

Product Description

Bondchem AR19 is a high strength retaining compound, designed to bond close fitting metal surfaces with an ultimate structural strength. **AR19** specializes in bonding cylindrical fitting parts, and maintains an unfaltering bond under all levels of cyclic load stress distribution

Typical Applications

Bondchem AR19 can be used in a wide variety of applications 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

Chemical Type	Anaerobic
Appearance	Green Liquid
Viscosity @ 25°C	
Brookfield Sp 1 @ 20rpm	100 - 150 cps
Specific Gravity	1.1

Performance of Cured Material

Fixture Time	<20 min @ 22°C
Full Cure Time	24 hours @ 22°C
Temperature Range	-50°C to 150°C
Strength Break Loose MIO	15-40 Nm
Strength Prevailing MIO	25-50 Nm

Packaging

Bondchem AR19 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 AR19 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.