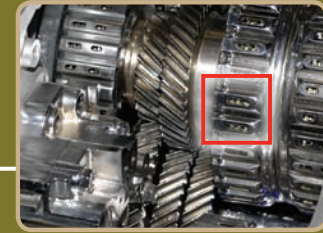
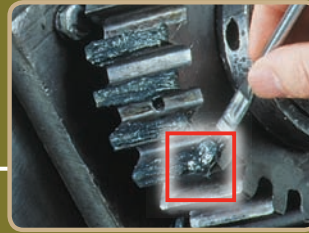


Your Source for
**MACHINING
COMPOUNDS**



Loctite® Clover® machining compounds (abrading compounds) are abrasive pastes designed especially for the cutting, smoothing and finishing of metal surfaces. They are silicon carbide-filled and are used as a supplemental process to grinding, milling, boring and Electrical Discharge Machining (EDM) on high or low tensile strength materials, including forged or hardened gears. These compounds produce an ultra-flat surface but not a polished one.

**HOW DOES GRIT SIZE
AFFECT METAL REMOVAL?**

Grit size directly relates to the finish left on the metal surface. A very coarse grit, such as our 54 grit, will quickly remove metal from the surface and leave a somewhat rough finish. To achieve a smoother finish, a smaller grit size should be used, such as 1,000 grit. This compound will fill the smaller metal voids and will, therefore, leave a smoother finish.

BENEFITS

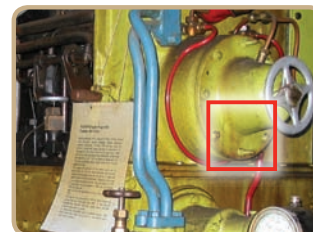
- Premixed and ready-to-use for consistent performance that is unattainable from mix-your-own slurries
- Manufactured from premium abrasive grits; only virgin silicon carbide abrasives, carefully sized, are used
- Water-soluble – the compound clings to blades for superior honing action, but washes away easily (Pat Gel® Water Mix only)
- Biodegradable (Pat Gel® Water Mix only)

Loctite® Adhesives and Sealants Product Specialists are available to assist you. For application assistance, call **1-800-LOCTITE (562-8483)**; *within Canada, call 1-800-263-5043*; or, contact us through the web at www.henkelna.com/loctite.

STRAIGHT FROM *The Source*

[Grade & Grit Selector Guide]

| GRADE | GRIT | TEXTURE & USE | AVERAGE PARTICLE SIZE OF ABRASIVE GRAINS | |
|-------|-------|--|--|--------------------|
| | | | 1/1,000 INCHES | MICRONS (0.001 MM) |
| 7A | 1,200 | Extremely Fine: For polishing and high precision lapping | 0.12 | 3 |
| 6A | 1,000 | | 0.20 | 5 |
| 5A | 800 | | 0.38 | 9 |
| 4A | 600 | Very Fine: For fine polishing and lapping | 0.56 | 14 |
| 3A | 500 | | 0.68 | 17 |
| 2A | 400 | | 0.90 | 23 |
| 1A | 320 | Fine: For finishing, valve lapping bearings, dies and gauges | 1.28 | 33 |
| A | 280 | | 1.75 | 44 |
| B | 240 | Medium Fine: For cylinder lapping | 2.48 | 63 |
| C | 220 | | 2.60 | 66 |
| D | 180 | Medium: General purpose for controlled metal removal | 3.40 | 86 |
| NC | 150 | | 4.80 | 122 |
| E | 120 | Coarse: For the initial "cut," fast removal of metal | 5.60 | 142 |
| F | 100 | | 6.80 | 173 |
| G | 80 | | 15.00 | 267 |
| J | 54 | Very Coarse: For fastest metal removal | 18.00 | 463 |



