

Anaerobic Adhesive Application

1. SCOPE

1.1 The specification shall describe the procedure which is required for the application of specific adhesive 86557106 (FNHA-2-E-069.00) Sealant Eliminator, 86527120 (FNHA-2-E-069.05) Primer 7649 and usage of 86525953 (FNHA-2-K-049.00) Solvent 7070.

1.2 This specification may involve hazardous materials, procedures and apparatus. This specification does not address the health and safety problems associated with its application or use. It is the specification user's responsibility to follow appropriate health or safety practices and determine the application or regulatory limitation before use.

2 RELATED SPECIFICATIONS

86557106 (FNHA-2-E-069.00)—Sealant Eliminator
86527120 (FNHA-2-E-069.05)—Primer 7649
86525953 (FNHA-2-K-049.00)—Solvent 7070

3. PROCESS

3.1 SAFETY

The MSDS's for primer, adhesive and solvent should be reviewed prior to the establishment of any procedure for the application of the subject products to assure that all safety precautions have been taken.

THE FLOOR AREA WHERE PRIMER, ADHESIVE AND SOLVENT ARE APPLIED SHOULD BE WELL VENTILATED.

UNDER NO CIRCUMSTANCES SHOULD PRIMER AND SEALANT BE MIXED DIRECTLY AS LIQUIDS.

PRIMER AND SOLVENT ARE HIGHLY FLAMMABLE.

Avoid contact with skin, eyes, and clothing. Wear suitable protective clothing including safety glasses or goggles and rubber or plastic gloves. Avoid breathing vapors. A small amount of acrylic acid contained in the adhesive may cause irritation to the eyes, nose and throat.

Do not use solvent in a system that uses a boiling vapor process.

3.2 SUBSTRATE CLEANING

3.2.1 The substrate surface to be coated shall be clean, dry, and free of oil and grease or any foreign material.

3.2.2 The solvent 86525953 (FNHA-2-K-049.00) may be used to remove the oil or grease. It can be used as a spray or in immersion cleaning processes at room temperature or heated. Spray surface generously and wipe with a clean cloth. Time should be allowed to let the surface dry completely prior to applying the primer or adhesive.

3.2.3 If the joint contains old sealant, it must be removed. The substrate should be cleaned by mechanical means.

3.2.4 The substrate may also be cleaned using a detergent and water for dirt and grime.

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					 NEW HOLLAND		ENGINEERING SPECIFICATION		
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3.3 PRIMER (IF REQUIRED) 86527120 (FNHA-2-E-069.05)

3.3.1 Temperature

The temperature of application shall be between -4 and 120°F (-20 and 49°C).

3.3.2 Mixing

Prior to opening the primer container, it shall be agitated well by shaking to assure the mixing of the primer.

3.3.3 Application

The primer shall be applied with either a brush or spray. A thin uniform coat shall be applied onto both mating surfaces. For small gaps treatment of only one surface may be adequate. However, porous surfaces may need repeated treatment.

Do not reseal an open container or return any material to its original container to prevent contamination.

Apply the sealant to one or both surfaces and assemble parts immediately.

3.3.4 Drying Time

The typical drying time before applying sealant at 20°C (63°F) is between 30 seconds and 70 seconds. Allow the solvent time to evaporate under good ventilation until the surfaces are completely dry. If the primer has not been covered with an adhesive within 1 month a new layer of the primer is required. Contamination of the surface before bonding should be prevented.

3.3.5 Limitations

The compound should not be used in pure oxygen and/or oxygen rich system.

DO NOT USE WITH BLEACHES (CHLORINE), PEROXIDES, NITRIC ACID OR OTHER STRONG OXIDIZING MATERIALS.

3.4 ADHESIVE 86557106 (FNHA-2-E-069.00)

3.4.1 Temperature

Apply the adhesive in the temperature range of -65°F (-54°C) to +300°F to (+149°C).

3.4.2 Application

Apply the adhesive to the pretreated surfaces in a suitable bead.

Hand Application—The gel can be extruded onto one side of a flange surface from a tube or caulking cartridge. Breaks in the bead are easily repaired by manipulation. Small parts can be covered adequately by pressing them into a saturated polyester urethane sponge or by roll-coating them with a short-nap roller.

Screen Printing—Complex shapes can be coated in seconds with precise control of material quantity and placement.

3.4.3 Mating

Mate the two surfaces with the adhesive together within three minutes and apply a gentle load. Where possible, move surfaces in relation to each other for a few seconds on assembly to properly distribute the sealant.

3.4.4 Coverage

Figure 1 (p. 3) can be used as a guide to selecting the proper amount of material. It relates the width of coverage after assembly to gap size for various bead diameters.

3.4.5 Cure Time

The cure time may vary with different pressure, temperatures, gap sizes, primer and materials. The time needed is about 1 to 12 hours unprimed and .25 to 2 hours primed.

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