

# **Technical Data Sheet**

#### Product Description:

390014 is a one-component anaerobic adhesives designed to secure cylindrical metal assemblies such as bearings on shafts, bushings, sleeves, housings, and keyways. It prevents loosening, corrosion and leakage caused by shock and vibration.

It is a general purpose, medium strength, removable, low viscosity retaining compound that prevents spin-out for rigid assemblies such as locking bushings and sleeves in housings or on shafts, bonding rotors to shafts, and as an augment to press fits.

#### **Adhesive Properties:**

Composition: Color: Viscosity: (Brookfield LVF Spindle 1 @ 12 rpm - 25 <sup>0</sup> C) Specific Gravity: Maximum Diameter of Thread/Gap Filling: Flash Point: Solvent Content: Shelf Life:		Green	90 - 140 cps 1.1 0.15 mm > 93°C None		
Curing Properties:					
Fixture time: Full Cure Time: Breakaway Torque, ISO 10964: (M10 black oxide steel nuts and bolts) Prevailing Torque, ISO 10964: (M10 black oxide steel nuts and bolts)		24 hours > =15 - 40 N > =20 - 50 N	> =15 - 40 Nm > =20 - 50 Nm		
Temperature Range		-55 10 150°C	-55 to 150°C		
Chemical / Solvent Resistance					
Chemical	Temp.	% Initia	% Initial Strength Retained		
		100 hours	500 hours	1000 hours	
Acetone	22°C	100	100	85	
Ethanol	22°C	100	100	100	
Motor Oil	125°C	100	100	100	
Gasoline	22°C	100	100	100	

#### **Directions for Use:**

22°C

87°C

Brake Fluid

Water/Glycol

Retaining Compound Anaerobic Adhesives are not recommended for use on most plastics due to potential cracking of plastic parts. Also, they are not recommended for use in systems that contain pure oxygen or an oxygen-rich environment, chlorine, or strong oxidizing substances.

100

100

100

85

100

80

# For Assembly

1. Ensure parts are clean, dry and free from oil, grease and dirt. For best results, clean and dry parts with solvent. (Activator can also be used on inactive surfaces or to accelerate the cure on active surfaces.)

2. If not sure of surface type, always use activator. Refer to Material Surface Activity and Cure Speed section for more information.

3. Avoid touching the metal surfaces with the bottle tip since the metal ions may react with the adhesive upon contact and eventually may clog the bottle tip.

4. Apply a bead of adhesive onto the shaft and inside the collar where the contact area will finally be assembled. For larger parts use more adhesive. Assemble parts and rotate to spread adhesive evenly around contact area.

5. Allow assemblies to set for sufficient time so that handling strength or full cure will occur before further processing or testing.

## For Disassembly

**1.** Apply localized heat (approximately 250°C) to bonded parts then disassemble while parts are still hot. Use extreme caution when working with heat sources (e.g. heat gun, flame, etc.).

#### Material Surface Activity and Cure Speed

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## Storage:

Store product in cool, dry area out of direct sunlight.

## Shelf Life

Retaining Compound Anaerobic Adhesives have a shelf life of twelve months when stored at 16° to 27°C in the original unopened container.

## **Technical Information**

The technical information, recommendations and other statements contained in this document are based upon tests or experience that Cedesa believes are reliable, but the accuracy or completeness of such information is not guaranteed.

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