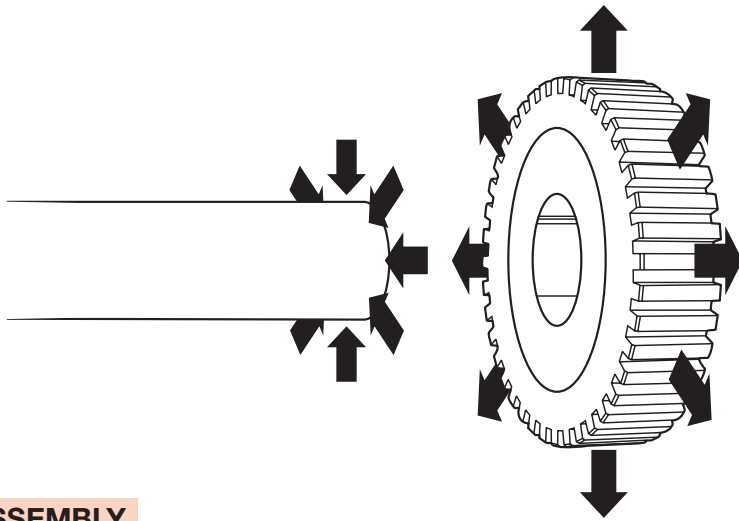


SHAFT MOUNTED ASSEMBLIES

SHRINK FIT



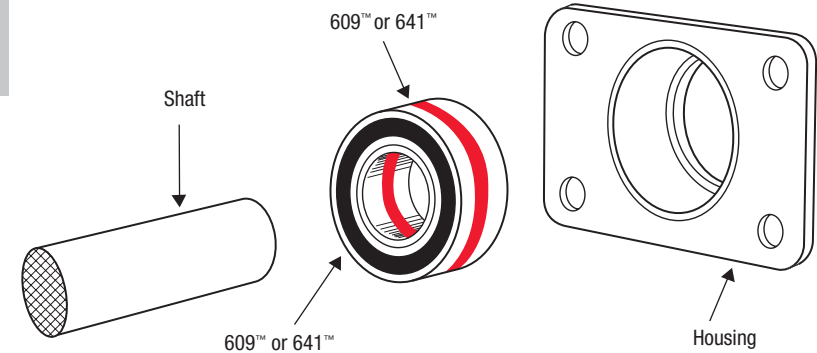
ASSEMBLY

1. Clean the shaft O.D. and component I.D.
2. Cool the shaft to cause contraction, or heat the component to cause expansion.
3. Apply a brush film of Loctite® 641™ Retaining Compound to the shaft or lower temperature part.
4. Install component and allow temperatures to equilibrate.
5. Wipe off excess.

Note: Loctite® 641™ Retaining Compound will add lubricity for easier assembly while sealing and protecting the bond area from environmental exposure and filling gaps for a more complete contact area.

HOUSED COMPONENTS

SLIP FIT



ORIGINAL

1. Select component to fit shaft.
2. Machine to reduce component O.D. or increase housing I.D. to permit approximate .002"-.004" diametral slip fit.
3. Clean all parts with Loctite® ODC-Free Cleaner & Degreaser and spray with Loctite® 7649™ Primer N™.
4. Apply Loctite® 609™ or 641™ Quick Metal® Retaining Compound to component O.D.
5. Install component. Do not rotate.
6. Wipe off excess.
7. Allow five minutes prior to service.

WORN

Procedures identical to original slip fit, except:

1. Determine the maximum radial gap.
2. If the maximum gap exceeds .005", Loctite® 7649™ Primer N™ must be used.
3. Take steps to maintain concentricity on large gaps.
4. Large 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 HOUSING page 24.