



Scotch-Weld™ Retaining Compound RT41

Product Data Sheet

Updated :February 2010
Supersedes :March 2007

Product Description Scotch-Weld RT41 is a single component, anaerobic retaining compound specially formulated to give controlled, medium strength. RT41 cures when confined in the absence of air between close fitting metal surfaces

Key Features Scotch-Weld RT41 is formulated for bonding cylindrical parts, to give medium strength retaining. Typical applications include mounting bearings in place on shafts and in housings. The controlled medium strength allows disassembly for servicing and bearing re-use. RT41 is designed to augment the strength of press fit assemblies. Once applied, parts slip together easily, lubricated by the adhesive. RT41 prevents corrosion of assembled parts.

Physical Properties

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| Chemical Type | Dimethacrylate |
| Appearance | Yellow/Brown |
| Specific Gravity | ~1.07 |
| Viscosity cPs | Range 400 –600 Typical Value 500 |

Performance Characteristics

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| Maximum Gap Fill | 0.20mm |
| Fixture Time | 15mins |
| Full Cure | 24hrs |
| Strength Build Up | 30 mins = 10% strength 1 hour = ~40% strength 24hours = 100% strength |
| Breakaway Torque N.m (ISO 10964) | Range 12 – 18 Typical 15 |
| Prevail Torque N.m (ISO 10964) | Range 8 – 12 Typical 10 |
| Chemical compatibility | Anaerobic adhesives and sealants should not be used in pure oxygen or chlorine lines. |
| Service Temperature Range | -50 to +150°C |

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| Additional Product Information | Anaerobic adhesives only cure in the absence of air and with metal part activation. Adhesive outside the joint will remain uncured and may be wiped away with a cloth. RT41 is suitable for medium strength retaining applications that require small to medium gap filling. Scotch-Weld RT41 is not recommended on certain plastics as stress cracking can sometimes result. Some anti-corrosion chemicals inhibit the cure system in this type of anaerobic. Trials are recommended to establish whether cleaning of the parts is necessary. AC64 Activator may be required on plated parts. |
| Application Techniques | Ensure parts are clean, dry and free from oil and grease. Apply adhesive to all engaged area. Assemble parts and allow to cure. Wipe excess adhesive from outside of joint. Heating the assembled parts accelerates the curing process. AC64 Activator may be used to accelerate cure and should be used if the application temperature is below 5°C. The use of an accelerator may reduce the final bond strength by up to 30% |
| Storage Conditions | Keep the adhesive in a cool, dry place away from direct sunlight. Under such conditions shelf life at room temperature will be 12 months. Refrigeration to 5°C gives optimum storage stability. |
| Shelf Life | 12 months from date of despatch by 3M when stored in the original carton at 21°C |
| Precautionary Information | Refer to product label and material Safety Data Sheet for health and safety information before using the product. For information please contact your local 3M Office. www.3M.com |
| For Additional Information | To request additional information or to arrange for sales assistance, call 0870 6080050 Address correspondence to: 3M United Kingdom PLC, 3M House, 28 Great Jackson Street, Manchester, M15 4PA |
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