

# TECHNICAL DATASHEET

## Cylindrisk fastlåsning Sylindrisk fastlåsing Sylinterinmuotoisten osien kiinnittämiseen Cylindrisk fastgørelse

### 36-32

36-32 is a fast curing, high strength anaerobic retaining compound for cylindrical fitting parts particularly where bond gaps can approach 0.25mm (0.01”).

36-32 is a single component anaerobic adhesive, which develops high strength rapidly when confined in the absence of air between close fitting metal surfaces.

#### **Applications:**

- Ideal to fill gaps up to 0.25 mm (0.01”) diameter clearance.
- Maximum strength at room temperature.
- Used for locking bushings and sleeves into housings and on shafts.
- Excellent retaining, sealing and thread locking compound.

#### **Adhesive Properties:**

**Composition:** Urethane Methacrylate

**Color:** Green Viscosity: 2,500 cps at 25 °C Brookfield RVT Spindle 4 @ 20 rpm

**Specific Gravity:** 1.09

**Maximum Diameter of Thread/Gap Filling:** 0.25 mm

**Flash Point:** > 93 °C

**Solvent Content:** None

**Shelf Life:** 1 year

#### **Curing Properties:**

**Handling Cure Time:** 5 minutes

**Functional Cure Time:** 1-3 hours

**Full Cure Time:** 24 hours

**Compressive Shear Strength:** (ISO 10123)

**After 24 hours at 22 °C** Steel Pins & Collars > 25 N/mm<sup>2</sup> > 4,300 psi

**After 30 minutes at 22 °C** Steel Pins & Collars 15 - 17 N/mm<sup>2</sup> 2,250 psi

Temperature Range -55 to 150 °C

### **Physical Properties:**

Coefficient of Thermal Expansion,  $80 \times 10^{-6}$  ASTM D 696, K-1

Coefficient of Thermal Conductivity, 0.10 ASTM C 177, W/(m·K)

Specific Heat, kJ/(kg·K) 0.30

### **Chemical Resistance:**

Chemical	Temp.	%Initial Strength Retained	
		500 hours	1000 hours
Acetone	22 °C	100	100
Ethanol	22 °C	100	100
Motor Oil	125 °C	100	100
Gasoline	22 °C	100	100
Brake Fluid	22 °C	100	100
Water/Glycol	87 °C	100	95

### **Directions for use:**

#### **For Assembly**

- For best results, clean all surfaces (external and internal) with a cleaning solvent and allow solvent to evaporate.
- If the material is an inactive metal or the cure speed is too slow, spray with a suitable Activator and allow to dry.
- **For Slip Fitted Assemblies**, apply adhesive around the leading edge of the pin and the inside of the collar and use a rotating motion during assembly to ensure good coverage.
- **For Press Fitted Assemblies**, apply adhesive thoroughly to both bond surfaces and assemble at high press on rates.
- **For Shrink Fitted Assemblies** the adhesive should be coated onto the pin, the collar should then be heated to create sufficient clearance for free assembly.
- Parts should not be disturbed until sufficient handling strength is achieved.

#### **For Disassembly**

- Apply localized heat to the assembly to approximately 250°C. Disassemble while hot.

### **Storage:**

Anaerobic adhesives shall be ideally stored in a cool, dry place in unopened containers at a room temperature between 5°C and 30°C.