

Product Description

Bondchem AR09 is a high strength low viscosity retaining compound, designed to bond close fitting metal surfaces with an ultimate structural strength. AR09 also cures in the presence of UV light so is ideal for applications where any migration of adhesive from the joint must be prevented. AR09 specializes in bonding cylindrical fitting parts, and maintains an unfaltering bond under all levels of cyclic load stress distribution.

Typical Applications

Bondchem AR09 can be used in a wide variety of applications, especially interference or press fit parts including:

- High strength retention of bearings
- Locking of keys and splines
- Bonding rotors, bushes and sleeves to shafts
- Securing loose or worn parts

Instructions For Use

1. For best results clean all surfaces with a cleaning solvent and allow to dry.
2. If the metal is inactive (see Compatibility Chart) apply suitable Bondchem primer.
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.

Properties of Uncured Material

Resin	Dimethacrylate
Colour	Green
Viscosity @ 25°C	
Brookfield Sp 2 @ 20rpm	100-150 cps

Performance of Cured Material

Fixture Time	10 min @ 20°C
Fixture Time with Primer	<5 Minutes
Full Cure Time	24 hours @ 20°C
Gap Fill	0.15mm
Temperature Range	-51°C to 148°C
Shear Strength	>25N/mm ²

Packaging

Bondchem AR09 is available in 10ml, 50ml, 250ml LDPE bottles. In addition, we can offer automated dispensing lines for the bulk dispensing of this material.

Storage & Shelflife

Bondchem AR09 should be stored in a cool dry area, out of direct sunlight. Stored correctly, this grade can offer a 24 month shelf life from manufacture.

Health and Safety in Use

Irritant: Contains Methacrylate Esters which may irritate eyes, respiratory organs and skin. In case of contact with the skin, wash immediately with plenty of water. For full Health and Safety information please consult the MSDS.