Issued: April 2018

Rapidstick 8641 Retaining Compound

PART NUMBER	AVAILABLE SIZE
8641-10	10ml Bottle
8641-50	50ml Bottle
8641-250	250ml Bottle

PRODUCT DESCRIPTION

Chemtools® Rapidstick 8641 Retaining Compound is a medium viscosity, medium strength, high temperature resistant versatile bearing compound that offers high performance, controlled strength, and excellent retaining, sealing, and thread locking properties. It is ideal for filling gaps with up to 0.20mm clearance, and for continuous working temperatures up to 148°C.

8641 is typically used for fittings, bearings, bushes, and oil seals, and is ideal for cylindrical parts that require disassembly. It also permits sliding fits and eliminates distortion.

DIRECTIONS (READ LABEL BEFORE USE)

ASSEMBLY

For best results, ensure all internal and external surfaces are cleaned with a cleaning solvent prior to application. if the material is an inactive metal, or the cure speed is too slow, spray with an 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, and the collar then heated to create sufficient clearance for free assembly.

Parts should not be disturbed until sufficient handling strength is achieved.

DISASSEMBLY

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

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TECHNICAL DATA

ADHESIVE PROPERTIES:

Composition	Methacrylate Ester
Colour	Yellow
Viscosity @ 25°C (Brookfield RVT, Spindle 4 @ 20 rpm)	1,000 cps (med)
Specific Gravity	1.07
Maximum Diameter of Thread/Gap Filling	0.20 mm
Flash Point	> 100°C
Solvent Content	None
Shelf Life	1 Year

CURING PROPERTIES:

Handling Cure Time	30 minutes
Functional Cure Time	2 – 4 hours
Full Cure Time	24 hours
Temperature Range	-54°C to +148°C

Compressive Shear Strength - ISO 10123

After 24 hours at 22°C (Steel Pins and Collars)	> 12 N/mm^2 (1,500 psi)

PHYSICAL PROPERTIES:

Coefficient of Thermal Conductivity, ASTM C177, W/m.K	0.10
Coefficient of Thermal Expansion, ASTM D696, K^{-1}	80×10^{-6}
Specific Heat, kJ/kg.K	0.30

CHEMICAL RESISTANCE PROPERTIES:

		% Initial Strength Retained	
Chemical	**Temperature**	**500 hours**	**1,000 hours**
Acetone	22°C	100	100
Ethanol	22°C	100	100
Motor Oil	125°C	100	100
Petrol	22°C	100	100
Brake Fluid	22°C	100	100
Water/Glycol	87°C	100	95

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FIRST AID & SAFETY PRECAUTIONS

Please refer to Safety Data Sheet (SDS) before use. Use with adequate ventilation and avoid breathing fumes. Avoid contact with eyes and skin. This product may produce adverse health conditions, ranging from minor skin irritation to serious systemic effects. It should not be used, stored, or transported until the handling precautions and recommendations as stated in the Safety Data Sheet (SDS) for this product have been fully understood by all persons who will work with the material.

STORAGE

Keep out of reach of children. Store in a sealed container in a cool, dry place (between 8°C - 27°C). Do not return any unused material to its original container.

Containers must be secured and stored upright during transit.

DISCLAIMER

Chemtools® has made every effort to ensure the information provided in this Technical Data Sheet is accurate at the time of publication. Chemtools® expressly recommends that the user make his/her own assessment to determine the suitability of the product for its intended purpose prior to application. Chemtools shall not be responsible for loss, damage, or injury, resulting from the reliance upon, or failure to adhere to, any recommendations or information contained herein; nor from abnormal use of the material; nor from any hazard inherent in the nature of the material.

FURTHER INFORMATION

Please visit Chemtools® online at www.chemtools.com.au for product photos, marketing materials, Technical Data Sheets, Safety Data Sheets, contact details, and other company/business related information.

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