

### HYLOGRIP HY6138 / 6640

#### Description

Hylogrip HY6138 is a fast curing single part, anaerobic, retaining adhesive for cylindrical parts. It gives high strength, and medium viscosity. When fully cured the product is highly resistant to heat, corrosion, vibrations, water, gases, oils, hydrocarbons and many other chemicals.

#### Typical Properties

Uncured Material	
Composition	Anaerobic Methacrylate
Colour	Green
Viscosity (Spindle No.6 @ 2.5rpm) (BS 5350: Part B9)	2500cps
Specific Gravity (ASTM D4659)	1.1
Max Gap Filling	0.20mm
Flash Point	>100°C (>212°F)
Solvent Content	0%

Cured Material	
Handling Cure Time (Zinc coated steel)	2 – 10 minutes
Functional Cure Time (Zinc coated steel)	1 hour
Full Cure Time (Zinc coated steel)	2 - 4 hours
Shear Strength (DIN 54454)	35 N/mm <sup>2</sup>
Temperature Range	-50°C to 150°C (-58°F to 302°F)

#### Instructions for Use

For best results ensure that both surfaces are clean, dry and free from contamination such as oil or grease. Surfaces may be cleaned using Acetone or an equivalent product. Prior to assembly apply sufficient product to both surfaces. Assemble the components, taking care not to disturb them until sufficient handling strength has developed. After initial cure any excess Hylogrip HY6138 can be easily wiped away using a cloth soaked in Acetone or a similar product.

#### Typical applications

Hylogrip HY6138 is a high strength general purpose, retaining adhesive for use on cylindrical fitting components including, bushings, sleeves, shafts and rotors.

Information given in this publication is based upon technical data gained in our own and other Laboratories and is believed to be true. However the material is used in conditions beyond our control thus we can assume no liability for results obtained or damages incurred through the application of the data present herein.

Hylomar Ltd, Cale Lane, Wigan WN2 1JT UK Tel: +44 (0) 1942 617000 Fax: +44 (0) 1942 617001	Revision date	16.09.2015	Page 1 of 2
	Product name	Hylogrip HY6138 / 6640 Issue 4	

### Handling & Safety Properties

Please refer to the Safety Data Sheet.

### Storage

To achieve maximum shelf life the product should be stored in the original, unopened container below 25°C (77°F).

### Packaging

Please contact our sales department for details.

Information given in this publication is based upon technical data gained in our own and other Laboratories and is believed to be true. However the material is used in conditions beyond our control thus we can assume no liability for results obtained or damages incurred through the application of the data present herein.

Hylomar Ltd, Cale Lane, Wigan WN2 1JT UK Tel: +44 (0) 1942 617000 Fax: +44 (0) 1942 617001	Revision date	16.09.2015	Page 2 of 2
	Product name	Hylogrip HY6138 / 6640 Issue 4	