



**PRODUCT SPECIFICATIONS**  
**ULTRALOC®**  
**ADHESIVES & SEALANTS**

**ULTRALOC® 3680**  
**Retaining Compound**

ULTRALOC 3680 is a fast curing; high strength anaerobic retaining compound for cylindrical joints. This 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.

**Applications:**

- Ideal to fill gaps up to 0.15 mm diameter clearance.
- Retaining Sleeves, Pulleys, Gears, Rotors, and Fans on shafts.
- Mounting sleeves, Securing bushings, bearings and plugs in housings.
- Excellent retaining, sealing and thread locking compound.

**Physical Properties:**

Composition:	Methacrylate Esters
Color:	Green
Viscosity:	1,250 cps at 25 °C
Brookfield RVT Spindle 3 @ 20 rpm	
Specific Gravity:	1.1
Maximum Diameter of Thread/Gap Filling:	0.15 mm
Flash Point:	> 93 °C
Solvent Content:	None
Shelf Life:	1 year

**Curing Properties:**

Handling Cure Time:	5 - 10 minutes
Functional Cure Time:	1-3 hours
Full Cure Time:	24 hours
Shear Strength:	22 - 25 N/mm <sup>2</sup>
Locking Torque	
--Break	30 - 40 N.m
--Prevailing	55 - 70 N.m
--Temperature Range	-55 to 150 °C

**Chemical Resistance:**

Chemical	Temp.	% Initial Strength Retained	
		500 hours	1000 hours
Acetone	22 °C	100	100
Ethanol	22 °C	100	99
Motor Oil	125 °C	100	100
Gasoline	22 °C	100	100
Brake Fluid	22 °C	100	100
Water/Glycol	87 °C	93	97

**Application Method:**

Surfaces should be dry, clean, and free of any contamination. Anaerobic adhesive should be applied to the part in sufficient quantity to fill the gaps.

**Storage:**

Anaerobic adhesives shall be ideally stored in a cool, dry place in unopened containers at a room temperature between 10 °C to 22 °C. Please do not return any unused material to its original container.

**PACKAGING:**

10ml	P/No 368010
50ml	368050
250ml	368025

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**PRECAUTIONS:** This product and the auxiliary materials normally combined with it are capable of producing adverse health effects ranging from minor skin irritation to serious systemic effects. None of these materials should be used, stored, or transported until the handling precautions and recommendations as stated in the Material Safety Data Sheets (MSDS) for this and all other products being used are understood by all persons who will work with the material.

**Warranty:** All products purchased from or supplied by Molytec Australia are subject to terms and conditions set out in the contract. Molytec Australia warrants only that its product will meet those specifications designated as such herein or in other publications. All other information supplied by Molytec Australia is considered accurate but are furnished upon the express condition the customer shall make its own assessment to determine the product's suitability for a particular purpose. Molytec Australia makes no other warranty, either express or implied, including those regarding such other information, the data upon which the same is based, or the results to be obtained from the use thereof; that any product shall be merchantable or fit for any particular purpose; or that the