

TECHNICAL DATASHEET

# STALOC 6S38

Retaining compound, high-strength



## PRODUCT DESCRIPTION

High-strength anaerobic adhesive used to tighten and seal bolted assemblies. Also used to bond and join cylindrical parts.

Tolerates gaps of up to 0.25mm in order to allow for higher manufacturing tolerances. Excellent resistance to corrosion, vibration, water, gas, different oils, hydrocarbons and many other chemical substances. The product can be used for applications with high static shear loads as well as dynamic loads. Used to fix bearings, gears, pulleys, shaft-to-collar connections, etc.

Cures quickly in anaerobic environment, also on stainless steel and passive surfaces.

## PHYSICAL PROPERTIES (WHEN LIQUID)

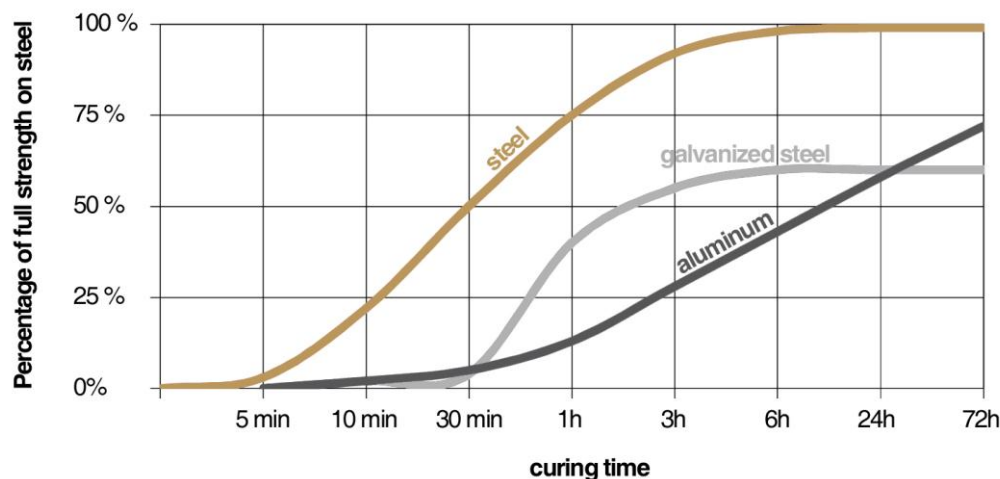
ATTRIBUTE	UNIT	SPECIFICATION
Colour		green / fluorescent under blue light
viscosity at +25°C	mPas	2,600 – 3,100
max. gap	mm	~ 0.25 mm
max. thread diameter		M 36
density at +25°C	g/ml	1.10 g/ml
flashing point	°C	> 100°C
chemical basis		urethane methacrylate
shelf life at +25°C		min. 1 year

## PHYSICAL PROPERTIES (WHEN CURED)

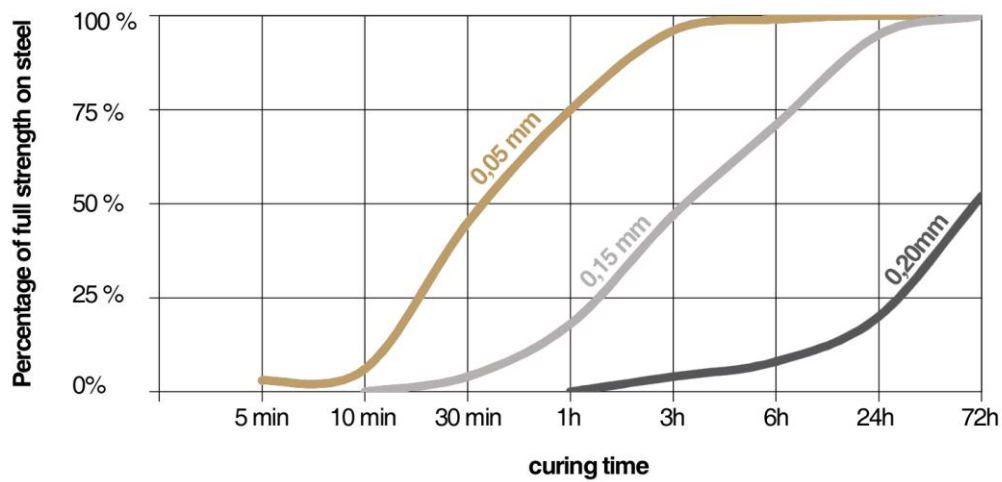
Tested with screw M10 x 20 - quality 8.8 galvanized - nut 0.8d (without preload)

