



### ***I. Product Description***

CRC Sleeve Retaining Compound is a single component anaerobic retaining and locking adhesive which develops extremely high strength. CRC Sleeve Retaining Compound cures between close fitting metal parts where there is an absence of air. This product will augment shrink and press fit assemblies in demanding vibrational and high-friction applications.

### ***II. Applications***

The product is designed for the bonding of cylindrical fitting parts. It can be applied to retaining sleeves, pulleys, gears, rotors, bushings, bearings and housing plugs. Recommended for filling gaps of .010.

### ***III. Features & Benefits***

- Compare to Loctite 640
- Designed for the bonding of cylindrical fitting parts
- Prevents loosening and leakage
- Fast cure time

### ***IV. Physical Properties***

<b>Base Compound</b>	Dimethcrylate Ester	<b>Toxicity</b>	Low
<b>Appearance</b>	Green Liquid	<b>Shelf Life @ 40°F</b>	1 year unopened
<b>Specific Gravity</b>	1.1	<b>Shear Strength (Steel nuts &amp; bolts)</b>	4500 psi
<b>Viscosity (cP @ 68°F)</b>	500 cP	<b>Flash Point (TCC)</b>	>200°F
<b>Service Temperature</b>	-75°F to 450°F	<b>Locking Strength</b>	Very High
<b>Full Cure Time</b>	24 hours		
<b>Gap Fill</b>	.010		
<b>Corrosivity</b>	None		

### ***V. Performance of Cured Material***

Bond Strength after 24 hours at 20°C to 25°C on steel nuts and bolts

	<b>Avg. Value</b>	<b>Range</b>
<b>Breakaway Torque</b>	100 in. lbs.	50 -150 in. lbs.
<b>Prevailing Torque</b>	300 in. lbs.	200 – no limit in. lbs.

### ***VI. Specifications and Approvals***

- MIL-R-46082B Type II

## VI. Directions

### For Assembly:

1. For best results, clean all surfaces (external and internal) with a CRC cleaning solvent and allow to dry.
2. Shake the product well before use.
3. **For Slip Fitted Assemblies**, apply adhesive around the leading edge of the pin and the inside of the collar and use a rotating motion during assembly to ensure good coverage.
4. **For Press Fitted Assemblies**, apply adhesive thoroughly to both bond surfaces and assemble at high press on rates.
5. For Shrink Fitted Assemblies **the adhesive should be coated onto the pin, the collar should then be heated to create sufficient clearance for free assembly.**
6. Allow assembly to cure for a minimum of 15 minutes before handling.
7. An adequate bond develops in 15 to 45 minutes and maximum strength is attained in 24 hours.

### For Disassembly:

1. Apply localized heat to nut or bolt to approximately 250° C. Disassemble while hot.

### For Cleanup:

1. Cured product can be removed with a combination of soaking in a CRC solvent and mechanical abrasion such as a wire brush.

**NOTE:** This product is not recommended for use in pure oxygen environments and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials. This product is not designed for plastics, particularly thermoplastics where stress cracking of the plastic could result. It is recommended to confirm compatibility of the product with all substrates prior to use.

## VII. Package Description

Part Number	Container Size
04537	1 oz Bottle
04535	4 oz Bottle
04536	16 oz Bottle

## VIII. Disposal

Disposal requirements vary by state and local jurisdiction. All used and unused product should be disposed of in conformance with local, state and federal regulations.

## IX. Special Use Warnings

### General

Use only in well ventilated area. Ventilation may be improved by opening a window or door or providing mechanical assistance. Vapors will accumulate readily and may ignite. Avoid continuous breathing of vapor and spray mist. Avoid contact with skin and eyes. If ventilation is not adequate, respiratory protection should be worn. For more information regarding short term and long term exposure, review this product's Material Safety Data Sheet.

**DISCLAIMER:** This information is accurate to the best of CRC Industries' knowledge or obtained from sources believed by CRC to be accurate. Before using any product, read all warnings and directions on the label. All products should be tested for suitability on a particular application prior to actual use. CRC Industries, Inc. makes no representations or warranties of any kind concerning this data.