This guide has been developed to assist maintenance personnel who service industrial centrifugal pumps in achieving their goals of pump reliability, longevity and cost reduction.

Most industrial centrifugal pumps carry a significant capital equipment value and it is therefore important to extend their useful lives and ensure that they run efficiently and reliably. Proactive maintenance can reduce the risk of breakdowns and increase pump reliability and longevity.

Many pump breakdowns are the result of simple, needless failures, such as the loss of clamp load between two assemblies caused by a loose fastener. This loss of clamp load could lead to misalignment and ultimately cause bearing failure. Taking some proactive steps can reduce the risk of this occurrence.

Loctite® products help to prevent common failures and extend end-product life in the OEM sector worldwide. These same technologies are used by the people who maintain equipment. Various Loctite® technologies can be used in all stages of pump maintenance:

- Assembly
- Installation
- Repairs
- On-going maintenance
- Disassembly

The use of Loctite® products in a proactive maintenance program can:

- Prevent common failures, both major and minor
- Allow for the recycling of parts to avoid scrap and replacement costs
- Assist in disassembly
- Help ensure reliability and a consistent running condition

PUMP ASSEMBLY

During the assembly of a pump there are many simple steps that can be taken to help reduce or eliminate common failures, and that will also make future disassembly much easier. Proven reliability applications and techniques are discussed, starting with the bearing housing all the way through to the final assembly of the pump casing and attaching the coupling.

PUMP REPAIR

Repairs are a critical element to pump maintenance. Because of the harsh environments and operating parameters, pump parts are subject to wear, erosion, corrosion, leaks, etc. In addition to preventative measures, Loctite® products can be used to restore pump parts. Alternative solutions such as scrap and replacement or the use of other repair technologies may be too costly. Using Loctite® products to restore parts is a very cost-effective solution because users can be assured of the consistent quality, performance, availability and support that is provided from Henkel.

Contact your local Henkel representative for help to meet your specific product application needs.
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Prevent oil leaks from threaded assemblies

**Cause:**
- Drain plugs, oiler nipples, fittings, etc. all have air space between the threads and can weep oil out from the bearing housing
- Constant pressure changes within the bearing housing can force these threaded assemblies to leak

**Seal threaded assemblies with Loctite® 577 or 572 Thread Sealants**
- Loctite® 572 Thread Sealant is designed to cure only when enclosed in metal, such as in a threaded assembly
- Once cured, moisture and oil cannot penetrate this barrier as the pressure changes within the bearing housing
- The thread sealant prevents fittings from loosening, yet allows for easy disassembly with normal hand tools
- Use Loctite® 577 for instant low pressure seal

**Steps:**
1. Clean parts of contamination with Loctite® 7063. If necessary, spray Loctite® 7649 Primer or Loctite® 7240 Activator onto threaded parts (male and female), allow to dry
2. Apply a band of Loctite® 572 Thread Sealant to male threads starting one to two threads from end of fitting
3. Assemble parts as per OEM specifications

**Results**
- Less oil consumption, thereby reducing the risk of the pump running low on lubricant
- Elimination of the potential hazards and clean up associated with oil leaks
- Elimination of seized fittings because moisture and air have been sealed out
- Elimination of rust and corrosion within the thread space
- Contaminants prevented from getting into the oil through the gaps in the threads
**CHALLENGE**

Prevent leaks and seizures between the bearing housing and oil seal

**Causes:**
- As with any press fit, there are small air spaces between the housing and the oil seal. This air space can create a leak path where corrosion can form

**SOLUTION**

- Fill the air spaces by applying a Loctite® 243 or 248 Medium Strength Threadlocker to the outside diameter of the oil seal

**Steps:**
1. Clean the outside diameter of the oil seal and the inside diameter of the bearing housing with Loctite® 7063 Cleaner & Degreaser
2. Apply Loctite® 243 or 248 Medium Strength Threadlocker to the outside diameter of the oil seal
3. Wipe off any excess and press into housing using normal techniques

**RESULTS**

- A sealed assembly eliminates leaks, contamination, and corrosion
- Elimination of clean up and hazards associated with oil seal leaks
- Less oil consumption
- Reduced risk of running low on lubricant
- Service of the pump is easier
- The oil seal can be easily removed with a screwdriver during the next overhaul
Keeping o-rings pliable to ensure a proper seal

**Cause:**
- The typical pump environment is very humid and water washout can remove lubricants from the o-ring.
- When adjustments are made to the impeller this creates sliding abrasion and potential damage to the o-ring and ultimately leads to the loss of sealing.
- O-rings cannot be serviced once installed and may begin to dry out.

