

Product Description

Bondchem AR11 is a high strength low viscosity retaining compound, designed to bond close fitting metal surfaces with an ultimate structural strength. **AR11** specializes in bonding cylindrical fitting parts, and maintains an unfaltering bond under all levels of cyclic load stress distribution.

Typical Applications

Bondchem AR11 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 @ 20°C Sp 1 @ 20rpm	100-150 cps

Performance of Cured Material

Fixture Time M10 Black oxide	< 20Minutes
Fixture Time with Primer	<5 Minutes
Full Cure Time	24 hours @ 20°C
Temperature Range	-51°C to 148°C
Breakaway Torque Test	15-40 N.m
Prevailing Torque Test	25-50 N.m

Packaging

Bondchem AR11 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 AR11 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.