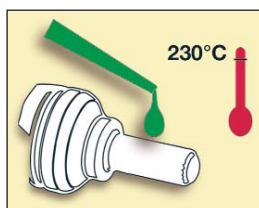


Product data

227 High temperature retainer

Anaerobic



General description

A controlled, higher shear strength anaerobic for bonding cylindrical parts, keyways etc when temperature resistance up to 230°C is required.*

The higher viscosity of **AJett 227** also makes it ideal for retaining applications with larger gap widths.

As with all **AJETT** retaining products, **227** stops vibration loosening parts, acts as a seal against leakage and corrosion and resists most chemicals and solvents. It is approved for most industrial metals, including steel, stainless steel, brass and plated items and can be undone with hand tools.

Benefits

- 100% surface contact improves joint strength reliability.
- High temperature resistance – up to 230°C*
- Higher strength formulation – typical shear strength of 27 N/mm² on steel parts.
- Allows larger tolerances to be used by curing through gaps up to 0.25 mm.
- Increases the strength of press fitted parts.
- Helps to reduce machining costs.
- Forms a plastic seal that prevents joints rusting or seizing up and galvanic corrosion.

- Seals against leakage.
- Stops vibration from loosening parts.
- Can be used on 'as received' parts.
- Wide temperature range in service.
- Green colour for easy identification.
- Cured product does not migrate.
- Easy to apply from bottle.
- Does not need activator or primer for plated parts (if application above 5°C).

Typical uses – retaining and sealing

- Cylindrical parts.
- Transmission bearings and keyways.
- Locating pins in radiators.
- Sleeves for pump housings

Replaces

- Shrink and interference fits.

Application

- By hand or automated.
- Single component – no mixing or primers.
- Self cures within the joint.

Cost saving

- Low inventory – one grade bonds a wide variety of bearings and other devices.
- Replaces expensive machining.
- Speedy – push fits can be used.
- Joint is easy to undo, no matter how many years it has been assembled.

* 230°C temperature resistance achieved after exposure at elevated temperatures.
'Anaerobic' – the locking and sealing process begins only when parts are assembled.

Typical properties

Composition	Dimethacrylate ester
Physical appearance	Liquid
Colour	Green
Odour	Light
Viscosity at 25°C	8,500 mPas
Flash point, closed cup	Above 100°C
Temperature range	-50 to +230°C
Handling strength	30 minutes at room temperature
Full cure	24 hours at room temperature
Shear strength – typical	27 N/mm² on steel parts
Shear strength – range	17 to 37 N/mm² on steel parts
Corrosiveness	None
Maximum gap fill	0.25 mm

Packaging

50 ml plastic bottles
Catalogue number **227/50**. Other sizes available to order.

Shelf life

12 months minimum in normal storage conditions (dry, room temperature) and in closed original packaging.

Precautions for use

Please refer to the **AJETT** material safety data sheet *MSDS 227*.

Application method

AJETT 227 works best on clean parts. Apply evenly to one surface, Assemble and allow to cure.

Solvent resistance

AJETT 227 maintains a minimum of 80% strength after 1,000 hours in most common automotive fluids when immersed and tested at room temperature.

The product is not for use with pure oxygen systems or systems containing strong oxidising materials.

Replacement

AJett 227 can be used instead of the following anaerobic products:
Three Bond 1388
Loctite 620

NOTE: Data provided shows mean averages arrived after laboratory testing. Manufactured batches may vary slightly.

This publication is intended to serve as a guide only. Customers should satisfy themselves by appropriate trials that the product is suitable for its intended use.

The information is given in good faith and based on the state of our knowledge about the product – but cannot be used as a sales specification.

The attention of users should be brought to eventual hazards arising from the use of the product if they differ from what it was originally formulated for.

The customer will agree and accept our general sales and supply condition, in particular the cause of limitation and relief of responsibility.

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