



KR38 Retaining Compounds High Strength

Kraken KR38 Retaining Compounds High Strength is a single component and solvent free feature. The products are specifically formulated for sealing, retaining, locking and bonding of metal or metal plated assemblies.

Advantages:

- It can be easily applied to threaded joints and removed easily with hand tools.
- The product fills high distance gaps and gives perfect results on wide-diameter (wider than 0.02 inch) applications.

Usage Areas:

- Can be used on all kinds of rough surfaces.
- Fills gaps in worn out joints.
- Fits bearings, prevents the dislocation.
- Fills smallest gaps due to its low viscosity and is used in sensitive fittings.
- Fits impellers and shafts together.
- Locks linings and boots to their beds and on the shaft.

How to use:

- Clean male and female threads before assembly with an absorbent tissue paper to remove any cutting oil.

- Apply the adhesive with a 360 turn to leading threads of the male and female fittings.
- Use an absorbent tissue paper to wipe off excess jointing compound in the direction of the thread.
- Assembly parts and hold on for 24 hours at 71,6-75,2°F to ensure full curing of jointing compound.
- For disassembly, use hand tools to remove mating parts. When it is hard to disassemble at room temperature, apply local heat until reaching 482°F and disassemble while hot. Then, remove any residual cured adhesive mechanically and clean parts with a proper solvent, acetone.

Limitations:

- Keep product in its original container at 71,6°F and avoid to contact with direct sunlight. Storage below 41°F and above 86°F can negatively affect product properties.
- Material removed from its original container can be contaminated during usage which affects both adhesive performance and storage life. Therefore, do not return contaminated product to the original container.



TECHNICAL DATA SHEET

www.krakenchem.com - info@krakenchem.com

Safety

Ensure good ventilation of the work station.
Wear personal protective equipment. Do not eat, drink or smoke when using this product.
Always wash hands after handling the product. Store in a well-ventilated place.
Keep cool. Check MSDS guidelines for disposal and further information concerning safety.

Shelf Life:

The shelf life is 36 months if stored in unopened-original package in a dry place.

Packaging (Weight/Volume):

1,69 fl oz.

Physical & Chemical Properties

General Properties;

Basis: Methacrylate ester

Consistency (Uncured): Liquid

Viscosity: Medium to High

Strength: High

Physical Properties of Uncured Adhesive;

Specific Gravity: (71,6°F) 1.04

Flash Point: (ASTM D56-05) >199°F

Temperature Range: -58°F to +302°F

Corrosivity: Non-corrosive

Viscosity: (ISO 2555 Brookfield RVT, spindle 3) 4000 - 4500 cPs

Gap Filling: up to 0.01 inch

Typical curing performance of adhesive

Curing Time at Room Conditions: Various type of curing time of adhesive on several substrates are given as follows. Note that

results can differ due to distance of bond gap and temperature.

Specimens: M10x25 bolt and proper nut
Condition: 71,6°F

Handling Time;

Brass: <60 secs

Steel: 5 to 7 mins

Stainless steel: 6 to 8 mins

Zinc plated steel: 5 to 15 mins

Aluminum: 20 to 35 mins

Average functional curing time: 1 to 3 hours

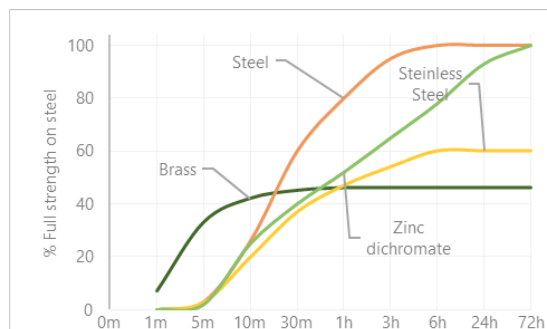
Average full curing time: 8 to 12 hours

Curing speed with different substrates: The curing rate of anaerobic adhesive greatly depends on type of surface material, substrate. The curing rate developed in time is determined by measuring breakaway torque of bolt and nut specimens. Test details and resultant graphs are given below.

Test Method: ISO 10964

Bolt and Nut Specs: M10x25

Condition: 71,6°F





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Typical performance of cured adhesive;
Test Method: ISO 10964
Specimens: Different type of nuts and bolts
Condition: 71,6°F

Cured for 24 hours;

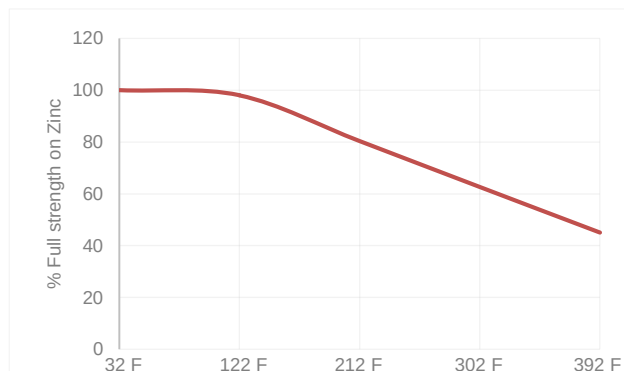
Type of specimen	Shear strength (N/mm ²)
Steel	26 N.m
Stainless Steel	28 N.m
Aluminium	17 N.m

Cured for 1 week;

Type of specimen	Shear strength (N/mm ²)
Steel	32 N.m
Stainless Steel	30 N.m
Aluminium	19 N.m

Resistance against Environmental Conditions;
Test Method: ISO 10123
Pin and collar specs: Steel
Curing Condition and Duration: 71,6°F, 1 week
Torque test conditions (exception is hot strength test): 71,6°F

Hot Strength: Strength is examined at various temperatures. The reference value of '% Full strength on zinc plated' is taken from previous tables corresponding 24 hours curing.



Heat Aging: Strength is examined on specimens that are aged at different temperatures. The reference value of '% Full strength on zinc plated' is taken from previous tables corresponding 24 hours curing.