ATTRIBUTE	UNIT	SPECIFICATION
finger tight after	min	2 - 5 min
functional cure time	h	1 - 3 h
final cure time	h	2 - 4 h
breakaway torque (ISO 10964)	Nm	~ 30 - 40 Nm
run-down torque (ISO 10964)	Nm	~ 50 - 70 Nm
shear strength (ASTM D-1002)	N/mm <sup>2</sup>	~ 25 - 35 N/mm <sup>2</sup>
temperature resistance	°C	- 55°C to +150°C

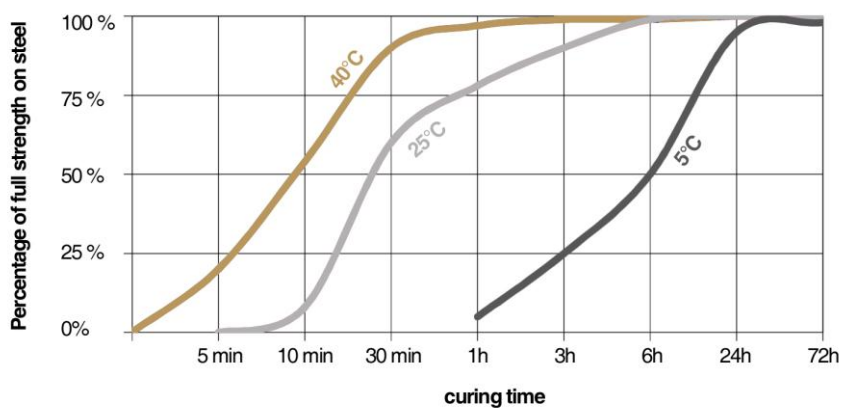
## CURING TIME DEPENDING ON SUBSTRATES



## CURING TIME DEPENDING ON THE GAP



## CURING TIME DEPENDING ON TEMPERATURE OF THE SUBSTRATE



## CHEMICAL RESISTANCE

After 24 hours of polymerisation

Substance	Temperature [°C]	resistance		
		after 100 h	after 1,000 h	after 5,000 h
Motor oil	125	excellent	excellent	excellent
Gear oil	125	excellent	excellent	excellent
Gasoline	25	excellent	good	good
Water / Glykol 50%	87	excellent	medium	medium
Brake fluid	25	excellent	good	medium



## APPLICATION

Recommended application – further information can be found in the material safety data sheet

Use on metal surfaces. The parts to be bonded need to be cleaned and degreased. It is recommended to use STALOC technical cleaners (e.g. STALOC industrial quick cleaner), in order to ensure the best results in terms of adhesion. Apply anaerobic adhesive filling the complete gap. Join the parts.

Applicability of the anaerobic adhesive on special surfaces or coatings, thermoplastics and elastomers needs to be tested.

The curing time of STALOC anaerobic adhesives can be accelerated using the STALOC activator for anaerobic adhesives.

Use suitable tools in case you need to disassemble the bonding. In order to ease the disassembly heat substrates to more than 200°C.

## STORAGE

Recommended storage for optimum shelf life

Store product at an optimum temperature between 5°C and 25°C. Keep cool and dry. Make sure that the content is not contaminated once the bottle has been opened, in order to ensure an optimum shelf life. In case you need any further information, please contact the STALOC team.

## SAFETY INFORMATION

Please send your request for the latest version of the material safety data sheet (MSDS).

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