



HOLDIT[®]

**Technical Datasheet
HOLDIT R60**

Revised Date: June 2011

Description

HOLDIT R60 is a high strength high viscosity retaining compound, designed to bond close fitting metal surfaces with an ultimate structural strength. R60 specialises in bonding cylindrical fitting parts, and maintains an unfaltering bond under all levels of cyclic load stress distribution.

Applications

HOLDIT R60 can be used in a wide variety of applications, especially interference or press fit parts including:

- Restoring worn shafts
- Locking of keys and splines
- Restoring spun bearings
- 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 cure speed is too slow apply HOLDIT A471 Activator or HOLDIT A649 Accelerator.
3. Before application kneed the product thoroughly.
4. Apply the adhesive to both the inside of the collar, and the leading edge of the pin, and assemble parts with a rotation motion, ensuring a high surface coverage.
5. Allow parts to cure to handling strength.

Properties of Uncured Material.

Resin	Dimethacrylate
Colour	Silver
Viscosity Brookfield Sp3 @ 20rpm	80,000 – 120,000 cps

Performance of Cured Material

Fixture Speed with Activator	<5 mins
Fixture Speed without Activator	10-60 mins @ 22°C
Gap Fill	0.38mm
Max Operating Temperature	-51°C to 120°C
Full Cure Time	24 hours @ 20°C
Shear Strength	>17Nmm2

Compatible Primers

Primer such as A649 Accelerator and A471 Activator can be used to speed the fixture time of the adhesive. Fixtures times can improve by as much as 50%. The use of primers can result in lower strength and performance and should be tested after full cure.

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



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Storage

HOLDIT R60 should be stored in a dry cool area, out of direct sunlight in temperatures between -10°C and 30°C. Optimal Storage temperature is 22±4°C. This product has a 18 month shelf life from manufacture when stored at 22±4°C.

Presentation

HOLDIT R60 is available in 50ml and 250ml tubes.

Health & Safety in Use

IRRITANT: Contains Methacrylate Esters and some products contain small amounts of Acrylic Acid. Irritates eyes, the respiratory organs and the skin. In case of contact with the skin wash immediately with plenty of water.

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

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