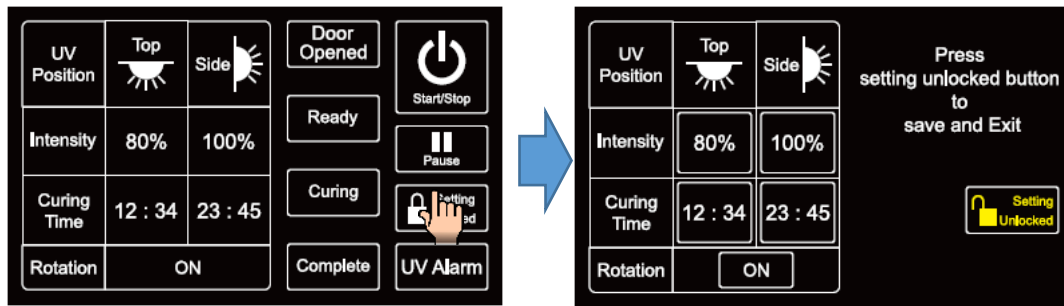
5.3 Turn on Chamber

- Switch on the power switch (No. 8).
- Make sure EMO button (No. 1) be released.
- Turn on No. 2 switch.

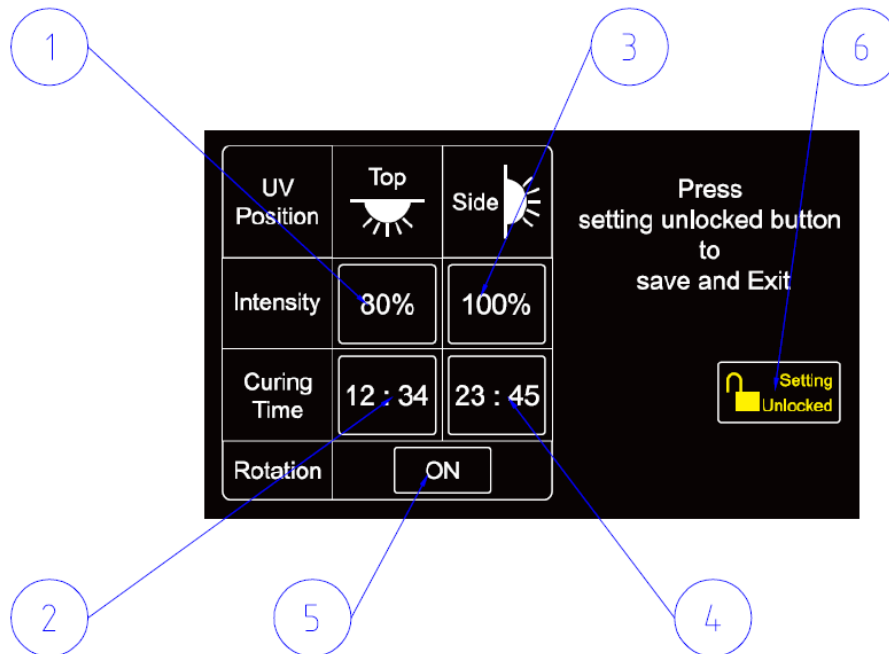
6 Operation

6.1 Setup Parameter

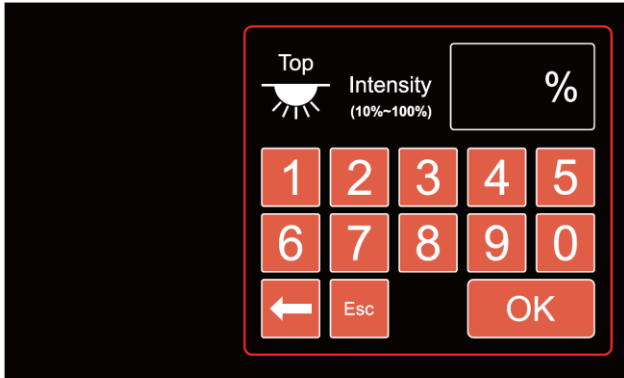
As below picture, press Setting Locked button on panel, will enter setup page.



