

SGT-PPA-150 3M™ VHB™ STRUCTURAL GLAZING TAPE APPLICATOR



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UNITED STATES – HOME OFFICE

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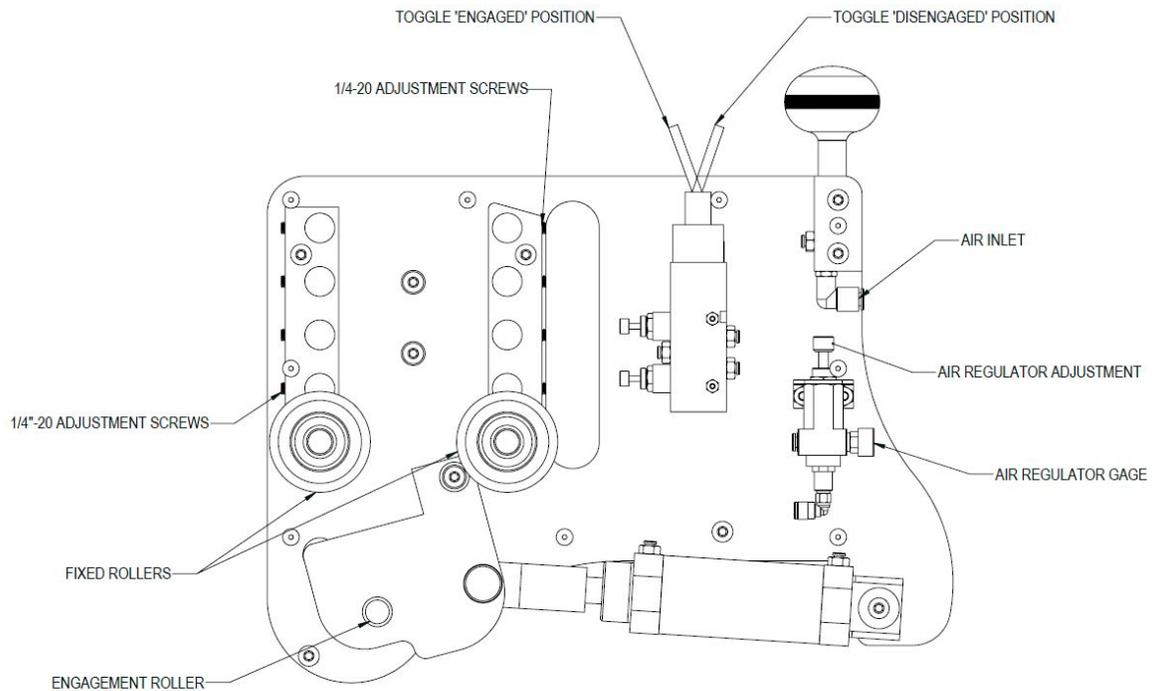
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DUE TO THE PROCESS OF CONTINUOUS IMPROVEMENT, THE PRODUCTS AND PROCEDURES IN THIS GUIDE ARE SUBJECT TO CHANGE WITHOUT NOTICE

GUIDE REVISION INFORMATION				
ACTIVITY	ADDENDUM RELEASE #	PAGES REVISED	RELEASE DATE	AUTHOR
MOST RECENT	#4	1	5/26/21	RAN
	#3	5	4/15/16	RAN
PREVIOUS REVISIONS	#2	3	9/17/15	MSW
	#1	Original Release	08/26/15	JLR