**Solution**

**Lubricate o-rings with Loctite® 8104 Food Grade Silicone Grease**
- Loctite® 8104 Food Grade Silicone Grease provides good lubrication over extended periods of time and has excellent water washout resistance.

**Steps:**
1. Clean o-ring to remove any grit or contaminants.
2. Apply Loctite® 8104 Food Grade Silicone Grease to the o-ring by smearing it to completely cover the entire surface.
3. Slide o-ring over the bearing housing and into the o-ring groove.

**Results**
- Lubricated o-rings remain pliable and capable of sealing oil in and contaminants out.
- O-rings prevented from adhering to the bearing frame.
Prevent corrosion and seizure of power end jack bolts, jam nuts and clamp bolts

**Cause:**
- Any exposed metal parts on a pump that are not stainless or coated, such as power end nuts and bolts, are subject to rust. When rust forms within the air space between the threads, the bolts will seize in place.

**SOLUTION**
- **Apply Loctite® 8023 Marine Grade Anti-Seize to the power end bolts**
  - Loctite® 8023 Marine Grade Anti-Seize is metal-free and has superior water washout resistance.
  - **Steps:**
    1. Apply Loctite® 8023 Marine Grade Anti-Seize liberally to the bolt threads.
    2. Assemble jam nuts onto the bolts.
    3. Thread the bolts into the bearing housing and adjust as required.

**RESULTS**
- Easy adjustment of bolts when needed to ensure that the pump runs closest to its BEP (Best Efficiency Point)
- Easy disassembly/removal of bolts.
**Challenge**

Prevent bearing spinout, corrosion and component damage

**Cause:**
- Bearings are prone to spinning either on their shafts or within their housings, resulting in damage to these parts regardless of whether or not they have been pressed, shrink or slip fitted in place.
- The air space that exists between a bearing and shaft is an area where rust can form and cause damage to the parts.

**Solution #1**

Apply a coating of Loctite® 641 Retaining Compound to the outside diameter of the outboard bearing.

- Loctite® 641 Retaining Compound is low strength, which allows for easy disassembly during future overhauls.

**Steps:**
1. Clean parts with Loctite® 7063 Cleaner & Degreaser.
2. Apply a coating of Loctite® 641 Retaining Compound to the outside diameter of the outboard bearing.
3. Assemble using normal techniques.

**Solution #2**

Inboard Bearing – Apply Loctite® 641 Retaining Compound to the inside diameter of the inboard bearing.

**Steps:**
1. Clean parts with Loctite® 7063 Cleaner & Degreaser.
2. Apply a bead of Loctite® 641 Retaining Compound to the circumference of the shaft at the leading area of engagement.
3. Press the bearing onto the shaft using normal techniques.
4. Wipe off any excess material.

**Results**

- Shaft and/or bearing housing damage is eliminated.
- Bearings are easily removed with standard tools.
- Corrosion (the brown smudge left on a shaft after a bearing has been removed is rust) is eliminated because the air space between the bearing and the shaft or housing is sealed.

Bearing Frame and Housing
CHALLENGE

Prevent oil leaks between the frame adapter and the oil seal

Causes:
• The small air spaces between the adapter and the oil seal can allow oil to leak

SOLUTION

Fill the air spaces by applying a Loctite® 243 or 248 Medium Strength Threadlocker to the outside diameter of the oil lip seal

• A Loctite® Medium Strength Threadlocker allows the oil seal to be easily removed with a screwdriver during the next overhaul

Steps:
1. Clean the outside diameter of the oil seal and the inside diameter of the frame adapter with Loctite® 7063 Cleaner & Degreaser
2. Apply Loctite® Medium Strength Threadlocker to the outside diameter of the oil seal
3. Wipe off any excess and press into the adapter using normal techniques and tools

RESULTS

• Elimination of leaks along with associated clean up and hazards.
• Less oil consumption
• Reduced risk of running low on lubricant
• Ease of pump service
• Elimination of leaks, contamination, and corrosion due to a unitized assembly
Prevent dowel pins from seizing to the bearing frame and frame adapter

**Cause:**
- The dowel pins are exposed to the exterior pump environment and if not protected can rust and seize themselves to the bearing frame. When these pins seize in the bearing frame the disassembly becomes very difficult.