Your Source **MACHINING COMPOUNDS GUIDE**

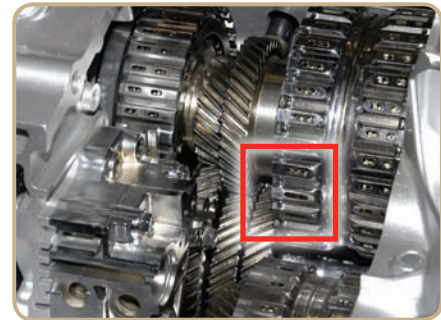
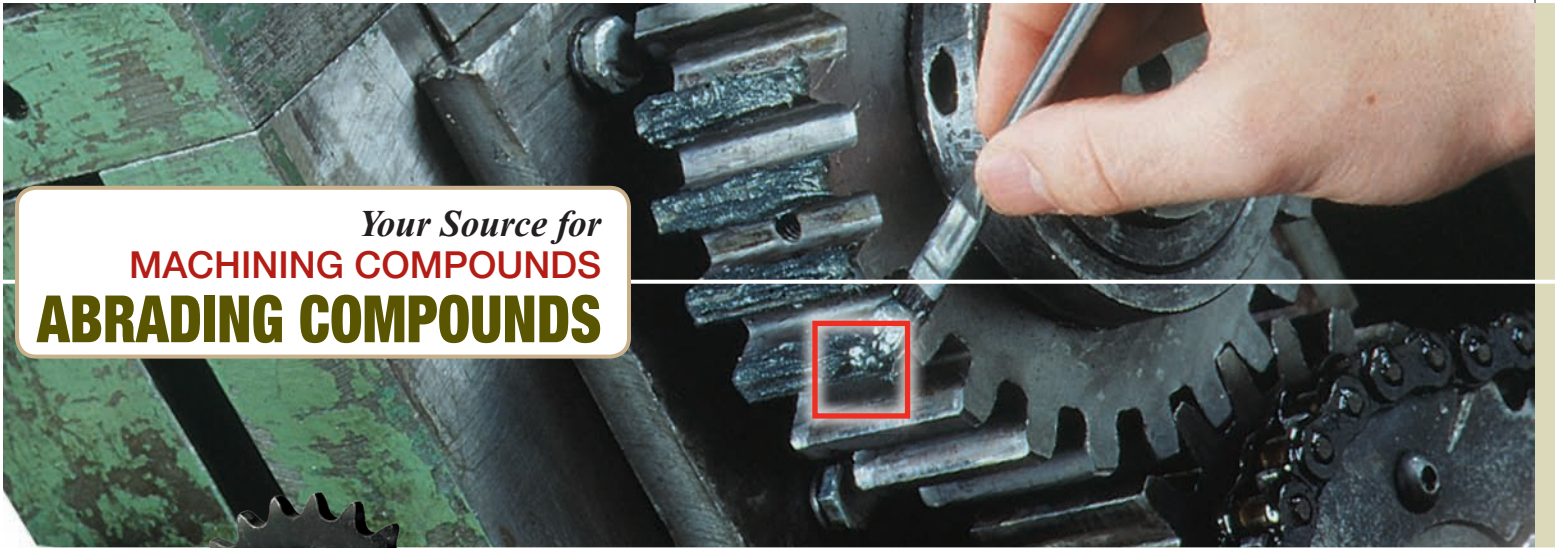
WHAT TYPE OF HONING IS NEEDED?

| Mower Blade / Bed Knife Sharpening | Very Coarse – Medium Grit | Fine – Extremely Fine Grit | |
|--|---|--|--|
| FAIRWAY MOWER MAINTENANCE | “INITIAL CUT” FAST REMOVAL OF METAL | CYLINDER LAPPING | FINE POLISHING AND LAPPING |
| Loctite® Clover® Silicon Carbide Reel Sharpening Grade F – 100 Grit Item # 39715 25 lb. pail | Loctite® Clover® Silicon Carbide Grade J – 54 Grit Item # 39483 1 lb. can 39486 100 lb. drum | Loctite® Clover® Silicon Carbide Grade C – 220 Grit Item # 39426 1 lb. can 39428 25 lb. pail | Loctite® Clover® Silicon Carbide Grade 2A – 400 Grit Item # 39523 1 lb. can |
| TEE AND GREEN MOWERS / TOURNAMENT BLADES | Loctite® Clover® Silicon Carbide Grade G – 80 Grit Item # 39473 1 lb. can 39476 100 lb. drum | Loctite® Clover® Silicon Carbide Grade B – 240 Grit Item # 39413 1 lb. can | Loctite® Clover® Silicon Carbide Grade 3A – 500 Grit Item # 39536 1 lb. can |
| Loctite® Clover® Silicon Carbide Reel Sharpening Grade E – 120 Grit Item # 39711 25 lb. pail | Loctite® Clover® Silicon Carbide Grade F – 100 Grit Item # 39463 1 lb. can 39465 25 lb. pail 39466 100 lb. drum | FINISHING, VALVE LAPPING, BEARINGS, DIES AND GAUGES | Loctite® Clover® Silicon Carbide Grade 4A – 600 Grit Item # 39549 1 lb. can 39551 25 lb. pail |
| Loctite® Clover® Silicon Carbide Reel Sharpening Grade D – 180 Grit Item # 39712 25 lb. pail | GENERAL PURPOSE FOR THE CONTROLLED REMOVAL OF METAL | Loctite® Clover® Silicon Carbide Grade A – 280 Grit Item # 39401 1 lb. can 39404 100 lb. drum | POLISHING AND PRECISION LAPPING |
| Loctite® Clover® Silicon Carbide Reel Sharpening Grade C – 220 Grit Item # 39723 25 lb. pail | Loctite® Clover® Silicon Carbide Grade E – 120 Grit Item # 39452 1 lb. can 39455 100 lb. drum | Loctite® Clover® Silicon Carbide Grade 1A – 320 Grit Item # 39510 1 lb. can 39512 25 lb. pail | Loctite® Clover® Silicon Carbide Grade 5A – 800 Grit Item # 39561 1 lb. can |
| | | | Loctite® Clover® Silicon Carbide Grade 6A – 1,000 Grit Item # 39574 1 lb. can |
| | | | Loctite® Clover® Silicon Carbide Grade 7A – 1,200 Grit Item # 39587 1 lb. can 39589 25 lb. pail 39590 100 lb. drum |

- Loctite® Clover® machining compounds can be removed using the same solvent in which they are carried.
- Loctite® Clover® grease mix products can be removed using a petroleum-based solvent: Loctite® ODC-Free Cleaner & Degreaser.
- Loctite® Clover® Silicon Carbide Pat Gel® Water Mix can be removed with water; once Loctite® Clover® products are removed, dry the area thoroughly and apply oil or grease to the metal to prevent corrosion.

HELPFUL HINTS

Your Source for
MACHINING COMPOUNDS
ABRADING COMPOUNDS



Sources **REVEALED**

[Manufacturing Industries]

- Pumps
- Gearbox
- Valves

- Machining
- Sharpening
- Precision Fitting

INDUSTRIES

Loctite® Clover® Silicon Carbide Grease Mix

The standard abrasive paste for fast metal removal. Produces a smooth, flat surface but not a polished one. Leaves a rust-preventing film on lapped surfaces.

