



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

Technical Data

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	-55°C to 150°C	

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.

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	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

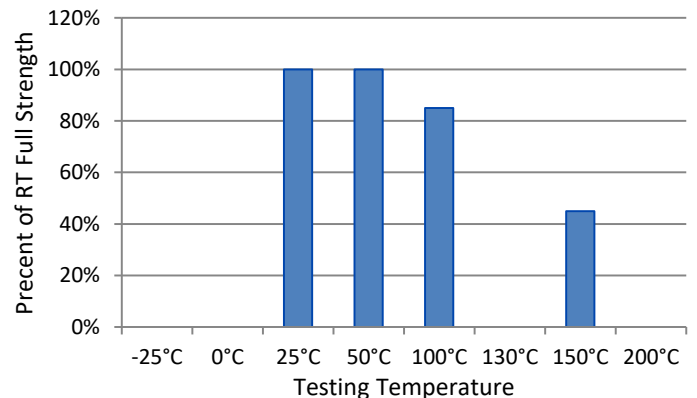
General Instructions

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)



H.B. Fuller Company
 9001 W. Fey Drive
 Frankfort, IL 60423
 +1.800.552.0317

www.hbfuller.com

Connecting what matters.™

IMPORTANT: Information, specifications, procedures and recommendations provided ("information") are based on our experience, and we believe this information to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

© and ™ are trademarks of H.B. Fuller Company or one of its affiliated entities.



NOTE TO USER: by ordering/receiving product you accept the **H.B. Fuller General Terms and Conditions of Sale** applicable in the region. Please request a copy if you have not received these. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, the total aggregate liability of H.B. Fuller for any claim or series of related claims however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill or any indirect or consequential losses arising out of or in connection with product supply.

H.B. Fuller
www.hbfuller.com