

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.

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 @ 20ºC
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.

The data, information and values contained in this Technical Data Sheet has been obtained by conducting various tests in a controlled laboratory environment, and should be used for guidance purposes only. Although we believe them to be reliable and accurate, users should always conduct their own tests in their specific working conditions to ensure that the product is suitable and effective for use. It is the users sole responsibility to determine the suitability of the product for the application. BOSS INDUSTRIAL cannot be held responsible for the results of procedures undertaken elsewhere, nor for the safeguarding of personnel or property, all of which is the duty of the user. Suitability of products or methods is discretionary. Therefore, warrantees or implied usage obligations should not be attributed to, and are not the responsibility of, BOSS INDUSTRIAL are not reliable for any financial loss or other damages incurred by the user as a result of the use of this product.

- Securing conveyor roller bolts.
- Locking bearing cover cap screws.