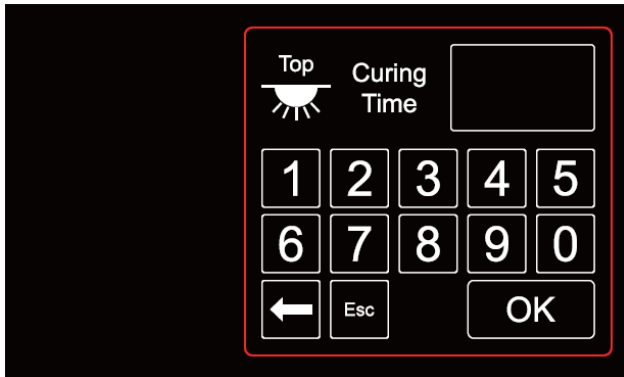
Click each area to setup each parameter, detail as below:



1. Setup LED power for top flood. The adjust range is 10~100%



2. Setup timer for timer for top flood.



The curing time will be shown as "xx:xx". Front two means minutes, rear two means second. The max. is 99 minutes and 59 seconds.

For example:

when you key in "3", the curing time will be "00:03", means curing time is 3 seconds.

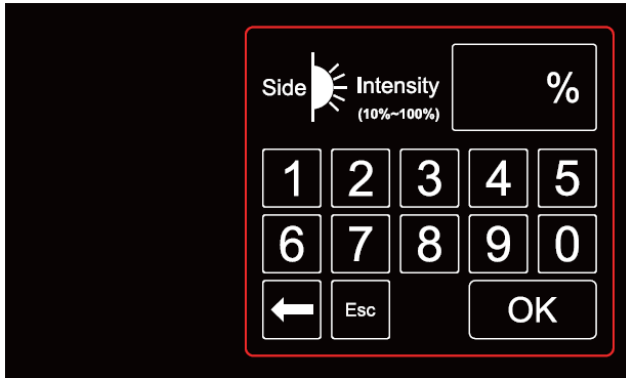
when you key in "30", the curing time will be "00:30", means curing time is 30 seconds.

When you key in "130", the curing time will be "01:30", means curing time is 1 minutes and 30 seconds.

When you key in "1130", the curing time will be "11:30", means curing time is 11 minutes and 30 seconds.

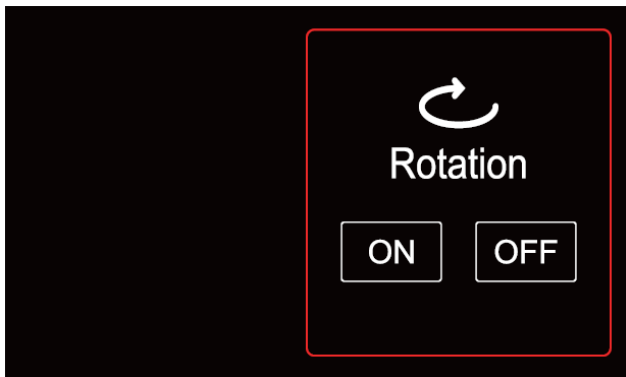
When you set time to 0, the flood will not work during curing.

3. Setup LED power for side flood.



4. Setup curing time for side flood.

5. Setup rotary table. You will define if the table will rotate during curing or not.

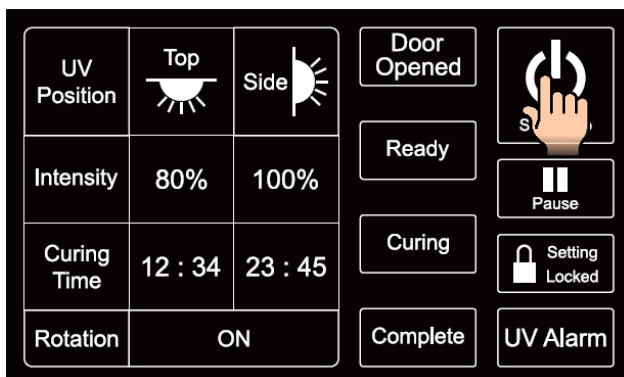




6. Click this button to save and exit.

6.2 Run the Chamber

As below picture, click below button (START/STOP) to run the chamber.

You also can click the START/STOP button to stop the chamber during curing.

