

# TECHNICAL DATA SHEET



## ANAEROBIC ADHESIVES one-component



## Retaining Compound 06K48 high-strength

The product curing (polymerisation) is carried out under the exclusion of atmospheric oxygen (anaerobic) and the catalytic action of the metal (metal contact).

WIKO 06K48 is fast curing, heat-resistant and used to fixate cylindrical joint connections as well as cylinder liners in engine blocks. The product is highly resistant to acids and bases. Moreover, the product can be used to fixate bearings in heating furnaces. **Not authorized for domestic gas installations according to TRGI 86/96.**

The permanent use of WIKO 06K48 in copper bonding, which gets in contact with water >40 °C is not recommended without thorough preliminary tests on original parts.

### Technical properties uncured product

Chemical base:	Methacrylate, anaerobic resin
Colour:	green, fluorescent
Viscosity <sup>1)</sup> [mPas]:	400-900
Density <sup>2)</sup> [g/ml]:	1,07-1,11
Max. clearance:	M20
Flashpoint [°C]:	> +100
Application temperature [°C]:	optimal at +23

1) At 25 °C, Brookfield viscometer

2) Measured according to DIN 53217, part 2 density sphere model 475/III

3) Measured according to DIN 51755

### Cured\*

Handling cure time [min]:	< 15
Functional cure time [h]:	3-6
Final strength after [h]:	12-24

### Technical properties hardened product

Breakaway torque [Nm]:	> 18
Prevailing torque [Nm]:	20-35
Temperature range [°C]:	-55 to +200
Max. gap filling [mm]:	0,25
Chemical stability:	you will find a comprehensive overview at <a href="http://www.gluetec.de">www.gluetec.de</a>

### Sizes / article number

10 ml bottle	06K48.F10
50 ml concertina bottle	06K48.Z50
250 ml bottle	06K48.F250

### Accessories / article number

Anaerobic activator	ANAK.D200
Catalyst	

### Storage & Durability

The shelf life is, at the optimum storage temperature of +5 °C to +23 °C in the closed original container, a maximum of 12 months. A higher storage temperature leads to a significantly lower durability. The storage temperature must not fall below +5 °C.

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## Information about application

This product is not suitable for metal-plastic couplings and oxygen facilities as well as for the sealing of basic products or systems with strong oxidizing acids. Use only on standard metal threads. Surface must be clean and free of grease. For this, use the degreaser product WIKO INDUSTRIAL QUICK CLEANER (art. No. AISR.D400). Apply product to fill the gap completely (male and female parts), assembly parts and shut completely. A bland or superficial closure may cause leakage over time. Don't move after tightening. Before operating the system, wait for 24 hours to allow complete curing time. In case of serial products, locking the joint with a pipe wrench to avoid breaking the previous film in its formative stages. In case of passive surfaces and/or low temperature, a fast cure can be obtained using WIKO AKTIVATOR anaerobic. Consult the MSDS before use. By usage of an activator, the curing values may drop by 15%.

### Note:

Please note the information and notes in our respective safety data sheets. The data contained herein are for informational purposes only and are believed to be accurate to the best of our knowledge. We assume no liability for the results. For optimum functionality of the adhesive system, please only use the cartridge and mixer systems tested and released by GLUETEC. The product is only suitable for professional and experienced users. It is the user's own responsibility to take precautions to protect property and people from the hazards that may be encountered in handling and using these products. Accordingly, GLUETEC specifically disclaims any warranty, expressed or implied, including any warranty or suitability commitments for a particular purpose. In particular, GLUETEC disclaims all liability for consequential or indirect damages of any kind.

\* according to GLUETEC testing method for anaerobic adhesives