

Product information

Bushing and Bearing Fixation

PI 25/25/06/2020



Description

High-strength, low-viscosity, oil-resistant dimethylacrylate ester-based adhesive which does not contain solvents and cures in the absence of oxygen.

Properties

- high strength
- outstanding capillary action
- resistant to gasoline and brake fluid at room temperature as well as to other materials
- cures in the absence of oxygen
- low viscosity

Technical data

Operating temperature range	-60 bis + 150 / -60 to + 150 °C
Thread sizes	bis M20 / up to M20
Shear resistance	20-30 N/mm ² DIN 54452
Strength class	hochfest / high strength
Color / appearance	grün / green
Prevailing torque	39 Nm DIN 54454
Thread friction value	0,17
Shelf life	mindestens 2 Jahre (ungeöffnet) / at least 2 years (unopened)
Base	Di-Methacrylatester / dimethylacrylate ester
Odor	charakteristisch / characteristic
Form	flüssig / liquid
Density	1,08 g/cm ³
Viscosity at 23 °C	200 mPas
Initial strength	3-12 min (aktiv); 12-60 min (passiv) / 3-12 min (active); 12-60 min (passive) min
Functional strength	3 - 5 h
Final strength	9 - 10 h
Shelf life in original sealed container	24 months
Recommended storage temperature	8 - 21 °C



Areas of application

For attaching coaxial assembly parts such as bearings, bushings, shafts and hubs as well as for joining plastics and rubber/metal or metal/metal surfaces.

Application

The components to be bonded must be roughly freed from contaminants such as oil films, dirt, paint or other coating materials to ensure the optimum bond. Wet bonding parts and then join them.

One must differentiate between active and passive materials during the curing time. Active materials generally refer to metals with a high iron or copper content (e.g. iron, steel, copper, brass, bronze). Active materials ensure rapid curing. Passive materials such as high-alloy (stainless) steel, zinc, aluminum or plastics only cure very slowly or only with the help of an activator.

Comment

Due to the anaerobic properties, there must always be enough air in the bottle. Otherwise the adhesive could harden prematurely. The bottle should therefore only be filled up to about 1/3. However, the quantity always corresponds to the content indicated on the container.

Available pack sizes

10 g Bottle plastic	3806 D
50 g Bottle plastic	3807 D

Our information is based on thorough research and may be considered reliable, although not legally binding.