

# ❖ **GARNET INSTRUMENTS LTD.**

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## **TECHNICAL SERVICES BULLETIN #17**

**Date: August 26, 1997**

**To: All Dealers.** Please distribute to applicable sales and/or shop personnel.

**SUBJECT: New Endcap Installation Procedures**

In our ongoing attempt to reduce bar failures we are introducing a new procedure for the installation of endcaps.

Through consultations with Loctite Canada we are recommending the following products: Loctite 7070 Cleaner, Locquic T7471 Primer, and Loctite 680 Retaining Compound.

The 680 Retaining Compound is designed so that it will cure in the absence of oxygen between close fitting metal surfaces. It is rated for a temperature range of -54°C to +149°C. It can handle gaps of .015". To help reduce the gap spacing we have redesigned the endcap. These new endcaps have a tapered edge on them where the tube and endcap meet so the seal will not be at risk of breaking. This is also the easiest way to tell if it can be used with Loctite. You must continue to use the JB Weld until your supply of old endcaps is used up. The Loctite method cannot be used on the old endcaps and the JB Weld cannot be used on the new endcaps.

The procedure for the installation will be:

- 1) Clean the end of the tube and the inside of the endcap with the 7070 Cleaner.
- 2) Prime the parts with the T7471 Primer and allow a few minutes to completely dry.
- 3) Apply the 680 Retaining Compound to both parts and assemble with a turning motion.

The curing time will be about 1 hour at room temperature. Detailed instructions will be added to the Shop Manuals. As well, a resistivity chart will be added to all manuals to ensure you and your customers are aware what fluids are safe for the Loctite bond.

Dealers in Canada can obtain all three of these products through Acklands. Dealers in the United States can obtain them through RS Hughes, Hisco, Detroit Ball Bearing, or Motion Industries. There may be other distributors specific to your local area and you are welcome to use them however you must use the items as specified with no substitutions permitted.

If you wish, you may obtain the set of three from us. We estimate that you should be able to do over 100 endcaps with the amount provided. All orders being shipped as of August 27<sup>th</sup>, 1997 will have the new endcaps so you **MUST** either obtain the products yourself or order from us.

Technical data sheets and MSDS sheets are available from us if you need them.

If you have any questions please call 1-800-617-7384 or 467-1010.

Tom Stalker  
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