

# OPERATION MANUAL

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## HAT-500 HYDRAULIC ADHESION TESTER



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## OPERATION

### **Safety**

When using the cyanoacrylate adhesive, ensure the work area is well ventilated, wear gloves and do not let any adhesive come into contact with your skin.

### **Taking Measurements**

Roughen the surface of the dolly using a fine-grade emery paper and remove any residue or dust. Check that no adhesive has been left in the dolly hole by trial fitting a plastic plug.

Clean the dolly surface and test area with a degreasant.

Insert the plastic plug into the dolly until the tip protrudes from the surface. Carefully apply a thin coat of adhesive to the surface of the dolly (try not to get any adhesive on the plastic plug).

Press the dolly onto the surface using thumb pressure for approximately 10 seconds and then remove the plastic plug. If you are testing a pipe using curved dollies, ensure that the aligning mark is lined up with the longitudinal axis of the pipe. Do not twist the dolly as this could introduce air bubbles. Allow the adhesive to dry for approximately 15 minutes.

Connect the HAT-500 to the dolly by pulling back the snap-on ring, pushing the head and releasing the snap-on ring. Ensure the HAT-500 is held so that the rubber hose is straight.

To pressurise the HAT-500, turn the handle clockwise. To decrease the pressure, turn anticlockwise. Set the red needle to zero before pressurising.

To destructively test the coating, increase the pressure slowly until the dolly pulls off. To non-destructively test the coating, increase the pressure slowly until the specified minimum value has been reached; you can then decrease the pressure to zero and remove the head. The dolly can be removed by using the heated dolly remover. The pressure is recorded from the red needle.

The cyanoacrylate adhesive should not be used with thermoplastic, non-convertible paint systems due to chemical reactions that could affect adhesion results. These paint systems include cellulose, vinyls, chlorinated rubbers and some acrylics. For these paint systems we suggest that a two-pack epoxy adhesive should be used.

Always store the HAT-500 with a dolly fitted to the head. This will prevent any damage to the pin.

### **Dolly Cleaning**

After use, clean the dolly with the dolly remover. A duration of 3–5 minutes per dolly should normally be sufficient to degrade the adhesive, which can then be scraped off. Ensure the work area is well ventilated. The hole can be cleaned using the drill bit.

### **Routine Maintenance**

If the HAT-500 is not used on a regular basis, you will need to pressurise once a month to 2500psi and leave for 1 minute. Always pressurise with the dolly fitted.

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