

APPLICATION OF TURCITE® USING THE SLYDRITEsm APPLICATION PROCESS

REQUIRED MATERIALS

- Turcite B®
- Waylock® adhesive
- Clean mixing board if applicable
- Wayclean II®
- Blast-Booth or 60 Grit Emery Cloth or Emery
- Application Spatula
- Clean Lint-Free Rags
- 99% Isopropyl Alcohol
- Clamps or Weights
- Wax Paper

A) Pre-clean heavy coolant and chip build up on machine components. We recommend Crystal Simple Green. Scrape off heavy grease and allow Simple Green to penetrate.

B) Clean the bond surface with Wayclean II®, This product is designed to cut grease and oil and leave very little residue, and is environmentally safe to use. White lint free rags should be used, not shop towels, and should be wiped until rag stays clean.

C) Surface finish should not be less than 40 RA per manufacturers specifications.

D) The metal surface to be bonded is then blasted with 36 grit Aluminum Oxide @ 100psi of air. Be sure the blast booth is a clean booth and the surface being blasted is free of grease and oil. 60 grit emery paper can be used in the field where blasting is not possible. All shiny surfaces (known as smeared finishes) must be dulled off even between mill grooves.

E) Prepare the Waylock® Adhesive by mixing each container individually first using separate mixing sticks. Then on a clean mixing board mix 1 to 1 by weight or volume. There are also waylock® applicator guns and tubes with self mixing nozzles available. The pot life of the Waylock® adhesive after being mixed is about 40 minutes for one quart batch depending on temperature and humidity.

F) Make a final wipe of the surface to be bonded as well as the etched side of the Turcite with 99% Isopropyl alcohol and a white lint free rag. Waylock® should then be applied using the spatula provided to assure the proper adhesive thickness.

G) Days of high Humidity can create and cause bond line failure. The use of heat lamps close to the bond area can prevent this.

H) Place weights or clamping device to create 5 to 15 psi of clamp pressure. Be sure to use wax paper between the Turcite and the weights or clamps.
(Length x Width x psi)=required lbs.

I) After a minimum of 6 hours cure temperature and humidity pending, Clean out all adhesive that over flowed and trim off excess material.

J) Turcite applied with Waylock® can be machined in 6 hours. Full cure is in 24 hours. Oil groove depth should be at least 50% of the thickness of the Turcite used. Carbide end mills are required. Oil groove patterns are available on our website.

The above application instructions cover the general application process that will work on any application of the bearing material. Pertaining to machine tools the Slydritesm process goes even further by assuring lube is being supplied to the bearing material once assembled to the machine. Geometric alignments are taken into consideration and inspection and replacement of way wipers and functioning way covers complete the process to assure a quality bond, positioning performance and maximum life of the product, *The Slydritesm Process*