**Solution:**
- Before assembly, apply Loctite® 8023 Marine Grade Anti-Seize to the dowel pins
  - Loctite® 8023 Marine Grade Anti-Seize Compound provides a protective coating to parts that are exposed to severe heat and moisture
- **Steps:**
  1. Clean the parts
  2. Apply Loctite® 8023 Marine Grade Anti-Seize to the pins
  3. Assemble adapter to the bearing frame

**Results:**
- Prevention of rust and seizure of these close fitting parts
- The bearing frame and frame adapter will be easier to separate during the next disassembly
**CHALLENGE**

Prevent gasket failure between the bearing frame and frame adapter

**Cause:**
- Leaks occur because a cut gasket can relax over time, resulting in loss of clamp load between the two flanges
- Cut gaskets can also leak because they are prone to extrusion, misalignment, shrinkage, and breaks
- Flange imperfections can be leak paths that a cut gasket may not be able to seal over time

**SOLUTION**

**Apply Loctite® 518 Flange Sealant to the flange face of the frame adapter**

- Loctite® 518 Flange Sealant not only eliminates the gasket but also eliminates all the failure modes of cut gaskets, and most importantly, it seals all of the air space between the two parts
- Loctite® 518 Flange Sealant can cure through fairly large gaps and surface imperfections
  
  Note: In some cases the cut gasket is required for spacing. In this case, apply Loctite® 5922 Flange Sealant to both sides of the gasket as a shellac

**Steps:**
1. Remove old gasketing material and other heavy contaminants with Loctite® 7200 Gasket Remover
2. Clean both flange surfaces with Loctite® 7063 Cleaner & Degreaser
3. Spray Loctite® 7649 Primer or Loctite® 7240 Activator on only one flange surface and allow to dry
4. Apply a continuous bead of Loctite® 518 Flange Sealant to the other surface
  
  Note: Circle bolt holes with sealant if appropriate
5. Assemble parts and tighten as required
6. Allow to cure
  - No pressure: immediate service
  - Low pressure: 1 hour
  - High pressure: 4 hours
  - Full performance of product: 24 hours

**RESULTS**

- Elimination of common cut gasket failures such as compression set, shrinkage, relaxation, and breaks
- Constant clamp load is ensured
- Reliable seal
- Elimination of oil leaks between the bearing frame and frame adapter, along with associated clean up costs and hazards
- Reduced oil consumption
- Reduced risk of running low on oil
CHALLENGE

Prevent fastener loosening and corrosion to frame adapter mounting bolts

Cause:
- Bolts can work themselves loose because they are always under strain caused by torque. Also, vibration, thermal expansion and contraction, and shock all contribute to loosening and reduction of clamp load.

SOLUTION

Apply Loctite® 243 or 248 Medium Strength Threadlocker to the frame adapter bolts

Steps:
1. Clean threads with Loctite® 7063 Cleaner & Degreaser
2. Apply several drops of Loctite® Medium Strength Threadlocker to the adapter bolts
3. Assemble and tighten as usual

RESULTS

- Prevention of the bolts from rusting and seizing in place because a Loctite® threadlocker will seal all of the air space within the threads
- Easy and consistent disassembly
- Prevention of bolts from loosening
- Torque and clamp load is maintained
- Proper clamp load is ensured between flange surfaces (when Loctite® 528 Flange Sealant is used instead of a cut gasket) which eliminates leaks
Prevent corrosion and seizure of packing gland nuts

**Cause:**
- The gland assembly is subject to severe corrosion and seizure because of the continuous flow of water that lubricates and cools the packing. This continuous flow of water also causes the gland studs and nuts to rust and seize.
- If the nuts seize to the studs, it becomes impossible to properly adjust the gland follower and ultimately, proper lubrication and cooling cannot be maintained. This can lead to the packing running dry, overheating and subsequent wearing and gouging of the shaft. What starts out as a simple failure mode of a corroded threaded assembly can lead to a major failure of one of the main pump components.

**Apply Loctite® 8023 Marine Grade Anti-Seize to the studs**
- Loctite® 8023 Marine Grade Anti-Seize is metal-free and is designed to have superior water washout resistance, a key feature in a gland application.

**Steps:**
1. Clean the parts
2. Apply Loctite® 8023 Marine Grade Anti-Seize to the studs
3. Assemble gland nuts and adjust gland follower as necessary

**Results:**
- Elimination of gland nuts freezing to the studs
- Proper adjustments can be made to the gland follower
- Water can properly flow through the packing for lubrication and cooling
- Excessive shaft wear can be prevented
Prevent seizure and loosening of gland studs

**Cause:**
- Just as the gland nuts can rust and seize to the gland studs, so can the gland studs rust and seize to the stuffing box. If the nuts were to seize to the studs, the torque required to remove them could cause the studs to back out.

**Apply Loctite® 2701 High Strength Threadlocker**

**Steps:**
1. Place several drops of Loctite® 2701 High Strength Threadlocker down the side of the female threads.
2. Apply several drops of Loctite® 2701 Threadlocker onto the stud threads.
3. Install the studs.

