

Technical Data Sheet

B638 HIGH STRENGTH RETAINER

Revised 03.08.10



B638 High Strength Retainer

PRODUCT DESCRIPTION

B638 Retainer is designed to give High Strength Retention under Cyclic loading. B638 will retain its full strength and not suffer fatigue under load stress.

APPLICATIONS

B638 is a cylindrical parts supplement, suited to Structural components such as cylindrical parts under dynamic load, keys, splines, even structural tubing with close tolerance fit.

USEFUL NOTES

Surface keying action is greatly increased by rough surface finish giving higher shear strength. Ideal roughness is between 10-120 microns with a preferred tolerance of between 30-100 microns.

PROPERTIES

Fixture time: 5-7 mins@25C Short
Handling Time: <6 hours achieving
Working Strength: 30N/mm (2)
Static Shear

INSTRUCTIONS FOR USE

Ensure parts are clean, dry and free from oil and grease.

PROCEDURE FOR APPLICATION

Product is normally hand applied from the bottle.

COMPATIBLE ACCELERATORS/PRIMERS

Primers such as B7471 (Standard Anaerobic Activator) or the faster B7649 Structural Accelerator can be used, however, up to 30% strength loss can occur when using accelerators.

STORAGE

Store in a cool area out of direct sunlight.
Shelf Life > 18 months @ 20°C.

HEALTH & SAFETY IN USE

IRRITANT: Contains Methacrylate Esters and some products contain small amounts of Acrylic Acid. Irritates eyes, the respiratory organs and the skin. In case of contact with the skin wash immediately with plenty of water.

This Technical information sheet does not constitute a Material Safety Data Sheet. Before using this product ensure you have read and fully understood Bondloc Material Safety Data Sheet B638.

TECHNICAL FEATURES

Resin	Urethane Acrylate
Colour	Green
Fixture Speed No Activator	5 mins
Fixture Speed With Activator	<5 mins
Viscosity Brookfield Sp3 @20rpm @ 25°C	2500 cps
Gap fill	0.2 mm
Flash Point	>85°C
Shelf Life	12 months min
Specific Gravity	1.08
Max Operating Temperature	-55°C to + 150°C

CURED PERFORMANCE

Full Cure Time	24 hours
Static shear strength	30 N/mm ²

PRESENTATION

Bottles.....10ml, 25ml, 50ml, 250ml
Clam Packs.....10ml, 25ml, and 50ml

PRECAUTIONS: This product and the auxiliary materials normally combined with it are capable of producing adverse health effects ranging from minor skin irritation to serious systemic effects. None of these materials should be used, stored, or transported until the handling precautions and recommendations as stated in the Material Safety Data Sheets () for this and all other products being used are understood by all persons who will work with the product.

Warranty: All products purchased from or supplied by Bondloc are subject to terms and conditions set out in the contract. Bondloc warrants only that its product will meet those specifications designated as such herein or in other publications. All other information supplied by Bondloc is considered accurate but is furnished upon the express condition the customer shall make its own assessment to determine the product's suitability for a particular purpose. Bondloc makes no other warranty, either express or implied, including those regarding such other information, the data upon which the same is based, or the results to be obtained from the use thereof; that any product shall be merchantable or fit for any particular purpose; or that the use of such other information or product will not infringe any patent.