



TECHNICAL DATA SHEET

Permanent Retainer

ThistleBond 'Permanent Retainer' is a high performance high strength adhesive designed to give fast cure on metal surfaces.

ThistleBond 'Permanent Retainer' is based on a specially selected di-methacrylate resin system which produces a rapid curing system with optimum adhesion properties and which withstands fatigue under dynamic loading conditions.

ThistleBond 'Permanent Retainer' is ideal for use for high strength retention of slip fitted components such as bearings, bushes, impellers, gears, pulleys, sleeves, spines, rollers, shaft etc.

ThistleBond 'Permanent Retainer' is simple, safe and easy to use.

Before proceeding, please read the following information carefully to ensure that the correct application procedure is fully understood.

SURFACE PREPARATION

Remove all heavy deposits of grease, oil, dirt and other contaminants by either solvent wiping, cleaning with industrial degreasers or by using hot aqueous baths.

MIXING

ThistleBond 'Permanent Retainer' is supplied ready for use and requires no mixing, however shaking the product to incorporate any slight separation is advised before use.

APPLICATION

ThistleBond 'Permanent Retainer' should be applied to one surface, parts should then be assembled.

Parts should be left for 20 minutes to reach handling strength and achieve full strength after 1 hour.

PHYSICAL CONSTANTS

Mixing Ratio Supplied ready for use.

Appearance Clear amber liquid.

Drying and Cure Times at 20°C/68°F

Handling Time	20 mins (approx)
Full Cure	1 Hour

Volume Solids 100%

V.O.C. Nil

Shelf Life Use within 12 months of purchase. Store in original sealed containers at temperatures between 5°C (40°F) and 25°C (77°F) away from direct sunlight.

PHYSICAL PROPERTIES

Strength (typical properties)

Break Loose*	15-40 N.m
Prevail*	25-50 N.m
Static Shear#	12-30 N/mm ²

*Tested on MIO steel nuts and bolts.

#Tested on low carbon steel pins and collars (220 MO7 complying with BS970: Part 1).

HEALTH & SAFETY

As long as normal good practices are observed **ThistleBond 'Permanent Retainer'** can be safely used.

Safety glasses should be worn.

A fully detailed **Material Safety Data Sheet** is either included with the material or is available on request.

PACKAGING

Supplied in 50gm units.

The information provided in this Product Data Sheet is intended as a general guide only and should not be used for specification purposes. The information is given in good faith but we assume no responsibility for the use made of the product or this information because this is outside the control of the company. Users should determine the suitability of the product for their own particular purposes by their own tests. Detailed specifications are available on request from the company.

FOR FURTHER INFORMATION PLEASE CONTACT



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