

## Metcal 922BT-STIFF

# Metcal 922BT-STIFF Series BT Nylon Double Helix Stiff Bristle Brush Tip User Manual

Model: 922BT-STIFF

## 1. PRODUCT OVERVIEW

The Metcal 922BT-STIFF Series BT Nylon Double Helix Stiff Bristle Brush Tip is designed for precise "spread" applications, such as the controlled dispensing and spreading of glues, fluxes, and other viscous materials. This tip features a stiff nylon bristle construction with a double helix design, ensuring consistent material flow and application. It is supplied in a pack of 12, providing ample supply for various tasks.



Figure 1: Metcal 922BT-STIFF Series BT Nylon Double Helix Stiff Bristle Brush Tip.

## 2. SETUP AND INSTALLATION

These brush tips are designed for use with compatible dispensing systems. Ensure the dispensing system is clean and free of any residue from previous applications before installation.

- 1. Inspect the Tip:** Before attaching, visually inspect the brush tip for any damage or manufacturing defects. Ensure the bristles are intact and the tip is clean.
- 2. Prepare Dispenser:** Ensure your dispensing pen or system is ready to accept a new tip. Refer to your dispenser's manual for specific attachment instructions.

3. **Attach the Tip:** Securely attach the 922BT-STIFF brush tip to the dispensing system. It should fit snugly to prevent leaks or dislodgement during use. Do not overtighten.
4. **Load Material:** Load the desired material (e.g., glue, flux) into the dispensing system according to the system's instructions.



Figure 2: Example of Metcal brush tips, illustrating different bristle types. The 922BT-STIFF features stiff nylon bristles.

### 3. OPERATING INSTRUCTIONS

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The 922BT-STIFF brush tip is designed for controlled application and spreading of materials. Follow these general guidelines for optimal performance:

- **Material Flow:** Initiate material flow by activating your dispensing system. Start with a low pressure setting and gradually increase until the desired flow rate is achieved.
- **Application Technique:** Gently touch the brush tip to the surface where the material is to be applied. The stiff bristles and double helix design facilitate even spreading.
- **Controlled Spreading:** Move the brush tip smoothly across the surface to spread the material. The stiff bristles help maintain control and prevent excessive material buildup.
- **Avoid Excessive Pressure:** Do not apply excessive downward pressure, as this can damage the bristles or lead to inconsistent application.
- **Clean Between Uses:** If applying different materials or if there are pauses in work, clean the tip as described in the Maintenance section to prevent clogging.

### 4. MAINTENANCE AND CARE

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Proper maintenance extends the life of your brush tips and ensures consistent performance.

- **Immediate Cleaning:** After each use, especially with quick-drying materials, immediately clean the brush tip to prevent material from hardening within the bristles.
- **Cleaning Solvents:** Use a solvent compatible with the material being dispensed. For water-based materials, warm water may suffice. For glues or resins, consult the material's manufacturer for recommended cleaning agents.
- **Gentle Cleaning:** Gently agitate the bristles in the cleaning solvent. Avoid harsh scrubbing or bending the bristles excessively, as this can deform the tip.
- **Drying:** Allow the brush tip to air dry completely before storage or next use. Ensure no solvent residue remains.
- **Storage:** Store unused and cleaned brush tips in a clean, dry environment, away from direct sunlight and extreme temperatures. Keep them in their original packaging or a protective container to prevent damage to the bristles.
- **Replacement:** Replace brush tips when bristles show signs of wear, fraying, or if consistent material flow cannot be achieved.

## 5. TROUBLESHOOTING

This section addresses common issues you might encounter with the brush tips.

Problem	Possible Cause	Solution
Inconsistent material flow or clogging.	Material hardened in bristles; air bubbles in material; incorrect material viscosity.	Clean the tip thoroughly. Purge air from the dispensing system. Ensure material viscosity is suitable for brush application.
Bristles appear splayed or damaged.	Excessive pressure during application; improper cleaning or storage; tip is worn out.	Reduce application pressure. Review cleaning and storage procedures. Replace the brush tip if severely damaged or worn.
Material leaking from tip attachment point.	Tip not securely attached; damaged tip base.	Ensure the tip is properly and securely attached to the dispenser. Replace the tip if the base is damaged.

## 6. SPECIFICATIONS

Attribute	Detail
Model Number	922BT-STIFF
Brand	Metcal
Material	Nylon (Stiff Bristle)
Tip Type	Double Helix Brush Tip
Gauge	22 Gauge
Quantity	Pack of 12
Product Dimensions (per item)	Approximately 3.54 x 3.15 x 0.79 inches
Item Weight (per item)	Approximately 0.71 ounces (0.02 Kilograms)
Manufacturer	OK International
Country of Origin	USA

## 7. WARRANTY AND SUPPORT

Metcal products are manufactured to high standards. For specific warranty information regarding the 922BT-STIFF brush tips, please refer to the documentation provided with your original purchase or visit the official Metcal website. As consumable items, brush tips typically have a limited warranty against manufacturing defects. For technical support, product inquiries, or to report any issues, please contact Metcal customer service or your authorized distributor. Contact information can usually be found on the Metcal website or on your purchase invoice.

- **Metcal Official Website:** [www.metcal.com](http://www.metcal.com) (Please verify the current official website for the most up-to-date information.)
- **Customer Service:** Refer to the website for regional contact details.

