

Technical Data Sheet

SELLOCK 3638 VERY HIGH RETAINER

1. Product Description

Sellock 3638 is a fast curing; high strength anaerobic retaining compound for cylindrical fitting parts particularly where bond gaps can approach 0.25mm (0.01"). Sellock 3638 retaining compound is a single component anaerobic adhesive, which develops high strength rapidly when confined in the absence of air between close fitting metal surfaces.

2. Properties

- Ideal to fill gaps up to 0.25 mm (0.01") diameter clearance.
- Maximum strength at room temperature.
- Used for locking bushings and sleeves into housings and on shafts.
- Excellent retaining, sealing and thread locking compound.
- This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be use with chlorine or other strong oxidising materials.

3. Technical Information

Chemical Base:	Urethane Methacrylate
Color:	Green
Appearance:	Liquid
Specific gravity(25°C):	1,09 g/cm ³
Viscosity (25°C):	2000-3000 mPas

Maximum Diameter of Thread/Gap Filling:	0,25 mm
Operating Temperature:	- 54 °C to 150 °C

After 24 hours at 20-25 °C

Shear strength steel collars and pins : >25 Nm
(ISO 1010123)

Chemical Resistance:

Chemical	Temp.	% Initial Strength Retained		
		100 hours	500 hours	1000 hours
Acetone	22 °C	90	90	90
Ethanol	22 °C	100	100	75
Motor Oil	125 °C	100	100	100
Unleaded Petrol	22 °C	100	90	85
Brake Fluid	22 °C	100	90	80
Water/Glycol(50/50)	87 °C	95	80	80



4. Application Details

For Assembly

- For optimum performance surfaces should be clean and free of grease (internal and external).
- If the material is an inactive metal or the cure speed is too slow, use an activator.
- Assemble and tighten as required.
- **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.
- **For Press Fitted Assemblies**, apply adhesive thoroughly to both bond surfaces and assemble at high press on rates.
- **For Shrink Fitted Assemblies** the adhesive should be coated onto the pin, the collar should then be heated to create sufficient clearance for free assembly.

For Disassembly

- In circumstances where hand tools do not work, use localized heat to bolt or nut, disassemble while hot.

For Clean Up

- To remove cured product use a combination of solvent and abrasion such as a wire brush

5. Packaging

50 ml bottle

6. Shelf Life

Anaerobic adhesives shall be ideally stored in a cool, dry place in unopened containers at a room temperature between 8 °C to 21 °C. Please do not return any unused material to its original container. Shelf life is 12 months

7. Caution

Keep out of reach of children.

Avoid contact with skin and eyes. Use gloves before application

Keep out of freezing, direct sunlight and temperatures above 40°C

Do not try to remove forcibly.



8. Health and Safety

For more information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Material Safety Data Sheet containing, physical, ecological, and toxicological and other safety related data.