

PRODUCT DESCRIPTION

SELON 631 is a single component anaerobic product suitable for threaded metal parts against loosening from shock and vibrations. Product cures spontaneously and rapidly when confined in absence of air between close fitting metal surfaces with small gap fill. Selon 631 develops a very high resistance against de-installing. Product with low viscosity to seal micro porosity in cast parts. Very well also for the protection of smaller thread connections

PROPERTIES OF UNCURED MATERIAL

NATURE: Methacrylic Anaerobic Resin
APPLICATION: Threadlocker
STRENGTH: High
COLOR: Green
VISCOSITY 25°C
(Brookfield 20 rpm) : 80-120 mPa.s
SPECIFIC GRAVITY (g/ml): 1,06
FLASH POINT: >100°C
SHELF LIFE: 24 months at temperature +5 ° C to +28 ° C.
PRODUCT STORAGE: Cool and dry place

FEATURES OF CURED PRODUCT

HANDLING CURE TIME (initial curing time M10 x 20 - h 0,8 mm)
BRASS: 1- 3 minutes
ZINC: 8-12 minutes
STEEL: 9-14 minutes
BREAKAWAY TORQUE ISO-10964: 25-35 N.m
PREVAILING TORQUE ISO-10964: 30-40 N.m
FUNCTIONAL CURE TIME: 3-6 hours
FULL CURE TIME: 12-24 hours
TEMPERATURE RANGE: -50°C +150°C
MAX GAP FILL: 0,08 mm

Technical data referring to test in according to ISO 10964 on M10 x 20 qly 8.8 zinc nut and bolt (bolt 0,8 h) - at 25°C. Break torque after 24 hours

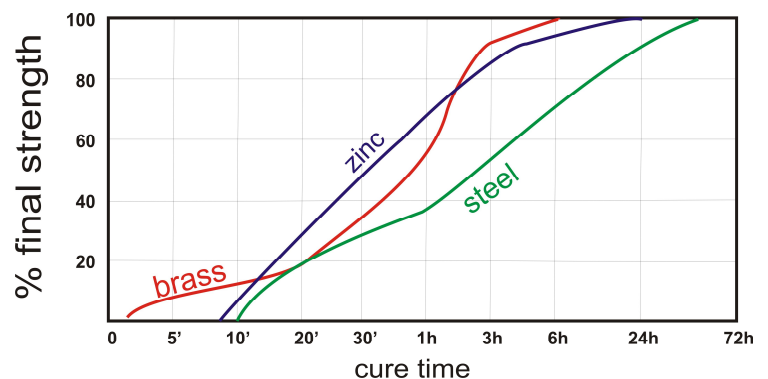
POLIMERIZATION INFORMATIONS

Curing time depend on main factors: kind of metals and gap fill dimension. The graph below shows the strength developed with time on some kind of metal. The different materials have been tested according to ISO 10964. The right temperature range of cure is from +20°C to +25°C. Low temperature from +5°C to +20°C increase curing time, higher temperature reduce polymerization time.

CHEMICAL RESISTANCE

Test method ISO 10964 (tested at 22°C)
Breakaway torque % after immersion (pre torque 5 N.m).

	T °C	100 h	500 h	1000 h
Water/Glycol	85	100	105	105
Brake Fluid	22	105	100	105
Motor Oil	125	100	110	110
Acetone	22	110	100	100
Gasoline	22	105	105	100



indicative values, nature,temperatures, large gaps, quality and size influence cure time

INSTRUCTION FOR USE

This product is not suitable for metal-plastic couplings and oxygen facilities as well as for the sealing of basic products or systems with strong oxidizing acids. Use only on standard metal threads. Surface must be clean and free of grease. For this, use the degreaser product Selon CLEANTEC 7500. Apply product to fill completely the gap (male and female parts), assemble parts and shut completely. A bland or superficial closure may cause leaks over time. Don't after tightening. Before operating the system to wait 24 hours to allow complete curing time of Selon sealant. In the case of series, locking the joint with a pipe wrench to avoid breaking the previous film in its formative stages. In case of passive surfaces and/or low temperature a fast cure can be obtained using Selon 7300 activator. Consult the MSDS before use.

GENERAL INFORMATION

The data contained in this document are provided for information purposes but are not specific supply even if they are considered as reliable products in our laboratories. TECNADE ensures consistent quality in relation to their own specifications. We can not take responsibility for results obtained by others where the methods of work are not under our direct control. It is your responsibility to verify the validity of the product characteristics in relation to its production needs and to take all necessary measures for the protection of people and things from the situations that may occur with the implementation of the product. TECNADE disclaims all express and / or tacit responsibility for damages of any kind, consequential or incidental inappropriate use of TECNADE product, including lost profits.