



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

Compressive Shear Strength (ISO 10123)				
After 24 hours at 22°C				
Steel Pins & Collars	>25 N/mm² >4,300 psi			
After 30 minutes at 22°C				
Steel Pins & Collars	15 – 17 N/mm² 2,250 psi			
Temperature Resistance	-55 to +150℃			
Coefficient of Thermal Expansion, ASTM D 696, K-1	80x10-6			
Coefficient of Thermal Conductivity, ASTM C 177, W/(m·K)	0.10			
Specific Heat, kJ/(kg·K)	0.30			

Our data sheets have been compiled to the best of our knowledge. The information included in our data sheets is exclusive information for the tended user and describes characteristics, with no declaration of commitment. We recommend trials in order to confirm that our products satisfy the particular application requirements. For an additional technical consultation, please contact our RD department. Adhetron is a brand of Pulsar Chem. Industry and Trade Co. INC.





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• CHEMICAL RESISTANCE

Chemical Tem	Toronorchuro	% Initial Strength Retained	
	Temperature	500 Hours	1000 Hours
Acetone	22ºC	100	100
Ethanol	22ºC	100	100
Motor Oil	125°C	100	100
Gasoline	22ºC	100	100
Brake Fluid	22ºC	100	100
Water/Glycol	87⁰C	100	95

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