**Eliminated potential for corrosion**
- Eliminated possibility of the studs backing out during gland adjustments.
**CHALLENGE**

Prevent corrosion within the gland flushing connector

**Cause:**
- Whether using a mechanical seal or packing, these components are typically cooled and lubricated by either a product flush or an external flush. In either case, the flushing connector is prone to corrosion and seizure. This is especially true for pumps configured with packing. Since packing typically requires 40-60 drops per minute for proper cooling and lubrication, there is plenty of available moisture for rust to attack the gland assembly components.

**SOLUTION**

Apply Loctite® 572 Thread Sealant

- Loctite® 572 Thread Sealant fills the air space within the threads
- Allows the flushing connector to be removed with normal hand tools when necessary

**Steps:**
1. Clean the parts with Loctite® 7063 Cleaner & Degreaser
2. Apply a band of Loctite® 572 Thread Sealant to male threads starting one to two threads from the end of the fitting
3. Assemble parts snugly. Do not overtighten

**RESULTS**

- Prevention of leaks and corrosion
- Eliminated seizure
- Ensured easy maintenance of flushing connectors
**CHALLENGE**

Prevent the frame adapter, stuffing box and casing from seizing together

**Cause:**
- When assembling these components, there are areas where the clearance is very tight. These small clearances are areas where rust and corrosion can work in to seize the components together, making disassembly very difficult.

**SOLUTION**

Apply Loctite® 8023 Marine Grade Anti-Seize compound during assembly

- Loctite® Anti-Seize compounds have superior water washout resistance, they will stay where they are applied

**Steps:**
1. Clean the parts
2. Apply Loctite® 8023 Marine Grade Anti-Seize to the outside diameter of the stuffing box at the mating point
3. Assemble components as usual

**RESULTS**

- Sufficient lubrication provided during assembly
- Prevention of rust while in service
- Efficient disassembly
Prevent leaks between the stuffing box and casing

**Cause:**
- The use of cut gaskets suffers from inherent problems, such as gasket relaxation, shrinkage, extrusion, and breakage, which can lead to leaks.

**SOLUTION #1**

Replace the cut gasket and apply Loctite® 518 Flange Sealant

**Sealant to the flange surface**
- Direct metal-to-metal contact along with the use of Loctite® 518 Flange Sealant allows for a positive seal.
- Since there is metal-to-metal contact, proper clamp load can be maintained and the two parts become unitized – they act as one.

**Steps:**
1. Remove old gasketing material with Loctite® 7200 Gasket Remover.
2. Clean both flanges with Loctite® 7063 Cleaner & Degreaser.
3. Spray Loctite® 7649 Primer or Loctite® 7240 Activator on only one surface and allow 1–2 minutes to dry.
4. Apply a continuous bead of Loctite® 518 Flange Sealant to the other surface.
5. Assembly and tighten as required.
6. Allow to cure.

**SOLUTION #2**

Coat the gasket material with Loctite® 5922 Flange Sealant

**Coat the gasket material with Loctite® 5922 Flange Sealant**
- If there is not enough clearance between the impeller and the casing to eliminate the gasket, the cut gasket must be used.
- Loctite® 5922 Flange Sealant will fill all the air space that cut gaskets simply cannot fill.
- Loctite® 5922 Flange Sealant will withstand expansion and contraction caused by pressure and temperature changes.

**Steps:**
1. Remove old gasketing material with Loctite® 7200 Gasket Remover.
2. Clean both flanges with Loctite® 7063 Cleaner & Degreaser.
3. Spray Loctite® 7649 Primer or Loctite® 7240 Activator to both flange faces and both sides of the gasket.
4. Allow 1–2 minutes to dry.
5. Smear Loctite® 5922 Flange Sealant to both sides of the pre-cut gasket.
6. Assembly and tighten as required.
7. Allow to cure.

**RESULTS**
- Eliminated casing gasket leaks.
- Eliminated corrosion and damage on the flange surface.

**CHALLENGE**

Prevent leaks between the stuffing box and casing
Prevent corrosion and seizure of the pump casing bolts

**Causes:**
- The severe pump environments of constant temperature, pressure, and humidity changes result in corrosion
- Casing bolts that are rusted and seized make pump maintenance difficult and create additional labour associated with drilling and tapping the bolt hole

**SOLUTION**

- Apply Loctite® 243 Medium Strength Threadlocker in the bolt holes prior to assembling the casing
  - Loctite® 243 Threadlocker fills all the air space within the threads

**Steps:**
1. Place several drops of Loctite® 243 Medium Strength Threadlocker down the side of the female threads
2. Apply several drops of Loctite® 243 Medium Strength Threadlocker onto the bolt threads
3. Install bolts

**RESULTS**
- Proper clamp load is maintained
- Elimination of rust and seizure
- Easy disassembly with normal hand tools
**CHALLENGE**

Prevent seizure of the impeller to the shaft

**Causes:**
- The combination of small air spaces within the threads and high humidity and temperatures allows for rust to develop and seize the impeller to the shaft.

