Bearing Mount for Relaxed Fits

INDUSTRIAL

PRODUCT DESCRIPTION
Permatex® Bearing Mount for Relaxed Fits is a high strength, single component anaerobic retaining adhesive for cylindrical joints. It is a green colored liquid resin that hardens and cures in the absence of air. Permatex® Bearing Mount for Relaxed Fits self-hardens into a tough plastic material when it is confined between close-fitting metal parts. The cured adhesive is a thermoset plastic suitable for exposure to most solvents and engine fluids. NSF White Book registered.

PRODUCT BENEFITS
- No mixing
- No curing outside of joint
- Prevents fretting and corrosion
- Allows the use of slip fit or press fit
- For use on assemblies with gaps up to 0.015" diametral

TYPICAL APPLICATIONS
- Used to bond cylindrical fitting parts
- Replaces set screws
- Replaces clamp rings
- Replaces snap ring
- Wheel bearings
- Idler shafts
- Bearings

DIRECTIONS FOR USE
1. Remove any grease or oil by using Permatex® Brake & Parts Cleaner.
2. For slip fitted assemblies, apply adhesive around the leading edge of the collar and use a rotating motion during assembly.
3. For press fits, adhesive should be applied thoroughly to both bond surfaces and assembled at high press-on rates.
4. 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.
5. For faster cure rates, use Permatex® Surface Prep on both surfaces.
6. Parts should not be disturbed until sufficient handling strength is achieved.
7. Any material that is on the outside of the assembly will not cure. Wipe off with a dry cloth.

TYPICAL CURING PERFORMANCE
Cure speed vs. substrate
The rate of cure will depend on the material used. Permatex® Bearing Mount for Relaxed Fits will react faster and stronger with Active Metals. However, Inactive Metals will require the use of an activator (Surface Prep) to obtain maximum strength and cure speed at room temperature.

<table>
<thead>
<tr>
<th>Active Metals</th>
<th>Inactive Metals</th>
</tr>
</thead>
<tbody>
<tr>
<td>Soft Steel Iron</td>
<td>Bright Platings</td>
</tr>
<tr>
<td>Copper</td>
<td>Anodized Surfaces</td>
</tr>
<tr>
<td>Brass</td>
<td>Titanium</td>
</tr>
<tr>
<td>Manganese</td>
<td>Zinc</td>
</tr>
<tr>
<td>Bronze</td>
<td>Pure Aluminum</td>
</tr>
<tr>
<td>Nickel</td>
<td>Stainless Steel</td>
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<tr>
<td>Aluminum Alloy</td>
<td>Cadmium</td>
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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.

PROPERTIES OF UNCURED MATERIAL

Technical Data Sheet

Permatex® Bearing Mount for Relaxed Fits is a high strength, single component anaerobic retaining adhesive for cylindrical joints. It is a green colored liquid resin that hardens and cures in the absence of air. Permatex® Bearing Mount for Relaxed Fits self-hardens into a tough plastic material when it is confined between close-fitting metal parts. The cured adhesive is a thermoset plastic suitable for exposure to most solvents and engine fluids. NSF White Book registered.

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**PERFORMANCE OF CURED MATERIAL**

Temperature Resistance - -54°C to +149°C (-65°F to +300°F)
Shear Strength – 4000PSI
Corrosivity - None (Slightly acidic, may discolor some metals.)
Maximum gap fill - .015" diametral

**Chemical / Solvent Resistance**
Aged under conditions and tested at 22°C(72°F)

<table>
<thead>
<tr>
<th>Temp</th>
<th>% Initial Strength retained after time</th>
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<tbody>
<tr>
<td>500hr</td>
<td>1000hr</td>
</tr>
<tr>
<td>Heat Aged</td>
<td>150°C</td>
</tr>
<tr>
<td>Motor oil(SL)</td>
<td>125°C</td>
</tr>
<tr>
<td>Antifreeze</td>
<td>87°C</td>
</tr>
<tr>
<td>Gasoline</td>
<td>23°C</td>
</tr>
<tr>
<td>Ethanol</td>
<td>23°C</td>
</tr>
<tr>
<td>Acetone</td>
<td>23°C</td>
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**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**

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Container Size</th>
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<tr>
<td>68050</td>
<td>50 ml bottle</td>
</tr>
<tr>
<td>68025</td>
<td>250 ml bottle</td>
</tr>
</tbody>
</table>

**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.

**NOTE**

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