



TECHNICAL DATA SHEET

A NEW FORCE IN CHEMICAL MANUFACTURING

AEROSOLS | WELDING CHEMICALS | ADHESIVES & THREADLOCKERS | ANTI-SEIZE & GREASES | CLEANING CHEMICALS & SOLVENTS | ELECTRICAL & ELECTRONICS

Issued: August 2020

Rapidstick™ 8660 Retaining Compound

PART NUMBER	AVAILABLE SIZE
8660-50	50ml Tube
8660-250	250ml Tube

PRODUCT DESCRIPTION

Chemtools® Rapidstick™ 8660 Retaining Compound is a fast curing, high strength compound with a paste-like consistency and very good gap cure properties. It is designed for cylindrical fitting parts, particularly where bond gaps can approach 0.5mm.

8660 develops high strength rapidly when confined in the absence of air between close fitting metal surfaces to prevent loosening and leakage from shock and vibration. It is typically used for restoring correct fits on worn shafts, spun bearings, and damaged keyways.

8660 is also an excellent sealing and threadlocking compound.

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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ADHESIVE PROPERTIES:

Composition	Urethane Methacrylate
Colour	Grey
Consistency	Paste
Viscosity @ 25°C (Brookfield HBT)	1,225,000 cps
Specific Gravity	1.13
Maximum Diameter of Thread/Gap Filling	0.5 mm
Flash Point	> 93°C
Solvent Content	None
Shelf Life	1 Year

CURING PROPERTIES:

Handling Cure Time	10 minutes
Functional Cure Time	2 – 3 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)	> 22 N/mm ² (3,100 psi)
After 30 minutes at 22°C (Steel Pins and Collars)	> 15 N/mm ² (2,000 psi)

PHYSICAL PROPERTIES:

Coefficient of Thermal Conductivity, ASTM C177, W/m.K	0.10
Coefficient of Thermal Expansion, ASTM D696, K ⁻¹	80 x 10 ⁻⁶
Specific Heat, kJ/kg.K	0.30

CHEMICAL RESISTANCE PROPERTIES:

Chemical	Temperature	% Initial Strength Retained	
		500 hours	1,000 hours
Acetone	22°C	100	95
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	98



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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. 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.