

Technical Data Sheet

ADTECH® 6608 HIGH STRENGTH RETAINER



ADTECH® 6608 IS DESIGNED FOR THE BONDING OF CYLINDRICAL FITTING PARTS, PARTICULARLY WHERE BOND GAP CAN APPROACH 0.25MM.

ADTECH® 6608 IS A SINGLE COMPONENT ANAEROBIC, ACRYLIC BASED PRODUCT. THE PRODUCT CURES WHEN CONFINED IN THE ABSENCE OF AIR BETWEEN CLOSE FITTING METAL SURFACES AND PREVENTS LEAKAGE AND LOOSENING FROM VIBRATION AND SHOCK.

BENEFITS

- Best resistance to dynamic, axial and radial loads
- Ideal for shafts, gears, pulley and siliar cylindrical parts

TECHNICAL DATA

Brookfield viscosity:	2000-3000 mPAs
Cure speed:	10 - 15 minutes
Temperature resistance:	-54°C to +150°C
Strength:	Medium to high
Shear strength (steel pins & collars) ISO 1010123:	>25Nm

AVAILABLE SIZES

Polybottle	50ml
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AVAILABLE COLOURS

Green

PREPARATION AND APPLICATION

Ensure that the surfaces to be bonded are smooth, clean and free from dust or other deposits.

The rate of cure is dependent on the substrates being used, the gap fill required and the ambient temperature at the time of the cure. When the cure speed is unacceptably long, or larger gaps are present, using Adtech® 1006 Activator will improve the cure speed. If the material is an inactive metal consider using activator.

Shake the product thoroughly before use. Assemble and tighten.

For shrink fitted assemblies, the adhesive should be coated onto the pin. The collar will then need to be heated to create sufficient clearance for free assembly.

For slip fitted, apply adhesive inside of the collar then to the leading edge of the pin, then use a rotating motion in assembly to ensure coverage.

For press fitted assemblies, apply adhesive thoroughly to both bond surfaces and assemble at high press on rates.

To prevent the clogging of the nozzle, do not let the tip touch metal surface during application.

For disassembly, use localised heat to bolt or nut, disassemble

thoroughly. Seek medical attention immediately.

Keep well out of reach of children.

To remove cured product use a combination of solvent and abrasion such as a wire brush

Adtech® 6608 should be stored in the original containers in a cool, dry place, at a temperature range of between 5°C and 20°C. In these conditions it has a storage life of at least 12 months

LIMITATIONS

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be use with chlorine or other strong oxidising materials

Where washing systems are used to clean the surfaces before bonding, it is important to check the compatibility of the washing solution with the adhesive. In some cases these solutions can affect the cure and performance of the adhesive. This product is not recommended for use on certain plastics.

HANDLING AND STORAGE

Use proper ventilation; avoid contact with skin and eyes.

If contact with skin occurs, rinse with warm water or dissolve gradually with appropriate debonder.

Do not try to remove forcibly.

If adhesive gets into eye, keep eye open and rinse

DISCLAIMER: Due to the variation in materials likely to be handled by prospective users of this product, together with differences in production techniques and ultimate performance required, it is important that this product is thoroughly evaluated under production and end use conditions before being commercially adopted. Such an evaluation should incorporate an ageing test and this test should be repeated if the substrates on which the this product is used are changed in any way or are purchased from a different source. During the evaluation and testing of the product, it is the purchasers/end user's responsibility to carry out appropriate actions for the protection of the environment, the health and safety of its employees and purchasers of its products. No employee of Ureka Global Ltd has any authority to waive or change the forgoing provisions. The above recommendations are made in good faith for the guidance of users and are without liability. Any queries should be made in writing to the head office of Ureka Global Ltd.

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