



# BOSS<sup>®</sup> 9660 Press Fit Metal Repair

### TYPICAL PROPERTIES

#### Monomer (Liquid)

Base Compound .....	Urethane Methacrylate
Appearance .....	Metallic Grey/Green Paste
Viscosity (cP @ 68°F) .....	1,000,000 - 2,000,000 cP
Specific Gravity (g/cc) .....	1.10
Gap Fill .....	Up to 0.5mm
Corrosivity .....	None
Flash Point (TCC) .....	>200°F
Toxicity .....	Low
Shelf Life @ 40°F .....	1 Year Unopened
Temperature Range .....	-65°F to 300°F

#### Polymer (Cured)

Appearance .....	Grey Solid
Compressive Shear Strength .....	2500 psi (steel pin & collar)

\*Information on this data sheet is subject to change without notice and should not be used for writing specifications.  
For additional information on specific applications, contact Accumetric, LLC



### FEATURES

- Cures when confined in the absence of air between close fitting metal surfaces
- Prevents loosening and leakage from shock and vibration
- Typical applications include restoring correct fits on worn shafts, spun bearings and damaged keyways

### DESCRIPTION

BOSS<sup>®</sup> 9660 Press Fit Metal Repair is a single component anaerobic adhesive designed for the bonding of cylindrical fittings, particularly where bond gaps are at or near 0.5 mm.

### CURING PERFORMANCE

The gap of the bond line will affect set speed. Smaller gaps tend to increase the speed. Activators can be applied to improve set speed but may also impair overall adhesive performance.

### SETTING TIME (68°F, 65% RH)

Substrate .....	Set Time / Full Cure
Steel .....	30-120 minutes / 24 hours
Zn Dichromate .....	60-120 minutes / 24 hours
Aluminum .....	60-120 minutes / 24 hours

## HOW TO USE

Surfaces to be bonded should be clean, dry and free of grease.

### For Slip Fitted Assemblies

Apply adhesive around the leading edge of the pin and the inside of the collar and use a rotating motion during assembly to ensure good coverage.

### For Press Fitted Assemblies

Apply adhesive thoroughly to both bond surfaces and assemble at high press on rates.

### For Shrink Fitted Assemblies

The adhesive should be coated onto the pin, the collar should then be heated to create sufficient clearance for free assembly.

**This product is not recommended for use in pure oxygen environments and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.**

This product is not designed for plastics, particularly thermoplastics where stress cracking of the plastic could result. It is recommended to confirm compatibility of the product with all substrates prior to use.

## CHEMICAL RESISTANCE

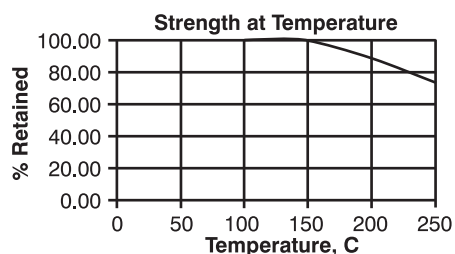
Shear strength on steel after 500 hours

### Solvent ..... % Strength Retained

Motor Oil .....	100
Unleaded Gasoline .....	100
Brake Fluid .....	75
Ethanol .....	95
Acetone .....	80
Water/Glycol Mix .....	90

## TEMPERATURE RESISTANCE

% Retained strength when tested at temperature



## CLEAN UP

Uncured sealant can be easily removed using a solvent such as alcohol or acetone. For an environmental and health friendlier choice use BOSS® Biggie Wipes. If the sealant is cured it must be removed mechanically by cutting and scraping.

## PACKAGING

BOSS® 9660 is available in 50ml tubes.

## SHIPPING LIMITATIONS

None.  
Reactive VOC 31 g/l (<4% wt)

## STORAGE AND SHELF LIFE

When stored in the original unopened containers at or below 90°F (32°C), BOSS® 9660 Press Fit Metal Repair has a shelf life of 12 months from date of shipment. In Countries where high heat and humidity are a factor, special precautions must be taken. Store product in a covered, well-ventilated warehouse and avoid excessive heat conditions. Storage in high heat, high humidity conditions may reduce shelf life by up to 30%. Rotation of stock is an absolute necessity.

Products can be refrigerated for improved shelf life but should be brought back to room temperature before use.

## CAUTION

DIRECT CONTACT OF UNCURED PRODUCT IRRITATES EYES AND MAY IRRITATE SKIN. OVEREXPOSURE TO VAPOR MAY IRRITATE EYES, NOSE, AND THROAT. Avoid eye and skin contact. Use with adequate ventilation. Do not handle contact lenses with sealant on hands. IN CASE OF EYE CONTACT, flush eyes with water for 15 minutes. Obtain medical attention. IN CASE OF SKIN CONTACT, remove from skin and flush with water. KEEP OUT OF THE REACH OF CHILDREN. For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).

## USERS PLEASE READ

The information and data contained herein is believed to be accurate and reliable; however, it is the user's responsibility to determine suitability of use. Since the supplier cannot know all the uses, or the conditions of use to which these products may be exposed, no warranties concerning the fitness or suitability for a particular use or purpose are made.

It is the user's responsibility to thoroughly test any proposed use of our products and independently conclude satisfactory performance in the application.

Likewise, if the application, product specifications or manner in which our products are used requires government approval or clearance, it is the sole responsibility of the user to obtain sure authorization.

**Non-warranty:** Because the storage, handling and application of the material is beyond Accumetric's control, we can accept no liability for the results obtained. Accumetric's sole limited warranty is the product meets the manufacturing specifications in effect at time of shipment. There is no warranty of merchantability or fitness for use, nor any other express or implied warranty. Accumetric will not be liable for incidental or consequential damages of any kind. The exclusive remedy for breach of such limited warranty is a refund of purchase price or replacement of any product shown to be other than as warranted.

Suggestions of uses should not be taken as inducements to infringe any patents.

MADE IN U.S.A.

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