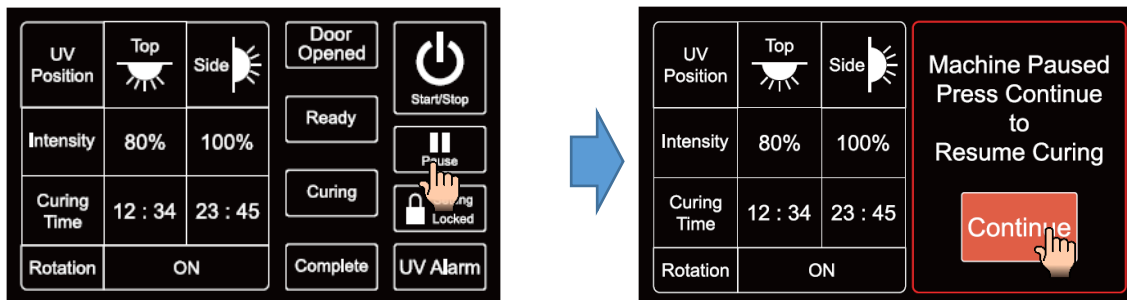


Once curing finish, “Complete” indicator will show as , you will need to open the door, or click  two times to recover the statue.


6.3 Pause

As below picture, click the PAUSE button to pause during curing. And click “Continue” to back to cure

Timer will continue when back from pause.



7 Troubleshooting

 Before proceeding with any repair or maintenance operation disconnect the tool from the main electricity supply.

Malfunction	Possible Cause	Corrective
No display appears on the screen	Main power cable is disconnected	Check that the main power cable is connected to an AC source.
	EMO button has been activated	Turn the EMO button clockwise until it pops out.
	Main switch is not turned on	Turn on the main switch, which locate on front top panel.
	Fuse break	Check the fuse in power inlet.
Cannot start curing, indicate "Door Open"	Door is opened	Close door.
	Door switch is defective.	Check door switch. Contact Henkel service
Cannot start curing, indicate "Complete"		Press START button twice. Or open door and close it.
Indicator "UV ALARM"	LED flood overheat	Shutdown machine and wait for cooling down.
	LED flood error	Contact Henkel service.

