

PRODUCT SPECIFICATION

400-RC

Anaerobic Adhesive

Description:

Designed for the assembly of cylindrical joints, this single component anaerobic acrylic retaining compound cures when confined in the absence of air between close fitting metal surfaces. It effectively seals joints to prevent leakage while securing components against loosening caused by shock and vibration.

Typical Properties of Cured/Uncured Material:

Uncured State Physical Properties		Uncured State Physical Properties	
Base	Acrylic	Viscosity	Low
Colour	Green Liquid	Strength	High
Chemical Form	Urethane Methacrylate	Application	Retaining
Cure	Anaerobic	Specific Gravity @ 25°C	1.13
Fluorescence	Positive under UV	Viscosity @ 25°C	400-600 mPas
Secondary Cure	Activator	Flash Point	See MSDS
Components	Single – Requires no mixing		

Typical Performance of Cured Material	
Operating Temperature °C (after 24hrs at 20-25°C)	-54°C - 150°C
Shear strength steel collars and pins ISO 1010123	>25Nm

Chemical and Solvent Resistance

Aged under the specified conditions and tested at 22°C.

General Information

This product is not recommended for use in pure oxygen or oxygen rich systems, nor should it be used in the presence of chlorine or other strong oxidising agents. For detailed guidance on safe handling, consult the Safety Data Sheet (SDS).

Where aqueous washing systems are used to clean surfaces prior to bonding, verify the compatibility of the cleaning solution with the adhesive. In certain instances, residual washing solutions may adversely affect both cure speed and final performance.

Environment	°C	% of initial strength		
		100 h	500 h	1000 h
Motor oil (MIL-L-46152)	125	100	100	100
Unleaded Petrol	22	100	100	100
Brake Fluid	22	100	100	100
Ethanol	22	100	100	100
Acetone	22	100	100	100
Water/Glycol 50/50	87	100	95	75

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Directions For Use:

1. For optimum performance, all surfaces, both internal and external, must be clean and free of grease.
2. When working with inactive metals, consider applying a suitable activator.
3. Assemble and tighten parts as required.
4. For shrink fitted assemblies, apply the product to the pin and heat the collar to create sufficient clearance for free assembly.
5. For slip fitted assemblies, apply the product inside the collar and around the leading edge of the pin, using a rotating motion during assembly to ensure complete coverage.
6. For press fitted assemblies, apply the product to both mating surfaces and ensure rapid press speeds during assembly.

Disassembly

Where standard hand tools prove ineffective, apply localized heat directly to the bolt or nut and disassemble while hot.

Clean Up

To remove cured product, use a combination of solvent and mechanical abrasion, such as a wire brush.

Handling & Storage:

Storage

Keep the product in its original, unopened container in a cool, dry location, ideally between 8 and 21°C. Temperatures below 2°C can adversely affect product properties. Do not freeze. Ensure the container remains tightly closed until ready for use.

Handling

Material removed from the container may become contaminated during use. Do not return any unused product to the original container. Improper handling or misuse of the product will invalidate all warranties.

Precaution:

1. Ensure adequate ventilation during use and avoid contact with skin and eyes.
2. In the event of skin contact, rinse thoroughly with warm water or use a suitable debonder to dissolve the adhesive. Do not attempt to force the skin apart.
3. If the product enters the eye, hold the eye open and wash thoroughly with water. Seek medical advice immediately.
4. Keep out of the reach of children.
5. Store in a cool, dry location between 8 and 21°C.

Disclaimer:

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