**Technical Datasheet**

**Holdtite R91**

**Product Description**

Holdtite R91 is a high strength low viscosity retaining compound, designed to bond close fitting metal surfaces with an ultimate structural strength. R91 specializes in bonding cylindrical fitting parts, and maintains an unfaltering bond under all levels of cyclic load stress distribution.

**Typical Applications**

Holdtite R91 can be used in a wide variety of applications, especially interference or press fit parts including:

* High strength retention of bearings
* Locking of keys and splines
* Bonding rotors, bushes and sleeves to shafts
* Securing loose or worn parts

**Instructions For Use**

1. For best results clean all surfaces with a cleaning solvent and allow to dry.
2. If the metal is inactive (see Compatibility Chart) apply suitable Bondchem primer.
3. Apply the adhesive to both the inside of the collar, and the leading edge of the pin, and assemble parts with a rotational motion, ensuring a high surface coverage.
4. Allow parts to cure to handling strength.

**Properties of Uncured Material**

|  |  |
| --- | --- |
| Resin | Dimethacrylate |
| Colour | Green |
| Viscosity @ 250C |  |
| Brookfield Sp 3 @ 20rpm | 125cps |

**Performance of Cured Material**

|  |  |
| --- | --- |
| Fixture Time | 15-20 min @ 200C |
| Fixture Time with Primer | <5 Minutes |
| Full Cure Time | 24 hours @ 200C |
| Gap Fill | 0.13mm |
| Temperature Range | -510C to 1480C |
| Strength Breakloose | 30-40Nm |
| Strength Prevailing | 25-50 Nm |

**Packaging**

Holdtite R91 is available in 10ml, 50ml, 250ml LDPE bottles. In addition, we can offer automated dispensing lines for the bulk dispensing of this material.

**Storage & Shelflife**

Holdtite R91 should be stored in a cool dry area, out of direct sunlight. Stored correctly , this grade can offer a 24 month shelf life from manufacture.

**Health and Safety in Use**

**Irritant**: Contains Methacrylate Esters which may irritate eyes, respiratory organs and skin. In case of contact with the skin, wash immediately with plenty of water. For full Health and Safety information please consult the MSDS.