SGT-PPA-150

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Part #50567
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:
To change roller positions, disconnect the air supply and loosen the ¼"-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 on 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 gage reads 7.5 (75 lbs).** 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 MANINTENANCE**

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).
SUPPORT
DI is a full service supplier offering tool recertification services that can be completed within two (2) weeks of receipt of 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.

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