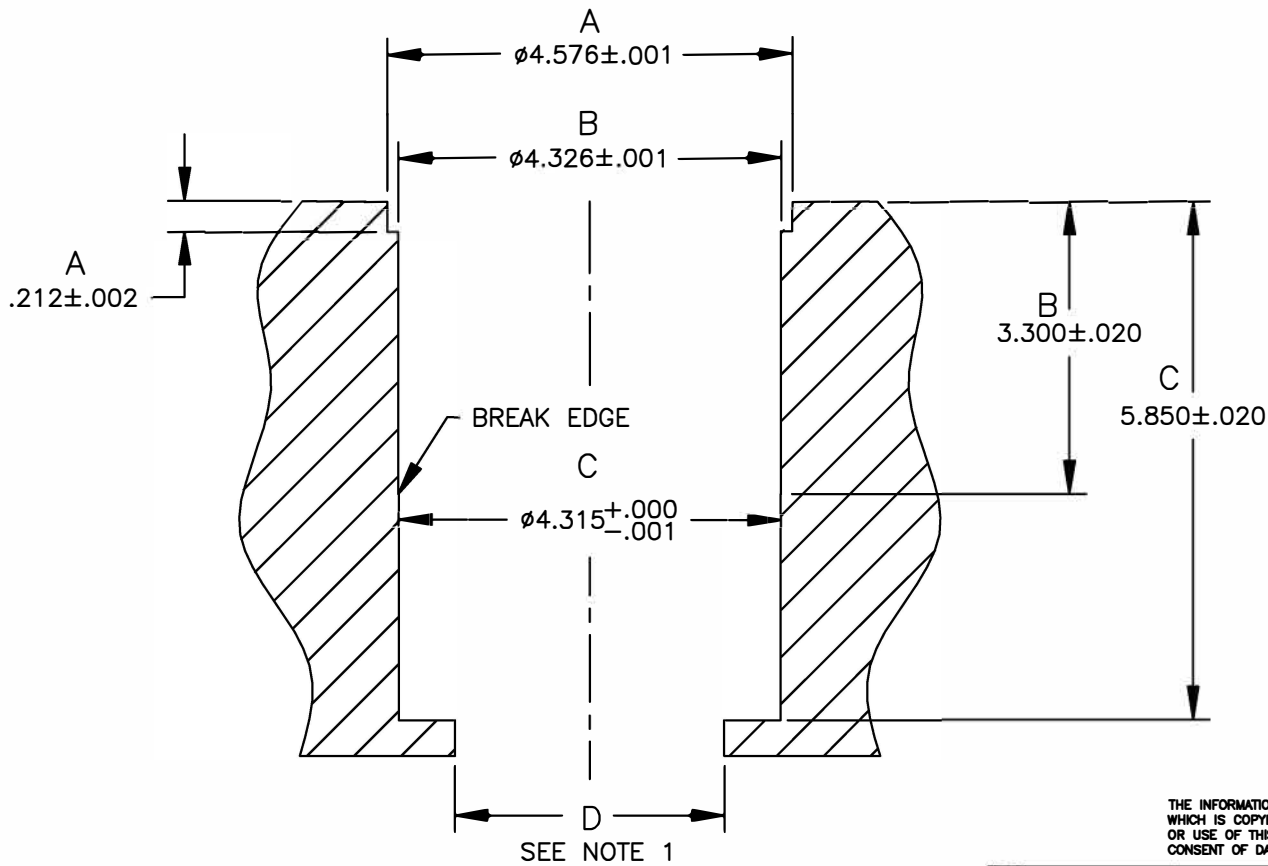



REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL
		/ /	



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DR. BY:	CAD DEPT	 Darton International, Inc. Carlsbad, CA USA (800) 713-2786 (760) 603-9895 FAX (760) 603-9829 WWW.DARTON-INTERNATIONAL.COM						
DATE:	05/02/06							
CHKD BY:		TITLE						
MATERIAL:		LS-7 DRY SLEEVE						
HARDNESS:		<table border="1"> <tr> <td>SIZE</td> <td>DWG NO.</td> <td>REV</td> </tr> <tr> <td>A</td> <td>300-027-SF-DF</td> <td>A</td> </tr> </table>	SIZE	DWG NO.	REV	A	300-027-SF-DF	A
SIZE	DWG NO.	REV						
A	300-027-SF-DF	A						
SCALE		NONE						
SHEET		1 OF 2						

