Technical Data Sheet

H.B. Fuller | Engineering Adhesives

35RC

35RC is a fast curing high strength anaerobic adhesive for locking and sealing threads, and retaining of cylindrical parts. Allows larger machining tolerances. Highly resistant to heat, corrosion, vibrations, water, gases, oils, hydrocarbons, and many chemicals.

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

Features and Benefits

- Green Anaerobic Retaining Compound and Sealant
- High Strength
- Fluorescent UV Indicator
- Excellent Gap and Void Filling Capability
- High Resistance to Heat, Corrosion, Vibrations, Water, Gases, Oils, Hydrocarbons, and Many Chemicals

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Physical Property	Value	Condition/Method
Uncured Material Characteristics		
Viscosity	1,250 +/- 300 cPs @ 0.50 rpm	Brookfield at 20°C to 25°C(68°F to 77°F)
Specific Gravity	1.1	
Flash Point	> 93°C (200°F)	
Shelf Life	12 months unopened	
Storage Condition	20°C (68°F)	
Set Time on Steel	15	
Full Cure Conditions	12 to 72 hours at 25°C	
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	22 to 40 N-m	ISO 10123
Service Temperature	-55ºC to 150ºC	

Cure Speed At Various Temperatures	% of Room Temperature Strength		
	25%	**50%**	**100%**
5°C	3 hrs	6 hrs	24 to 72 hrs
40°C	7 min	8 min	2 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.

Safety and Disposal

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

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.

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Cure Speed On Various Substrates	% of Room Temperature Strength		
	25%	**50%**	**100%**
Steel	22 min	34 min	18 to 72 hrs
Aluminum	2 hrs	15 hrs	
Zn Dichromate	40 min	2hrs	

Cure Speed For Various Gap Sizes	% of Room Temperature Strength		
	25%	**50%**	**100%**
0.05mm	28 min	35 min	10 to 72 hrs
0.25mm	40 hrs	70 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
Brake Fluid	22°C	80%	1000 hours measured at room conditions
Acetone	22°C	90%	1000 hours measured at room conditions

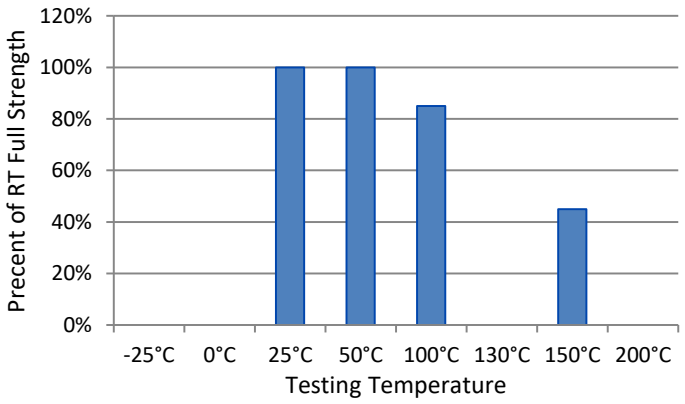
General Instructions

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 0421

Hot Strength (%RT strength, tested at temperature)



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