



Technical Datasheet HOLDIT R41

Revised Date: June 2011

Description

HOLDIT R41 is a high strength medium viscosity retaining compound, designed to bond close fitting metal surfaces with a medium structural strength. HOLDIT R41 specialises in bonding cylindrical fitting parts, and maintains an unfaltering bond under all levels of cyclic load stress distribution.

Applications

HOLDIT R41 is designed for applications that may need disassembly for service or maintenance access 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 apply suitable primer such as HOLDIT A649 Accelerator and HOLDIT A471 Activator.
3. Apply the product 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	Yellow
Viscosity @ 25°C	
Brookfield Sp2 @ 20rpm	1,500cps

Performance of Cured Material

Fixture Time	10-15 mins @ 22°C
Fixture Time with Primer	<5mins
Full Cure Time	24 hours @ 20°C
Gap Fill	0.2mm
Temperature Range	-51°C to 148°C
Shear Strength ISO 10123	8-16 Nmm ²

Conversions

(°C x 1.8)+32 = °F
 N/mm x 5.71 = lb/in
 MPa x 145 = psi
 N/mm² x 145 = psi
 N x 0.225 = lb
 N·m x 8.851 = lb·in
 N·mm x 0.738 = lb·ft
 mPa·s = cP

Packaging

HOLDIT R41 is available in 10ml, 50ml and 250ml bottles.

Storage

HOLDIT R41 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 & 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.

ACTIVE & INACTIVE METAL TABLE

Super Active Very Fast Cure	Active Fast Cure	Inactive Slow Cure	Passive Primer Necessary
Brass, Copper, Magnesium	Iron, Steel, Nickel, Aluminium	Stainless Steel, Titanium, Zinc, Anodized Aluminium, Galvanised Steel	Ceramics, Glass, Plastics, Painted Finishes

