

RA -03

XXXXX, ANAEROBIC ADHESIVE

TECHNICAL DATA SHEET

MARCH 2021



PRODUCT DESCRIPTION

RA-03 is a low viscosity, high strength anaerobic adhesive designed to retain cylindrical parts. Once cured the product prevents leakage and/or loosening of parts from vibration and shock.

This product is acceptable as a retaining compound in and around food processing areas according to NSF S5 (Registration No.163875).

KEY FEATURES

- Low Viscosity
- Oil tolerant
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DIRECTIONS FOR USE

- For best results, clean all surfaces (Internal and external) with Born2Bond™ Pre-Bonding Cleaner and wait until fully evaporation.
- The product is designed for close fitting flanged parts with gaps up to **xxx** mm.
- Apply manually as a continuous bead or by screen printing to one surface of the flanges.
- If the cure speed is too slow, use Born2Bond™ Anaerobic Activator.
- Tighten flanges after application.
- Cured product can be removed by using of Born2Bond™ Adhesive & Gasket Remover and a soft scraper.
- Finish the cleaning process with a Born2Bond Pre-Bonding Cleaner soaked soft cloth.

METHOD OF USE

Manual: Directly from the bottle with or without dispensing tips for more precise dispensing

Semi-Automated: Use of pressure-time systems for accurate volume and larger series

Full-Automated: fully automated robot or application lines

APPLICATIONS

TA-90

STORAGE/SHELF LIFE

Store product in the unopened container in a dry area out of direct sunlight. Storage below 7 °C or greater than 28 °C can adversely affect product performance. If stored properly, this product has a shelf life of **XX** months.

HEALTH/SAFETY

The Safety Data Sheet is available on the Bostik website and should be consulted for proper handling, cleanup and spill containment before use. Keep containers covered to minimize contamination.

LIMITATIONS

This product is not recommended for use in pure oxygen and/or oxygen-rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials. Material removed from containers may be contaminated during use. Do not return product to the original container. Bostik will not assume responsibility for product that has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or customer service representative.

PRODUCT CHARACTERISTICS

Basis Technology	Anaerobic adhesive
Components	1K
Appearance / Color	Green
Cure	Anaerobic
Temperature use Range	-55° C to 150°C

UNCURED PHYSICAL PROPERTIES

Viscosity (<i>Brookfield: Sp1 @50rpm @25°C</i>)	20 – 55 mPa.s
Specific Gravity	XXXXXX 1.08

CURING PROPERTIES

The table below show the curing properties of the product on mild steel according to ISO 10964

Fixture time @ 20°C	<10min
Fixture time with Activator* @ 20°C	<15min
Full Cure @20°C	12h

*Bostik Born2Bond Anaerobic Activator

BONDING PERFORMANCE

The performance data reported below were measured according to ISO 10964

Breakaway torque mild steel ISO 10964 unseated	12Nm
Prevailing torque mild steel	28Nm
Breakaway torque mild steel ISO 10964 pre-torqued	30Nm
Prevailing torque mild steel ISO 10964 pre-torqued	40Nm
Oil tolerance (Strength)	XXX Nm

HOT STRENGTH

Remaining @ 1°C	1°C : %
Remaining @ 1°C	1°C : %

CONVERSIONS

$$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$$

$$\text{kV/mm} \times 25.4 = \text{V/mil}$$

$$\text{mm} / 25.4 = \text{in}$$

$$\mu\text{m} / 25.4 = \text{mil}$$

$$\text{N} \times 0.225 = \text{lb}$$

$$\text{N/mm} \times 5.71 = \text{lb/in}$$

$$\text{N/mm}^2 \times 145 = \text{psi}$$

$$\text{MPa} \times 145 = \text{psi}$$

$$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$$

$$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$$

$$\text{mPa}\cdot\text{s} = \text{cP}$$

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