

WEICONLOCK® AN 302-50 Locking of Threads and Stud Bolts



Locking of threads and stud bolts

- medium viscosity
- high strength
- hard to disassemble

Technical Data

Colour	transparent	
Fluorescent	yes	
For thread connections up to	M 20 R ¾"	
Viscosity	500 nt mPa·s	
Gap bridging up to max.	0,15 mm	
Breakaway torque	30 - 35 Nm	
Prevail torque	55 - 70 Nm	
Shear strength Nmm ² (DIN 54452)	25 - 35 N/mm ²	
Handling strength	(35 % strength)	2 - 5 min.
Final strength	(100 % strength)	2 - 4 h
Temperature resistance	-60°C to +175°C	
Minimum shelf life	at room temperature	24 mon.
Compressive strength (free cutting steel / grub screw = 8.8)		
M 3x6	max.	1500 bar
M 4x6	max.	1500 bar
M 5x8	max.	1300 bar
M 6x10	max.	800 bar
M 8x12	max.	600 bar
M 10x16	max.	500 bar

Approvals / Guidelines

ISSA Code	53.402.13
IMPA Code	450827
MIL-Spec	complies with MIL-T-83523

Surface Pre-Treatment

To achieve optimum results, the mounting parts should be degreased and cleaned, e.g. with WEICON Surface (roughen the surfaces, if required). WEICONLOCK can also be used on uncleaned surfaces, e.g. screws as delivered. However, the cleaner the surface, the better the results achieved.

Application

WEICONLOCK is applied evenly straight from the Pen with the help of the dosing tip; avoid direct contact between dosing tip /metal. For sealing applications, apply WEICONLOCK to the thread in circles. Assemble parts and screw tight. Do not pour any WEICONLOCK back into the bottle that has already come into contact with metal. Even extremely small metal particles cause the adhesive to cure inside the bottle. Therefore, in serial production, the use of dosing devices is recommended.

Storage

Store WEICONLOCK in the unopened original container at room temperature. Avoid sources of heat and direct sunlight. The air inside the packaging helps maintain storage stability.

Instructions for use

When using WEICON products, the physical, safety-related, toxicological and ecological data and regulations in our EC safety data sheets (www.weicon.com) must be observed.

Accessories

- 10021433 Activator F, 200 ml, green
- 10001256 Dosing Tip, 1 PCE

Available sizes

- 10019897 WEICONLOCK® AN 302-50 Locking of Threads and Stud Bolts, 20 ml, transparent
- 10019929 WEICONLOCK® AN 302-50 Locking of Threads and Stud Bolts, 50 ml, transparent
- 10019972 WEICONLOCK® AN 302-50 Locking of Threads and Stud Bolts, 200 ml, transparent

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Note

The specifications and recommendations given in this technical data sheet must not be seen as guaranteed product characteristics. They are based on our laboratory tests and on practical experience. Since individual application conditions are beyond our knowledge, control and responsibility, this information is provided without any obligation. We do guarantee the continuously high quality of our products. However, own adequate laboratory and practical tests to find out if the product in question meets the requested properties are recommended. A claim cannot be derived from them. The user bears the only responsibility for non-appropriate or other than specified applications.

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