

## Super-Weld RC-09 Retaining Compounds

### DESCRIPTION

RC-09 Retaining Compounds are single part, low viscosity, fast curing anaerobic resin used for bonding rigid assemblies of all types. It can also be used effectively to increase the strength of most mechanical assemblies.

### APPLICATIONS

RC-09 locks keys and splines. Eliminates backlash in worn assemblies. Locks bearings in place, preventing spin-out. Bonds rotor to shafts in fractional and sub fractional horsepower motors. Locks bushings and sleeves in housings and on shafts. Augments press fits. Restores the fit to worn assemblies or out-of-tolerance parts. This lower viscosity product is recommended for interference or close fitting parts where large gap filling is not required.

### USEFUL HINTS/NOTES

Where cure speed is long, acceptable bond times can be obtained by treating the parts with Primer T or N.

### PROPERTIES

Fast Fixture, usually under 10 minutes. Medium Strength Removable compound. Typical Strength: 2,000-3,000 psi.

### INSTRUCTIONS FOR USE

Ensure parts are clean, dry and free from oil and grease.

### PROCEDURE FOR APPLICATION

Product is normally hand applied from the bottle.

### COMPATIBLE ACCELERATORS/PRIMER

Primer T or N can be used. However up to 30% strength loss can occur when using primers.

### STORAGE

Store in a cool area out of direct sunlight. Shelf Life > 12 month @ 68°F

### TECHNICAL FEATURES

Resin: ..... Dimethacrylate  
Color: ..... Green  
Cure Speed with Activator: ..... <5 minutes  
Cure Speed without Activator: .... 10-30 min @77°F  
Viscosity : ..... 120-150 cps  
Gap Fill: ..... .005"  
Flash Point: ..... >200°F  
Shelf Life: ..... 12 months @ 68°F  
Specific Gravity: ..... 1.09 to 1.12  
Max. Operating Temperature: .... -65°F to + 300°F

### CURED PERFORMANCE

Full Cure Time: ..... 24 hours @ 68°F  
Shear Strength: ..... 2,000-3,000 psi

### PRESENTATION

Bottles: ..... 10ml, 50ml , 250ml & 1ltr

### HEALTH & SAFETY IN USE

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

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**Military Grade (Mil-R-46082B) Type I**

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