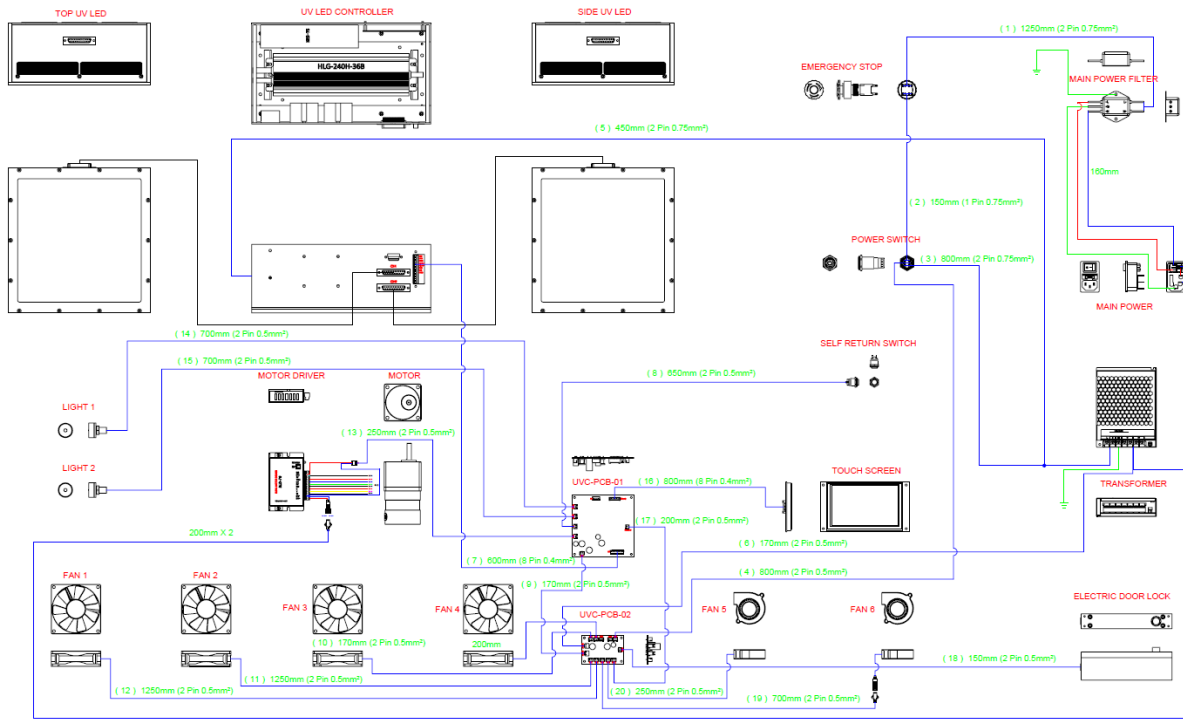
8 Care and Maintenance

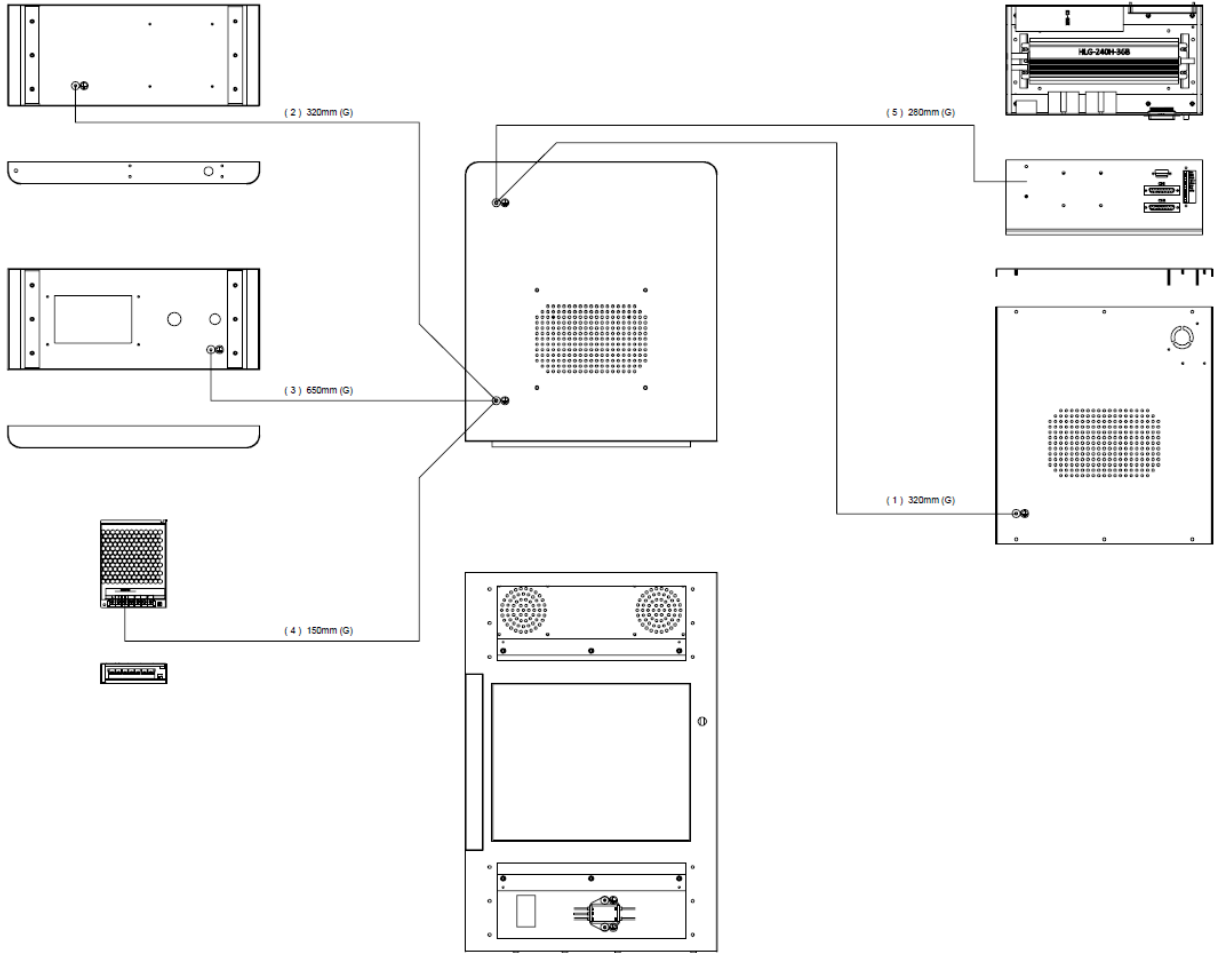
The unit requires no special care and maintenance.

9 Accessories and Spare Parts

OPTIONAL ACCESSORIES & SPARE PARTS	
UV V Light Radiometer Dosimeter	265282
EQ PR11 DLP PRINTER	2416987
EQ PR10 DLP PRINTER	2312297
EQ CL36 CABLE	2423147
CL36 LED CONTROLLER	2423148
CL36 LED FLOOD HEAD	2423149

10 Diagrams





11 Warranty

Henkel expressly warrants that all products referred to in this Instruction Manual for (#2331226 Loctite® CL36 LED Cure Chamber) (hereafter called “Products”) shall be free from defects in materials and workmanship. Liability for Henkel shall be limited, as its option, to replacing those Products which are shown to be defective in either materials or workmanship or to credit the purchaser the amount of the purchase price thereof (plus freight and insurance charges paid therefor by the user). The purchaser’s sole and exclusive remedy for breach of warranty shall be such replacement or credit.

