HERNON®
Formulating Solutions

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Cylinlock® 845

Product Description

Hernon Cylinlock® 845 is a fast curing, high strength anaerobic adhesive designed to retain and seal cylindrical assemblies. This compound will cure on metallic or non-metallic substrates and is suitable for exposure to most solvents and withstands temperatures of 300ºF (149ºC).

Hernon Cylinlock® 845 cures quickly at room temperature without the need for surface activators or heat to join cylindrical assemblies. Fixturing strength develops in 24 hours. **Hernon Primer 49 or 50** can be used to reduce fixturing time on inactive surfaces and to increase cure through gap.

Certified from NSF for NSF/ANSI/CAN Standard 61 for domestic hot water systems not exceeding 60ºC (140ºF).

Product Benefits

- Increases reliability.
- Reduces coat.
- Cures at room temperature.
- Single component (no mixing).
- Allows relaxed tolerance.
- Prevents corrosion.
- Easily joins dissimilar materials
- Allows slip fits instead of press and interference fits.

Performance Testing

Each batch of **Cylinlock® 845** is tested to the lot requirements of MIL-R-46082B (Type II), and to the detail requirements of ASTM D5363 (AN0412).

Typical Applications

- Holding gears and sprockets onto gearbox shafts
- Holding rotors on electric motor shafts

Typical Properties (Uncured)

Property	Value
Chemical Type	Methacrylate ester
Appearance	Green fluorescent liquid
Specific Gravity @ 25ºC	1.09
Viscosity @ 25ºC, cP	400-550
Flash Point (TCC)	See SDS

Typical Cured Performance

Compressive Shear Strength
Tested at RT, on steel pins and collars according to ASTM D4562.

Cure Conditions	Shear Strength, psi
24 Hours, RT	≥ 2500
15 minutes, RT	≥ 1800

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 Safety Data Sheet (SDS).

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some case, these aqueous washes can affect the cue and performance of the adhesive.

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.

Directions for Use
For best results, clean all surfaces (external and internal) with a **Hernon®** cleaning solvent and allow to dry. If the material is an inactive metal or the cure speed is to slow, apply **Primer 49 or 50** and allow to dry.

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.

For Press Fitted Assemblies, apply adhesive thoroughly to both bond surfaces and assemble at high press on rates.

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.
Parts should not be disturbed until sufficient handling strength is achieved.

Disassembly and Cleanup

To aid in disassembly anaerobic compounds can be weakened by heating to at least 500ºF (260ºC). Once disassembled, cured adhesive can be removed with a solvent.

Storage

Cylinlock® 845 should be stored in a cool, dry location in unopened containers at a temperature between 45ºF to 85ºF (7ºC to 29ºC) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused material, do not return any material to its original container.

Dispensing Equipment

Hernon® offers a complete line of semi and fully automated dispensing equipment. Contact **Hernon® Sales** for additional information.