



**40RC**

40 RC is a fast curing high strength anaerobic adhesive for locking and sealing threads, and retaining of cylindrical components. Highly resistant to heat, corrosion, vibrations, water, gases, oils, hydrocarbons and many chemicals.

Technology / Base	Urethane Methacrylate
Type of Product	Retaining Compound Adhesive and Sealant
Components	One Component
Curing	Anaerobic with Secondary Heat Cure
Appearance / Color	Green
Consistency	Liquid

**Features and Benefits**

- Green Anaerobic Retaining Compound
- High Strength
- High Resistance to Heat, Corrosion, Vibrations, Water, Gases, Oils, Hydrocarbons, and Many Chemicals
- Controlled flow viscosity
- Replaces clamp rings, set screws, and snap rings

**Technical Data**

Physical Property	Value	Condition/Method
<b>Uncured Material Characteristics</b>		
Viscosity	400 to 600 cPs	Brookfield at 25°C, Spindle 2, 20 rpm
Specific Gravity	1.13	
Flash Point	> 100°C	
Shelf Life	12 months unopened	
Storage Condition	8 to 28°C	
Set Time on Steel	15	
Full Cure Conditions	2 to 72 hours at 25°C	
<b>Cured Material Properties</b>		
Coefficient of Thermal Expansion	80 ppm/K	ASTM D696
Thermal Conductivity	0.1 W/mK	ASTM C177
Specific Heat	0.3 kJ/kgK	
Pin/Collar Shear Strength	18 to 35 N-m	ISO 10123
Service Temperature	-55°C to 150°C	

Cure Speed At Various Temperatures	% of Room Temperature Strength		
	25%	50%	100%
5°C	3 hrs	6 hrs	30 to 72 hrs
40°C	4 min	8 min	50 min to 72 hrs

**Storage**

Products should be stored unopened in a cool, dry place out of direct sunlight. Products may be refrigerated for improved shelf life, but should be brought back to room temperature before use.

**Curing Performance**

The rate of cure will depend on environmental conditions and the substrates used. The gap of the bond line will affect set speed. Smaller gaps tend to increase set speed. Activators may be applied to further improve set speed, but may also impair overall adhesive performance.

**Safety and Disposal**

For complete safety and handling information, please refer to the appropriate Safety Data Sheets prior to using this product.



## Technical Data

Cure Speed On Various Substrates		% of Room Temperature Strength		
		25%	50%	100%
Steel	10 min	20 min	2 to 72 hrs	
Aluminum	1 hrs	8 hrs		

Cure Speed For Various Gap Sizes		% of Room Temperature Strength		
		25%	50%	100%
0.05mm	10 min	230 min	2 to 72 hrs	
0.25mm	6 hrs	15 hrs		

Chemical Resistance Testing			
	Test Temperature	% of Room Temperature Strength	Condition
50% Water/50% Glycol	87°C	75%	1000 hours measured at room conditions
Unleaded Gasoline	22°C	100%	1000 hours measured at room conditions
Motor Oil	125°C	100%	1000 hours measured at room conditions
Brake Fluid	22°C	100%	1000 hours measured at room conditions
Acetone	22°C	100%	1000 hours measured at room conditions

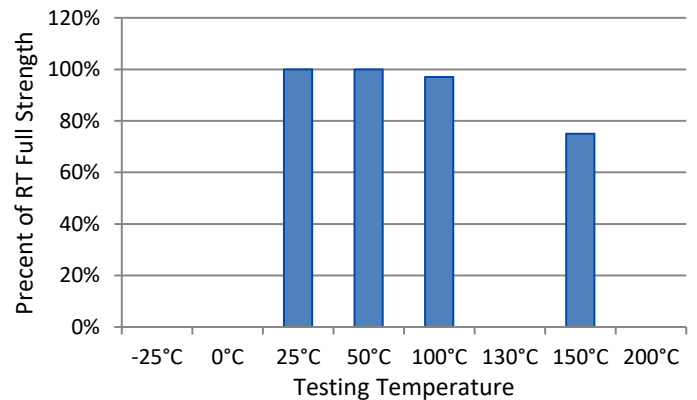
## General Instructions

Surfaces to be bonded should be clean and dry and free of grease. Product should be applied in enough quantity to fill all engaged threads or gap. The product performs best in thin bond gaps. Very large gaps may create gaps that will affect the cure speed and overall strength. Good contact is essential. It is recommended to confirm compatibility of the product with all substrates prior to use. This product is not recommended for use with strong oxidizing materials. Where aqueous washing systems are used to clean the surfaces before bonding, these aqueous washes can affect the cure and performance of the adhesive. This product is not normally recommended for use on plastics, users must check compatibility of the product with such substrates.

## Specifications

ASTM D-5363 AN 0412

## Hot Strength (%RT strength, tested at temperature)



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