

Higlue 648 Retaining compound

Technical Data Sheet
Jiangxi Gooz Adhesive Co.,Ltd

Product name:HiGlue 648 retaining compound
Producer:Jiangxi Gooz Adhesive Co.,Ltd
Address:Bldg, B3, Gongye Road, Lutang Village, Yining Town, Xiushui County, Jiujiang,
Jiangxi China
FAX:+86 07927662665

PRODUCT DESCRIPTION:

Higlue 648 is a low viscosity, high strength retaining compound with high temperature resistance. Ideal for retention of parts with a clearance or interference fit.

Higlue 648 is a green, fluorescent, low viscosity, high strength, urethane methacrylate acrylic, anaerobic retaining compound designed for bonding cylindrical fitting parts. It prevents loosening and leakage from shock and vibration. Typical applications include holding gears and sprockets onto gearbox shafts and rotors on electric motor shafts. It provides robust curing performance.

- Fluorescent,Low viscosity,High strength
- Designed for bonding cylindrical fitting parts
- Offers high temperature performance and oil tolerance
- Works on active metals (e.g. mild steel) as well as passive substrates such as stainless steel and plated surfaces
- Tolerates minor surface contaminations from various oils such as cutting, lubrication, anti-corrosion and protection fluids

PRODUCTION INFORMATION:

Model	Higlue 648
Color	Green
Fixture Time	5.0 min/24hours.
Gap Fill	0.15 mm
Key Characteristics	Oil Tolerant, Strength: High Strength, Temperature Resistant
Operating Temperature	-55.0 - 180.0 °C (-65.0 - 355.0 °F)

Shear Strength, Steel	27.0 N/mm ² (3900.0 psi)
Substrates	Metal: Steel
Viscosity	400~600 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.