| | | | |
|--------|-----------------------|-------|--------------|
| Item # | Grade A – 280 Grit | 39401 | 1 lb. can |
| | Grade A – 280 Grit | 39404 | 100 lb. drum |
| | Grade 1A – 320 Grit | 39510 | 1 lb. can |
| | Grade 1A – 320 Grit | 39512 | 25 lb. pail |
| | Grade 2A – 400 Grit | 39523 | 1 lb. can |
| | Grade 3A – 500 Grit | 39536 | 1 lb. can |
| | Grade 4A – 600 Grit | 39549 | 1 lb. can |
| | Grade 4A – 600 Grit | 39551 | 25 lb. pail |
| | Grade 5A – 800 Grit | 39561 | 1 lb. can |
| | Grade 6A – 1,000 Grit | 39574 | 1 lb. can |
| | Grade 7A – 1,200 Grit | 39587 | 1 lb. can |
| | Grade 7A – 1,200 Grit | 39589 | 25 lb. pail |
| | Grade 7A – 1,200 Grit | 39590 | 100 lb. drum |
| | Grade B – 240 Grit | 39413 | 1 lb. can |
| | Grade C – 220 Grit | 39426 | 1 lb. can |
| | Grade C – 220 Grit | 39428 | 25 lb. pail |
| | Grade D – 180 Grit | 39439 | 1 lb. can |
| | Grade D – 180 Grit | 39441 | 25 lb. pail |
| | Grade NC – 180 Grit | 39499 | 1 lb. can |
| | Grade E – 120 Grit | 39452 | 1 lb. can |
| | Grade E – 120 Grit | 39455 | 100 lb. drum |
| | Grade F – 100 Grit | 39463 | 1 lb. can |
| | Grade F – 100 Grit | 39465 | 25 lb. pail |
| | Grade F – 100 Grit | 39466 | 100 lb. drum |
| | Grade G – 80 Grit | 39473 | 1 lb. can |
| | Grade G – 80 Grit | 39476 | 100 lb. drum |
| | Grade J – 54 Grit | 39483 | 1 lb. can |
| | Grade J – 54 Grit | 39486 | 100 lb. drum |

Loctite® Clover® Duplex Packaging Kit

CONTAINS CLOVER SILICON CARBIDE GREASE MIX GRADES E/A

Loctite® Clover® Silicon Carbide Grease Mix in two convenient grit sizes (120 and 280).

| | | | |
|--------|--------------------------|-------|------------------------|
| Item # | Grade E/A – 120/280 Grit | 39598 | Kit – 4 oz. duplex can |
|--------|--------------------------|-------|------------------------|

Loctite® Clover® Silicon Carbide Reel Sharpening Mix

Water-soluble. This compound clings to blades for superior honing action but washes away for easy cleanup.

| | | | |
|--------|--------------------|-------|-------------|
| Item # | Grade C – 220 Grit | 39723 | 25 lb. pail |
| | Grade D – 180 Grit | 39712 | 25 lb. pail |
| | Grade E – 120 Grit | 39711 | 25 lb. pail |
| | Grade F – 100 Grit | 39715 | 25 lb. pail |

Loctite® Clover® Silicon Carbide Pat Gel® Water Mix

Paste formulation for fast metal removal. Biodegradable, recommended for applications where cleanup with water is required.

| | | | |
|--------|-----------------------|--------|-------------|
| Item # | Grade A – 280 Grit | 39406 | 1 lb. jar |
| | Grade 1A – 320 Grit | 39515 | 1 lb. jar |
| | Grade 2A – 400 Grit | 39528 | 1 lb. jar |
| | Grade 3A – 500 Grit | 39541 | 1 lb. jar |
| | Grade 3A – 500 Grit | 39542 | 25 lb. pail |
| | Grade 4A – 600 Grit | 39554 | 1 lb. jar |
| | Grade 5A – 800 Grit | 39566 | 1 lb. jar |
| | Grade 6A – 1,000 Grit | 39579 | 1 lb. jar |
| | Grade 7A – 1,200 Grit | 39592 | 1 lb. jar |
| | Grade B – 240 Grit | 39418 | 1 lb. jar |
| | Grade B – 240 Grit | 39419* | 25 lb. pail |
| | Grade C – 220 Grit | 39431 | 1 lb. jar |
| | Grade D – 180 Grit | 39444 | 1 lb. jar |
| | Grade NC – 150 Grit | 39504 | 1 lb. jar |
| | Grade E – 120 Grit | 39458* | 25 lb. pail |
| | Grade E – 120 Grit | 39457 | 1 lb. jar |
| | Grade F – 100 Grit | 39468 | 1 lb. jar |
| | Grade G – 80 Grit | 39478 | 1 lb. jar |
| | Grade G – 80 Grit | 39479 | 25 lb. pail |
| | Grade J – 54 Grit | 39488 | 1 lb. jar |

* Made-to-order item.

