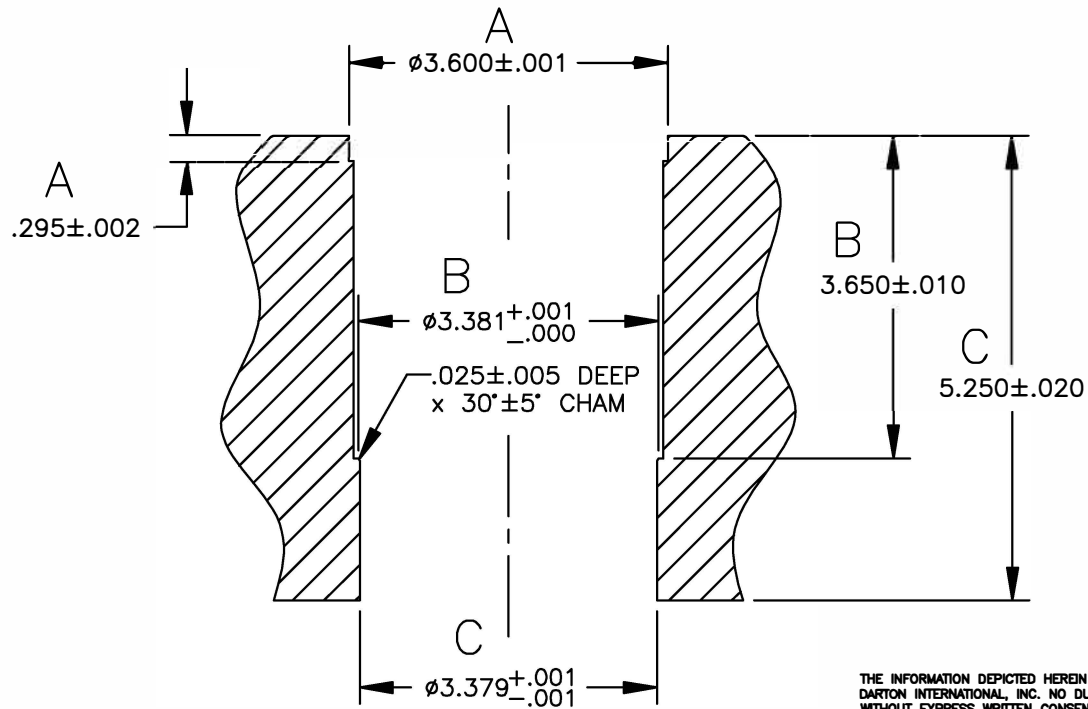



REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL
		//	



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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:	04/13/18			
CHK'D BY:		TITLE		
MATERIAL:		CYLINDER SLEEVE- TOYOTA 2ZZ 82mm SF/DF		
HARDNESS:		SIZE	DWG NO.	REV
		A	300-042-1	C
		SCALE	SHEET	
		1/2	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

1. MACHINE BLOCK BORES A, B, & C TO BE .001 CLEARANCE OF SLEEVE
2. MACHINE BLOCK AT BORE CENTER 87.5mm/3.445
3. APPLY A SMALL AMOUNT OF LOCTITE #518 OR #620 TO SLEEVE AT B DAIAMTER AND TO BLOCK BORE C
4. INSTALL AT ROOM TEMPERATURE AND CLAMP SLEEVE DOWN TO DECK UNTIL LOCTITE HAS CURED
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		
DATE: 4/13/18		(800) 713-2786 (760) 603-9895 FAX (760) 603-9629 WWW.DARTON-INTERNATIONAL.COM		
CHK'D BY:	TITLE: BLOCK SPECIFICATION- 2ZZ TOYOTA 82mm	SIZE: A	DWG NO. 300-042-1	REV C
MATERIAL:	SCALE 1/2	SHEET 2 OF 2		
HARDNESS:				