

# R930 Retainer

Engineering Adhesives

## DESCRIPTION

R930 Non Corrosive, High Temperature Retainer, is designed to give very high strength retention under cyclic loading at high temperatures. It will retain its full strength and not suffer fatigue under load stress, and will give dynamic performance at elevated temperatures up to 230°C (intermittent). It has also been formulated to allow longer assembly times on highly reactive surfaces, such as brass and copper and to avoid partial curing during assembly.

<b>Physical Properties (liquid product)</b>	
Chemical base:	Methacrylate Ester
Colour:	Green
Viscosity:	5500-7000cps
Specific Gravity	0.94
Max.thread diameter:	M36
Max. gap filling:	0.20mm
Temp Range:	-55°C to 150°C Constant Up to 230°C Intermittent
<b>Physical Properties (cured product) @23°C</b>	
Initial Strength:	14-20 minutes
Final Strength:	24 hours
Breakaway Strength (T <sub>BA</sub> ) (ISO 10964)	Up to 36 N.m
Prevailing Strength (T <sub>P</sub> ) (ISO 10964)	Up to 27 N.m
Static Shear Strength: (ISO 10123)	23.66 MPa

## APPLICATIONS

R930 is a cylindrical parts supplement, suited to Structural components such as axial joints under dynamic load, keys, splines, even structural tubing with close fit tolerance, while providing performance at high temperatures up to 230°C (intermittent).

Surface keying action is greatly increased by rough surface finish, giving higher Shear Strength. Ideal roughness is between 10-120 microns with a preferred tolerance of between 30-100 microns. Larger surface gaps over 175 microns can result in ultimate strength loss.

R930 usually sets in under 2 minutes on highly active materials but still retains a relatively fast cure on polished surfaces such as mild steel and other ferrous metals. Reactivity on stainless steel is usually slower, but typically bonds form within 1 hour.

## DIRECTIONS FOR USE

- 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).



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**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.

**PACKAGING**

Bottles: 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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