

Modular Encoders Bonding and Debonding Instructions

Bonding Method:

Step 1

Prepare motor shaft for bonding by using solvent to remove any oil, grease or other contaminants from shaft.

Step 2

Apply Loctite Primer T to the motor shaft.
Once applied the primer has a life of one week.

Step 3

Install encoder using the supplied installation instructions.
Do not install the cover at this time

Step 4

Using a fine tip dispenser apply a small amount of Loctite 290 to the seam between the encoder hub and shaft opposite the hub setscrew.
Wipe off excess.

The Loctite will set up at approximately 25% strength within 15 minutes and fully cures within one hour when used with Primer T. See the manufacturer's website for further information on curing the adhesive.

<http://tds.loctite.com/tds5/docs/290-EN.pdf>

Step 5

Install cover. Unit is ready for use.

Debonding Method:

Step 1

Remove cover.

Step 2

Loosen setscrew in hub. If the setscrew is Loctite bonded in place either apply heat from a soldering iron or apply the debonding agent to the setscrew.


Step 3

Apply Pacer Technologies Debonder-Cleanup Agent X/8, P/N 06100 to seam between motor shaft and encoder hub. Wait approximately 30 to 40 minutes to allow debonding agent to penetrate the Loctite bond.

Debonding agent is available from:

- **Manufacturer:** Pacer Technology, 9420 Santa Anita Avenue, Rancho Cucamonga, CA 91730-6117 Phone: 909-987-0550
- **Distributor:** Crosslink Technology, 3103 Cannongate Drive Fort Wayne, IN 46808 Phone: 800-383-1154

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Step 4

Remove mounting screws securing encoder to mounting surface.

Step 5

Set the slide position by model type as follows:

- RCM15: Slide pushed in
- R22i: Slide pushed in
- R35i: Slide pushed in
- RCML15: Slide pulled out
- RM15: Slide pulled out
- RM21: Slide pushed in
- RCM21: Slide pushed in

Step 6

Using 2 thin screwdrivers, pry up evenly on the modular encoder base near where the mounting screws go through the base, while avoiding prying on thin sections. When the encoder lifts high enough off the mounting surface, use larger screwdrivers to complete the removal of the encoder.


Step 7

Wipe the excess solvent from the shaft and inside of encoder hub. Use appropriate method to remove Loctite from shaft.

Step 8

Check encoder for damage. Return for repair if necessary.

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