**SOLUTION**

- Apply Loctite® 8023 Marine Grade Anti-Seize compound to the shaft threads prior to impeller assembly

**Steps:**
1. Clean the shaft and impeller threads.
2. Apply Loctite® 8023 Marine Grade Anti-Seize to the shaft threads.
3. Assemble the impeller using normal techniques.

**RESULTS**

- Prevention of seizure
- Easier disassembly


**CHALLENGE**

Prevent keyway wallow by securing the key stock in the keyway – new components

*Causes*
- In a new assembly the fit between the key stock and the keyway are usually fairly tight. Over time the fit between the key stock and the keyway can loosen and lead to damage to the keyway.

**SOLUTION**

- Proactively apply Loctite® 243 Medium Strength Threadlocker to the keyway and then insert the key stock
  - The viscosity of a Loctite® Medium Strength Threadlocker is appropriate for the gap fill and provides the proper amount of strength, while allowing for easy removal.
  - If the key needs to be removed, simply use a hammer to tap a metal chisel or drift against the key stock to pop it out of the keyway.

*Steps:*
1. Clean the keyway and key stock with Loctite® 7063 Cleaner & Degreaser.
2. Apply several drops of Loctite® 243 Medium Strength Threadlocker directly into the keyway.
3. Insert the key stock into the keyway.
4. Wipe off any excess threadlocker.

*Note: Cover the shaft with a rag to prevent splatter when inserting the key stock.*

**RESULTS**

- Prevention of corrosion
- Prevention of keyway wallow
- A unitized assembly
**Challenge**

Stop keyway wallow and prevent downtime and scrap costs – worn components

**Cause:**
- Over time, keyways can wear if the key stock is not secured in place, which results in keyway wallow. This is a common failure for power transmission components such as couplings, sprockets, sheaves, etc.
- If keyway wallow is allowed to perpetuate, further damage can result, such as a sheared key stock or damage to the coupling. If the key stock shears, the result is a loss of power transmission (i.e. the pump will stop running) and further damage to the shaft will occur.

**Solution**

If the keyway has already been wallowed out, use Loctite® 660 Quick Metal Retaining Compound to stop the wallow and allow the components to return to service

- Loctite® 660 Quick Metal Retaining Compound is a very thick product, which allows it to fill large gaps.

**Steps:**
1. Clean the keyway and key stock with Loctite® 7063 Cleaner & Degreaser.
2. Apply Loctite® 660 Quick Metal Retaining Compound into the keyway.
3. Assemble parts and wipe off excess.

**Note:** If keyway wallow is severe, shims can be used on both sides of the keyways in conjunction with the Loctite® 660 Quick Metal Retaining Compound.

**Results**

- Assembly is restored, unitized, and ready for service without a major overhaul.
Prevent coupling from loosening or moving, resulting in disengagement, damage, or misalignment

**Cause:**
- Couplings are held in place by a key and a set screw
- If the set screw was to loosen, the coupling can begin to slide along the shaft and disengage, or it can begin to wallow out the keyway

**Loctite® 243 Medium and Loctite® 222 Low Strength Threadlockers**

**Steps:**
1. Clean set screw with Loctite® 7063 Cleaner & Degreaser
2. If necessary, spray all threads with Loctite® 7649 Primer or Loctite® 7240 Activator and allow to dry
3. Apply a couple of drops of a Loctite® 222 Low Strength Threadlocker to the set screw (use a Loctite® 243 Medium Strength Threadlocker if the set screw is over 1/4” in diameter)
4. Assemble in the coupling as usual

**Note:** Consider applying a Loctite® Retaining Compound or Threadlocker to the shaft prior to assembling the coupling to completely unitize the coupling to the shaft and prevent any possible corrosion

**RESULTS**
- Assembly is restored, unitized, and ready for service without a major overhaul
Prevent pump mounting bolts from losing clamp load, leading to misalignment

**Cause:**
- Vibration and possible impact shock can work to loosen the mounting bolts
- Loose bolts result in a loss of clamp load, which in turn allows the pump to lose its level and aligned configuration

