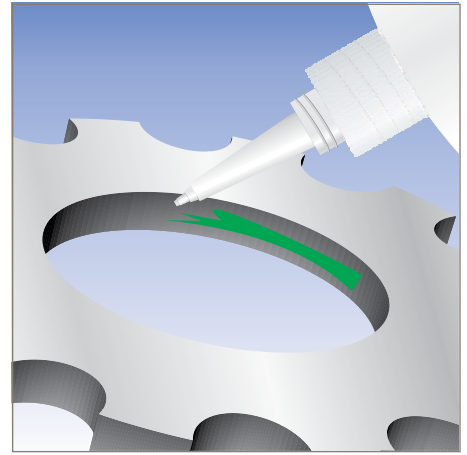


Retainer Compounds Anaerobic Adhesives

RC Series



Lock, Seal and Retain Non-Threaded Surfaces

Parker RC Series Anaerobic Retainer Compounds are liquid resins that cure (in the absence of air) when placed in contact with metallic or non-threaded parts with small gaps. Overflow is not likely to contaminate or obstruct the application, and can be easily wiped away (as long as it is exposed to air) by using oils or polar solvents.

The RC series retainer compounds are recommended for sliding assemblies or interference fit parts. They allow for larger tolerances and can be a substitute for precision machining, resistant to water, fuel, gases, oils, and other chemical products. These adhesives have very high strength and help prevent leakage and loosening of parts caused by vibration.



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Product Features:

- Solvent free
- Cures at room temperature
- Resistant to major chemicals
- Wide temperature range (see Properties Table on next page)
- Easy to use
- Can be handled immediately
- Cost efficient



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Usage Guidelines:

- Clean parts, completely eliminating oily and other contaminating particulates, such as rust, dust and previous adhesive from parts
- Can be applied directly from its original container
- To assure proper bond, cover the entire surface to be bonded with the product to avoid failures on bonding and sealing
- Apply the product all around the pin and along the collar's external border. Assemble the pieces rotating them in place to ensure complete distribution of the product
- Apply the product on the pin and heat the bore to create clearance enough for assembling
- Apply the product on both surfaces to ensure filling of the entire area and then assemble the pieces under high pressure
- Keep the container tightly closed to maintain product integrity

Set Time:

Partial cure occurs in less than 20 minutes, depending on the substrate where the product was applied and the gap fills between the parts. In presence of large gaps or when the setting time is too long, it is recommended to use the Activator ST02 to accelerate cure speed.

General Information:

This product should not be used in pure or high oxygen systems, nor shall it be indicated to seal materials that come in contact with chlorine or other oxidizers.

Storage:

- Store product in cool and dry location, in its original container, at maximum temperature of 70°F (21°C)
- To avoid product contamination,

do not return used product to original container

- Do not expose the product to excessive heat or direct sun light

Safety Precautions:

- While handling the product, use such personal protection devices as safety glasses and gloves
- In case of contact with eyes, wash with plenty of water and get medical attention if irritation persists
- In case of contact with skin, use a paper or tissue to remove excess and then wash with plenty of water and neutral soap. Get medical attention if skin irritation persists
- If clothes are contaminated, remove immediately to avoid prolonged contact, resulting in skin irritation
- Keep this industrial product out of the reach of children³

RC Series Typical Properties Chart

Parker Part Number	Color	Working Temperature	Activator Used	Gap Fill	Viscosity	Setting Time ¹		Torque		Torque
						Partial	Total	Breakaway	Prevail ²	
						mm	mPa's (cP)	Min.	Hrs.	
RC81	Green	-58 to 392°F -50 to 200°C	ST02	0.12	100 to 150	3 to 20	24	30 to 70	18 to 40	High
RC83	Green	-58 to 302°F -50 to 150°C	ST02	0.25	500 to 800	3 to 20	24	30 to 70	18 to 40	High
RC84	Green	-58 to 302°F -50 to 150°C	ST02	0.22	1800 to 2400	3 to 20	24	30 to 70	18 to 40	High

1. The setting time is strongly influenced by substrate, room temperature and presence of activators. Above data regard to substrate carbon steel flushed in temperature of 72°F (22°C) without use of activators.

2. Refer to MSDS for additional information.

