Higlue 638 Retaining Compound

Technical Data Sheet
Jiangxi Gooz Adhesive Co.,Ltd

Product name:HiGlue 638 Retaining Compound
Producer:Jiangxi Gooz Adhesive Co.,Ltd
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PRODUCT DESCRIPTION:

HiGlue 638 is designed for the bonding of cylindrical fitting parts, particularly with narrow bond gaps approaching 0.25 mm.
The product cures when confined in the absence of air between close-fitting metal surfaces and prevents loosening and leakage due to shock and vibration.
It not only works on active metals but also on passive substrates, exhibiting robust cure performance. The product offers high-temperature performance and good oil tolerance, and tolerates minor surface contaminants.

- High temperature resistance
- Tolerates minor contaminants, including industrial oils
- High strength on all metals, including passive substrates (e.g. stainless steel)
- Ideal for shafts, gears, pulleys and similar cylindrical parts

PRODUCTION INFORMATION:

Model	Higlue 638
Color	Green
Fixture Time	4.0 min/24hours.
Gap Fill	0.15 - 0.25 mm
Key Characteristics	Fluorescent, Oil Tolerant, Strength: High Strength, Temperature Resistant, Viscosity: High Viscosity
Operating Temperature	-55.0 - 150.0 °C
Shear Strength, Steel	31.0 N/mm² (4500.0 psi)

Substrates	Metal: Steel
Viscosity	2,000~3,000 mPa·s (cP)
Capacity	10ml 50ml 250ml

DIRECTIONS FOR USE:

For Assembly
1. For best results, clean all surfaces (external and internal) with a cleaning solvent and allow to dry.
2. To accelerate cure speed or where large gaps are present, use activator and allow to dry.
3. For Slip Fitted Assemblies, apply adhesive around the leading edge of the pin and the inside of the collar and use a rotating motion during assembly to ensure good coverage.
4. For Press Fitted Assemblies, apply adhesive thoroughly to both bond surfaces and assemble at high press on rates.
5. For Shrink Fitted Assemblies, the adhesive should be coated onto the part to produce a smooth, even film of material. If heating the hub for assembly, coat the pin. If the pin is to be cooled for assembly, coat the hub. If both heating and cooling is to be done, apply material to cooled part. Avoid condensation on cooled parts.
6. Parts should not be disturbed until sufficient handling strength is achieved.

For Disassembly
1. Remove with standard hand tools.
2. If needed,apply localized heat to the assembly to approximately 250 °C. Disassemble while hot.
3. If this temperature is not possible, heat as much as possible and use mechanical aids.

Clean-up

1. Cured product can be removed with a combination of soaking in a solvent and mechanical abrasion such as a wire brush.

Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.
Optimal Storage: 8°C to 21°C. Storage below 8°C or greater than 28°C can adversely affect product properties.
Material removed from containers may be contaminated during use. Do not return product to the original container.