

Instructions for using ergo.® anaerobic retaining compounds

Area of application

Liquid, single-component ergo.® retaining compounds are used to secure bearings and other cylindrical parts into shafts or onto housings. The adhesive is applied as a liquid and cures when it is confined between two metal substrates that are isolated from air/oxygen.

Instructions

Assembly

Remove all traces of grease from the surface of the components using ergo.® 9190 Metal Cleaner and allow to dry.

If the surface material is an inactive metal, it can be primed with ergo.® 4900 accelerator (sprayed or dipped). Allow the solvent to evaporate. Please also refer to the Technical Data Sheet for the activator.

For slip fitted assemblies, apply a 360° bead of adhesive to the front edge of the pin and to the inside of the hub and assemble components by rotating them 90°.

For bonded press fitted assemblies, apply adhesive evenly to both mating surfaces and quickly assemble at high press on rates.

For heat shrink fitted assemblies, apply a continuous and even film of the adhesive to the shaft. Heat the hub to $\leq 130^{\circ}\text{C}$. Quickly assemble components.

Do not disturb parts before the adhesive reaches sufficient handling strength.

Disassembly

Remove using commercially available, standard hand tools such as extractors or pullers.

If hand tools do not work because of excessive engagement, apply heat to the bonded area to $\geq 250^{\circ}\text{C}$ and disassemble while hot.

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