**SOLUTION #1:**
- **Apply Loctite® 2701 High Strength Threadlocker to the mounting bolts**

**Steps:**
1. Clean threads with Loctite® 7063 Cleaner & Degreaser
2. Apply several drops of Loctite® 2701 High Strength Threadlocker to the mounting bolts
3. Assemble and tighten as usual

**RESULTS**
- Mounting bolts are secured in place
- Proper clamp load is maintained
- Elimination of bolt corrosion
- Prevention of misalignment

**SOLUTION #2:**
- **Apply Loctite® 290 Wicking Grade Threadlocker to the mounting bolts after the pump has been levelled and aligned**

**Steps:**
1. Clean the parts with Loctite® 7063 Cleaner & Degreaser
2. Align the pump
3. Tighten the nuts on the mounting studs
4. Apply several drops of Loctite® 290 Wicking Grade Threadlocker to the mounting bolts
Challenges:

Prevent oil loss from seepage

Cause:

- This cast part can have porosities created during the casting. These porosities can lead to the housing weeping oil

Solutions:

Solution #1:

Coat interior of bearing frame to seal porosities with Loctite® Nordbak® 7221 Chemical Resistant Coating

Steps:

1. Remove visible and invisible contaminants. Clean with Loctite® 7063 Cleaner & Degreaser
2. Abrasive blast the surface to a near white metal finish. Remove dust. Clean with Loctite® 7063 Cleaner & Degreaser
3. Mix and apply Loctite® Nordbak® 7221 Chemical Resistant Coating to the interior of the bearing frame, min 0.5 mm thick, using two coats. Apply second coat when gel time of first coat is reached

Solution #2:

For a part where the specific leak points are known, brush on Loctite® 290 Wicking Grade Threadlocker

Steps:

1. Clean the surface
2. Bake it dry
3. Brush on Loctite® 290 Threadlocker
4. Allow to cure

Results:

- Elimination of oil loss through seepage
- Reduced oil consumption
- Reduced clean up
**Casing / Impeller Wear**

**Challenge**

Rebuild worn areas to restore pump casing and impellers

**Causes:**
- Pump casings and impellers are subject to wear from abrasive slurries and solids, cavitation, and chemical attack. Each of these can wear down internal sections of pump casing.
- Some of the common wear areas include the cutwater, wear ring seats, impeller vane tips, and inside the volute.
- Casing and impeller wear typically falls within the following four category types:
  1. Minor abrasive wear from pumping light slurries
  2. Heavy casing wear and erosion from pumping solids and/or cavitation
  3. Chemical attack
  4. Wear to specific areas of the casing or impeller

**Solution #1**

Rebuild minor surface wear, or rebuild worn areas of the casing and impeller. Apply Loctite® 3478 Superior Metal or Loctite® Nordbak® 7222 Wear Resistant Putty to rebuild worn cutwaters, wear ring seats, impeller vane tips, or other specific areas of the casing. Coat the surface with Loctite® Nordbak® 7227 or 7228 Brushable Ceramic.

- Provides a high gloss, low friction finish to help ensure the pump runs as close to its BEP (Best Efficiency Point) as possible.
- Use Loctite® 3478 Superior Metal to rebuild worn areas, where machining is required to reach the desired dimensions.
- Use Loctite® 7222 Wear Resistant Putty to rebuild worn areas on places where cavitation and wear are constantly present. Product is not machinable.

**Steps:**

1. Remove visible and invisible contaminants. Clean with Loctite® 7063 Cleaner & Degreaser.
2. Abrasive blast the surface to a near white metal finish. Remove dust. Clean with Loctite® 7063 Cleaner & Degreaser.
3. Rebuild the surface with Loctite® 3478 Superior Metal or Loctite® 7222 Wear Resistant Putty. Mix and apply products according to the package instructions.
4. Apply a coat of Loctite® Nordbak® 7228 Brushable Ceramic White. When gel time is reached, apply a second coat of Loctite® Nordbak® 7227 Brushable Ceramic Grey, to a min 0.5 mm final thickness, to allow for easy visual inspection of the coating and wear.