[Loctite® Abrading Compounds Properties Chart]

| PRODUCT | GRADE | GRIT | ITEM NUMBER | PACKAGE TYPE & SIZE |
|--|---|---------|-------------|------------------------|
| CLOVER® SILICON CARBIDE REEL SHARPENING MIX | C | 220 | 39723 | 25 lb. pail |
| | D | 180 | 39712 | 25 lb. pail |
| | E | 120 | 39711 | 25 lb. pail |
| | F | 100 | 39715 | 25 lb. pail |
| CLOVER® SILICON CARBIDE GREASE MIX | J | 54 | 39483 | 1 lb. can |
| | | | 39486 | 100 lb. drum |
| | G | 80 | 39473 | 1 lb. can |
| | | | 39476 | 100 lb. drum |
| | F | 100 | 39463 | 1 lb. can |
| | | | 39465 | 25 lb. pail |
| | | | 39466 | 100 lb. drum |
| | E | 120 | 39452 | 1 lb. can |
| | | | 39455 | 100 lb. drum |
| | NC | 150 | 39499 | 1 lb. can |
| | D | 180 | 39439 | 1 lb. can |
| | | | 39441 | 25 lb. pail |
| | C | 220 | 39426 | 1 lb. can |
| | | | 39428 | 25 lb. pail |
| | B | 240 | 39413 | 1 lb. can |
| | A | 280 | 39401 | 1 lb. can |
| | | | 39404 | 100 lb. drum |
| | 1A | 320 | 39510 | 1 lb. can |
| | | | 39512 | 25 lb. pail |
| | 2A | 400 | 39523 | 1 lb. can |
| | 3A | 500 | 39536 | 1 lb. can |
| | 4A | 600 | 39549 | 1 lb. can |
| | | | 39551 | 25 lb. pail |
| | 5A | 800 | 39561 | 1 lb. can |
| | 6A | 1,000 | 39574 | 1 lb. can |
| | 7A | 1,200 | 39587 | 1 lb. can |
| | | | 39589 | 25 lb. pail |
| | | | 39590 | 100 lb. drum |
| | E/A | 120/280 | 39598 | Kit – 4 oz. duplex can |
| | CLOVER® SILICON CARBIDE PAT GEL® WATER MIX | J | 54 | 39488 |
| G | | 80 | 39478 | 1 lb. jar |
| | | | 39479 | 25 lb. pail |
| F | | 100 | 39468 | 1 lb. jar |
| E | | 120 | 39457 | 1 lb. jar |
| | | | 39458* | 25 lb. pail |
| NC | | 150 | 39504 | 1 lb. jar |
| D | | 180 | 39444 | 1 lb. jar |
| C | | 220 | 39431 | 1 lb. jar |
| B | | 240 | 39418 | 1 lb. jar |
| | | | 39419* | 25 lb. pail |
| A | | 280 | 39406 | 1 lb. jar |
| 1A | | 320 | 39515 | 1 lb. jar |
| 2A | | 400 | 39528 | 1 lb. jar |
| 3A | | 500 | 39541 | 1 lb. jar |
| | | | 39542 | 25 lb. pail |
| 4A | | 600 | 39554 | 1 lb. jar |
| 5A | | 800 | 39566 | 1 lb. jar |
| 6A | | 1,000 | 39579 | 1 lb. jar |
| 7A | | 1,200 | 39592 | 1 lb. jar |

* Made-to-order item.