DIRECTIONS FOR USE

HPZ Locking Compound

Field guide for locking bronze eccentric bushings

BEFORE STARTING

Verify these directions against the supplied three-component kit label and crusher manual. Follow the site lockout procedure and verify isolation. Read the current component safety data sheets (SDS) for ventilation, protective equipment and handling.

1 Prepare the bushing

Bring the bushing to **16–27 °C (60–80 °F)**. Seal the eyebolt holes and lower bushing joints. Apply an approved release agent only where bonding is unwanted. Set up the funnel before mixing.

2 Mix one complete kit

Add all the Hardener and Foundation to the Resin. Mix for **5 minutes** until the colour is uniform. If the job requires multiple kits, mix each kit separately.

3 Pour into the locking pockets

Pour promptly through a funnel into the specified pockets. Keep compound out of the bushing bore and oil passages. Working time is **10 minutes at 24 °C (75 °F)**.

4 Allow to harden, then heat the casting

At **24 °C (75 °F)**, allow **30–60 minutes** for initial hardening. Once the compound is hard, heat the bearing casting at **60 °C (140 °F) for 30 minutes**. Never heat from inside the bushing or apply heat directly to the compound.

CURE AND RETURN TO SERVICE

The manufacturer lists **8 hours at 24 °C (75 °F)** for cure. Temperature and mixed mass affect working and cure times. Verify cure and complete the crusher manufacturer’s return-to-service checks before restarting.

Hot work Burning can release toxic fumes. Follow the current SDS and site hot-work procedure before welding or torch cutting near cured compound.

Source Original supplier technical information (02/94a) CCOHS lockout guidance