

Technical Data Sheet

Product

Anaerobic Retaining Compound RT 601

Revision date: March 2017

Date of issue: June 2015

Reference No. : 400001010601

Product Description

Rite Lok RT 601 is a single component, general purpose, anaerobic retaining compound. **RT 601** cures when confined in the absence of air between close fitting metal surfaces

Key Features

Rite Lok RT 601 is formulated for bonding cylindrical parts, to give high strength bonds. Typical applications include bonding gears on to shafts. **RT 601** is designed to augment the strength of press fit assemblies. Once applied, parts slip together easily, lubricated by the adhesive. **RT 601** prevents corrosion of assembled parts.

Physical Properties

Chemical Type	Dimethacrylate
Appearance	Green
Specific Gravity	~1.07
Viscosity cPs	Range 100 –150 Typical Value 125

Performance Characteristics

Maximum Gap Fill	0.20mm
Fixture Time	15mins
Full Cure	24hrs
Strength Build Up	20 mins = 10% strength 1 hour = ~50% strength 24hours = 100% strength
Breakaway Torque N.m (ISO 10964)	Range 25 – 50 Typical 36
Prevail Torque N.m (ISO 10964)	Range 22.5 – 50 Typical 35
Shear Strength N/mm² (ISO 10123)	Range 12 – 26 Typical 18.5
Chemical compatibility	Anaerobic adhesives and sealants should not be used in pure oxygen or chlorine lines.
Service Temperature Range	-50 to +150°C

Additional Product Information Anaerobic adhesives only cure in the absence of air and with metal part activation. Adhesive outside the joint will remain uncured and may be wiped away with a cloth.
RT 601 is suitable for high strength retaining applications that require small gap filling. RT 601 is not recommended on certain plastics as stress cracking can sometimes result. Some anti-corrosion chemicals inhibit the cure system in this type of anaerobic. Trials are recommended to establish whether cleaning of the parts is necessary. Activator may be required on plated parts.

Application Techniques Ensure parts are clean, dry and free from oil and grease.
Apply adhesive to all engaged area. Assemble parts and allow to cure. Wipe excess adhesive from outside of joint.
Heating the assembled parts accelerates the curing process.
AC64 Activator may be used to accelerate cure and should be used if the application temperature is below 5°C. The use of an accelerator may reduce the final bond strength by up to 30%

Storage Conditions Keep the adhesive in a cool, dry place away from direct sunlight. Under such conditions shelf life at room temperature will be 12 months.
Refrigeration to 5°C gives optimum storage stability.

Shelf Life 12 months from date of despatch when stored in the original carton at 21°C

**Precautionary
Information**

Refer to product label and material Safety Data Sheet for health and safety information before using the product.

Product Use

All statements, technical information and recommendations contained in this document are based upon tests or experience are reliable. However, many factors beyond control can affect the use and performance of product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the product to determine whether it is fit for a particular purpose and suitable the user's method or application.

Note

Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendation

Petrotechno Ltd, Canada

7050 gablehurst cres.Mississauga,
Ontario , Canada

Phone: +1(647) 476 4750

Fax: +1(647) 476 4751

www.petrotechno.com