**Note:** Use Loctite® 7232 High Temperature Wear Resistant Putty and Loctite® 7234 High Temperature Brushable Ceramic at elevated temperatures, up to 205 °C dry service temperature.
CHALLENGE

Casing / Impeller Wear

Repair damage from chemical attack and provide a protective coating. Coat the casing and the impeller with Loctite® Nordbak® 7221 Chemical Resistant Coating

• Protects parts in severe chemical environments

Steps:
1. Remove visible and invisible contaminants. Clean with Loctite® 7063 Cleaner & Degreaser
2. Abrasive blast the surface to a near white metal finish. Remove dust. Clean with Loctite® 7063 Cleaner & Degreaser
3. Mix and apply Loctite® Nordbak® 7221 Chemical Resistant Coating, min 0.5 mm thick, using two coats. Apply second coat when gel time of first coat is reached

SOLUTION #2

Repair heavy surface wear to the casing. Rebuild the casing with Loctite® Nordbak® 7218 or 7219 or 7230 or 7226 or 7229 Wearing Compound

• Consult a Henkel Technical Specialist for correct product selection

Steps:
1. Remove visible and invisible contaminants. Clean with Loctite® 7063 Cleaner & Degreaser
2. Abrasive blast the surface to a near white metal finish. Remove dust. Clean with Loctite® 7063 Cleaner & Degreaser
3. Mix and apply the selected Loctite® Nordbak® Wearing Compound as per the package instructions
4. Apply a topcoat of Loctite® Nordbak® 7227 or 7228 or 7234 Brushable Ceramic. When gel time is reached, apply a second coat, to a min 0.5 mm final thickness, to provide a low-friction finish

SOLUTION #3

Rebuild worn areas to restore pump casing and impellers

• Reduced component consumption by salvaging and extending the life of pump casings
• Casings protected from wear and chemical attack
• Pumps helped to run close to their BEP

RESULTS
Challenge

Restore worn shaft to the original condition

Causes:
• Wear caused by packing and oil seals is typically the result of constant pressure and abrasion against the shaft surface
• Over time, oil seals can cut a groove in a shaft
• Neglect and improper water lubrication can cause the packing to heat up and in turn to cause severe wear to the shaft

Solution

Rebuild shafts with Loctite® 3478 Superior Metal

- Loctite® 3478 Superior Metal is an epoxy with high compressive strength that will not rust

Steps:
1. To make the repairs, turn the shaft on a lathe and even out the worn areas to at least 0.75 mm (0.03”), leaving a rough surface finish
2. Clean the shaft of any cutting fluids or oils with Loctite® 7063 Cleaner & Degreaser
3. Mix the product as per the package instructions
4. While the shaft is turning on the lathe, apply Loctite® 3478 Superior Metal by pressing it into the shaft. Firm pressure is required to squeeze out any potential air pockets
5. The cured product can be turned on the lathe and brought down to the original shaft diameter

Results

- Quick return to service
- Reduced component consumption
- Extended shaft life
Challenge:
Repair wallowed out keyways

Cause:
- Shaft vibration and external forces affect key stability. Over time, this instability leads to keyway wallow.

Solution:
Apply a bead of Loctite® 660 Quick Metal Retaining Compound directly in the worn keyway

- Loctite® 660 Quick Metal Retaining Compound is a heavy-bodied product designed to fill large voids, up to 0.25 mm (0.01”). For voids bigger than 0.25 mm (0.01”) use Loctite® 3478 Superior Metal.

Steps:
1. If the keyway wallow is severe, you may need to add shims to both sides.
2. Apply Loctite® 660 Quick Metal Retaining Compound directly into the keyway.
3. Press the new key stock into the keyway and the assembly is restored without having to take apart the pump.

Results:
- A secured fit to the keyway
- Elimination of repeat wallowing
**CHALLENGE**

Prevent corrosion damage to external parts

**Causes:**
- The external components can suffer from rust and chemical attack due to exposure to the elements, extreme temperature changes, humidity, and chemicals.

**RESULTS**
- Extended equipment life
- Reduced component consumption
- Increased pump reliability

**SOLUTION**

**Loctite® Nordbak® 7221 Chemical Resistant Coating**
- Originally developed to protect mining equipment from sulfuric acid
- Provides an excellent coating to protect pump parts from a variety of severe chemical environments.

**Steps:**
1. Remove visible and invisible contaminants. Clean with Loctite® 7063 Cleaner & Degreaser.
2. Abrasive blast the surface to a near white metal finish. Remove dust. Clean with Loctite® 7063 Cleaner & Degreaser.
3. Mix and apply Loctite® Nordbak® 7221 Chemical Resistant Coating as per the package instructions, min 0.5 mm thick, using two coats. Apply second coat when gel time of first coat is reached.
## PUMP ASSEMBLY

