



03RC

03RC is a high strength anaerobic adhesive for retaining of close fitted parts, shafts, bushes, pulleys, rotors, especially suitable to be used on oily surfaces as is. Highly resistant to heat, corrosion, vibrations, water, gases, oils, hydrocarbons and many chemicals.

Technology / Base	Urethane Methacrylate
Type of Product	Retaining Compound Adhesive
Components	One Component
Curing	Anaerobic with Secondary Heat Cure
Appearance / Color	Green
Consistency	Liquid

Features and Benefits

- High Strength Anaerobic Adhesive
- High Resistance to Heat, Corrosion, Vibrations, Water, Gases, Oils, Hydrocarbons, and Many Chemicals
- UV Fluorescent

Technical Data

Physical Property	Value	Condition/Method
Uncured Material Characteristics		
Viscosity	100 to 150 cPs	Brookfield at 25°C, Spindle 1, 20 rpm
Specific Gravity	1.1	
Flash Point	> 93°C	
Shelf Life	12 months unopened	
Storage Condition	8 to 28°C	
Set Time on Steel	15	
Full Cure Conditions	6 to 72 hours at room temperature, or 40°C bondline temperature for 1 hour to achieve ≥90% of strength on steel	
Cured Material Properties		
Coefficient of Thermal Expansion	80 ppm/K	ASTM D696
Thermal Conductivity	0.1 W/mK	ASTM C177
Specific Heat	0.3 kJ/kgK	
Pin/Collar Shear Strength	20 to 32 N-m	ISO 10123
Service Temperature	-55°C to 150°C	

Cure Speed At Various Temperatures	% of Room Temperature Strength		
	25%	50%	100%
5°C	4 hrs	8 hrs	72 hrs
40°C	7 min	12 min	3 to 72 hrs

Storage

Products should be stored unopened in a cool, dry place out of direct sunlight. Products may be refrigerated for improved shelf life, but should be brought back to room temperature before use.

Curing Performance

The rate of cure will depend on environmental conditions and the substrates used. The gap of the bond line will affect set speed. Smaller gaps tend to increase set speed. Activators may be applied to further improve set speed, but may also impair overall adhesive performance.

Safety and Disposal

For complete safety and handling information, please refer to the appropriate Safety Data Sheets prior to using this product.



Technical Data

Cure Speed On Various Substrates		% of Room Temperature Strength		
		25%	50%	100%
Steel	15 min	30 min	6 to 72 hrs	
Aluminum	2 hrs	15 hrs		

Cure Speed For Various Gap Sizes		% of Room Temperature Strength		
		25%	50%	100%
0.05mm	20 min	40 min	15 to 72 hrs	
0.25mm	20 hrs	48 hrs		

Chemical Resistance Testing			
	Test Temperature	% of Room Temperature Strength	Condition
50% Water/50% Glycol	87°C	80%	1000 hours measured at room conditions
Unleaded Gasoline	22°C	85%	1000 hours measured at room conditions
Motor Oil	125°C	100%	1000 hours measured at room conditions

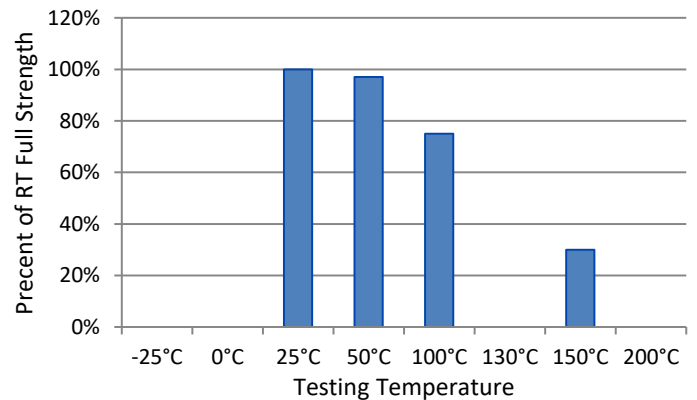
General Instructions

Surfaces to be bonded should be clean and dry and free of grease. Product should be applied in enough quantity to fill all engaged threads or gap. The product performs best in thin bond gaps. Very large gaps may create gaps that will affect the cure speed and overall strength. Good contact is essential. It is recommended to confirm compatibility of the product with all substrates prior to use. This product is not recommended for use with strong oxidizing materials. Where aqueous washing systems are used to clean the surfaces before bonding, these aqueous washes can affect the cure and performance of the adhesive. This product is not normally recommended for use on plastics, users must check compatibility of the product with such substrates.

Specifications

ASTM D-5363 AN 0411

Hot Strength (%RT strength, tested at temperature)



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