WEICON

WEICONLOCK®

WEICONLOCK® AN 302-77 Pipe and thread sealing



Pipe and thread sealing for large thread parts and flanges

- · higher viscosity
- · high strength
- · hard to disassemble

Technical Data

Colour		red
Fluorescent		yes
For thread connections up to		M 36
Viscosity		6.000 mPa⋅s
Gap bridging up to max.		0,25 mm
Breakaway torque		30 - 40 Nm
Prevail torque		10 - 15 Nm
Shear strength Nmm² (DIN 54452)		10 - 20 N/mm ²
Handling strength		40 - 60 min.
Final strength	(100 % strength)	6-12 h
Temperature resistance		-60 °C to +150 °C
Minimum shelf life	at room temperature	24 mon.
Compressive strength (free cu	utting steel / grub screw = 8.8)	
M 3x6	max.	1500 bar
M 4x6	max.	1500 bar
M 5x8	max.	1500 bar
M 6x10	max.	500 bar
M 8x12	max.	400 bar
M 10x16	max.	300 bar
Annroyals / Guidelines		

Approvals / Guidelines

ISSA Code		53.402.27
IMPA Code		450832
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.

Pipe and thread sealant

Application

WEICONLOCK is applied evenly straight from the Pen with the help of the dosing tip; avoid direct contact between dosing tip/metal. Apply WEICONLOCK to the thread in circles. Screw the pipe thread together and tighten it to the desired alignment. When used as flange sealing, apply a continuous bead to one flange side, then assemble parts quickly 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 Dosing Tip, 1 PCE 10001256

Available sizes

10019989 WEICONLOCK® AN 302-77 Pipe and thread

sealing, 200 ml, red WEICONLOCK® AN 302-77 Pipe and thread 10019935

sealing, 50 ml, red



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 requested properties are recommended. A claim cannot be derived from them.