



TECHNICAL INFORMATION

938 Retainer

DESCRIPTION

938 Dynamic Strength Retaining Compound is designed to give high strength retention under cyclic loading. 938 will retain its full strength and not suffer fatigue under load stress. The product also provides the advantage of low corrosivity with the added benefit of WRAS approval.

APPLICATIONS

938 is a cylindrical parts supplement, suited to Structural components such as cylindrical parts under dynamic load, keys, splines, even structural tubing with close tolerance fit.

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. The larger surface gaps over 175 microns can result in Ultimate Strength loss.

PROPERTIES

Fast Hold:.....5-7 mins @ 25°C
Short Ultimate Cure:.....<6 hours
In principle Achieves 30N/mm(2) Static Shear

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 15 minutes).
- Store in cool conditions.
- Keep out of direct sunlight.

COMPATIBLE ACTIVATORS

Activators such as 7800 Structural Activator or the faster 7600 Structural Activator can be used, however, up to 30% strength loss can occur when using accelerators.

TECHNICAL FEATURES

Physical Properties (liquid product)

Chemical base: Methacrylate Diester
Colour: Green / Fluorescent
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: 2 – 5 minutes
2. Functional strength: 0,5 – 1 hour
3. Final strength 4 – 6 hours
4. Shear strength (A) 25-30N/mm²
DIN54452
5. Loose-break torque (B) >40Nm
6. Prevailing torque: (C) >50Nm
7. Thermal range: -55°C up to +150°C

STORAGE

Shelf Life:12 months @ 20°C

PACKAGING

Bottles: 10ml, 50ml & 250ml 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 some products contain reduced amounts of Acrylic Acid to reduce irritancy.

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