



# TECHNICAL INFORMATION

## 930 Retainer

### DESCRIPTION

930 Retainer is designed to give a very high strength retention under cyclic loading at high temperatures. It will retain its full strength and not suffer fatigue under load stress, and will give dynamic performance at elevated temperatures up to 230°C. 930 also exhibits excellent adhesion (without the use of Acrylic Acids), to highly polished or difficult surfaces such as brass and copper.

It has also been formulated to allow longer assembly times on highly reactive surfaces, such as brass and copper, to avoid partial curing during assembly. 930 also has WRAS approval.

### APPLICATIONS

930 is a cylindrical parts supplement, suited to Structural components such as axial joints under dynamic load, keys, splines, even structural tubing with close tolerance fit, while providing performance at high temperatures up to 230°C.

### USEFUL HINTS/NOTES

Surface keying action is greatly increased by rough surface finish, giving higher Shear Strength. Ideal roughness is between 10-120 microns with a preferred tolerance of between 30-100 microns. Larger surface gaps over 175 microns can result in ultimate strength loss.

### PROPERTIES

930 sets usually in under 2 minutes on highly active materials but still retains a relatively fast cure on polished surfaces such as mild steel and other ferrous metals. Reactivity on stainless steel is usually slower but typically bonds form within 1 hour.

Fast Fixture Copper and Brass: ...<3 minutes  
Typical Fixture:....10-15 minutes Steels with 0.05 gap.  
Typical cure 12-24 hours dependent on temperature material / gap.

### DIRECTIONS FOR USE

- Parts should be clean, dry and dust free.
- Degreased parts will assist results.
- Apply sufficient product to fill joint.
- Assemble parts in traditional manner.
- To achieve handling strength allow product to cure (approximately 30 minutes).
- Store in cool conditions.
- Keep out of direct sunlight.

### COMPATIBLE ACTIVATORS

7800 Standard Anaerobic Activator can be used. However, up to 30% strength loss can occur when using accelerators.

Portobello Industrial Estate, Birtley, County Durham, United Kingdom, DH3 2RE Tel: +44 (0)191 411 3191 Fax: +44 (0)191 411 3192

E-mail: [info@holdtite.com](mailto:info@holdtite.com) Web: [www.holdtite.com](http://www.holdtite.com)

### TECHNICAL FEATURES

#### Physical Properties (liquid product)

Chemical base:	Methacrylate Diester
Colour:	Green / Flourescent
Viscosity:	25°C Brookfield DVII 2500-3500mPas Spindle 3 @ 20rpm.
Density:	1.10 25°C
Max.thread diameter:	M36
Max. gap filling:	0.20mm
Flash point:	>100°C

#### Physical Properties (cured product)

Measured on M10 x 20 bolt – grade 8.8 zinc galvanised – nut 0.8d loose free running

(A) Mild steel pin/collars to ISO method / DIN 54454.

(B) + (C) M10's x 20 threads bolt

1. Initial strength after: 20 – 30 minutes
2. Functional strength after: 2-4 hours
3. Final strength 12 – 24 hours
4. Shear strength (A) 25-30N/mm<sup>2</sup> DIN54452
5. Loose-break torque (B) >40Nm
6. Prevailing torque: (C) >50Nm
7. Thermal range: -55° up to +150°C.  
>60% up to 180°C\*  
>40% up to 230°C\*

### STORAGE

Shelf Life:12 months @ 20C

### PACKAGING

Bottles: 10ml, 50ml & 250ml and Bulk up to 20Kg

### HEALTH & SAFETY IN USE

Please refer to MSDS

IRRITANT: R43 - R36/37/38 - S23 - S24/25 - S37/39 - S51

Contains Methacrylate Esters and does not contain Acrylic or Methacrylic Acid which are irritants.

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