A claim of defect in materials or workmanship in any Products shall be allowed only when it is submitted in writing within one month after discovery of the defect or after the time the defect should reasonably have been discovered and in any event, within (12) months after the delivery of the Products to the purchaser. This warranty does not apply to perishable items. No such claim shall be allowed in respect of products which have been neglected or improperly stored, transported, handled, installed, connected, operated, used or maintained. In the event of unauthorized modification of the Products including, where products, parts or attachments for use in connection with the Products are available from Henkel, the use of products, parts or attachments which are not manufactured by Henkel, no claim shall be allowed.

No Products shall be returned to Henkel for any reason without prior written approval from Henkel. Products shall be returned freight prepaid, in accordance with instructions from Henkel.

NO WARRANTY IS EXTENDED TO ANY EQUIPMENT WHICH HAS BEEN ALTERED, MISUSED, NEGLECTED, OR DAMAGED BY ACCIDENT.


EXCEPT FOR THE EXPRESS WARRANTY CONTAINED IN THIS SECTION, HENKEL MAKES NO WARRANTY OF ANY KIND WHATSOEVER, EXPRESS OR IMPLIED, WITH RESPECT TO THE PRODUCTS.

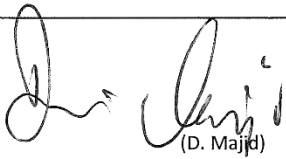
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12 Declaration of Conformity

Konformitätserklärung	
Der Hersteller gemäß der EU-Richtlinien	Henkel AG & Co. KGaA Standort München Gutenbergstr. 3 D-85748 Garching bei München
erklärt, dass das nachfolgend bezeichnete Gerät auf Grund seiner Konzipierung und Bauart den unten aufgeführten europäischen Richtlinien, harmonisierten Normen und nationalen Normen entspricht.	
Bezeichnung des Gerätes	EQ CL36 LED Aushärtekammer 405 nm
Gerätenummer	2331226
Einschlägige EU-Richtlinien	EU-Maschinenrichtlinie 2006/42/EG EU-Richtlinie Elektromagnetische Verträglichkeit 2014/30/EU EU-Richtlinie Niederspannung 2014/35/EU EU-Richtlinie RoHS 2011/65/EU EU-Richtlinie WEEE 2012/19/EU
Angewandte harmonisierte Normen	EN ISO 12100:2010 EN 61000-6-1:2007+A1:2011, EN 61000-6-3:2007, EN 61000-3-2:2014, EN 61000-3-3:2013 EN 60204-1:2006+A1:2009+AC:2010: EN 50581:2012
Bevollmächtigter für die technischen Unterlagen	Henkel AG & Co. KGaA Standort München Gutenbergstr. 3 D-85748 Garching bei München
Garching, 2018-06-29	 (D. Majid) Business Director AG Deutschland/Schweiz Standortleiter München

Declaration of Conformity	
The Manufacturer according to the EC regulations	Henkel AG & Co. KGaA Standort München Gutenbergstr. 3 D-85748 Garching bei München
declares that the unit designated in the following is, as a result of its design and construction, in accordance with the European regulations, harmonized standards and national standards listed below.	
Designation of the unit	EQ CL36 LED Cure Chamber 405 nm
Unit number	2331226
Applicable EC Regulations	EC Directive of Machinery 2006/42/EC EC Directive for Electro-Magnetic Compatibility 2014/30/EU EC Directive of Low Voltage 2014/35/EU EC Directive of RoHS 2011/65/EU EC Directive of WEEE 2012/19/EU
Applicable harmonized standards	EN ISO 12100:2010 EN 61000-6-1:2007+A1:2011, EN 61000-6-3:2007, EN 61000-3-2:2014, EN 61000-3-3:2013 EN 60204-1:2006+A1:2009+AC:2010: EN 50581:2012
Authorized person for technical files	Henkel AG & Co. KGaA Site Munich Gutenbergstr. 3 85748 Garching bei München Germany
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Manual P/N: 9001877, Rev B, Date Created: 08/01/2018, Revision Date: 09/14/2018