

# WINKEL PRO 6W38

## HIGH STRENGTH RETAINING COMPOUND



### Technical Bulletin

WINKEL PRO 6W38 is a fast curing universal product with highest strength for static shear and dynamic loads. The product curing (polymerisation) is carried out under the exclusion of atmospheric oxygen (anaerobic) and the catalytic action of the metal (metal contact). WINKEL PRO retaining compound 6W38 is used for bonding gear wheels, pulleys and rotor waves connections with electronic motors etc. Compared to conventional anaerobic adhesives, the GREEN LINE products are completely free of hazardous-labeling and thus offer the user a clear added value. Moreover, non-hazardous products have a better shelf-life and a high temperature resistance up to +180°C.

#### Technical properties uncured product

Chemical base:	Methacrylate, anaerobic resin
Colour:	green, fluorescent
Viscosity <sup>1)</sup> [mPas]:	2000-5000
Density <sup>2)</sup> [g/ml]	1,04-1,08
Max. clearance:	M36
Flashpoint <sup>3)</sup> [°C]:	>+100
Application temperature [°C]:	optimal at +23

1) At 25 °C, Brookfield viscometer

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

3) Measured according to DIN 51775

#### Technical properties hardened product

Breakaway torque [Nm]:	25-35
Prevailing torque [Nm]:	20-35
Temperature range [°C]:	-55 to +180
Max. gap filling [mm]:	0,30

#### Information about application

This product is not suitable for metal-plastic couplings and oxygen facilities as well as for the sealing of basic products or systems with strong oxidizing acids. Use only on standard metal threads. Surface must be clean and free of grease. For this, use degreaser agent WINKEL PRO FAST CLEANER. Apply product to fill the gap completely (male and female parts), assembly parts and shut completely. A bland or superficial closure may cause leakage over time. Don't move after tightening. Before operating the system wait for 24 hours to allow complete curing time. In case of serial products lock the joint with a pipe wrench to avoid breaking the previous film in its formative stages. In case of passive surfaces and/or low temperature a fast cure can be obtained using WINKEL PRO Anaerobic Activator. Consult the MSDS before use. By usage of an activator the curing values may drop by 15%.

Art. Nr. :	Packaging:
20603	50 ml
20604	250 ml
20605	1 L

#### Cured\*

Handling cure time [min]:	5-10
Functional cure time [h]:	1-3
Final strength after [h]:	12-24

#### 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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