



# Technical Data Sheet

## Bondloc B648 High Temperature Retainer

**PRODUCT DESCRIPTION**

B648 is recommended for High Strength securing where continuous working temperature is rated up to 180°C. B648 is a medium viscosity retainer of high strength dealing with gaps of 0.15mm.

**APPLICATIONS**

B648 is used for securing all types of cylindrical parts, such as bearings, gears, splines, pulleys, keyways, set screws suitable for press fits or slip fits. B648 reduces fatigue life by eliminating stresses in the assembly.

**USEFUL NOTES**

Where inspection of assemblies is required or where limitation of migration around joint interfaces is necessary, another version of B648 is available with a dual cure system.

**PROPERTIES**

Temperature + 180°C  
 Green anaerobic cure B648  
 Fixture in under 15 minutes

**INSTRUCTIONS FOR USE**

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

**COMPATIBLE ACCELERATOR/PRIMER**

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 >18 months at 20°C.

**TECHNICAL FEATURES**

Resin	Dimethacrylate
Colour	Green
Fixture speed with activator	<5 mins
Fixture speed without activator	10-15 mins
Viscosity Brookfield Sp3 @20rpm@25°C	500cps
Gap Fill	0.15mm
Flash Point	>100°C
Shelf Life	18 months
Specific Gravity	1.06
Temperature Range	-55°C to +180°C

**TYPICAL BOND CHARACTERISTICS**

Full Cure Time	2-6 hours
Shear Strength	>26N/mm <sup>2</sup>

**HEALTH & SAFETY**

This technical information sheet does not constitute a Safety Data Sheet (SDS). Before using this product ensure you have read and fully understood this products SDS.

**PACKAGING FORMAT**

Bottles.....10ml,25ml,50ml,250ml  
 Clam Packs.....10ml,25ml,50ml

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 Units 1 & 2  
 Bewdley Business Park  
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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 Safety Data Sheets (SDS) for this and all other products being used are understood by all persons who will work with the product. Warranty: All products purchased from or supplied by Bondloc are subject to terms and conditions set out in the contract. Bondloc warrants only that its product will meet those specifications designated as such herein or in other publications. All other information supplied by Bondloc is consider accurate but are furnished upon the express condition the customer shall make its own assessment to determine the product's suitability for a particular purpose. Bondloc makes no other warranty, either express or implied, including those regarding such other information, the data upon which the same is based, or the results to be obtained from the use thereof; that any product shall be merchantable or fit for any particular purpose; or that the use of such other information or product will not infringe any patent.

