Technical Data Sheet

B620 HI Strength Retainer Revised 03.08.10

B620 HI Strength Retainer

PRODUCT DESCRIPTION

B620 is designed for the bonding of cylindrical fitting parts. The product cures when confined in the absence of air between close fitting metal surfaces and prevents loosening and leakage from shock and vibration.

APPLICATIONS

Typical applications include locating pins in radiator assemblies, sleeves into pump housings and bearings in auto transmissions. Particularly suitable for applications where temperature resistance up to 200°C is required.

TYPICAL BOND CHARACTERISTICS

Fast hold	5-7 mins @ 25°C
Short ultimate cure	<6 hours

Achieving 30N/mm (2) static shear

INSTRUCTIONS FOR USE

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. The larger gaps over 175 microns can result in Ultimate strength loss. Ensure parts are clean, dry and free from oil and grease.

PROCEDURE FOR APPLICATION

Product us normally hand applied from the bottle.

TECHNICAL FEATURES

Resin	Mod Urethane Acrylate
Colour	Green
Cure speed with activator	<5 mins on gaps
Cure speed without activator	5 mins
Viscosity Brookfield Sp3 @20rpm @ 25°C	5000 - 1200 cps
Gap fill	0.2mm
Flash point	>85°C
Shelf life	12 months @ 20°C
Specific gravity	1.08
Max. Operating temperature	-55°C to + 200°C

CURED PERFORMANCE

Full cure time	24 hours
Static shear strength	30 Nmm²
Range	22 to 40 Nmm²

Test methods ISO.10123/MIL46082B

STORAGE

Store in a cool area out of direct sunlight.
Shelf life - 12 months @ 20°C

HEALTH & SAFETY IN USE

IRRITANT - Contains Methacrylate Esters. Irritates eyes, the respiratory organs and then skin. In case of contact with the skin wash immediately with plenty of water.

ACCELERATORS/PRIMERS

Primers such as B7471 Anaerobic activator or the faster B7649 structural accelerator can be used, however up to 30% strength loss can occur when using accelerators.

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.

PRESENTATION

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