Product Description

Hernon® Cylinlock® 823 is a single component, anaerobic retaining adhesive designed for the bonding of cylindrical parts. The product cures when confined in the absence of air between close fitting metal surfaces.

Typical Applications

Use to bond cylindrical fitting parts, particularly where consistently clean surfaces cannot be assured. Applications include retaining roller bearings or oil impregnated bushings into housings.

Typical Properties (Uncured)

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Chemical Type</td>
<td>Urethane methacrylate</td>
</tr>
<tr>
<td>Appearance</td>
<td>Green fluorescent liquid</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td>1.09</td>
</tr>
<tr>
<td>Viscosity @ 25ºC, cP</td>
<td>100 to 200</td>
</tr>
<tr>
<td>Flash Point</td>
<td>See SDS</td>
</tr>
</tbody>
</table>

Typical Cured Performance

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

<table>
<thead>
<tr>
<th>Cure Conditions</th>
<th>Shear Strength, psi</th>
</tr>
</thead>
<tbody>
<tr>
<td>24 Hours</td>
<td>≥ 2500</td>
</tr>
<tr>
<td>30 minutes</td>
<td>≥ 1500</td>
</tr>
</tbody>
</table>

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 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

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 EF® Activator 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 Hernon® Gasket Remover 30.

Storage

Cylinlock® 823 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.

These suggestions and data are based on information we believe to be reliable and accurate, but no guarantee of their accuracy is made. HERNON MANUFACTURING®, INC. shall not be liable for any damage, loss or injury, direct or consequential arising out of the use or the inability to use the product. In every case, we urge and recommend that purchasers, before using any product in full scale production, make their own tests to determine whether the product is of satisfactory quality and suitability for their operations, and the user assumes all risk and liability whatsoever, in connection therewith. Hernon’s Quality Management System for the design and manufacture of high-performance adhesives and sealants is registered to the ISO 9001 Quality Standard.