

Retainer R35

Technical Data Sheet

GENERAL INFORMATION:

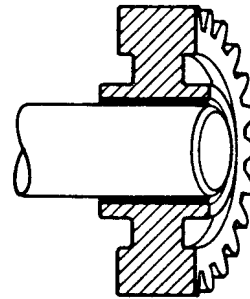
SAF-T-LOK anaerobic adhesive/sealants are specialized, single component solvent free liquids and pastes, custom formulated to lock, seal, retain, and bond metal parts and assemblies.

Stable in the presence of air, these products solidify when placed between two mating metal parts forming resilient, vibration and leak resistant bonds and seals. **SAF-T-LOK** adhesive/sealants provide valuable performance characteristics including resistance to ordinary, as well as fretting corrosion, galvanic attack, and vibrational loosening over a wide temperature range, while still allowing disassembly with ordinary tools where desired.

PRODUCT DESCRIPTION:

SAF-T-LOK R35 is a higher viscosity retaining compound with very high shear strength, and performance capabilities to 350°F. It was developed for bonding mating cylindrical surfaces such as bushings, bearings, gears, hubs and pulleys onto shafts and splines; and to augment the strength of press fits. **SAF-T-LOK R35** will cure to full strength in 4-8 hours, depending on configuration and clearances, but faster cure is obtainable with **SAF-T-LOK PRIMER**, or by heating to 200°F for 10-20 minutes.

SAF-T-LOK R35 satisfies TYPE III for MIL R 46082 and ASTM 4562 specifications.



BENEFITS:

REDUCES COSTS

Eliminates costly machining such as milling, threading, drilling, tapering, broaching, knurling, and reaming needed for mechanical locking systems; or, close tolerances and smooth finishes needed for press fits, by allowing the use of slip fits. Restores proper fit to worn assemblies, or assemblies out of tolerance.

IMPROVES RELIABILITY

Eliminates fretting corrosion and vibration induced loosening. Augments strengths of press fits.

EASY AND SAFE TO USE

One part adhesive requires no measuring, mixing, or heating to solidify. No build-up on dispensing; wipes up conveniently for cleaning. Little or no odor for a safe and pleasant work place. Wide variety of application methods available to suit specific needs.

IMPORTANT NOTICE: All statements and technical data contained herein are based on tests we believe to be reliable, but the accuracy of completeness thereof is not guaranteed. It is recommended that the buyer test this product to determine its suitability for his application before use. **SAF-T-LOK Corporation** is not responsible for loss, claim or damages resulting from use of its products.

PHYSICAL CHARACTERISTICS:

MEETS TYPE III FOR MIL R 46802 AND ASTM 4562

UNCURED

Resin	Dimethacrylate
Color	Green
Viscosity	1500cps.
Specific Gravity	1.1
Flash Point	>250°F
Toxicity	Low
Corrosivity	None
Storage Stability	12 mo. @ <80°F

CURED

Shear Strength	4000psi
Full Cure	4-8 Hrs.
Cure Speed	(See CURE SPEED plot)
Temperature Range	-65°F to 350°F
Gap Filling	0.002-0.010in.
Chemical Resistance	Excellent

CURE SPEED of R35 on STEEL

