

Product Description

Bondchem AR15 is a high strength high viscosity retaining compound, designed to bond close fitting metal surfaces with an ultimate structural strength. AR15 specializes in bonding cylindrical fitting parts, and maintains an unflinching bond under all levels of cyclic load stress distribution.

Typical Applications

Bondchem AR15 can be used in a wide variety of applications, especially interference or press fit parts including:

- Restoring worn shafts
- Locking of keys and splines
- Restoring spun bearings
- 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	Silver
Viscosity @ 25°C	
Brookfield Sp 5 @ 20rpm	50000-100000cps

Performance of Cured Material

Fixture Time	<10 @ 22°C
Fixture Time with Primer	<5 Minutes
Full Cure Time	24 hours @ 20°C
Gap Fill	0.38mm
Temperature Range	-51°C to 120°C
Breakaway Strength	35 Nm
Prevailing Strength	22 Nm

Packaging

Bondchem AR15 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 AR15 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.