



## Technical Datasheet

### Holdtite R91

#### Product Description

Holdtite R91 is a high strength low viscosity retaining compound, designed to bond close fitting metal surfaces with an ultimate structural strength. R91 specializes in bonding cylindrical fitting parts, and maintains an unfaltering bond under all levels of cyclic load stress distribution.

#### Typical Applications

Holdtite R91 can be used in a wide variety of applications, especially interference or press fit parts including:

- ☐ High strength retention of bearings
- ☐ Locking of keys and splines
- ☐ Bonding rotors, bushes and sleeves to shafts
- ☐ Securing loose or worn 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 (see Compatibility Chart) apply suitable Holdtite primer.
3. Apply the adhesive to both the inside of the collar, and the leading edge of the pin, and assemble parts with a rotational motion, ensuring a high surface coverage.
4. Allow parts to cure to handling strength.

#### Properties of Uncured Material

Resin	Dimethacrylate
Colour	Green
Viscosity @ 250C	
Brookfield Sp 3 @ 20rpm	125cps

#### Performance of Cured Material

Fixture Time F	15-20 min @
ixture Time with Primer	200C <5 Minutes
Full Cure Time	24 hours @ 200C
Gap Fill	0.13mm
Temperature Range	-50°C to 150°C
Strength Breakloose	30-40Nm
Strength Prevailing	25-50 Nm

#### Packaging

Holdtite R91 is available in 10ml, 50ml, 250ml LDPE bottles. In addition, we can offer automated dispensing lines for the bulk dispensing of this material.

#### Storage & Shelflife

Holdtite R91 should be stored in a cool dry area, out of direct sunlight. Stored correctly, this grade can offer a 24 month shelf life from manufacture.

#### Health and Safety in Use

Irritant: Contains Methacrylate Esters which may irritate eyes, respiratory organs and skin. In case of contact with the skin, wash immediately with plenty of water. For full Health and Safety information please consult the MSDS.

The data, information and values contained in this Technical Data Sheet have been obtained by specific tests conducted in a controlled environment, and should be used for guidance purposes only. Although we believe them to be reliable and accurate, users should always conduct their own tests in their specific working conditions to ensure that the product is suitable and effective for use. It is the users sole responsibility to determine the suitability of the product for the application. Pako Holdtite Ltd cannot be held responsible for the results of procedures undertaken elsewhere, nor for the safeguarding of personnel or property, all of which is the duty of the user. Suitability of products or methods is discretionary. Therefore, warranties or implied usage obligations should not be attributed to, and are not the responsibility of, Pako Holdtite Ltd. Pako Holdtite Ltd are not liable for any financial loss or other damages incurred by the user as a result of the use of this product.