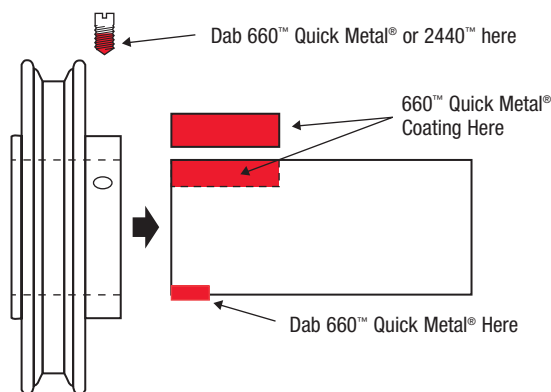


STRENGTHEN KEYED ASSEMBLIES

STANDARD DUTY



ASSEMBLY

1. Clean all parts with Loctite® ODC-Free Cleaner & Degreaser.
2. If necessary, spray all parts (I.D. and O.D.) with Loctite® 7649™ Primer N™.
3. Apply Loctite® 660™ Quick Metal® Retaining Compound coating into keyway and on key.
4. Apply dab(s) of Loctite® 660™ Quick Metal® Retaining Compound onto shaft opposite keyway or evenly spaced around shaft.
5. Assemble parts. Wipe off excess.
6. Apply Loctite® 660™ Quick Metal® Retaining Compound dab to set screw.
7. Tighten set screw.
8. Allow 5-10 minutes prior to service.

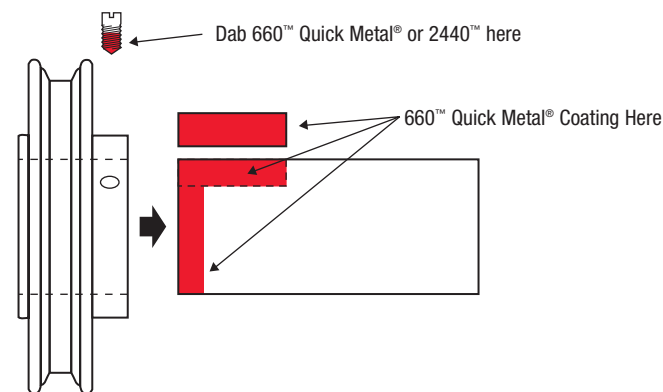
- Note:**
- Loctite® 660™ Quick Metal® Retaining Compound is NOT recommended for radial gaps exceeding .010" on shaft or keyway.
 - See REPAIRING BADLY WALLOUED KEYWAY for procedure page 18.

DISASSEMBLY

1. Tap component and key with hammer.
2. Pull as usual.

STRENGTHEN KEYED ASSEMBLIES

HEAVY DUTY



ASSEMBLY

1. Clean all parts with Loctite® ODC-Free Cleaner & Degreaser.
2. Apply a Loctite® 660™ Quick Metal® Retaining Compound coating around shaft, into keyway, and on key.
3. Assemble parts. Wipe off excess.
4. Apply a Loctite® 660™ Quick Metal® Retaining Compound dab to screw.
5. Tighten set screw.
6. Allow 30 minutes prior to service.

- Note:**
- If gap exceeds .005", use Loctite® 7649™ Primer N™ on appropriate area (shaft or keyway).
 - Loctite® 660™ Quick Metal® Retaining Compound is NOT recommended for radial gaps exceeding .010" on shaft or keyway.
 - See REPAIRING BADLY WALLOUED KEYWAY for procedure page 18.

DISASSEMBLY

1. Tap component and key with hammer.
2. If necessary, apply localized heat (450°F for five minutes).
3. Pull while hot.