**Technical Datasheet**

**Holdtite R62**

**Product Description**

Holdtite R62 is a high strength, high temperature retaining compound, designed to bond close fitting metal surfaces with an ultimate structural strength. R62 specializes in bonding cylindrical fitting parts, and maintains an unfaltering bond under all levels of cyclic load stress distribution. This product has additional adhesion promoters allowing excellent performance on aluminium, plated metals, stainless steel and hybrid alloy parts.

**Typical Applications**

Holdtite R62 is designed for high temperature resistance, and excells in many applications including:

* High strength retention of bearings into auto transmissions.
* Bonding location pins in radiator assemblies.
* Bonding rotors, bushes and sleeves into pump housings.
* 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 5 @ 20rpm | 5,000 to 10,000 cps |

**Performance of Cured Material**

|  |  |
| --- | --- |
| Fixture Time | 15-20 min @ 220C |
| Full Cure Time | 24 hours @ 220C |
| Strength Breakloose M10 | 23Nm |
| Strength Prevailing M10 | 25Nm |
| Temperature Range | -510C to 1770C |

**Packaging**

Holdtite R62 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 R62 should be stored in a cool dry area, out of direct sunlight. Stored correctly , this grade can offer an 18 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.