

## LOCK'TRON R1638 HIGH STRENGTH ANAEROBIC RETAINER COMPOUND

### ● PRODUCT DESCRIPTION

Lock'tron R1638 is a fast curing, high strength anaerobic retaining compound for cylindrical fitting parts particularly where bond gaps can approach 0.25mm (0.01"). R1638 is a single component anaerobic adhesive, which develops high strength rapidly when confined in the absence of air between close fitting metal surfaces.

- Ideal to fill gaps up to 0.25 mm (0.01") diameter clearance.
- Maximum strength at room temperature.
- Used for locking bushings and sleeves into housings and on shafts.
- Excellent retaining, sealing and thread locking compound.

### ● CURING PROPERTIES

Handling Cure Time	5 Minutes
Functional Cure Time	1 – 3 Hours
Full Cure Time	24 Hours

### ● UNCURED PROPERTIES

Base	Urethane Methacrylate
Color	Green
Viscosity	2,500 cps
Specific Gravity	1.09
Gap Filling	0.25 mm
Flash Point	>93°C
Solvent Content	None

### ● CURED PROPERTIES

<b>Compressive Shear Strength (ISO 10123)</b>	
After 24 hours at 22°C	
Steel Pins & Collars	>25 N/mm <sup>2</sup> >4,300 psi
After 30 minutes at 22°C	
Steel Pins & Collars	15 – 17 N/mm <sup>2</sup> 2,250 psi
Temperature Resistance	-55 to +150°C
Coefficient of Thermal Expansion, ASTM D 696, K-1	80x10 <sup>-6</sup>
Coefficient of Thermal Conductivity, ASTM C 177, W/(m·K)	0.10
Specific Heat, kJ/(kg·K)	0.30



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### ● CHEMICAL RESISTANCE

Chemical	Temperature	% Initial Strength Retained	
		500 Hours	1000 Hours
Acetone	22°C	100	100
Ethanol	22°C	100	100
Motor Oil	125°C	100	100
Gasoline	22°C	100	100
Brake Fluid	22°C	100	100
Water/Glycol	87°C	100	95

