

# WEICONLOCK® AN

## 306-38 Retaining Cylindrical Assemblies



Retaining cylindrical assemblies for bearings, gear wheels and bolts | fast cure | drinking water approval

- medium viscosity
- high strength
- hard to disassemble

#### Technical Data

Colour	green
Fluorescent	yes
For thread connections up to	M 36
Viscosity	2.500 mt mPa·s
Gap bridging up to max.	0,2 mm
Breakaway torque	35 - 45 Nm
Prevail torque	50 - 70 Nm
Shear strength Nmm <sup>2</sup> (DIN 54452)	25 - 30 N/mm <sup>2</sup>
Handling strength	5 min.
Final strength (100 % strength)	1-3 h
Temperature resistance	-60°C to +150°C
Minimum shelf life	at room temperature
Compressive strength (free cutting steel / grub screw = 8.8)	24 mon.
M 3x6	max.
M 4x6	max.
M 5x8	max.
M 6x10	max.
M 8x12	max.
M 10x16	max.

#### Approvals / Guidelines

Hygiene Institute	UBA KTW-BWGL
ISSA Code	75.628.18/19/20
IMPA Code	815222/23/24
MIL-Spec	complies with MIL-A-46106 MIL-A-46146

#### 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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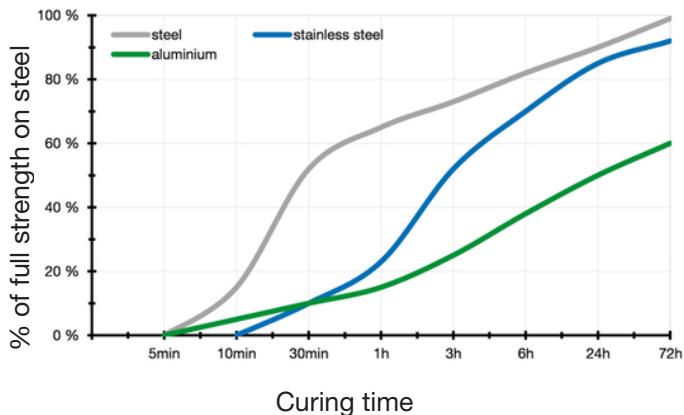
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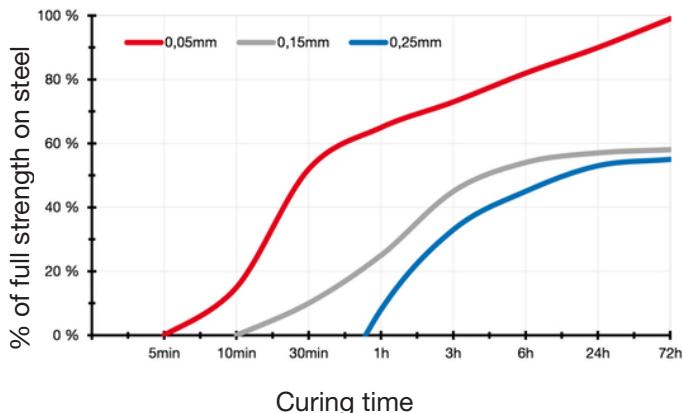
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## WEICONLOCK® Retaining Cylindrical Assemblies

### Reaction rate of various materials



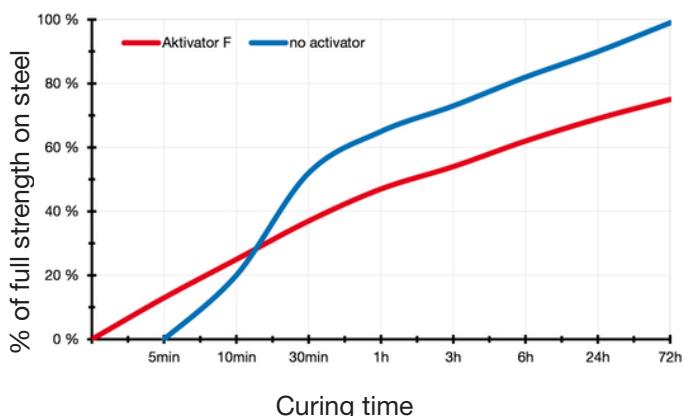
### Reaction rate at different gaps



### 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 uncleared surfaces, e.g. screws as delivered. However, the cleaner the surface, the better the results achieved.