NOTE:

LOCTITE #518

- TEMP. RANGE: -65 TO 300 DEG. F
- SPECIFIC GRAVITY; 1.13
- CHARACTERISTICS: RIGID, THIXOTROPIC, GENERAL PURPOSE
- COLOR: RED
- FULL CURE: 4 HR.
- FLASH POINT: 212 DEG. F
- BEGINS TO HARDEN: 30 MIN.
- APPLICATION: METAL THREADS, STEEL AND BRASS, FITTINGS, PIPES, VALVES, GAUGES, REFRIGERANT SYSTEMS, STEM
- TYPE: ANAEROBIC
- SUBSTRATES: METAL
- ITEM: GASKET SEALANT
- VISCOSITY: PASTE
- COUNTRY OF ORIGIN: UNITED STATES (SUBJECT TO CHANGE)

LOCTITE #620


- REQUIRES: SECONDARY HEAT CURE AT 356 DEG. F. TO GENERATE HIGH TEMP. RESISTANCE
- SHEER STRENGTH : 3800 (PSI)
- MAX. TEMP.: 450 DEG. (F)
- APPLICATION: SHAFT MOUNT, SLIP FIT
- TYPE: HIGH TEMP.
- FULL CURE: 4 HR.
- COMPOUND TYPE: HIGH VISCOSITY, HIGH TEMP. ADHESIVE
- STANDARDS: CFIA LISTED
- FILLING GAO SIZE: UP TO 0.015"
- PRIMER: N 7649 TO SPEED CURE ON INACTIVE METALS
- ITEM: RETAINING COMPUND
- (USING LOCTITE #620 AS A HEAT TRANSFER MAY MAKE IT DIFFUCULT TO REMOVE SLEEVE)
- (WE DO NOT SUPPLY #620 LOCTITE)

REVISIONS

REV	DESCRIPTION	DATE	APPROVAL
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INSTALLATION NOTE:

1. BORE THRU TO MAIN WEB AT FINISH
BORE DIA +.010
2. PRIOR TO BORING FOR SLEEVE INSTALLATION
BORE EXISTING SLEEVE TO FINISH BORE DIMENSION +.020
STOPPING AT MAIN BEARING WEB.
3. A & B diameter -net to -0.001 press fit; C diameter -net to +.001 clearance
4. BLOCK BORE CENTER = 4.400
5. INSTALL SLEEVES AT ROOM TEMPERATURE AND CLAMP SLEEVES DOWN AT DECK UNTIL LOCKTITE HAS CURED, THEN DECK AND HONE
6. NEW BLOCKS NEED TO BE VIBRATORY STRESS RELIEVED PRIOR TO DECKING AND HONING
7. DO NOT PRESSURE WASH BLOCK AFTER INSTALL
8. MAKE SURE NOT TO GET LOCKTITE ON FLANGE AREA

DR. BY: CAD DEPT		Darton International, Inc. Carlsbad, CA USA (800) 713-2786 (760) 603-9895 FAX (760) 603-9629 WWW.DARTON-INTERNATIONAL.COM		
DATE: 3.29.18		TITLE: BLOCK SPECIFICATION- LS 1 BLOCK SPECS		
DRG'D BY:	SIZE: A	DWG NO. 300-027 SF-DF	REV A	
MATERIAL:	SCALE 1/2		SHEET 2 OF 2	
HARDNESS:				