



# Technical Datasheet HOLDIT R69

Revised Date: June 2011

## Description

HOLDIT R69 is a low viscosity, general purpose, anaerobic retaining compound used for press-fit and tight-clearance, and slip-fit metal applications. The product performs on aluminium, steel, plated, stainless steel, and special alloy parts. R69 exhibits good temperature and solvent resistance. R69 can be used where lubricity is needed to press for parts or to create an air-tight seal on cylindrical assemblies. This product cures rapidly on all metal surfaces.

## Applications

- Locks keys & splines
- Locks bearings in place preventing spin-out
- Bonds rotor to shaft in low horse power
- Augments press fits
- Locks bushings & sleeves in housing & on shafts
- Restores the fit to worn assemblies or out-of-tolerance 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. 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	Clear/Amber
Toxicity	Low
Solid	100%
Viscosity	100-150cps
Specific Gravity	1.04

## Performance of Cured Material

Fixture Speed	15-20 min @ 22°C
Full Cure	24 hrs @ 22°C
Temperature Range	-51°C to 200°C
Product Conformity	MIL-R-46082
Product Conformity	ASTM D-4363
Product Conformity	GM-1183024

## Shear Strength

Cold Rolled Steel	20Nmm <sup>2</sup>
Aluminium	4Nmm <sup>2</sup>

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

## Environmental and Fluid Resistance (Shear Strength Values)

Heat Age	100%
Engine oil @ 150°C	92%
Brake Fluid @ 150°C	88%
ATF @ 150°C	75%
50/50 water / ethylene glycol @ 120°C	55%
Water @ 100°C	62%
Gasoline @ 25°C	100%
Diesel Fuel @ 25°C	100%
Ethyl Alcohol @ 25°C	55%

## 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 R69 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 R69 is available in 10ml, 50ml and 250ml Bottle

**Note**

HOLDIT R69 is a low viscosity rapid curing liquid which augments press fit and slip fit applications.

**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/mm<sup>2</sup> 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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