

Technical Data Sheet

Product

Anaerobic Retaining Compound RT 620G

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Product Description Rite Lok RT 620G is a single component, high viscosity, thixotropic anaerobic retaining compound. RT 620G cures when confined in the absence of air between close fitting metal surfaces

Key Features Rite Lok RT 620G is formulated for bonding cylindrical parts, to give high strength bonds. RT 620G is designed to augment the strength of slip fit assemblies and for use on loose-fitting or worn parts, where larger gap fill is required. RT 620G is designed for high service temperature applications. prevents corrosion of assembled parts.

Physical Properties	Chemical Type	Dimethacrylate
	Appearance	Yellow/Green
	Specific Gravity	~1.03
	Viscosity cPs (Brookfield RVT spindle 4, 2.5rpm)	Range 10,000 – 30,000 Typical Value 20,000
	Viscosity cPs (Brookfield RVT spindle 4, 20rpm)	Range 5,000 – 10,000 Typical Value 7,500

Performance Characteristics	Maximum Gap Fill	0.4mm
	Fixture Time	15mins
	Full Cure	24hrs
	Strength Build Up	40 mins = 10% strength 3 hour = ~50% strength 24hours = 100% strength
	Breakaway Torque N.m (ISO 10964)	Range 25 – 42 Typical 34
	Prevail Torque N.m (ISO 10964)	Range 25 – 42 Typical 32
	Chemical compatibility	Anaerobic adhesives and sealants should not be used in pure oxygen or chlorine lines.
	Service Temperature Range	-50 to +230°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 620G is suitable for medium strength retaining applications that require large gap filling. RT 620G 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.
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 that are reliable. However, many factors beyond control can affect the use and performance of a 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 we cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendation