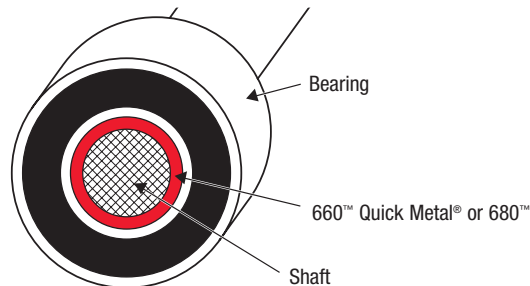


# SHAFT MOUNTED ASSEMBLIES

## SLIP FIT - LIGHT/HEAVY DUTY



### ORIGINAL

1. Machine shaft to .002" radial slip fit with 50-80 rms finish (second cut).
2. Clean all parts with Loctite® ODC-Free Cleaner & Degreaser.
3. Spray all parts (I.D. and O.D.) with Loctite® 7649™ Primer N™. Do NOT use primer for heavy duty applications.
4. Apply a Loctite® 660™ Quick Metal® Retaining Compound coating around shaft and engagement area.
5. Assemble parts with rotating motion.
6. Wipe off excess.
7. Allow 2 hours prior to service.

### WORN SHAFT

Follow directions above except:

1. Determine radial gap.
2. If radial gap exceeds .005", Loctite® 7649™ Primer N™ must be used.
3. Take steps to maintain concentricity with large gaps.
4. Larger gaps require longer cure times (30-60 minutes).
5. Loctite® 660™ Quick Metal® Retaining Compound is NOT recommended for radial gaps exceeding .010".
6. See procedure for BADLY WORN SHAFT page 19.

**Note:** Loctite® 660™ Quick Metal® Retaining Compound is very fast fixturing (30 seconds or less) with Loctite® 7649™ Primer N™.

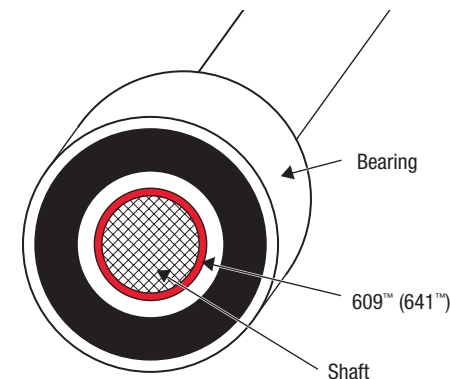
### MAXIMUM STRENGTH

1. Same as above, except use Loctite® 680™ Retaining Compound with Loctite® 7471™ Primer N™ or no primer.
2. Allow 4-24 hours to cure.

### MAXIMUM TEMPERATURE (400°F continuous)

# SHAFT MOUNTED ASSEMBLIES

## PRESS FIT



### STANDARD

1. Clean shaft O.D. and component I.D.
2. Apply a bead of Loctite® 609™ (641™) Retaining Compound to circumference of shaft at leading edge of insertion or leading area of engagement.  
**Note:** • Retaining compound will always be squeezed to the outside when applied to shaft.  
• Do NOT use with Loctite® Anti-Seizes or similar product.
3. Press as usual. Wipe off excess.
4. No cure time required.  
**Note:** Loctite® 609™ (641™) Retaining Compound is used due to low viscosity and wetting properties.

### TANDEM MOUNT

1. Apply retaining compound to bore of inside component.
2. Continue assembly as above.