

## Technical Datasheet AT6.605

### Product Description

**BOSS AT6.605** is an oil tolerant medium strength threadlocker, that cures anaerobically to lock all types of metal threaded fasteners. **AT6.605** is designed for applications that require future disassembly with standard hand tools, and offers excellent temperature and solvent resistance once cured. **AT6.605** is also thixotropic, which aids assembly by reducing the migration of the liquid adhesive following application. This grade can even cure rapidly on plated, oily metal, or inactive surfaces.

### Typical Applications

**BOSS AT6.605**, is well suited to a number of applications including:

- Replacing lock washers and plastic inserts.
- Locking machine tool access bolts.
- Locking and sealing gear box and drive shaft bolts.
- Securing conveyor roller bolts.
- Locking bearing cover cap screws.

### Instructions For Use

1. For best results clean all surfaces with a cleaning solvent and allow to dry.
2. If the metal is inactive, (see Compatibility Chart), apply suitable **BOSS primer CX**
3. Shake the product thoroughly before application.
4. Apply the adhesive to the fixing position of the fastener or onto the internal threads of a blind hole.
5. Use suitable methods to assemble components, and tighten to required torque level.
6. Allow to cure fully before applying load.

### Properties of Uncured Material

Resin	Modified Acrylate
Colour	Blue
Viscosity @ 25°C	
Brookfield Sp 2 @ 20rpm	1300-3000 cps

### Performance of Cured Material

Fixture Speed	5 to 10 Minutes @ 25°C
Fixture Speed with Primer	<1 Second
Full Cure Time	24 hours @ 20°C
Typical Breakaway Strength	24 Nm
Typical Prevailing Strength	5 to 7 Nm
Gap Fill	0.04mm
Temperature Range	-53°C to 148°C

### Packaging

**BOSS AT6.605**, is available in 10ml, 50ml, 250ml LDPE bottles. In addition, we can offer automated dispensing lines for the bulk dispensing of this material.

### Storage & Shelflife

**BOSS AT6.605**, should be stored in a cool dry area, out of direct sunlight. Stored correctly, this grade can offer a 12 month shelf life from manufacture.