



Technical Data Sheet

Product

Anaerobic Retaining Compound RT 641

Revision date: March 2017

Date of issue: June 2015

Reference No. : 400001010641

Product Description

Retaining Compound Anaerobic Adhesives are one-component anaerobic adhesives designed to secure cylindrical metal assemblies such as bearings on shafts, bushings, sleeves, housings, and keyways. They prevent loosening, corrosion and leakage caused by shock and vibration.

Product Features

Bearing Mount Retaining Compound RT 641 is a medium strength, low viscosity retaining compound, for bonding cylindrical parts, with controlled strength to allow disassembly for servicing and bearing re-use. It is also designed to augment the strength of press fit assemblies.

Technical Information Note

The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Typical Uncured Physical Properties

Property	Values	Notes
Color	Yellow	
Chemistry	Dimethacrylate cP	
Viscosity	400 to 800 cP	Brookfield Viscometer spindle #2 at 20 rpm
Fixture Time	25min (avg time) (≤30min range)	Reference ISO 10964

Typical Mixed Physical Properties

Time to Full Cure: 24 h

Conditions

Test Condition : Room Temperature

Cure Speed:

Active (Fast) ←	→	Inactive (Slow)
<ul style="list-style-type: none"> • Brass • Bronze • Commercial aluminum • Copper • Iron • Kovar® • Manganese • Monel® • Nickel 		<ul style="list-style-type: none"> • Anodized aluminum • Cadmium • Chemical black oxide • Galvanized steel • Gold • Inconel® • Magnesium • Magnetite steel • Plated parts • Pure aluminum • Silver • Stainless steel • Zinc

Typical Cured Characteristics

Property	Values	Values	Test Condition
Temperature Range	-54 to 149 °C	-65 to 300 °F	Constant
Compressive Shear	2950 lb/in ²		

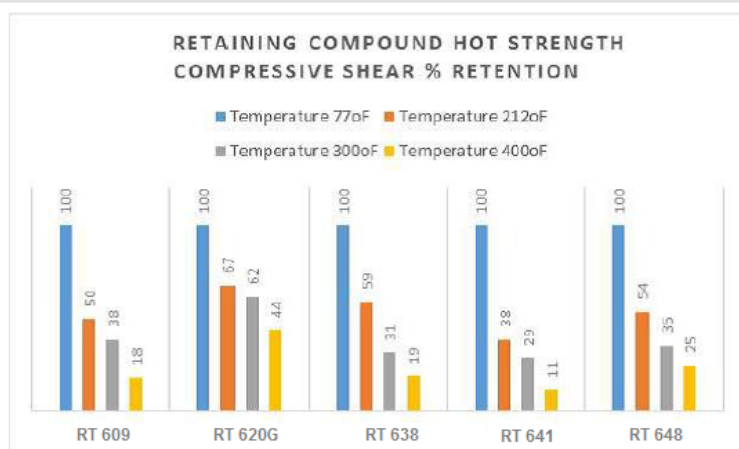
Typical Physical Properties

Appearance: Liquid

Typical Performance Characteristics

Property	Values	Notes
Breakaway Torque	90in-lb - typical value (60 - 130in-lb range)	Reference ISO 10964. To convert to (N.m) divide (in.lb) by 8.851.
Prevailing Torque	90in-lb - typical value (70 - 105in-lb range)	Reference ISO 10964. To convert to (N.m) divide (in.lb) by 8.851.

Hot Strength % Retention:



Handling/Application Information

Directions for Use

Retaining Compounds 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 piping systems that contain pure oxygen or an oxygen-rich environment, chlorine, or strong oxidizing substances.

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

For Assembly:

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

For Disassembly:

Apply localized heat (approximately 490oF / 254oC) to bonded parts then disassemble while parts are still hot. Use extreme caution when working with heat sources (e.g. heat gun, flame, etc.)

Storage and Shelf Life

Store product in cool, dry area out of direct sunlight

Retaining Compound Anaerobic Adhesives have a shelf life of 12 months when stored at 60° to 80°F (16° to 27°C) in the original unopened container.

ISO Statement

This product was manufactured under a quality system registered to ISO 9001 standards.

Precautionary Information

Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product.

Precautionary Information

Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product.

Information

Technical Information: The technical information, guidance, and other statements contained in this document are based upon records, tests, or experience to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information.

Product Selection and Use: Many factors beyond control and uniquely within user's knowledge and control can affect the use and performance of a product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

Limitation of Liability: Except for the limited remedy stated above, and except to the extent prohibited by law, will not be liable for any loss or damage arising from or related to the product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.

Petrotechno Ltd, Canada

7050 Gablehurst Cres. Mississauga,
Ontario, Canada

Phone: +1(647) 476 4750

Fax: +1(647) 476 4751

www.petrotechno.com