



Cyclo Industries, Inc

401 Maplewood Dr • Jupiter, FL 33458 • 561-775-9600

TECHNICAL DATA SHEET

Worn Parts Retaining Compound

C-66050

3. Assemble as per directions.

PRODUCT DESCRIPTION

Cyclo® Worn Parts Retaining Compound is a one component, anaerobic, paste-consistency retaining compound for cylindrical joints. This product cures when confined in the absence of air between metal surfaces. This product possesses excellent gap cure properties.

PRODUCT BENEFITS

- Creamy consistency that can be smoothed onto parts to repair worn areas
- No mixing required
- Resistant to oils, cutting fluids, chlorinated solvents, gas, diesel fuel
- Quickly gets parts back into service
- Restores fit to worn shafts and housings

TYPICAL APPLICATIONS

- Refitting worn shafts and housings
- Repair worn keyways
- Repair loose set screws
- Refit worn couplings
- Form-in-place shims

DIRECTIONS FOR USE

1. For best results, surfaces should be clean and free of oil and grease.
2. Completely fill joint with adhesive.
3. For slip fitted assemblies, apply adhesive around the pin and the leading edge of the collar. Using a rotating motion will ensure good coverage.
4. For press fitted assemblies, apply adhesive to both bonded surfaces and assembled 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 enough clearance for free assembly
6. Parts should not be disturbed until sufficient handling strength is achieved.
7. Product that squeezes outside the joint will not cure. Wipe off with cloth.

For Cleanup

1. Wipe off excess material with a clean cloth.
2. Clean hands with soap and water.

For Disassembly

1. Apply localized heat to assembly to approximately 232°C(450°F). Disassemble while hot.

For Reassembly

1. Remove any loose product from the assembly.
2. Apply primer to mating parts.

PHYSICAL PROPERTIES

	Typical Value
Appearance	Grey paste
Specific Gravity	1.13
Viscosity (cP)	1,200,000
Flash Point (T.C.C.), °C (°F)	>93 (>200)
Gap Fill (inches)	0.005 to 0.020
Temperature Range °C (°F)	-54 to +149 (-65 to +300)
Cure speed (75°F) Fixture –	10 minutes
Full cure –	24 hours

TYPICAL CURING PERFORMANCE

Cure speed vs. substrate

The rate of cure will depend on the material used. **Cyclo®** Worn Parts Retaining Compound will react faster and stronger with **Active Metals**. However, **Inactive Metals** will require the use of an activator (**Cyclo®** C-930 Surface Preparation) to obtain maximum strength and cure speed at room temperature.

Active Metals	Inactive Metals
Soft Steel Iron	Bright Platings
Copper	Anodized Surfaces
Brass	Titanium
Manganese	Zinc
Bronze	Pure Aluminum
Nickel	Stainless Steel
Aluminum Alloy	Cadmium

The graph below shows the breakaway strength developed with time on 3/8" - 16 Grade 5 bolts and Grade 8 nuts compared to different materials.

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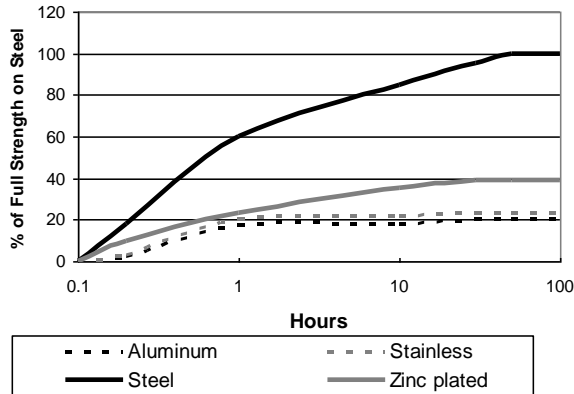
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Cure Speed vs Substrate

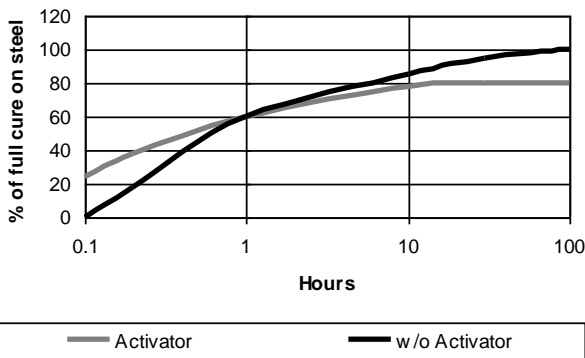


Cure speed vs. activator

Where cure speed is unacceptably long, or large gaps are present, applying an activator (**Cyclo® C-930 Surface Preparation**) to the surface will improve cure speed. A 3/8-16 steel nut and bolt assembly will fixture in about 5 minutes using an activator, while fixturing will occur in about 20 minutes without an activator. Full cure in 24 hours for both procedures.

The graph below shows the breakaway strength developed with time using **Cyclo® C-930 Surface Preparation**.

Cure Speed vs Activator



GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as

a sealant for chlorine or other strong oxidizing materials. For safe handling information on this product, consult the **Material Safety Data Sheet, (MSDS)**.

This product is not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). It is recommended to confirm compatibility of the product with such substrates.

ORDERING INFORMATION

Part Number	Container Size
C-66050	50 ml. tube

STORAGE

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C (46° to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container.

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