

Technical Data Sheet

Product Description:

301430 is a single component, highest strength, anaerobic retaining compound. It is a fast curing, developing high strength quickly and will withstand higher service temperature than standard products. 301430 cures when confined in the absence of air between close-fitting metal surfaces.

Applications:

- Formulated for bonding cylindrical parts, to give very high strength bonds.
- Typical applications include mounting gears and rotors on the shafts.
- Designed to augment the strength of press fit assemblies.
- Once applied, parts slip together easily, lubricated by the adhesive.
- Prevents corrosion of assembled parts.

Physical Properties:

Composition:	Dimethacrylate / Triacrylate
Color:	Green
Viscosity:	600 cps at 25 °C
Specific Gravity:	1.08
Shelf Life:	12 months

Performance Characteristics:

Maximum Gap Fill	0.20mm
Fixture Time	10mins
Full Cure	24hrs
Strength Build Up	15 mins = 10% strength 45 mins = ~50% strength 24hours = 100% strength
Breakaway Torque N.m (ISO 10964)	Range 18 – 40 Typical 29
Prevail Torque N.m (ISO 10964)	Range 11 – 45 Typical 30
Shear Strength N/mm ² (ISO 10123)	Range 20 – 33 Typical 28
Chemical compatibility	Anaerobic adhesives and sealants should not be used in pure oxygen or chlorine lines.
Service Temperature Range	-50 to +150°C

Additional Product Information:

Anaerobic adhesives only cure in the absence of air and with metal part activation. Adhesive outside the joint will remain uncured and may be wiped away with a cloth. 301430 is suitable for high strength retaining applications that require small to medium gap filling. 301430 is not recommended on certain plastics as stress cracking can sometimes result. Some anti-corrosion chemicals inhibit the cure system in this type of anaerobic. Trials are recommended to establish whether cleaning of the parts is necessary.

Application Techniques:

Ensure parts are clean, dry and free from oil and grease.
Apply adhesive to all engaged threads. Assemble parts and allow to cure. Wipe excess adhesive from outside of joint.
Heating the assembled parts accelerates the curing process.
An anaerobic activator may be used to accelerate cure and should be used if the application temperature is below 5°C. The use of an accelerator may reduce the final bond strength by up to 30%.

Storage Conditions:

Keep the adhesive in a cool, dry place away from direct sunlight. Under such conditions shelf life at room temperature will be 12 months.
Refrigeration to 5°C gives optimum storage stability.

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