### BEARING FRAME AND HOUSING

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### PUMP CASING

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<td>135725</td>
<td>46</td>
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<td>Loctite® 290 Threadlocker</td>
<td>Wicking for post-assembly</td>
<td>50 ml</td>
<td>135727</td>
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<td>Loctite® 268 High Strength Threadlocker</td>
<td>Semi-solid, high strength</td>
<td>19 g stick</td>
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<td><strong>OTHER PRODUCTS</strong></td>
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<td>Adhesives</td>
<td>Loctite® 330 Multi-Bond</td>
<td>General purpose, no mix adhesive</td>
<td>50/35 ml</td>
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<td>Loctite® 3490</td>
<td>Premixed epoxy mixer cups</td>
<td>2 x 25 ml</td>
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<td>Loctite® 3430</td>
<td>Fast curing, high strength</td>
<td>2 x 24 ml</td>
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<td>Cleaners</td>
<td>Loctite® 7200 Gasket Remover</td>
<td>Aggressive gasket remover</td>
<td>12 x 200 ml</td>
<td>498854</td>
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<td>Loctite® 7850 Hand Cleaner</td>
<td>Pre-rinsed hand cleaning wipes</td>
<td>12 x 200 ml</td>
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<td>Loctite® 7561 Biodegradable Cleaner &amp; Degreaser</td>
<td>General purpose, environmentally friendly</td>
<td>12 x 750 ml</td>
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<td>Loctite® 7093 Cleaner &amp; Degreaser</td>
<td>General purpose cleaner</td>
<td>400 ml</td>
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<td>Penetrants/</td>
<td>Loctite® 8203 Pen-Way Spray</td>
<td>Moisture displacer &amp; rust preventer</td>
<td>12 x 400 ml</td>
<td>142710</td>
<td>50</td>
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<td>Lubricants</td>
<td>Loctite® 8046</td>
<td>Press rusted parts</td>
<td>12 x 400 ml</td>
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<td>Loctite® 8106 Multi Purpose Grease</td>
<td>General purpose lubricating paste</td>
<td>400 ml</td>
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<td>Primer</td>
<td>Loctite® 7649 Primer</td>
<td>Anaerobic primer/cleaner</td>
<td>400 ml</td>
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<tr>
<th><strong>PUMP REPAIR</strong></th>
<th><strong>APPLICATIONS</strong></th>
<th><strong>LOCTITE® SOLUTIONS</strong></th>
<th><strong>BENEFITS</strong></th>
<th><strong>PACK SIZE</strong></th>
<th><strong>IDH NO.</strong></th>
<th><strong>PAGE</strong></th>
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<tbody>
<tr>
<td><strong>OIL SEEPAGE</strong></td>
<td>Loctite® Nordbak® 7223</td>
<td>Chemical Resistant Coating</td>
<td>Protection against chemical attack</td>
<td>5.4 kg</td>
<td>7223</td>
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<td>Loctite® 290 Threadlocker</td>
<td>Wicking for post-assembly</td>
<td>50 ml</td>
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<td><strong>CASING / IMPELLER WEAR</strong></td>
<td>Loctite® 3478</td>
<td>Superior Metal</td>
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<td>Loctite® 7222</td>
<td>Wear Resistant Putty</td>
<td>Ceramic fiber filled epoxy</td>
<td>1.3 kg</td>
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<td>Loctite® Nordbak® 7218 Wearing Compound</td>
<td>Trowelable, large ceramic beads</td>
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<td>Loctite® Nordbak® 7219 High Impact Wearing Compound</td>
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<td>Protection against chemical attack</td>
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<td>Loctite® Nordbak® 7225</td>
<td>Pre-Wax</td>
<td>Fine particle wear up to 120 °C</td>
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<td>Loctite® Nordbak® 7227 Brushable Ceramic</td>
<td>Grey</td>
<td>Smooth, corrosion-resistant coating</td>
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<tr>
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<td>Loctite® Nordbak® 7228 Brushable Ceramic</td>
<td>White</td>
<td>Smooth, corrosion-resistant coating</td>
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<td>Protection up to 230 °C</td>
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<td>Loctite® Nordbak® 7230 High Temperature Wearing Compound</td>
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<td>Loctite® Nordbak® 7234 High Temperature Brushable Ceramic</td>
<td>Protection up to 205 °C</td>
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<td><strong>SHAFT WEAR</strong></td>
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<td>Loctite® Hysol® 3471</td>
<td>Steel-filled repair epoxy</td>
<td>500 g</td>
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<td><strong>KEYWAY VALLEY</strong></td>
<td>Loctite® 660 Quick Metal Retaining Compound</td>
<td>Press fit repair</td>
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<td><strong>CORROSION</strong></td>
<td>Loctite® Nordbak® 7225</td>
<td>Chemical Resistant Coating</td>
<td>Protection against chemical attack</td>
<td>5.4 kg</td>
<td>7225</td>
<td>58</td>
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</tbody>
</table>
The data contained herein are intended as reference only. Please contact your local Henkel Technical Support Group for assistance and recommendation on specifications for these products.