

# Technical Data Sheet

**AN6380**

## Description

Fast curing high strength anaerobic adhesive for locking and sealing threads, and retaining of cylindrical parts. It allows larger machining tolerances. Highly resistant to heat, corrosion, vibrations, water, gases, oils, hydrocarbons, and many chemicals. Approved for gas - Gaz de France.

## Physical properties

Composition: anaerobic methacrylate  
Color: green  
Viscosity (+25°C - mPa s): 2.600 - 3.400  
Specific weight (+25°C - g/ml): 1,1  
Fluorescence: under blue light  
Flash point: > +100°C  
Shelf life +25°C: 1 year in unopened packaging  
Max diameter of thread/ gap filling: M 36/1½"/0,20 mm

## Curing performance

Curing rate depends on the assembly clearance, material surfaces and temperature. Functional strength is usually reached in 1 - 3 hours and full curing takes 24 - 36 hours. In case of passive surfaces and/or low temperature, a fast cure can be obtained using an Activator.

## Curing properties (typical)

Tested on ½" thread specimens at +20°C. Results may change according to temperature and gap.

Handling time:

- Brass (naked OT 58): < 1 minute
- Chromed and nicked brass: 3 - 6 minutes
- Steel: 2 - 5 minutes
- Aluminum: 6 - 18 minutes

Bolt M10 x 20 Zn - quality 8.8 - nut h = 0,8 d at +25°C:

Functional cure time: 1 - 3 hours  
Full cure time: 2 - 4 hours

Locking torque(ISO 10964):

- breakaway: 30 - 40 N m
- prevailing: 55 - 70 N m

Shear strength (ISO 10123): 25 - 35 N/mm<sup>2</sup>

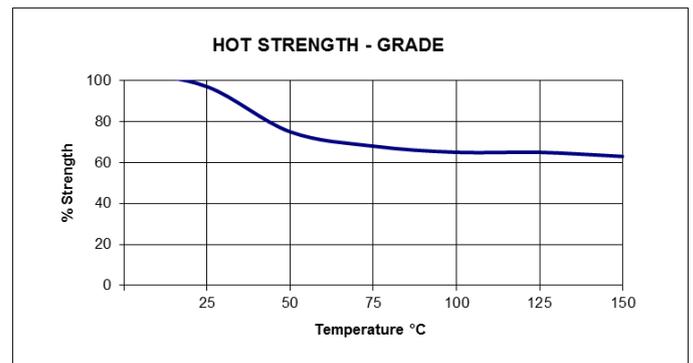
Impact strength (ASTM D950): 5 - 12 kJ/m<sup>2</sup>

Temperature range: -55°C/+150°C

## Environmental resistance

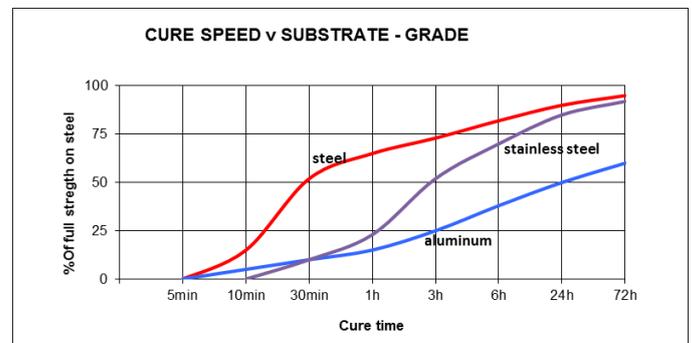
### Hot strength

The graph below shows the mechanical strength vs. temperature. Specimens – steel pin/collars tested in accordance with ISO 10123.



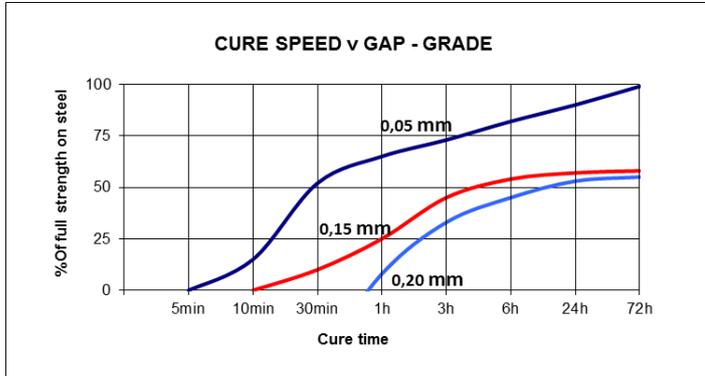
### Cure speed v substrate

The graph hereunder shows the breakaway strength development of the product (with time) on steel pin/collars tested in accordance with ISO 10123 at + 25°C.



