

### Product Description

Bondchem AR12 is a high strength low viscosity retaining compound, designed to bond close fitting metal surfaces with an ultimate structural strength. AR12 specializes in bonding cylindrical fitting parts, and maintains an unflinching bond under all levels of cyclic load stress distribution even at elevated temperatures.

### Typical Applications

Bondchem AR12 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        |                |
| Brookfield Sp 1 @ 30rpm | 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                 | 0.1 mm          |
| Temperature Range        | -51°C to 150°C  |
| Breakaway Strength       | 10 - 20 Nm      |
| Prevailing Strength      | 10 - 20 Nm      |

### Packaging

Bondchem AR12 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 AR12 should be stored in a cool dry area, out of direct sunlight. Stored correctly, this grade can offer a 12 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.