

LOCTITE*Adhesives for more
reliable assemblies***APPLICATION CASE HISTORY****No. 118**

Pump Wear Sleeves Assembled Using Loctite® RC™ 609 Retaining Compound

Problem:

On sleeve bearing pumps, normal procedure dictates that they be hardened and ground to achieve long life. Hardening tends to warp a shaft, and where long warped shafts have to be corrected by grinding, tremendous expense can be experienced. Once warpage has occurred, key fitted ends and impeller threads can never be economically corrected.

Solution:

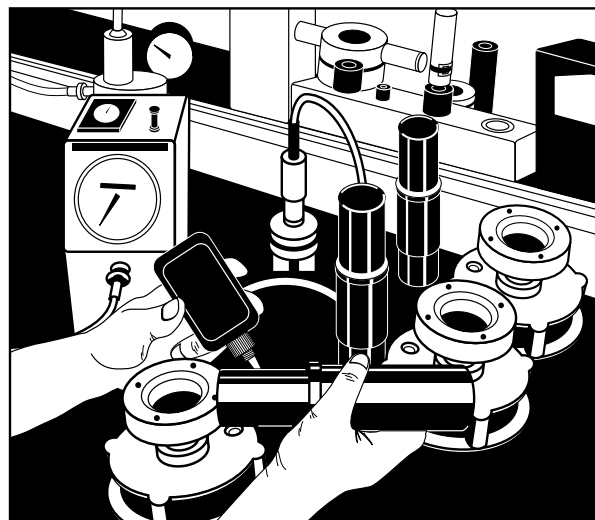
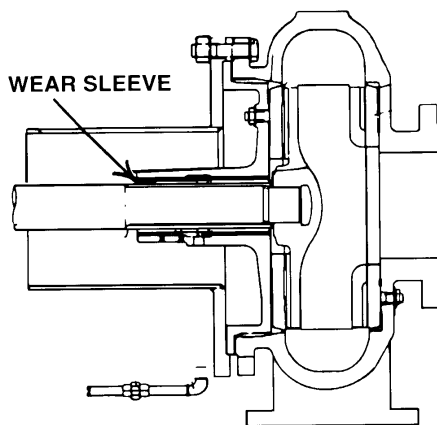
One of our customers decided to put an end to this expensive operation and chose a new approach using Loctite RC 609 Retaining Compound.

Straight shafting is used with one end turned accurately in one chucking. Wear sleeves are assembled at the plain bearing location using the following procedure:

- Step 1: Both mating parts are cleaned with Loctite Cleaning Solvent 755.
- Step 2: Locquic® Primer T is applied to both parts.
- Step 3: Several rings of RC 609 is applied to the shaft and sleeve.
- Step 4: The parts are mated and twisted 180° to ensure total adhesive coverage.

Results:

The cost of this new methods cuts the expense in half while producing a quieter-running, longer-living assembly.

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