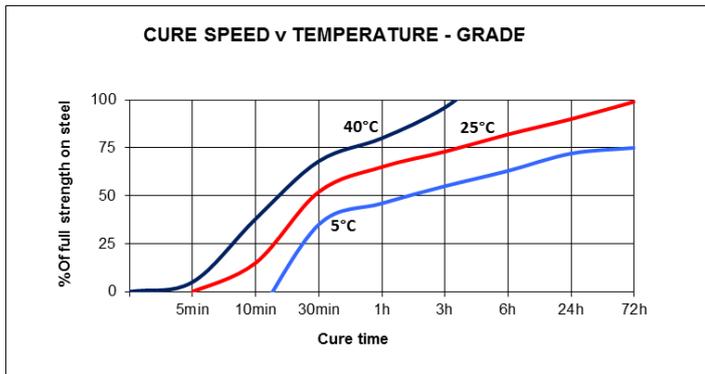
**Cure speed v gap**

The graph below shows the product shear strength (as %) at different increasing controlled gaps.  
Specimens - Steel pins/collars, tested in accordance with ISO 10123 at + 25°C.



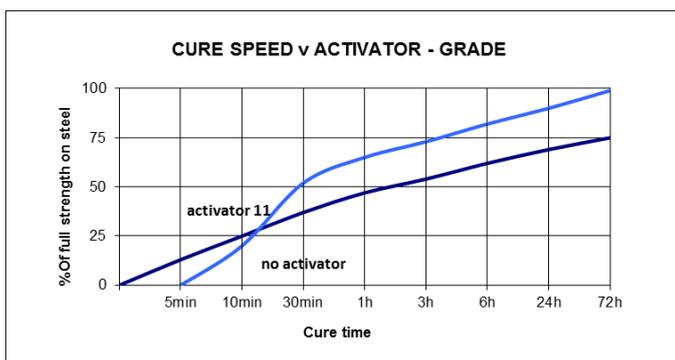
**Cure speed v temperature**

The following graph shows the breakaway strength of the product (as %) at different temperatures.  
Specimens – steel pin/collars tested in accordance with ISO 10123.



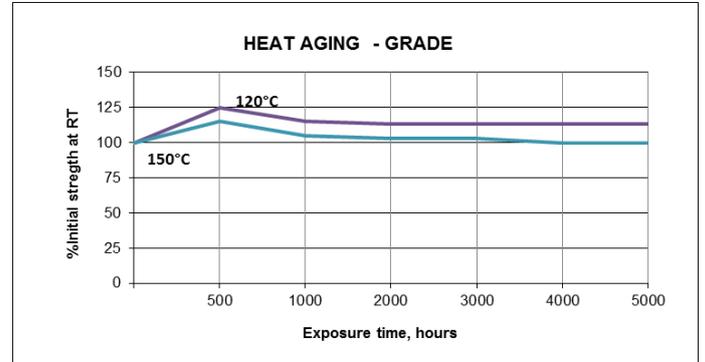
**Cure speed v activator**

Polymerization could be slowed down by substrate nature, large gaps; cure speed can be improved by applying appropriate activator to the substrate(s).  
The following graph shows the breakaway strength of the product (as %) and the cure speed developments using our activator compared to the ones with no activator.  
Specimens – steel pin/collars tested in accordance with ISO 10123.



**Heat aging**

The graph below shows the strength resistance behavior as a function of temperature/time.  
Specimens – steel pin/collars tested in accordance with ISO 10123 at + 25°C.



**Chemical resistance**

Aged under conditions below after 24 hours from polymerisation at indicated temperature. Tested at + 25°C.

Substance	°C	Resistance after 100 h	Resistance after 500 h	Resistance after 1000 h
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Motor oil	125	excellent	excellent	excellent
Gear box oil	125	excellent	excellent	excellent
Gasoline	25	excellent	good	good
Water/glycol 50%	87	excellent	discrete	discrete
Brakes oil	25	excellent	good	discrete

**Directions for use**

1. Clean the surfaces with a Cleaner and allow to dry.
2. Curing time may be slower if gaps are large and/or on inactive surfaces: the use of an Activator can be considered to reduce it.
3. Shrink fitted assemblies: to heat the collar, apply the adhesive to the pin. To cool the pin, apply the adhesive to the collar. If both heating and cooling are required, apply the adhesive to the cooled part avoiding condensation.
4. Press fitting assemblies: apply the adhesive on the pin and collar and assemble to the required pressure using a press.
5. Slip fitted assemblies: apply the adhesive on the leading edge of the pin and on the inside of the collar. Assemble with twisting action to ensure full coverage.
6. Allow the parts to achieve functional strength before subjecting them to any service loads.

When used as a sealant: apply a bead of adhesive to 360° between the first and second male thread, screw the female giving the desired pre-torque. For large diameter fittings and threads, apply the adhesive on both parts.

### **Disassembly and cleaning**

To disassemble the pieces, use conventional tools. When possible, disassembly is made easier by heating pieces at +150°C/+250°C and hot disassembling them.

Remove the cured product mechanically and finish cleaning with Acetone.

### **Warnings**

This adhesive is not approved for usage with neither pure nor with gaseous oxygen.

It is not suitable for applications on plastics.

The liquid product may damage paints and elastomers. If the product gets in contact, even accidentally, with some thermoplastics, stress cracking of the plastics could happen.

### **Storage**

Keep product in a cool and dry room at no more than + 25°C. To avoid contaminations do not refill containers with used product.

### **Safety and handling**

Consult Material Safety Data Sheet before use.