

TECHNICAL DATA SHEET



ANAEROBIC ADHESIVES GREEN LINE

Retaining Compound user-friendly 06K60UF high-strength



The product curing (polymerisation) is carried out under the exclusion of atmospheric oxygen (anaerobic) and the catalytic action of the metal (metal contact).

- Metallic paste
- Used to repair worn out areas and restore correct fits
- Due to the large gap this product is perfectly suited for worn out ball bearings
- Can be drilled, shaped and grinded after full curing

Compared to conventional anaerobic adhesives, GREEN LINE products are completely label-free. In addition to a longer shelf life of 24 instead of 12 months, they also offer the user improved storage stability and increased temperature resistance of up to +180° C in use.

Technical Properties of Uncured Product

Chemical Base:	Methacrylate, anaerobic resin
Colour:	Metallic grey, slightly fluorescent
Viscosity ¹⁾ [mPas]:	200,000 – 600,000
Density ²⁾ [g/ml]:	1.13-1.17
Flashpoint ³⁾ [°C]:	> +65
Application Temperature [°C]:	10-40

1) At 25 °C, Brookfield viscometer

2) Measured according to DIN 53217, part 2 density sphere model 475/III

3) Measured according to DIN 51755

Curing Properties*

Handling Cure Time [min]:	5-15
Functional Cure Time [h]:	3-6
Final Strength After [h]:	24

Technical Properties of Hardened Product

Breakaway torque [Nm]:	18-28
Temperature range [°C]:	-55 to +180
Ideal Gap-filling Capacity [mm]:	0.3

Sizes / Article Number

50 ml Accordion Bottle	06K60UF.Z50
250 ml Tube	06K60UF.T250

Accessories / Article Number

Anaerobic Activator	ANAK.D200
Curing Accelerator	

Storage & Durability

The shelf life is, at the optimum storage temperature of +5 °C to +23 °C in the closed original container, a maximum of 24 months. A higher storage temperature leads to a significantly lower durability. The storage temperature must not fall below +5 °C.

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Information about application

The retaining compounds are not suitable for: Metal-plastic flange connections, in areas where gaseous oxygen is used, and sealing against media with strongly oxidizing acids.

The product is to be used only on standard metal threads. The affected surface must be free of grease and completely clean. For this purpose, the degreaser WIKO INDUSTRIAL FAST CLEANER (AISR.D400) should be used. Then completely fill the gap between the two parts with the retaining compound, put the parts together and seal them completely. Insufficient sealing may cause leakage after a certain time. Do not move the parts once the curing process has started.

Before start-up, allow the bonding to cure completely for 24 hours. In the case of series production, lock or lock the bonding with a pipe wrench to prevent the layer already in the curing process from breaking open. In case of passive surfaces and/or low temperatures, fast curing can be achieved by using WIKO ACTIVATOR FOR ANAEROBES (ANAK.D200). Before using the product, please consult the Safety Data Sheet. When using the activator, a 15% reduction in strength must be expected.

Note:

Please note the information and notes in our respective safety data sheets. The data contained herein are for informational purposes only and are believed to be accurate to the best of our knowledge. We assume no liability for the results. For optimum functionality of the adhesive system, please only use the cartridge and mixer systems tested and released by GLUETEC. The product is only suitable for professional and experienced users. It is the user's own responsibility to take precautions to protect property and people from the hazards that may be encountered in handling and using these products. Accordingly, GLUETEC specifically disclaims any warranty, expressed or implied, including any warranty or suitability commitments for a particular purpose. In particular, GLUETEC disclaims all liability for consequential or indirect damages of any kind.

* according to GLUETEC testing method for anaerobic adhesives