

# Cylinlock™ for cylindrical bonding

## Main Benefits

- Improves machine reliability by strengthening the shaft and sleeve assembly
- Lowers costs with scope for wider machining tolerances



## Features

- Fills the microscopic voids that are inherently present in even the best interference fits and hardens to strengthen the assembly.
- Cylinlock™ and Metal Cement™ undergo anaerobic (absence of oxygen) curing when confined between mating metal surfaces.
- Ultrabond™ (821), apart from anaerobic curing, offers added flexibility by curing when exposed to ultraviolet light.
- Enhances the performance of mechanical retaining methods such as splines, keyways, set screws and interference fits.

## Other Benefits

- Seals internal surfaces and prevents fretting corrosion
- Distributes loading and prevents stress concentration even in the assembly of dissimilar material
- Easy alignment or assembly with wider fitting tolerances
- High chemical and temperature resistance
- Easy to apply and clean, no mixing required

## Typical Applications

- Pins and keyways
- Bearings
- Brushing and sleeves
- Gears, pulleys and sprockets
- Rotors and flywheels
- Brazed and soldered joints



## Usage Information

Package Size	Area Coverage with a thickness of 0.075 mm (in <sup>2</sup> )
10 ml Bottle	0.129
20 ml Bottle	0.258
25 ml Syringe	0.316
30 ml Syringe	0.387
50 ml Bottle	0.635
250 ml Tube	3.181
300 ml Cartridge	3.820
1000 ml Bottle	12.710

	Moderate Strength	High Strength				Large Gap Fill
	Cylinlock™ 827	Cylinlock™ 823	Cylinlock™ 842	Cylinlock™ 845	Cylinlock™ 821	Metal Cement™ 850
Key Performance	Reasonable, For bearings	General purpose, For oily surfaces	High service temperature	For severe service	Dual cure	For worn parts & emergency repair
Color	Yellow	Green	Green	Green	Amber	Silver
Viscosity, cP	1950	100 to 150	2000	1050	900 to 500	1,900,000
Gap Fill, mm	0.254	0.127	0.1016	0.08	0.27	0.508
Shear Strength, N/mm <sup>2</sup> (psi)	12 (1770)	21 (3050)	21 (3000)	20 (4000)	22 (3000)	21 (3000)
Curing Method	Anaerobic	Anaerobic	Anaerobic	Anaerobic	UV or Anaerobic	Anaerobic
Cure Speed @ 24°C, Fixture/Full	5 min/24 hrs	5 min/24 hrs	50 min/24 hrs	10 min/24 hrs	15 sec of UV or 5 min/24 hrs	10 to 20 min/ 1 to 2 hrs
Recommended EP™ Primer	48 or 50	48 or 50	49 or 50	48 or 50	48 or 50	49 or 50
Temperature Range, °C	-55 to 150	-55 to 150	-55 to 232	-55 to 150	-55 to 150	-55 to 150
Specification			ML-8-810019 Type I			