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Including The **P4Track** Company

INS 550

Notes on the use of LOCTITE 603 RETAINER (replacement for 601)

How it works

The principle of these retainers is to fill uniformly a space between two cylindrical components and bond them securely together whilst maintaining a high degree of concentricity. The retainer will only cure with the exclusion of air from the joint. It is very important that there is only a small clearance between the parts otherwise the retainer will not cure.

Assembly

All Exactoscale products of this type are carefully designed and manufactured to fall into the category of "slip fit", thus creating the necessary clearance according to size to achieve a satisfactory joint.

Cleanliness

It is vital that all parts are scrupulously clean. Remove all traces of grease, oil, debris etc.

Application

Using a small pointed tool such as a cocktail stick, apply retainer sparingly to the axle, shaft etc. at the approximate location of the wheel, gear etc. Assemble the components together using a rotating motion. This ensures even distribution of the retainer thus maintaining concentricity and expels any air in the joint. Carefully slide the component into final position on the shaft. Remove any surplus retainer with a tissue. Allow to cure for at least an hour. It is vitally important that no pressure is exerted on the joint whilst curing.

Disassembly

If you find it necessary to disassemble a cured joint, this can be done by heating to 250 °C. **DO NOT** try to do this with plastic-centred wheelsets!
Any remaining cured retainer may be removed by soaking in Loctite solvent and use of mechanical abrasion, such as a small wire brush.

Storage

These products may deteriorate if left on the workbench. They are best stored in a dry location between 8 °C to 21 °C. Although outside this range, we have found that storing in a domestic refrigerator at 3 °C has been found to be quite satisfactory.

Further Information

A manufacturer's Data Sheet for Loctite 603 can be found here:
<http://65.213.72.112/tds5/docs/603-EN.PDF>

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