

A2638 – Technical Data Sheet



Bondrite Adhesives Limited
Unit 3H
Sileby Road Industrial Estate
Barrow-Upon-Soar
Leicestershire LE12 8LP
Tel: 01509 815550

Description

A2638 is designed for the bonding of cylindrical fitting parts particularly where bond gap can approach 0.25mm, and maintains an unflinching bond under all levels of cyclic load stress distribution. The product is a single component anaerobic, ultra high strength medium viscosity product.

A2638 cures when confined in the absence of air between close fitting metal with an ultimate structural strength. The product is designed for the permanent fixture of parts and not recommended for parts that may require a strip down or maintenance related dis-assembly.

Applications include interference or press fit parts including high strength retention of bearings, bonding rotors, bushes and sleeves to shafts, locking of keys and splines and securing of loose or worn parts.

Characteristics

Base	Dimethacrylate
Viscosity	2000-4000 mPas
Fixture Time	<10mins
Colour	Green
Gap Fill	Up to 0.25mm
Flash point	See MSDS

Typical Performance of Cured Material

	Typical value
Full Cure Time	24 hours @ 20°C
Operating Temperature	-50°C to 150°C
Strength Break loose M10	30Nm
Strength Prevailing M10	22Nm

Directions for use

1. For optimum performance surfaces should be clean and free of grease (internal and external).
2. If the material is an inactive metal consider using activator.
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.

Precaution

1. Use with proper ventilation. Avoid contact with skin and eyes.
2. If contact with skin occurs, rinse with warm water or dissolve gradually with appropriate debonder.
3. Do not try to remove forcibly.

4. If adhesive gets into eye, keep eye open and rinse thoroughly. Seek medical attention immediately.
5. Keep well out of reach of children.
6. Where washing systems are used to clean the surfaces before bonding, it is important to check the compatibility of the washing solution with the adhesive. In some cases these solutions can affect the cure and performance of the adhesive.

Storage

Keep adhesive in a cool, dry place out of direct sunlight.

Please consult the A2638 Health & Safety Data Sheet for statutory regulation information.

Information relating to the products of Bondrite Adhesive Limited is based on tests carried out under laboratory conditions. If any of our products are not used in accordance with our instructions or are used under conditions which vary from our laboratory, they may not perform in accordance with any information provided and Bondrite shall not have any liability in this case. Bondrite will accordingly provide samples of our products, on request and free of charge, for Customers to carry out their own tests as to suitability of our product for their purposes and as used in their intended environment.

Purchase from Bondrite