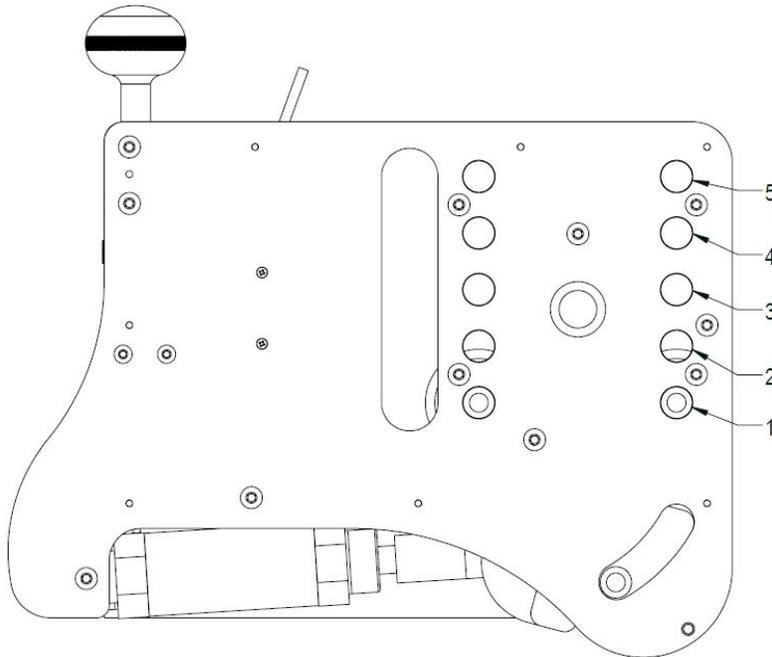
OVERVIEW

This is general documentation for the Developmental Industries' (DI) Pneumatic Pressure Applicator SGT-PPA-150. It is intended to apply final pressure when bonding glass or metal panels to frames with 3M™ VHB™ Structural Glazing Tape. This document outlines the use of the DI-SGT-PPA-150 for structural glazing applications. Contact your 3M™ VHB™ Structural Glazing Tape Sales Specialist or Technical Service Representative to determine the suitability of 3M™ VHB™ Structural Glazing Tape for structural glazing applications.



SET-UP

The SGT-PPA-150 has five (5) sets of holes in which the upper roller wheels can be adjusted. To determine the proper setup, add the thickness of all materials to be pressed. Then, determine the correct roller placement from the following chart:



RANGE CHART		
POSITION	MINIMUM	MAXIMUM
5	4 3/4" (121MM)	5 15/16" (151MM)
4	3 5/8" (92MM)	4 13/16" (122MM)
3	2 1/2" (64MM)	3 11/16" (94MM)
2	1 3/8" (35MM)	2 1/2" (64MM)
1	3/8" (9.5MM)	1 7/16" (36MM)

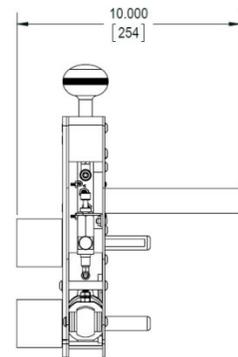
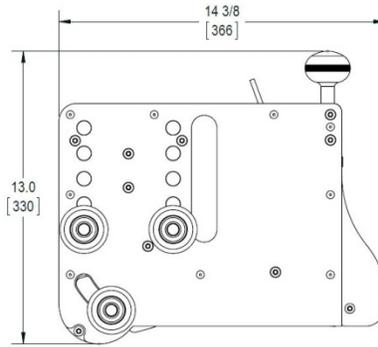
To change roller positions, disconnect the air supply and loosen the 1/4"-20 set screws with the 1/8" Allen wrench supplied. Slide the fixed roller shafts out of the current position (1-5) and slide them into the desired position (1-5). Note that both fixed rollers are to be placed in the same numbered position. Take care to align the flat of the roller shaft to the outside of the tool to ensure the set screw will only contact the flat of the shaft. The shaft can be damaged and difficult to reposition if the set screw is tightened on the shaft anywhere but the flat.

All rollers can also be adjusted in and out to a maximum extension of about 1-1/8" off of the skid plate. Use a metal rule or tape measure to ensure all three rollers are the same distance off of the plastic skid plate. Some applications may require the roller wheels to be offset to accommodate a specific frame profile. It is the responsibility of the end-user to select the proper roller wheel positioning for each specific project.

