

WEICONLOCK® AN 306-48 Retaining Cylindrical Assemblies



Retaining cylindrical assemblies | high-temperature-resistant | BAM

- medium viscosity
- high strength
- hard to disassemble

Technical Data

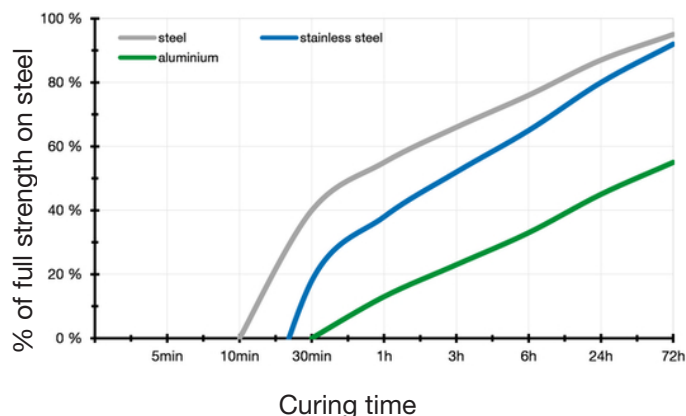
| | | |
|--|---------------------|----------|
| Colour | green | |
| Fluorescent | yes | |
| For thread connections up to | M 20 R ¾" | |
| Viscosity | 550 nt mPa·s | |
| Gap bridging up to max. | 0,15 mm | |
| Breakaway torque | 30 - 35 Nm | |
| Prevail torque | 55 - 77 Nm | |
| Shear strength Nmm² (DIN 54452) | 25 - 35 N/mm² | |
| Handling strength | 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. | 1250 bar |
| M 6x10 | max. | 800 bar |
| M 8x12 | max. | 600 bar |
| M 10x16 | max. | 500 bar |

Approvals / Guidelines

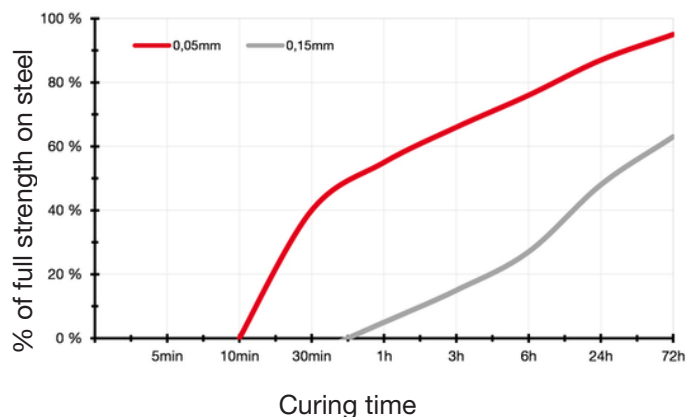
| | |
|-------------------|---------------------------------------|
| Hygiene Institute | UBA KTW-BWGL |
| MIL-Spec | complies with MIL-A-46106 MIL-A-46146 |

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Reaction rate of various materials



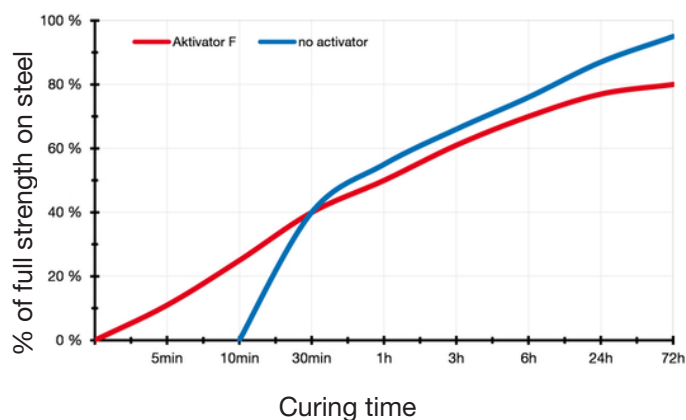
Reaction rate at different gaps



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.

Reaction with activator F



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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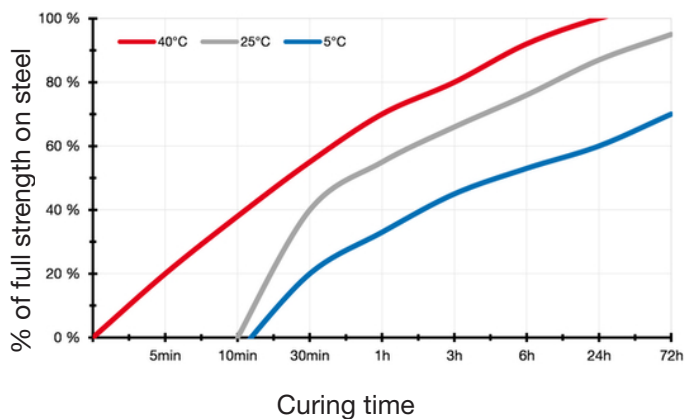
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Application

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.

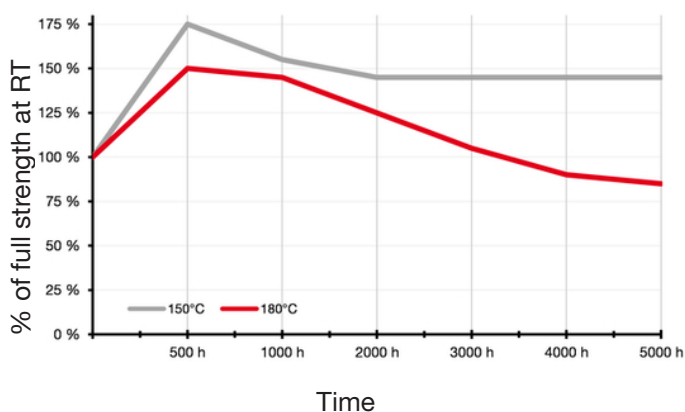
Reaction speed at temp.



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.

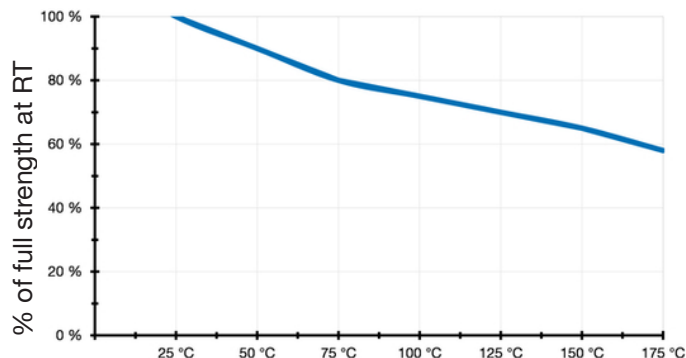
Heat aging



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) must be observed.

Strength in heat



Accessories

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

Available sizes

- 10016442 WEICONLOCK® AN 306-48 Retaining Cylindrical Assemblies, 20 ml, green
- 10017893 WEICONLOCK® AN 306-48 Retaining Cylindrical Assemblies, 50 ml, green
- 10020035 WEICONLOCK® AN 306-48 Retaining Cylindrical Assemblies, 200 ml, green

To the product detail page:



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