

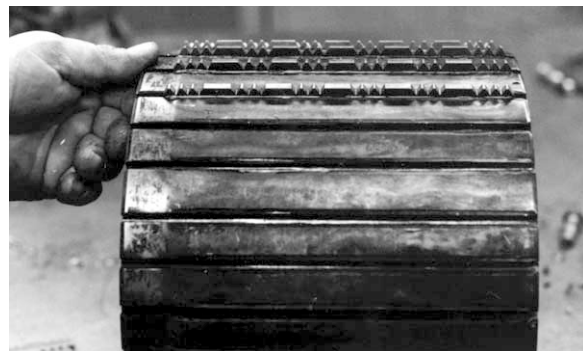
LOCTITE*Adhesives for more
reliable assemblies***APPLICATION CASE HISTORY****No. 231**

Loctite® Quick Metal® Saves Sawmills Labor and Service Costs on Coleman Inserts

Up To Half-Day Service Time Saved, Roll Life Extended

Situation:

Two major sawmills in western Canada were spending many dollars in service time to replace worn Coleman inserts from Coleman rolls. The process was typically long and labor intensive. Rolls were removed from service and taken back to the shop where a combination of heat and an air chipper were used to dig out the old inserts. Once this was done, new inserts were placed into the keyed slots of the old roll. The edges of the roll surrounding the inserts were then mechanically peined to hold the new inserts in place. With most rolls averaging 2-3 feet long and containing an average of 20 to 30 inserts, this process could take up to one day per roll. At a change rate of once a month, the mills were incurring extensive service costs. They wanted to find a better method for replacing the inserts.



Inserts on Coleman Rolls held in place with Loctite® Quick Metal® without peining the edges of the roll. This saved the sawmills a half day in service time and labor, and has extended the life of the rolls.

Solution:

Loctite 660 Quick Metal Retaining Compound is a creamy, non-running gel that is applied to cylindrical parts to repair worn areas, restore correct fit and prevent keyway wallow. This anaerobic adhesive fills gaps up to 0.020" and has a temperature range of -65°F to +300°F. It contains no metal, yet hardens to a strength that often doubles that of a press fit. Because Quick Metal is an anaerobic, it sets in just 10 minutes as assembly removes the presence of air.

Results:

When replacing inserts, the millwrights now apply a bead of Quick Metal down the center of the key. The inserts are then slipped into place. It is no longer necessary to mechanically pein the roll to hold the inserts in place. Once Quick Metal has cured, the inserts can withstand 3,000 psi of shear loading. This has saved the sawmills not only time in labor and service, but has also extended the life of the rolls themselves.

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