

Andre AdJet[®] Valve



1. Introduction “external sealants”

Acrylate adhesives, better known as ‘external sealants’, are very low-viscosity acrylates that possess excellent capillary flow properties, enabling them to flow into even the tightest fits like the case mouth area. These adhesives cure anaerobically (in the absence of oxygen) and under UV radiation (360–405 nm).

2. Handling with External Sealants

When using these acrylates, it is important to follow the instructions below:

1. Acrylates react with water, so avoid humidity; for example, use a dehumidifier in the pneumatic system.
2. Acrylates react with metal ions, so never allow them to come into contact with metal.
3. They cure anaerobically, i.e. they begin to cure when no oxygen is present (e.g. in the fit of the case mouth).
4. The use of LDPE tubing and containers is recommended. LDPE (low density) promotes the exchange with oxygen and prevents drying out. Opening the bottle is actually beneficial.

As they harden when exposed to UV light, protect them from direct sunlight or LED light

3. Dispensing AdJet valve

The Andre AdJet dispensing valve is a user-friendly valve for precise application of low viscosity adhesives. Due to its compact size, it can be easily integrated into existing machines. **It is compatible with Hernon Shureshot without any changes.**

The M8 sensor socket and exchangeable dosing needles allow a quick exchange of the components.

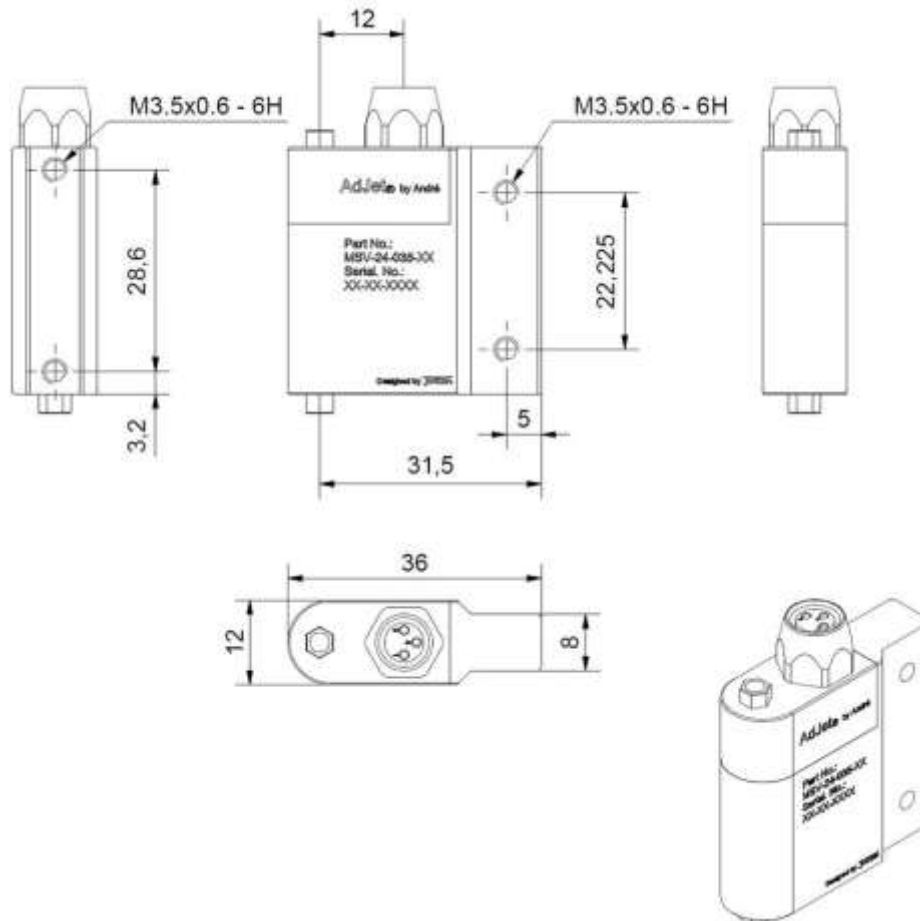


Main features:

- changeable dispensing nozzles (different sizes and length), recommend distance between nozzle and the application part is 5-7 mm
- M8 sensor socket
- fast response time
- easy to clean with 99,9% IPA or acetone (stronger)

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4. Dimensions



General FAQ /User Manual

Valve Settings

Which distance between needle and ammunition is needed?
As close as possible, we commend 5-7 mm

Which angle of the valve is recommended?
For the bullet from top and for the primer horizontal position

What is the optimum operation pressure?
Depends on the needle diameter, approx. 1 – 1.3 bar

What is the optimum operation time?
Depends on the needle diameter, 4-7 msec
For fine adjustment, please use the Andre controller. 1A.20.099.26

What is the Ohm rate ?
40 Ohm

What's the recommend cleaning material ?
Acetone (very strong) or IPA (99.9%), do not use IPA that contains water.

What's the recommend tube length ?
Tube length between valve and pressure reservoir should be maximum 150 cm

Why do bubbles form at the tip of the needle and why is the adhesive not being jetted?

1. Air pressure is too low

If the dispensing pressure is too low, a small amount of adhesive may remain inside the needle after each cycle. Increasing the pressure slightly often solves the problem. However, if the pressure is set too high, the adhesive may be ejected continuously instead of being jetted correctly.

2. The needle inner diameter is too large

An oversized needle can negatively affect jetting performance. We offer dispensing needles with different inner diameters to optimize the process for your application.

3. Spike duration is too long

*An incorrect spike duration can influence the jetting behavior. Our **Andre Controller** allows precise adjustment of the valve control with pulse times below **0.5 ms**, enabling optimum dispensing performance.*

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4. Contamination prevents the valve from closing completely

*Contamination inside the valve or needle can prevent the valve from sealing properly, resulting in bubble formation or poor jetting performance. Our new generation of **External Sealant** is formulated **without pigments**, significantly reducing the risk of clogging and ensuring more reliable long-term operation.*

5. Maintenance

Before the initial installation and prior to dispensing the acrylate, it is important to flush the entire valve system with fresh IPA, acetone or another chemically compatible ketone to eliminate any moisture that may have accumulated in the tank, feed tubing and valve. You can position a bottle of IPA/acetone directly inside the pressure tank. Adjust your supply pressure to approximately 1 bar at the pneumatic regulator. Place a small container or cleaning rag beneath the valve nozzle to catch the acetone. Turn on the system and initiate the jetting process. Let the acetone flow through the valve until it has been completely dispensed from the tank, fluid lines, and valve.

6. Accessories

4.1 Dispensing needle

Stainless steel with PTFE inlet

ID 0.19 mm, length 9mm

ID 0.25 mm, length 9mm

4.2 Fitting

Peek or POM material for 4/2 mm hoses or 3.2/2.2 mm

Hoses, controler, sensor cable, pressure tank upon request.