OPERATION

Once the correct position is selected, be sure the toggle switch is in the 'disengage' position and connect the air hose with the quick-connect fitting to your air supply. **Adjust the regulator until the gauge reads 7.5 (75 psi).** *Note: Some glazing applications may require a different pressure setting. Contact 3M technical support for the desired setting for your application.*

Once the regulator gage is set, the toggle switch will now cycle the movable cylinder. Cycle the roller several times to ensure proper movement. With the toggle switch in the 'disengage' position, apply the upper rollers on the



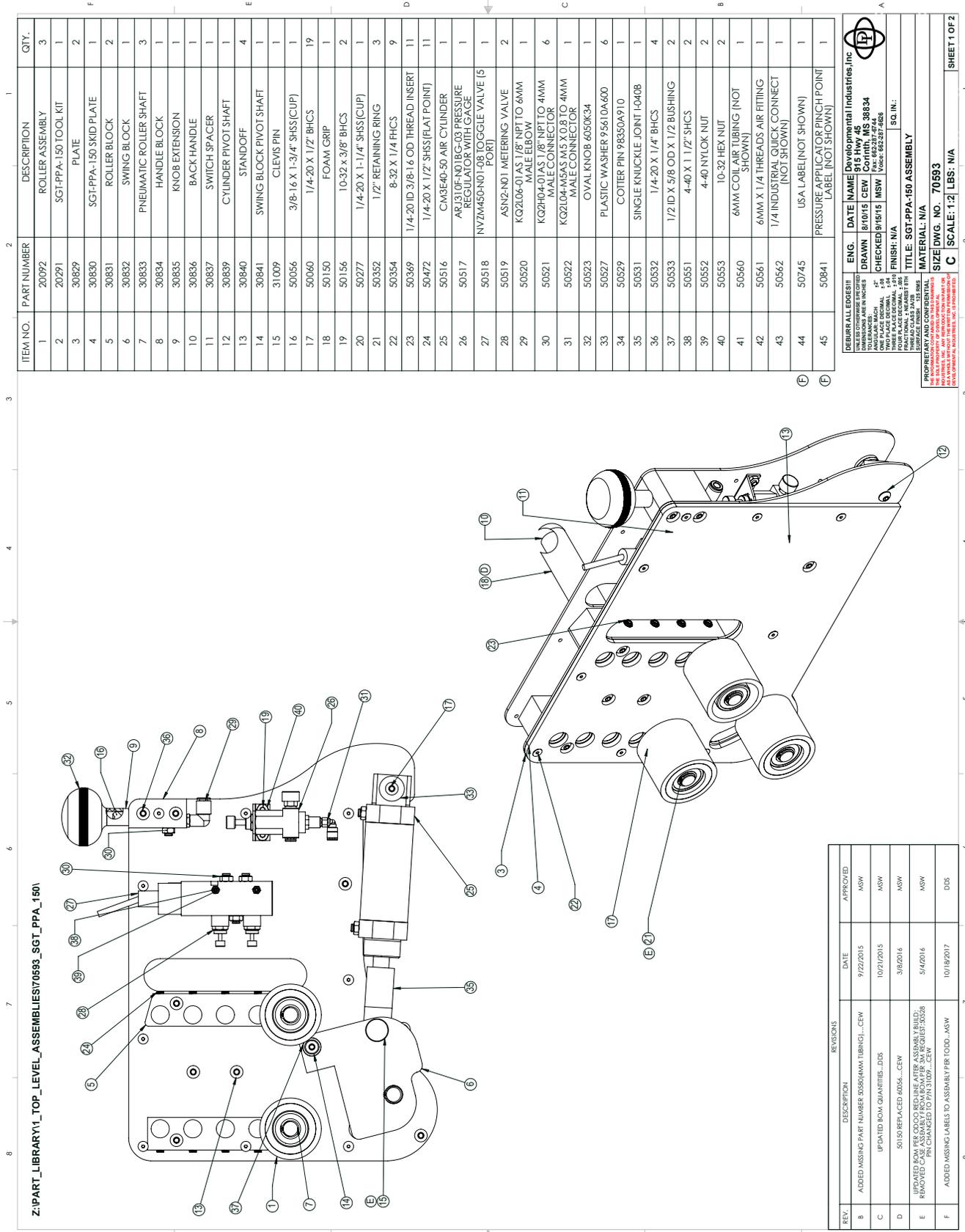
material with the skid plate near the edge of the frame assembly. Toggle the switch to the 'engage' position. The device is now applying pressure and ready for use. Use the provided handles to guide the tool and avoid applying pressure to moving parts.

