

R903 Retainer

Engineering Adhesives

DESCRIPTION

R903 is an Oil Tolerant High Strength Retainer, designed for direct use on as received parts such as those with oily films.

Typical Properties (Liquid Product)	
Chemical base:	Modified Methacrylate
Colour:	Green
Viscosity:	110-140cps
Specific Gravity	1.08
Max. gap filling:	0.1mm
Temp Range:	-50°C to 150°C
Physical Properties (cured product) @23°C	
Measured on M10 x 20 bolt, loose free running.	
Initial strength:	1 hour
Final strength:	24 hours
Cured Performance	
Full Cure Time:	24 hours
Statics Shear (oiled film)	21-24 N/mm(2) (ISO/MIL)
Static Shear (degreased)	20.33MPa
The test methods used are ISO 10123/MIL 46082B on mild steel Pin/Collars to the above specifications.	

APPLICATIONS

R903 Retainer has been designed for the permanent retention of close fitting parts. It is a high strength, low viscosity securing compound, used for the retaining of cylindrical parts in situ with the ability to overcome light oil residues or contamination during assembly. R903 is ideal for slip fit or interference fits on gears, pulleys, keyways, splines, sleeves and bushes etc.

Use as a conventional high strength Retainer on cleaned parts with strengths up to 28 N/mm² or as a convenient all-purpose locker on oily parts, with >20N/mm² strength depending on oil type and film

DIRECTIONS FOR USE

Where possible, remove thick deposits of grease or dirt. However, R903 will penetrate the film once it has been tightened.

- Parts should be clean, dry and dust free.
- Degreased parts will assist results.
- Apply sufficient product to fill joint.
- Assemble parts in traditional manner.
- To achieve handling strength allow product to solidify (approximately 15 minutes).

COMPATIBLE ACTIVATORS , ACCELERATORS & PRIMERS

Activators such as A471 Structural Activator or the faster A649 Structural Activator can be used, however, up to 30% strength loss can occur when using accelerators



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PACKAGING

Bottles: 10ml, 50ml & 250ml
Bulk: 15kg

STORAGE & SHELF LIFE

Store in a cool area out of direct sunlight
Shelf Life: 12 months @ 20°C

HEALTH & SAFETY

Please refer to SDS

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