**Technical Datasheet Holdtite R48**

**UHS Technology**

Holdtite R48 is produced from our latest high strength technology for permanent metal assemblies and fixings.

**Product Description**

Holdtite R48 is a ultra high strength low viscosity retaining compound, designed to bond close fitting metal surfaces with an ultimate structural strength. R48 specializes in bonding cylindrical fitting parts, and maintains an unfaltering bond under all levels of cyclic load stress distribution. Designed for the permanent fixture of parts and not reccomended for parts that may require a strip down or maintenance related dis-assembley.

**Typical Applications**

Holdtite R48 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 or the gap >0.2mm, apply Bondchem A249 activator to increase cure speed.
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**

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| --- | --- |
| Resin | Dimethacrylate |
| Colour | Green |
| Viscosity @ 25°C |  |
| Brookfield Sp 3 @ 30rpm | 400 – 600 cps |

**Performance of Cured Material**

|  |  |
| --- | --- |
| Fixture Time Stainless Steel | 8-15 min @ 22°C |
| Fixture Time with A249 | <3 Minutes |
| Full Cure Time | 24 hours @ 20°C |
| Gap Fill (Diametrical) | Up to 0.25mm  |
| Strength Break Loose M10 | 50 Nm |
| Strength Prevailling M10 | 40 Nm |
| Temperature Range | -50°C to 180°C |

**Packaging**

Holdtite R48 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 R48 should be stored in a cool dry area, out of direct sunlight. Stored correctly , this grade can offer a 12 month shelf life from manufacture.