The rate of movement should be approximately **2 feet in 5 seconds**. Apply pressure in two passes, back and forth, down the entire length of the frame assembly. To remove the device, simply toggle the switch to the 'disengage' position to open the rollers. Repeat the process on all edges of the panel. Be careful not to run the upper rollers off the panel edge as this may break the glass panel and/or damage the tool.

TOOL MAINTENANCE

The SGT-PPA-150 tool has been designed with minimal moving parts. Maintenance is very simple and consists of keeping the rollers clean (of uncured silicone).

Cleaning: The roller wheels can be cleaned using a towel wet with a mixture of isopropyl alcohol and water (50:50). Heavy contamination can be removed using 3M™ Adhesive Remover (Citrus Base) 6040 with a clean towel or a 3M™ Scotch-Brite™ Ultra-Fine Hand Pad 7448. Complete a final cleaning using a mixture of isopropyl alcohol and water (50:50).



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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	20092	ROLLER ASSEMBLY	3
2	20291	SGT-PPA-150 TOOL KIT	1
3	30829	PLATE	2
4	30830	SGT-PPA-150 SKID PLATE	1
5	30831	ROLLER BLOCK	2
6	30832	SWING BLOCK	1
7	30833	PNEUMATIC ROLLER SHAFT	3
8	30834	HANDLE BLOCK	1
9	30835	KNOB EXTENSION	1
10	30836	BACK HANDLE	1
11	30837	SWITCH SPACER	1
12	30839	CYLINDER PIVOT SHAFT	1
13	30840	STANDOFF	4
14	30841	SWING BLOCK PIVOT SHAFT	1
15	31009	CLEVIS PIN	1
16	50036	3/8-16 X 1-3/4' SHSS(CUP)	1
17	50060	1/4-20 X 1/2' BHCS	19
18	50150	FOAM GRIP	1
19	50156	10-32 X 3/8" BHCS	2
20	50277	1/4-20 X 1-1/4" SHSS(CUP)	1
21	50352	1/2" RETAINING RING	3
22	50354	8-32 X 1/4 FHCS	9
23	50369	1/4-20 ID 3/8" 1.6 OD THREAD INSERT	11
24	50472	1/4-20 X 1/2" SHSS(FLAT POINT)	11
25	50516	CM3E40-50 AIR CYLINDER	1
26	50517	ARJ310F-N01BC-03 PRESSURE REGULATOR WITH GAUGE	1
27	50518	NV2M450H01-08 TOGGLE VALVE (5 POKI)	1
28	50519	ASN2-N01 METERING VALVE	2
29	50520	KQ2L06-01 AS 1/8" NPT TO 6MM MALE ELBOW	1
30	50521	KQ2H04-01 AS 1/8" NPT TO 4MM MALE CONNECTOR	6
31	50522	KQ2L04-M5AS M5 X 0.8 TO 4MM MALE CONNECTOR	1
32	50523	OVAL KNOB 6050K34	1
33	50527	PLASTIC WASHER 95610A-600	6
34	50529	COTTER PIN 98350A910	1
35	50531	SINGLE KNUCKLE JOINT H040B	1
36	50532	1/4-20 X 1/4" BHCS	4
37	50533	1/2 ID X 5/8 OD X 1/2 BUSHING	2
38	50551	4-40 X 1 1/2" SHCS	2
39	50552	4-40 NYLON NUT	2
40	50553	10-32 HEX NUT	2
41	50560	6MM COIL AIR TUBING (NOT SHOWN)	1
42	50561	6MM X 1/4 THREADS AIR FITTING	1
43	50562	1/4 INDUSTRIAL QUICK CONNECT (NOT SHOWN)	1
44	50745	USA LABEL(NOT SHOWN)	1
45	50841	PRESSURE APPLICATOR PINCH POINT LABEL (NOT SHOWN)	1

DEBURR ALL EDGES!!!	ENG.	DATE	NAME	Developmental Industries, Inc.
USABLE OVERHANGS PER DTD	DRAWN	8/10/15	CEW	915 Hwy 45
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SUPPORT

DI is a full-service supplier offering tool recertification services that can be completed within two (2) weeks of receipt of the tool. Expediting service can be requested. Additional information, service plans, and pricing can be found at www.mmmsupplier.com. Contact us with any parts or service needs.

Developmental Industries, Inc.

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