



**ANL Series Retaining Compounds**

Pacer ANL Series anaerobic retaining compounds are formulated to facilitate the assembling of rigid cylindrical shaft-related configuration parts, such as bearings, bushings, sleeves and gears to shafts with slip fit or line fit tolerances. When applied to active metals such as mild or hardened steel, brass, bronze and iron, no activator is required for normal cure. For inactive surfaces such as stainless steel, monel, phenolic and certain other non-metallic surfaces, Pacer Anaerobic Primer should be utilized. Avoid use on all thermoplastics and most thermoset plastics.

<b><u>PROPERTY</u></b>	<b><u>ANL-RC</u></b>	<b><u>ANL-RC80</u></b>	<b><u>ANL-RC/HT</u></b>
<b>Description</b>	High strength, general purpose retaining compound	High strength, slip fit retaining compound	High temperature, high strength retaining compound
<b>Color</b>	Green	Green	Green
<b>Viscosity, cps</b>	100-150	750-1750	5000-12000
<b>Gap fill, inches (diametral)</b>	.005	.015	.015
<b>Fixture time, steel, (min.)</b>	<20	<20	<20
<b>Service Temperature - after cure (F)</b>	-65 to 300	-65 to 300	-65 to 450
<b>Compression Shear, steel, 24hr, (psi) *</b>	2290-4000	>2800	>2400
<b>Compression Shear, steel, (psi) tested @72F*</b>	1hr = 1490-3000	1hr @93C/199F= >3500	24hr @177C/350F= >3500

\*ASTM D4562-01

**STORAGE AND SHELF LIFE:**

For optimum results, store below 77<sup>0</sup> F (25<sup>0</sup> C) in original containers. Stored under these conditions, a one-year shelf life can be expected.



**APPLICATION AND CURE CHARACTERISTICS:**

Fixture and cure speed is dependent upon surface activity of the metal being utilized. Steel, brass, copper, iron, and aluminum alloys containing copper will fixture faster than plated surfaces, stainless steel, and pure aluminum. Anaerobic Primer (09628-1 gal or 09621-2 oz) can be used to speed up cure. Product can be fully cured at 200<sup>0</sup> F (93<sup>0</sup> C) for 30 minutes or at 250<sup>0</sup> F (121<sup>0</sup> C) for 25 minutes.

Apply a bead around part to be bonded and assemble with a twisting motion to spread adhesive. Liquid adhesive will not center the part automatically, and additional mechanical fixturing is recommended until adhesive reaches handling strength. Excess adhesive on the outside of the joint will not cure, and can be removed with a solvent-soaked cloth. **Do not return unused adhesive to the bottle. Contaminated adhesive will cause the entire bottle to cure.**

<b>ANL-RC</b> = Meets the following specifications
MIL-R-46082B = Type I
ASTM D-5363 = Group 04, Class 1, Grade 1

**SAFETY AND HANDLING PRECAUTIONS:** Store below 77<sup>0</sup> F (25<sup>0</sup> C) in original containers. Liquid adhesive can irritate skin and eyes. May cause dermatitis on prolonged contact in sensitive individuals. In case of eye contact, flush with water for 15 minutes, see a physician if symptoms persist. If swallowed, do not induce vomiting. Get immediate medical attention. Use of safety glasses, protective clothing and gloves recommended for prolonged exposure to liquid adhesive.

For more information, refer to Material Safety Data Sheet, available upon request. In case of emergency, call Pacer Technology at 800-538-3091 (outside CA only), or 909-987-0550.

<b>Size / Part Numbers</b>	<b>ANL-RC</b>	<b>ANL-RC80</b>	<b>ANL-RC/HT</b>
10 mL	FG06170	*	FG06180
50 mL	FG06172	FG06192	FG06182
250 mL	FG06171	FG06191	FG06181
1 L	FG06173	*	FG06183

\* Contact Industrial Sales for information

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