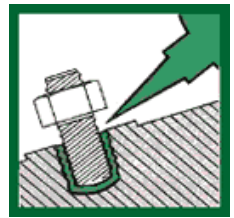


THREADLOCKING

For locking studs, nuts, screws and all threaded fasteners. Loosening from vibration or shock is prevented and thread corrosion is eliminated. They seal against leakage of oils, water, liquid and gas. The choice table meets right product demand on basis of requested strength and diameter or tolerance of the connections.



PRODUCT	Class of locking *	Max. diameter of thread	Max. gap filling	Viscosity 25°C mPa.s (LT - MT - HT)	Color **	Curing time		Locking torque N.m		Shear strength N/mm ²	Temperature range (°C)
						handling (minutes)	functional (hours)	breakaway	prevailing		
24-18	1	M24 - 15/16"	0,20mm - .008"	1000 MT	Violet/F	15 - 30	1 - 3	4 - 8	2 - 4	3 - 5	-55 +150
54-03	2	M24 - 15/16"	0,20mm - .008"	1000 MT	Blue/F	10 - 20	1 - 3	14 - 18	5 - 8	8 - 12	-55 +150
55-03	2	M36 - 1-13/32"	0,25mm - .010"	2000 - 7500 MT	Blue/F	10 - 20	1 - 3	17 - 22	8 - 12	9 - 13	-55 +150
55-04	2	M36 - 1-13/32"	0,25mm - .010"	1500 - 6500 MT	Red/F	10 - 15	1 - 3	20 - 25	40 - 55	10 - 15	-55 +150
70-14	3	M5 - 13/64"	0,07mm - .003"	10 - 20 LT	Green/F	10 - 20	1 - 3	15 - 25	30 - 40	8 - 12	-55 +150
83-54	3	M20 - 25/32"	0,15mm - .006"	500 LT	Green/F	10 - 20	1 - 3	28 - 35	50 - 65	15 - 20	-55 +150
83-55	3	M20 - 25/32"	0,15mm - .006"	500 LT	Red/F	10 - 20	1 - 3	28 - 35	50 - 65	15 - 20	-55 +150
86-72	3	M56 - 2-3/16"	0,30mm - .012"	8000 - 15000 MT	Red/F	20 - 40	3 - 6	20 - 35	40 - 70	15 - 25	-55 +230

LEGEND

CLASS OF LOCKING:

- 1- Low, easy to dismantle
- 2- Medium, possible to dismantle
- 3- High, permanent locking.

VISCOSITY BROOKFIELD:

- HT- High thixotropy
- MT- Medium thixotropy
- LT- High thixotropy

LOCKING TORQUE:

- Bolt M10 x 20
- Quality 8,8
- Nut = 0,8d

COLOR:

- F = Fluorescent under blue light

SUGGESTED APPLICATIONS

- 24-18** Low strength anaerobic adhesive for thread locking of nuts, bolts and screws of all types that require to be easily dismantled. Highly resistant to heat, corrosion, vibrations, water, gases, oils, hydrocarbons and many chemicals.
- 54-03** Medium strength anaerobic adhesive for thread locking of nuts and bolts of all types that require to be dismantled. Lubricating effect on screwing. Highly resistant to heat, corrosion, vibrations, water, gases, oils, hydrocarbons and many chemicals.
- 55-03** Medium strength anaerobic adhesive for thread locking of nuts and bolts of all types that require to be dismantled. Lubricating effect on screwing. Suitable to be used on oily surfaces. Highly resistant to heat, corrosion, vibrations, water, gases, oils, hydrocarbons and many chemicals. Approved for potable water (KTW - DVGW). Approved for gas (DVGW nr. NG-5146AU0399) European norm EN 751-1.
- 55-04** Medium viscosity anaerobic adhesive for thread locking of large diameter studs, nuts and bolts of all types that require to be dismantled. Highly resistant to heat, corrosion, vibrations, water, gases, oils, hydrocarbons and many chemicals.
- 70-14** Low viscosity and high capillary action for locking and sealing threaded fasteners and close fittings parts after assembly, also to penetrate and seal metal porosity in moulds and castings. Medium to high strength locking. Highly resistant to heat, corrosion, vibrations, water, gases, oils, hydrocarbons and many chemicals.
- 83-54** High strength anaerobic adhesive for locking and sealing of studs, nuts, bolts and threaded fasteners not requiring dismantling. High torque strength. Highly resistant to heat, corrosion, vibrations, water, gases, oils, hydrocarbons and many chemicals.
- 83-55** High strength anaerobic adhesive for locking and sealing of studs, nuts, bolts and threaded fasteners not requiring dismantling. Highly resistant to heat, corrosion, vibrations, water, gases, oils, hydrocarbons and many chemicals. Specially formulated for oily surfaces.
- 86-72** Very high temperature resistant (+230°C), high strength anaerobic adhesive for locking and sealing thread connections and fitted parts. High viscosity and thixotropic effect allows larger tolerances. Highly resistant to corrosion, vibrations, water, gases, oils, hydrocarbons and many chemicals. DIN DVGW approved thread sealant for gas (according to DIN EN 751-1 Reg. Nr. NG - 5146AT0264).

