

## Technical Datasheet

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# Retaining cylindrical AL-641



yellow  
medium viscosity  
medium strength

Retaining cylindrical

### Technical Data

Colour	yellow
Fluorescent	Yes
For threaded joints up to	M 20 R ¾"
Viscosity at +25°C (+77°F) according to Brookfield	550 nt mPa·s
Max. gap bridging	0,12 mm
Breakaway strength (Thread)	12 - 15 Nm
Prevailing strength	17 - 22 Nm
Shear strength Nmm² (DIN 54452)	8 - 12 N/mm²
Handling strength at room temperature	10 - 20 min.
Final strength (100%) after	3 - 6 h
Temperature resistance	-60 to +150 °C

\*Strength values based on M 10 screws, 8.8 grade, thickness of nut 0,8.d Static shear strength based on cylindrical parts of abt. Ø 13 mm, tolerance (D-d) = 0,05 mm, l/d = 0,88

### Surface pre-treatment

In general, Retaining cylindrical AL-641 does not require special pretreatment as slightly oily surfaces (e.g. on as received parts) will be tolerated. However, best results will be achieved on cleaned, degreased parts. If required, the parts should be slightly roughened.

### Processing

Retaining cylindrical AL-641 is ready for use and should be applied evenly direct from the bottle/tube with the dispensing tip (avoid direct contact of dispensing tip with metal). On press fitted parts and larger cylindrical assemblies a thin and uniform layer should be applied on both surfaces. Join parts quickly. For sliding seats, turn

the parts against each other when joining for an optimal distribution of the adhesive. Joint parts should not be moved until handling strength is reached. Do not pour back into the bottle any Retaining cylindrical AL-641 fluid which had contact with metal; even smallest metal particles will cause the content of the bottle to cure. In series construction, the use of manual or automatic applicators is recommended.

### Storage

Retaining cylindrical AL-641 can be stored in the unopened original container for at least 24 months at room temperature. Keep away from heat sources and direct sunlight. The air in the bottle/tube keeps Retaining cylindrical AL-641 liquid.

### Safety and health

When using products, the physical, safety technical, toxicological and ecological data and regulations in our EC safety data sheets must be observed.

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