

WINKEL PRO 6W41

RETAINING MEDIUM



Technical Bulletin

WINKEL PRO 6W41 is an universal, medium-strength adhesive to fixate bearings in bushes and wheels on shafts. The product curing (polymerisation) is carried out under the exclusion of atmospheric oxygen (anaerobic) and the catalytic action of the metal (metal contact). The product is especially suited for bonding of cylindrical assembly parts. Compared to conventional anaerobic adhesives, the GREEN LINE products are completely free of hazardous-labeling and thus offer the user a clear added value. Moreover, non-hazardous products have a better shelf-life and a high temperature resistance up to +180°C.

Technical properties uncured product

Chemical base:	Methacrylate, anaerobic resin
Colour:	yellow, fluorescent
Viscosity ¹⁾ [mPas]:	400-700
Density ²⁾ [g/ml]	1,05-1,09
Max. clearance:	M36
Flashpoint ³⁾ [°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 51775

Technical properties hardened product

Breakaway torque [Nm]:	> 8
Prevailing torque [Nm]:	10-20
Temperature range [°C]:	-55 to +180
Max. gap filling [mm]:	0,20

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 degreaser agent WINKEL PRO FAST CLEANER. 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 lock 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 WINKEL PRO Anaerobic Activator. Consult the MSDS before use. By usage of an activator the curing values may drop by 15%.

Art. Nr. :	Packaging:
20606	50 ml
20607	250 ml
20608	1 L

IMPORTANT NOTICE: This information is presented to assist the user in determining whether our products are suitable for his intended application and user assumes all risks and liability whatsoever in connection therewith. No warranty or representation express or implied, shall apply to these products. Seller's only obligation shall be to replace quantity of this product which has proven to not substantially comply with the data presented Manufacturer's latest bulletin. Seller shall not be liable for any property loss or damage, direct or consequential, arising out of the use of or the inability to use the product. No protection from any law or patent is to be inferred and all patent rights are reserved. See Material Safety Data Sheet.

Cured*

Handling cure time [min]:	< 10
Functional cure time [h]:	4-8
Final strength after [h]:	24

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 24 months. A higher storage temperature leads to a significantly lower durability. The storage temperature must not fall below +5°C.