

Product Description

AR18 is a ultra high strength medium viscosity retaining compound, designed to bond close fitting metal surfaces with an ultimate structural strength. **AR18** specializes in bonding cylindrical fitting parts, and maintains an unfaltering bond under all levels of cyclic load stress distribution. Designed for the permanent fixture of parts and not recommended for parts that may require a strip down or maintenance related dis-assembly.

Typical Applications

AR18 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 or the gap >0.2mm, apply **A249 activator** to increase cure speed.
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 @ 25°C	
Brookfield Sp 2 @ 20rpm	2000 - 4000 cps

Performance of Cured Material

Fixture Time Stainless Steel	<10 min @ 22°C
Fixture Time with A249	<3 Minutes
Full Cure Time	24 hours @ 20°C
Gap Fill (Diametrical)	Up to 0.25mm
Strength Break Loose M10	30 Nm
Strength Prevailing M10	22 Nm
Temperature Range	-50°C to 150°C

Packaging

AR18 is available in 50ml LDPE bottles.

Storage & Shelflife

AR18 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.