

Technical Data Sheet Cylinlock[®] 827

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Product Description

Hernon[®] Cylinlock[®] 827 is a single component anaerobic retaining adhesive for cylindrical joints. The product cures when confined in the absence of air between close fitting metal surfaces. This product develops medium strength to facilitate disassembly.

Typical Applications

Used to bond cylindrical fitting parts, particularly where disassembly is required for service operations. Applications included retention of bearings onto shafts and into housings.

Typical Properties (Uncured)

Property	Value
Chemical Type	Methacrylate ester
Appearance	Yellow fluorescent liquid
Specific Gravity	1.08
Viscosity @ 25°C, cP	450 to 550
Flash Point	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 at 22°C	>2000

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 cases, these aqueous washes can affect the cure 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

Assembly

- 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 too slow, spray with **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 500°F (260°C). Once disassembled, cured adhesive can be removed with **Hernon[®] Gasket Remover 30**.

Storage

Cylinlock[®] 827 should be stored in a cool, dry location in unopened containers at a temperature between 45°F to 85°F (7°C to 29°C) 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.

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