

# WEICONLOCK® AN 305-77 Thread Sealing



Nonfood Compounds  
Program Listed S2  
Registration 159910

Threadsealing | drinking water and DVGW approval | BAM

- high viscosity
- medium strength
- disassembly with normal tools

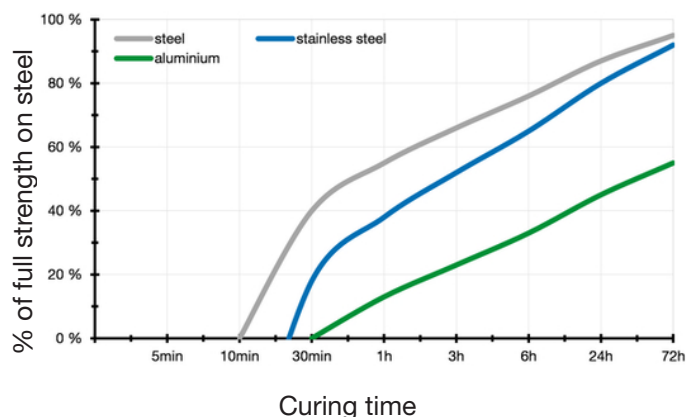
## Technical Data

Colour	yellow
Fluorescent	yes
For thread connections up to	M 80 R 3"
Viscosity	24.000 - 70.000 ht mPa·s
Gap bridging up to max.	0,5 mm
Breakaway torque	18 - 22 Nm
Prevail torque	10 - 14 Nm
Shear strength Nmm <sup>2</sup> (DIN 54452)	6 - 13 N/mm <sup>2</sup>
Handling strength	15 - 30 min.
Final strength (100 % strength)	1-3 h
Temperature resistance	-60 °C to +150 °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.	1500 bar
M 6x10 max.	800 bar
M 8x12 max.	700 bar
M 10x16 max.	500 bar

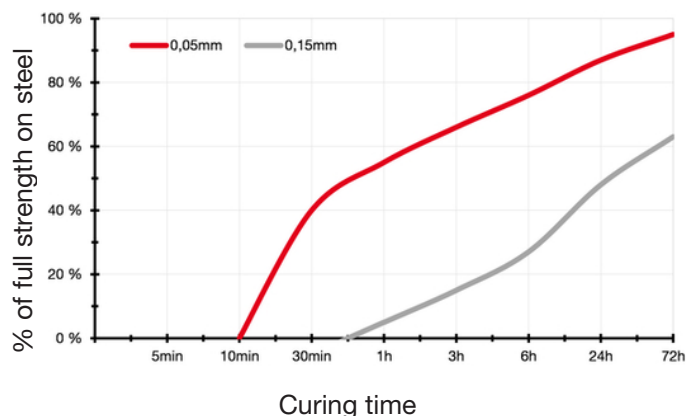
## Approvals / Guidelines

NSF	S2 (FDA 21 CFR)
BAM	DIN EN 1797
WRAS	BS 6920-1:2000
Hygiene Institute	UBA KTW-BWGL
DVGW	DIN EN 751-1
AGA	AS 4623-2008
ISSA Code	75.628.13/14
IMPA Code	815214/15
MIL-Spec	complies with MIL-T-83523

## Reaction rate of various materials



## Reaction rate at different gaps



## 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.

## 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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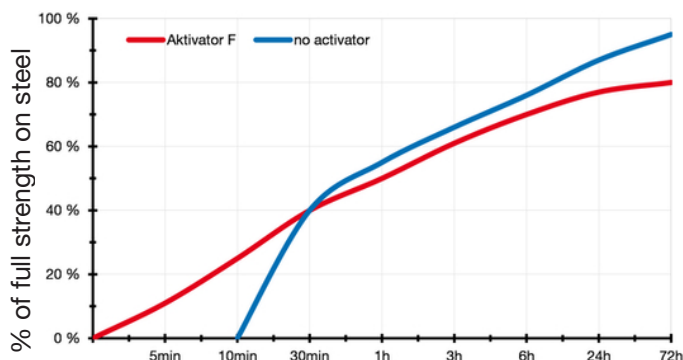
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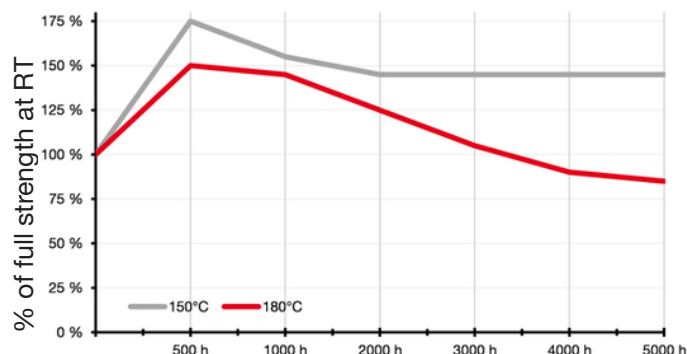
## Pipe and thread sealant

### Reaction with activator F



Curing time

### Heat aging



Time

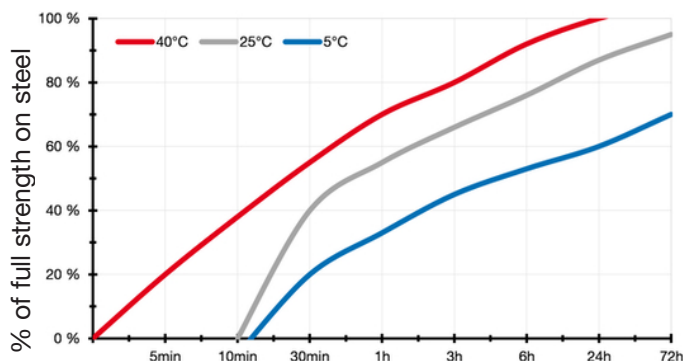
### Application

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.

### Instructions for use

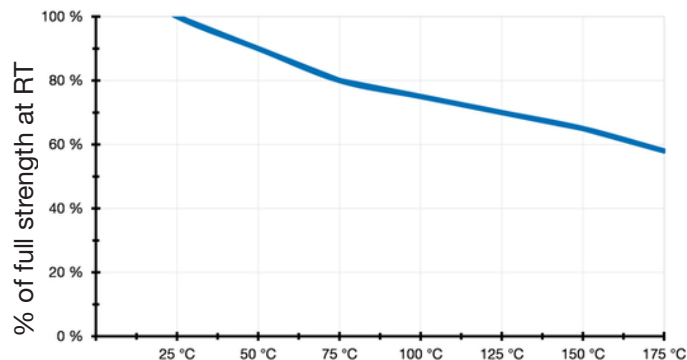
When using WEICON products, the physical, safety-related, toxicological and ecological data and regulations in our EC safety data sheets (www.weicon.com) must be observed.

### Reaction speed at temp.



Curing time

### Strength in heat



### Accessories

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

### Available sizes

- 10019949 WEICONLOCK® AN 305-77 Thread Sealing, 50 ml, yellow
- 10020011 WEICONLOCK® AN 305-77 Thread Sealing, 200 ml, yellow
- 10034148 WEICONLOCK® AN 305-77 Thread Sealing, 300 ml, yellow

### 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.

To the product detail page:



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