

RA-20

**HIGH STRENGTH, HIGH VISCOSITY,
RETAINING ANAEROBIC ADHESIVE**

TECHNICAL DATA SHEET

JUNE 2021



PRODUCT DESCRIPTION

Bostik Born2Bond™ Retaining anaerobic adhesives are a cost effective, adaptable alternative or addition to mechanical retaining processes. Capable of bonding all types of cylindrical assemblies, these single-component solutions also seal all metal joints to eliminate the risk of fretting corrosion. They achieve 100% surface-to-surface contact, producing a cohesive, durable connection capable of withstanding vibration, extreme temperatures and chemical substances.

RA-20 is a high viscosity, high strength anaerobic adhesive designed to retain cylindrical parts exposed to temperatures up to 230°C. Once cured the product prevents leakage and/or loosening of parts from vibration and shock.

For more information, please consult <https://born2bond.bostik.com>

KEY FEATURES

- High strength
- High viscosity
- High power transmission
- Resistance to dynamic loads
- Vibration resistant
- Corrosion prevention
- Recommended for gaps up to 0.2mm
- Single component
- Suitable for active and passive metals

DIRECTIONS FOR USE

1. For best results, clean all surfaces (internal and external) with Born2Bond™ Pre-Bonding Cleaner and wait until fully evaporated.
2. If the cure speed is too slow on inactive metals, use Born2Bond™ Anaerobic Activator.
3. For slip fitted parts, apply the adhesive around the pin and the inside of the collar and rotate during assembly to ensure fully coverage.
4. For press fitted parts, apply adhesive fully to both surfaces and assemble at high pressure.
5. For shrink fitted parts, the adhesive should be on the pin, the collar should be heated.
6. Parts should be fixed until sufficient handling strength is achieved.

METHOD OF USE

Manual: Directly from the bottle with or without dispensing tips for more precise dispensing.

Semi-Automated: Use of pressure-time systems for accurate volume and larger series.

Full-Automated: fully automated robot or application lines.

APPLICATIONS

- Gear manufacturing
- Machine engineering
- Bearing assembly
- Drive shafts

STORAGE/SHELF LIFE

Store product in the unopened container in a dry area out of direct sunlight. Storage below 7 °C or greater than 28 °C can adversely affect product performance. If stored properly, this product has a shelf life of 18 months.

HEALTH/SAFETY

The Safety Data Sheet is available on the Bostik website and should be consulted for proper handling, cleanup and spill containment before use. Keep containers covered to minimize contamination.

LIMITATIONS

This product is not recommended for use in pure oxygen and/or oxygen-rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials. Material removed from containers may be contaminated during use. Do not return product to the original container. Bostik will not assume responsibility for product that has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or customer service representative.

PRODUCT CHARACTERISTICS

Basis Technology	Acrylic
Components	1K
Appearance / Color	Green
Cure	Anaerobic
Temperature use Range	-55° C to 230°C

UNCURED PHYSICAL PROPERTIES

Viscosity (Brookfield: Sp5 @20rpm @25°C)	5000 – 12000 mPa.s
Specific Gravity ASTM D1475 - 13(2020)	1.08

CURING PROPERTIES

The table below shows the curing properties of the product on mild steel according to ISO 10964

Fixture time @ 20°C	60min
Fixture time with Activator* @ 20°C	<15min
Full Cure @20°C	24h

*Bostik Born2Bond Anaerobic Activator

BONDING PERFORMANCE

The performance data reported below were measured according to ISO 4857 after curing for one week at 22°C (71.6°F).

Shear strength [ISO 4587 - mild steel]	>26 N/mm ²
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CONVERSIONS

$$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$$

$$\text{kV/mm} \times 25.4 = \text{V/mil}$$

$$\text{mm} / 25.4 = \text{in}$$

$$\mu\text{m} / 25.4 = \text{mil}$$

$$\text{N} \times 0.225 = \text{lb}$$

$$\text{N/mm} \times 5.71 = \text{lb/in}$$

$$\text{N/mm}^2 \times 145 = \text{psi}$$

$$\text{MPa} \times 145 = \text{psi}$$

$$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$$

$$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$$

$$\text{mPa}\cdot\text{s} = \text{cP}$$

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