Technical Datasheet
HOLDIT R68

Revised Date: June 2011

Description

HOLDIT R68 High Strength Retaining Compound is a single part, high viscosity, high strength anaerobic resin used for bonding rigid assemblies of all types. This material can be used effectively to increase the strength of most mechanical assemblies.

Applications

HOLDIT R68 can be used in a broad variety of applications such as:

- Locks keys and splines
- Eliminates backlash in worn assemblies
- Locks bearings in place, preventing spin out
- Bonds rotor to shaft in low horsepower motors
- Locks bushing and sleeves in housing and on shafts
- Restores the fit to worn assemblies or out-of-tolerance parts.
- This high viscosity product is not recommended for extremely close or interference fits. For large gaps, use of HOLDIT Primer to ensure a fast, full cure is advisable.

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. Please see table below for information on Active and Inactive metals.
3. Before application shake the product thoroughly.
4. Apply the adhesive to the fixing position of the fastener or onto the internal threads of a blind hole.
5. Assemble components, and tighten to require torque level.
6. Allow to fully cure before applying load.

Properties of Uncured Material.

Chemical Type	Anaerobic
Colour	Green
Toxicity	Low
Solid	100%
Viscosity @ 25°C, cPs Brookfield RVT, Spindle 3 @ 20rpm	1,370 cPs
Specific Gravity	1.1

Performance of Cured Material

Fixture Speed	15-20 mins @ 22°C
Full Cure	24 hrs @ 22°C
Temperature Range	-51°C to 177°C
Product Conformity	MIL-S-46082B
Product Conformity	22473E DIN 54454

Shear Strength

Cold Rolled Steel	22Nmm2

Static shear strength was measured on cylindrical parts with a 0.002”diametrical clearance.

Environmental and Fluid Resistance (Shear Strength Values)

Heat Age	105%
Engine oil @ 150°C	100%
Brake Fluid @ 150°C	82%
ATF @ 150°C	80%
50/50 water / ethylene glycol @ 120°C	80%
Water @ 100°C	80%
Gasoline @ 25°C	100%
Diesel Fuel @ 25°C	100%
Ethyl Alcohol @ 25°C	95%

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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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.

Storage

HOLDIT R68 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 R68 is available in 10ml, 50ml and 250ml Bottle

Note

The high strength of this material may require heat to disassemble.

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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