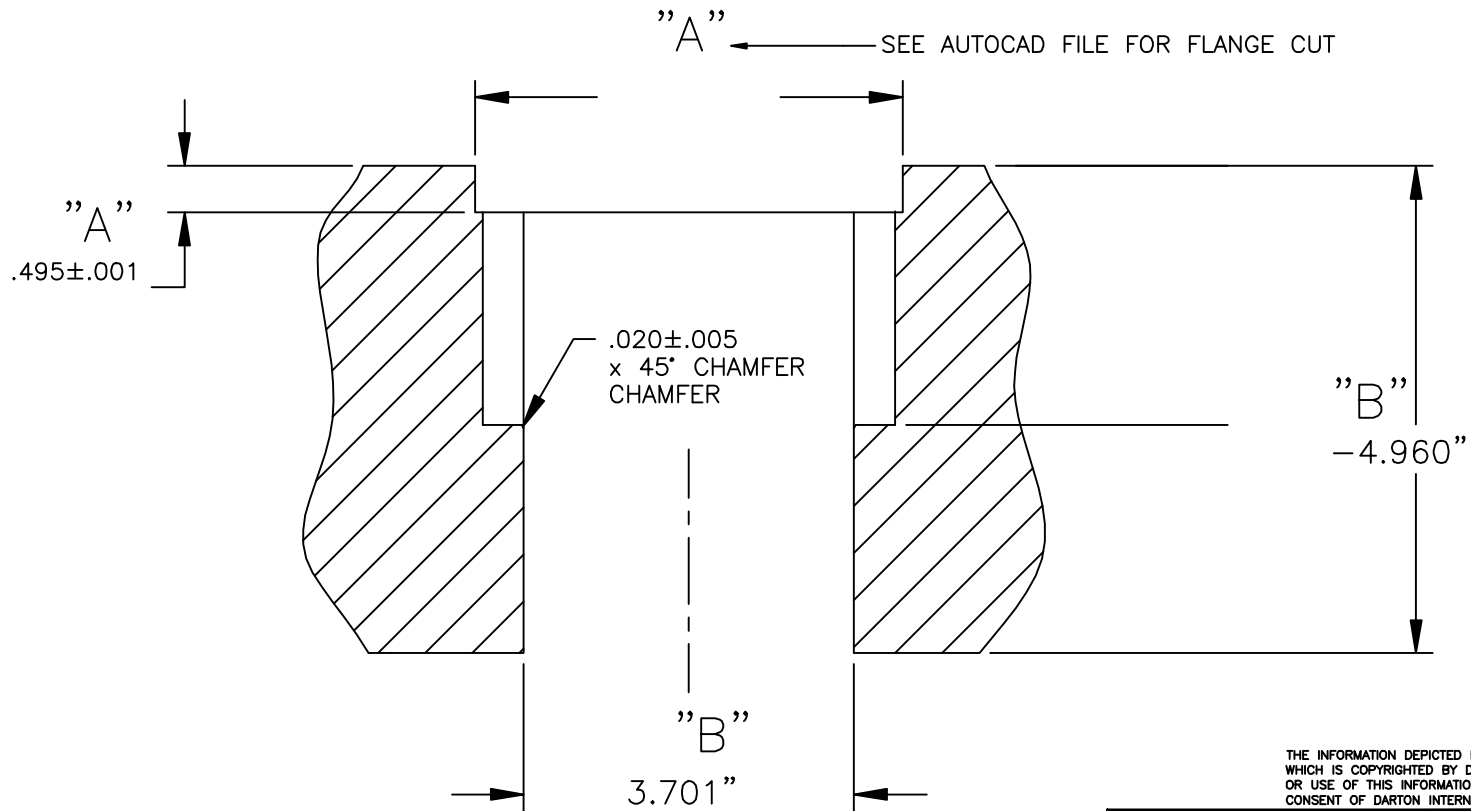


**NOTE:**


1. PRIOR TO BORING FOR SLEEVE INSTALLATION, BORE EXISTING SLEEVE TO FINISH BORE DIMENSION  $+0.020$  - 5.200 DEEP
2. BORE CENTER - 113MM or 4.449"
3. DECK SURFACE AFTER SLEEVE INSTALLATION TO GASKET RA SPEC.

REVISIONS

REV	DESCRIPTION	DATE	APPROVAL



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DR. BY:	CAD DEPT	 <b>Darton International, Inc.</b> Carlsbad, CA USA (800) 713-2786 (760) 603-9895 FAX (760) 603-9629 WWW.DARTON-INTERNATIONAL.COM		
DATE:	08/14/19			
CHK'D BY:		TITLE		
MATERIAL:		BLOCK SPECIFICATION - SUBARU FA 20 WRX DRY		
HARDNESS:		SIZE	DWG NO.	REV
		A		
		SCALE	SHEET 1 OF 3	
		1/2		

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 )

NOTE:

1. PRIOR TO BORING FOR SLEEVE INSTALLATION, BORE EXISTING SLEEVE TO FINISH BORE DIMENSION +.020 STOPPING AT MAIN BEARING WEB.
2. APPLY LOCTITE #518 OR #620 TO BLOCK AND SLEEVE AT C (4.200 DIMENSION)
3. INSTALL SLEEVES AT ROOM TEMPERATURE AND CLAMP SLEEVES DOWN AT DECK UNTIL LOCKTITE HAS CURED, THEN DECK AND HONE
4. NEW BLOCKS NEED TO BE VIBRATORY STRESS RELIEVED PRIOR TO DECKING AND HONING
5. DO NOT PRESSURE WASH BLOCK AFTER INSTALL
6. MAKE SURE NOT TO GET LOCKTITE ON FLANGE AREA

REVISIONS

REV	DESCRIPTION	DATE	APPROVAL
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DR. BY: CAD DEPT		Dartton International, Inc. Carlsbad, CA USA	
DATE: 6/19/19		(800) 713-2786 (760) 603-9895 FAX (760) 603-9629 WWW.DARTTON-INTERNATIONAL.COM	
CHK'D BY:	TITLE: BLOCK SPECIFICATION - SUBARU FA-20 VRX 86-90mm	DWG NO. 300-039	REV -
MATERIAL:	SCALE 1/2	SHEET 2 OF 3	
HARDNESS:	SIZE A		

