

# Technical Data Sheet

B641 Bearing Fit

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**FORMULAS THAT WORK**

## B641 Bearing Fit

### PRODUCT DESCRIPTION

Bearing Fit B641 is a single part Anaerobic securing compound, designed for fitting cylindrical metal assemblies and cures when confined between the parts.

### APPLICATIONS

B641 will secure all types and sizes of Bearings, Shafts and Cylindrical parts which will require disassembly in the future. B641 is of medium strength and is colour coded yellow for job identification.

### USEFUL NOTES

Where cure speed is long, acceptable bond times can be obtained by treating the parts with B7471 activator or by using the faster B7649 accelerator.

### PROPERTIES

Fast fixture, usually under 15 minutes.  
Medium strength removable compound.  
Typical strength 12N/mm (2).

### INSTRUCTIONS FOR USE

Ensure parts are clean, dry and free from oil and grease.

### PROCEDURE FOR APPLICATION

Product is normally hand applied from the bottle.

### COMPATIBLE ACCELERATORS/PRIMERS

Primers such as B7471 (Standard Anaerobic Activator) or the faster B7649 Structural Accelerator can be used, however, up to 30% strength loss can occur when using accelerators.

### STORAGE

Store in a cool area out of direct sunlight.  
Shelf Life > 12 months @ 20°C.

### HEALTH & SAFETY IN USE

IRRITANT: Contains Methacrylate Esters. Irritates eyes, the respiratory organs and the skin. In case of contact with the skin wash immediately with plenty of water.

This Technical information sheet does not constitute a Material Safety Data Sheet. Before using this product ensure you have read and fully understood Bondloc Material Safety Data Sheet B641.

### TECHNICAL FEATURES

|                              |                     |
|------------------------------|---------------------|
| Resin                        | Mod. Dimethacrylate |
| Colour                       | Yellow              |
| Fixture Speed No Activator   | 10-15 mins          |
| Fixture Speed With Activator | <5 mins             |
| Viscosity                    | 1500 cps            |
| Gap fill                     | 0.2 mm              |
| Flash Point                  | >100°C              |
| Shelf Life                   | 12 month min        |
| Specific Gravity             | 1.06                |
| Max Operating Temperature    | -55°C to + 150°C    |

### CURED PERFORMANCE

|                             |                          |
|-----------------------------|--------------------------|
| Full Cure Time              | 12 hours                 |
| Static shear strength       | 12N/mm <sup>2</sup>      |
| iso 10123 pin/collars range | 1-16 N/mm <sup>(2)</sup> |

### PRESENTATION

B641 is available in 25ml, 50ml, 250ml and bulk packs.  
Clam packs available in 25ml and 50ml.

PRECAUTIONS: This product and the auxiliary materials normally combined with it are capable of producing adverse health effects ranging from minor skin irritation to serious systemic effects. None of these materials should be used, stored, or transported until the handling precautions and recommendations as stated in the Material Safety Data Sheets (MSDS) for this and all other products being used are understood by all persons who will work with the product.

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