

Product Description

Bondchem AR10 is a high strength, high temperature retaining compound, designed to bond close fitting metal surfaces with an ultimate structural strength. **AR10** specializes in bonding cylindrical fitting parts, and maintains an unfaltering bond under all levels of cyclic load stress distribution. This product has additional adhesion promoters allowing excellent performance on aluminium, plated metals, stainless steel and hybrid alloy parts.

Typical Applications

Bondchem AR10 is designed for high temperature resistance, and excels in many applications including:

- High strength retention of bearings into auto transmissions.
- Bonding location pins in radiator assemblies.
- Bonding rotors, bushes and sleeves into pump housings.
- Securing loose or worn parts.

Instructions For Use

This adhesive is UV sensitive. Any exposure to daylight, UV light and artificial light should be kept to an absolute minimum during storage and handling.

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 @ 20°C Spindle 5 @ 20rpm	5,000 to 12,000 cps

Performance of Cured Material

Fixture Time M10 Black oxide	< 15 Minutes
Full Cure Time	24 hours @ 22°C
Breakaway Torque Test	23 N.m
Temperature Range	-51°C to 177°C
Prevailing Torque Test	25 N.m

Packaging

Bondchem AR10 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 AR10 should be stored in a cool dry area, out of direct sunlight. Stored correctly, this grade can offer an 18 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.