

Threadlocker

TECHNICAL DATA SHEET

02K70 high-strength

The product curing (polymerisation) is carried out under the exclusion of atmospheric oxygen (anaerobic) and the catalytic action of the metal (metal contact). The product is used to secure screws in the state as delivered, without cleaning. Fixes stud bolts, ball and antifriction bearings that typically do not have to be dismantled. Especially suited for highly stressed screw connections.



Trading units	Item no.:
10 ml bottle	02K70.F10
50 ml bottle	02K70.F50
250 ml bottle	02K70.F250

Physical Properties (liquid state)

Chemical characteristics:	Methacrylic Anaerobic Resin	
Colour:	Green / fluorescent	
Viscosity:	400 – 700 mPas	25°C Brookfield LV spindle 62; 30U/min
Density:	1.07 – 1,11 g/ml	
Max. clearance:	M 20	
Flash point:	> 100°C	
Working temperature:	optimal at 23°C	
Storage:	Cool and dry	
Shelf life:	12 months at optimum temperature +23°C	

Physical Properties (Cured state)

Handling cure time:	5 – 10 minutes
Functional cure time:	3 – 6 hours
Full cure time:	12 – 24 hours
Breakaway torque:	30 – 50 Nm
Prevailing torque:	30 – 50 Nm
Temperature range:	- 55°C up to + 150°C

Measured on M10 x 20 - quality 8.8 zinc nut - and bolt 0.8d (without initial load), after 24 hours.

Chemical Resistance

Due to the huge amount of data, you can find a wide range of proved materials on our homepage www.gluetec-industrieklebstoffe.de. In this overview you can find several chemicals and gases which are commonly used in industry.

The list of resistance is based on years of practical experience, on laboratory experiments and on the behaviour of similar plastics. The list should just give a hint, if the probability of resistance is given. Self tests by the end-consumer can not be replaced by the list, due to the different operating conditions.

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Usage instructions

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 WIKO Industrial Fast Cleaner. Apply product to fill the gap completely (male and female parts), assemble parts and shut completely. A bland or superficial closure may cause leakage over time. Don't move after tightening. Before operating the system to wait 24 hours to allow complete curing time. In the case of serial products, 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 WIKO Activator Anaerobic. Consult the MSDS before use. By usage of an activator the curing values may drop by 15%.

The information contained in this data sheet, especially the suggestions for processing and application of products, is based on our experience and newest expertise. Due to the facts that materials can be very diverse and that we have no influence on the working conditions, we recommend to perform sufficient tests to validate the compatibility of the products. Our company shall neither be held liable for this information nor for a verbal or written consultation. Additionally, please consider the information of our safety data sheets.