

# WEICONLOCK® AN 306-01 Retaining Cylindrical Assemblies



## Retaining cylindrical assemblies for bearings | shafts and bushings

- low viscosity
- high strength
- hard to disassemble

### Technical Data

Colour	green
Fluorescent	yes
For thread connections up to	M 12
Viscosity	125 nt mPa·s
Gap bridging up to max.	0,1 mm
Breakaway torque	25 - 30 Nm
Prevail torque	50 - 60 Nm
Shear strength Nmm <sup>2</sup> (DIN 54452)	17-22 N/mm <sup>2</sup>
Handling strength	10 - 20 min.
Final strength (100 % strength)	2-4 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.	900 bar
M 8x12 max.	800 bar
M 10x16 max.	500 bar

### Approvals / Guidelines

ISSA Code	75.628.15/16/17
IMPA Code	815216/17/18
MIL-Spec	complies with MIL-A-46106 MIL-A-46146

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### 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. In the case of pressed joints and larger parts to be joined, both surfaces should always be wetted thinly and evenly. Join parts swiftly. For sliding seats, twist parts against each other when joining for optimum spreading of the adhesive. Bonded parts should not be moved until handling strength is reached. 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](http://www.weicon.com)) must be observed.

### Accessories

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

### Available sizes

10017880	WEICONLOCK® AN 306-01	Retaining Cylindrical
10020017	Assemblies, 50 ml, green WEICONLOCK® AN 306-01	Retaining Cylindrical
10020045	Assemblies, 200 ml, green WEICONLOCK® AN 306-01	Retaining Cylindrical
	Assemblies, 20 ml, green	

#### 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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