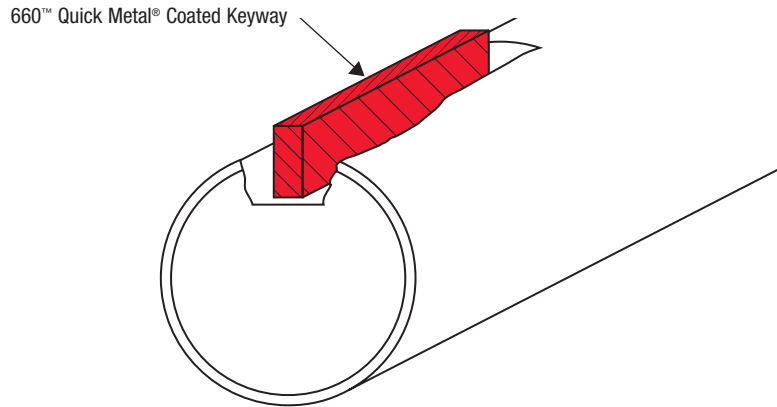


STRENGTHEN KEYED ASSEMBLIES

REPAIRING BADLY WALLOVED KEYWAY



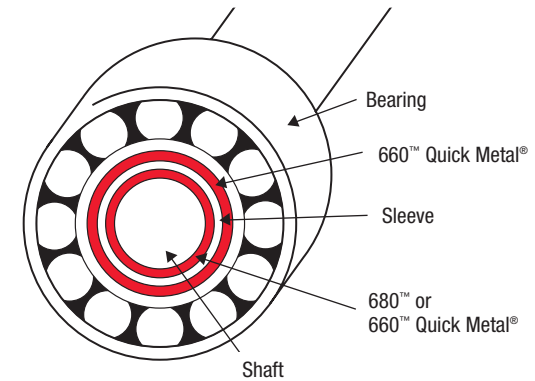
1. Clean all parts with Loctite® ODC-Free Cleaner & Degreaser.
2. If necessary, spray all parts with Loctite® 7649™ Primer N™. Allow to dry.
3. Apply a Loctite® 660™ Quick Metal® Retaining Compound coating into keyway.
4. Assemble as required using Loctite® 660™ Quick Metal® Retaining Compound.
5. Allow 30-60 minute cure time.

Note:

- Loctite® 660™ Quick Metal® Retaining Compound is NOT recommended for lateral gaps exceeding .010".
- Higher strengths are obtained by NOT using Loctite® 7649™ Primer N™ with small (.002"-.004") gap, and allowing longer cure (4-24 hours).

SHAFT MOUNTED ASSEMBLIES

REPAIRING BADLY WORN SHAFT



1. Determine a minimum radial gap.
2. Select and trim appropriate sleeve to allow component slip fit.
3. Roughen sleeve O.D. with emery cloth.
4. Clean all parts with Loctite® ODC-Free Cleaner & Degreaser.
5. Apply a Loctite® 680™ or Loctite® 660™ Quick Metal® Retaining Compound coating around the shaft.
6. Install sleeve.
7. Apply a coating of Loctite® 660™ Quick Metal® Retaining Compound to sleeve O.D.
8. Install component as required onto sleeved shaft.
9. Allow 30-60 minute cure.

Note:

- Loctite® 660™ Quick Metal® Retaining Compound is NOT recommended for radial gaps exceeding .010".
- Higher strengths are obtained by NOT using Loctite® 7649™ Primer N™ with small (.002"-.004") gap, and allowing longer cure (4-24 hours).