### Reaction with activator F



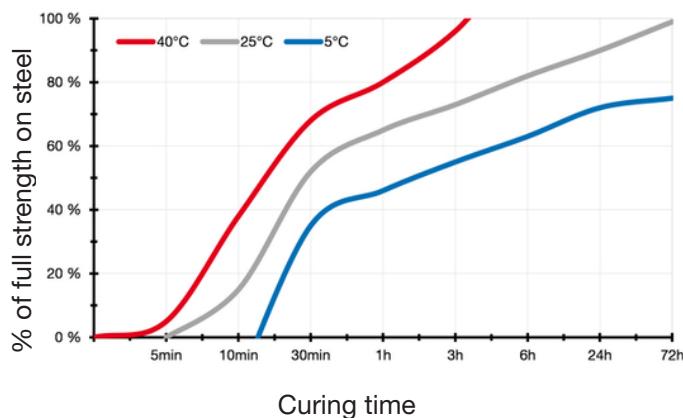
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## 306-38 Retaining Cylindrical Assemblies

### 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.

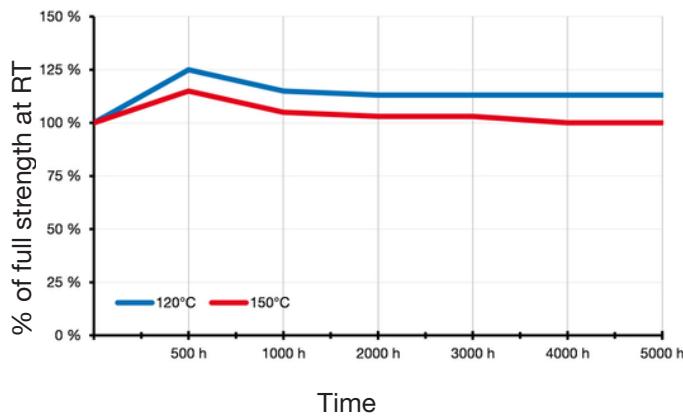
### Reaction speed at temp.



### 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.

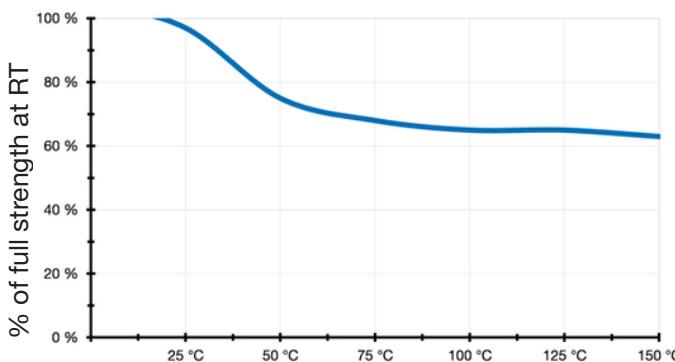
### Heat aging



### 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.

### Strength in heat



### Accessories

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

### Available sizes

10016443 WEICONLOCK® AN 306-38 Retaining Cylindrical Assemblies, 20 ml, green  
 10030478 WEICONLOCK® AN 306-38 Retaining Cylindrical Assemblies, 10 ml, green  
 10017888 WEICONLOCK® AN 306-38 Retaining Cylindrical Assemblies, 50 ml, green  
 10020027 WEICONLOCK® AN 306-38 Retaining Cylindrical Assemblies, 200 ml, green

To the product detail page:



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