



GREEN SLIP FIT RETAINING COMPOUND

PART NO. AR250

DESCRIPTION

AR250 is a fast-curing, high-strength, anaerobic adhesive for locking and sealing threads, and retaining of cylindrical parts. This formula allows larger machining tolerances and is recommended for slip-fit applications. AR250 is highly resistant to heat, corrosion, vibrations, water, gases, oils, hydrocarbons, and many chemicals.

PHYSICAL PROPERTIES

Technology / Base	Urethane Methacrylate
Type of Product	Adhesive and Sealant
Components	One Component
Curing	Anaerobic with Secondary Heat Cure
Appearance / Color	Green
Consistency	Viscous Liquid

TECHNICAL DATA

Property	Value	Method/Condition
Rheology		
Viscosity	2000 +/- 500 cps	Brookfield at 25°C, Spindle 3, 20 rpm
Density		
Specific Gravity	1.10	N/A
Uncured Materials Characteristics		
Flash Point	> 93°C (200°F)	N/A
Gap Fill	0.015 inch	N/A
Shelf Life	12 months unopened	N/A
Storage Condition	20°C (68°F)	N/A
Cured Materials Characteristics		
Full Cure Conditions	24 hours at 25°C	N/A
Cure Appearance	Green Solid	N/A
RoHS Compliant	Yes	N/A
Cured Mechanical Properties		
Locking Strength	High	N/A
Pin/Collar Shear Strength	>3500 psi	ASTM D4562
Service Temperature	-55°C to 150°C (-65°F to 300°F)	N/A

SPECIFICATIONS AND APPROVALS

Mil-R-46082B, Type III;
ASTM D-5363 AN0421



INSTRUCTIONS

Surfaces to be bonded should be clean, dry and free of grease. Product should be applied in enough quantity to fill all engaged threads or gap. The product performs best in thin bond gaps. Very large gaps may create voids that will affect the cure speed and overall strength. Good contact is essential. It is recommended to confirm compatibility of the product with all substrates prior to use. This product is not recommended for use with strong oxidizing materials. Where aqueous washing systems are used to clean the surfaces before bonding, these aqueous washes can affect the cure and performance of the adhesive. This product is not normally recommended for use on plastics, users must check compatibility of the product with such substrates.

CURING PERFORMANCE

The rate of cure will depend on environmental conditions and the substrates used. The gap of the bond line will affect set speed. Smaller gaps tend to increase set speed. Activators may be applied to further improve set speed, but may also impair overall adhesive performance.

STORAGE

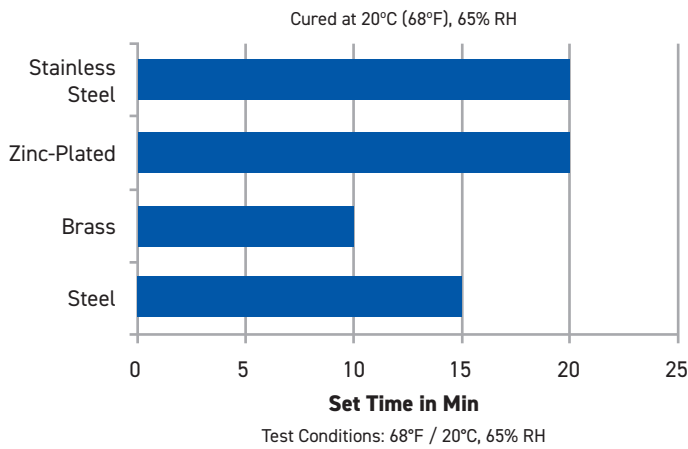
Products should be stored unopened in a cool, dry place out of direct sunlight. Products may be refrigerated for improved shelf life, but should be brought back to room temperature before use.

SAFETY & DISPOSAL

For safe handling information on this product, consult the Safety Data Sheet (SDS).



SET TIME ON VARIOUS SUBSTRATES

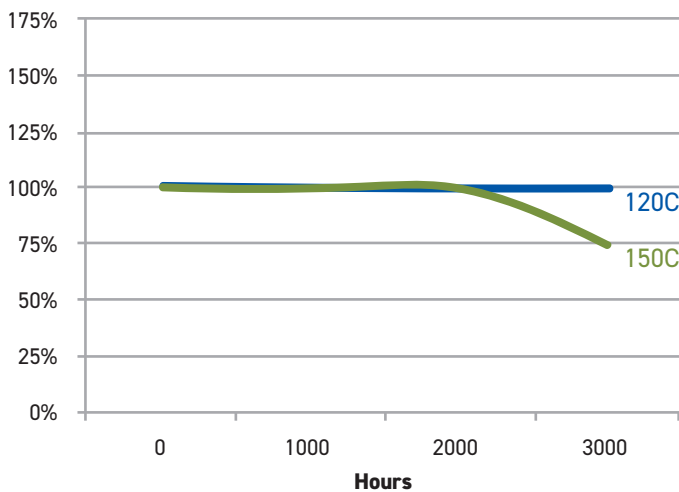


SOLVENT RESISTANCE

Solvent	Example	Resistance
Alcohol	Ethanol, methanol	Excellent
Ester (aromatic)	Ethylacetate	Poor
Ketone (aromatic)	Acetone, benzophenone	Poor
Aliphatic hydrocarbon (alkanes)	Petrol, heptanes, hexane	Good
Aromatic hydrocarbons	Benzyl, toluol, xylol	Good
Halogenated hydrocarbons	Methylenchloride, chloroform, chlorobenzol	Poor
Weak aqueous acid	Nitrite, muriatic acid, sulphuric acid, phosphoric acid	Excellent (poor if concentrated)
Weak aqueous base	Sodium hydroxide solution, caustic potash	Excellent (poor if concentrated)

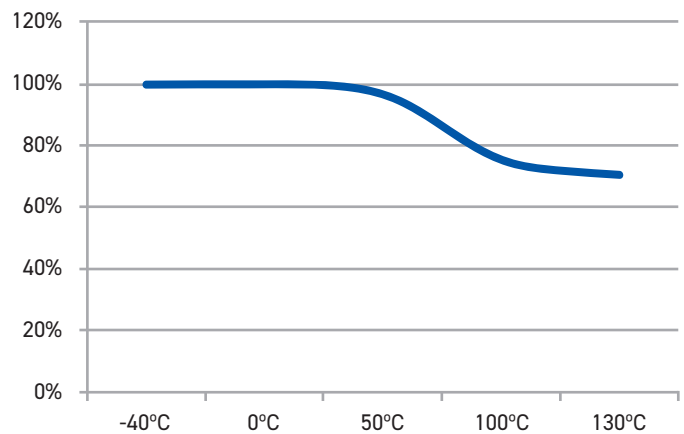
HEATING AGING

Aged at Temperature Indicated & Tested at 22°C



HOT STRENGTH

%RT Strength, Tested at Temperature



DISCLAIMER

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GorillaPro.com

9001 W. Fey Dr. · Frankfort, IL 60423 · +1-888-676-7763
SUPPORT: 1-888-MRO-PROF, gorillapro@hbfuller.com



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