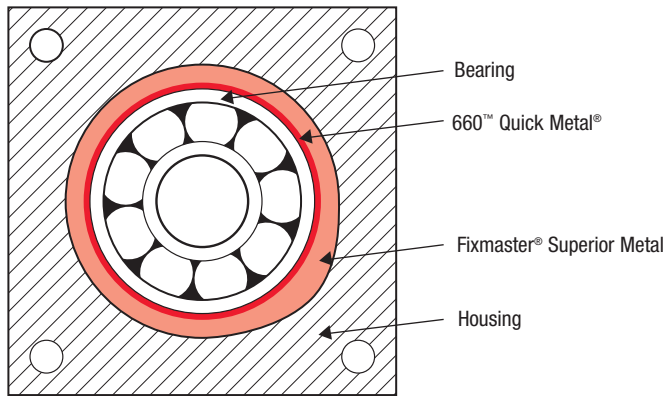


# HOUSED COMPONENTS

## REPAIRING BADLY WORN HOUSING



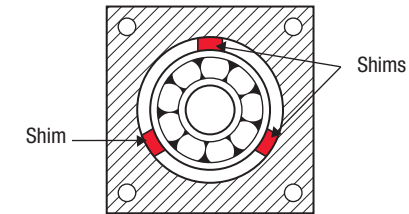
### ASSEMBLY

1. Roughen housing I.D. with emery cloth or abrasive media.
2. Clean the housing I.D. with Loctite® ODC-Free Cleaner & Degreaser.
3. Clean the component O.D. and apply a release agent.
4. Prepare (mix) Loctite® Fixmaster® Superior Metal.
5. Apply a coating of Loctite® Fixmaster® Superior Metal to the I.D. of the housing.
6. Position the component in housing. Maintain concentricity.
7. Pack Loctite® Fixmaster® Superior Metal into the gaps and voids.
8. Wipe off excess material.
9. Allow to cure 30 minutes.
10. Pull component.
11. Clean the release agent from component O.D.
12. Clean and roughen the housing I.D.
13. Assemble with Loctite® 660™ Quick Metal® Retaining Compound as required.
14. Recommended for light duty service.

**Note:** This procedure is for use when machining is not an option. If you want a procedure for using Loctite® Fixmaster® Superior Metal and machining back to original tolerance, then contact your local Henkel Adhesive and Sealants Specialist.

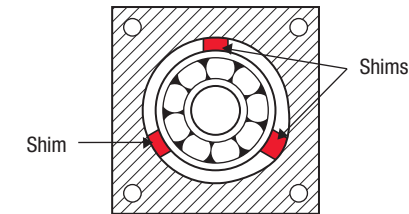
# HOUSED COMPONENTS

## COMPONENT CENTERING



### EXCESSIVE / EVEN WEAR

1. Position the component in bore.
2. Select three equilateral mounting points.
3. Determine the radial gap at those points.
4. Select appropriate shim stock.
5. Cut three pieces approximately 1/8" wide to fit bore depth.
6. Bond the shims to bore at mounting points using Loctite® 380™ Black Max® Instant Adhesive.
7. Assemble per instructions on page 23.



### EXCESSIVE / UNEVEN WEAR

1. Position the component in bore.
2. Select three equilateral mounting points.
3. Determine the radial gap at those points.
4. Select and cut appropriate shim stock for each point.
5. Bond the shims to bore at mounting points using Loctite® 380™ Black Max® Instant Adhesive.