

Threadlocker

TECHNICAL DATA SHEET

02K75 high-strength and heat-resistant

The product curing (polymerisation) is carried out under the exclusion of atmospheric oxygen (anaerobic) and the catalytic action of the metal (metal contact). High-strength product for highly stressed screw connections. The product is used to fixate and seal screws, stud bolts, nuts, thread inserts and thread plugs against impact, vibration and corrosion. Depending on the thread diameter, the product is difficult to dismantle or even impossible to dismantle.



Trading units	Item no.:
50 ml bottle	02K75.F50
250 ml bottle	02K75.F250

Liquid Properties

Chemical characteristics:	Methacrylic anaerobic resin	
Colour:	Red	
Viscosity:	10,000 – 15,000 mPas	25 °C Brookfield LV spindle 64; 6 U/min
Specific gravity:	1,05 – 1,09 g/ml	
Max. clearance:	M 36	
Flash point:	> 100°C	
Working temperature:	optimal at 23 °C	
Storage:	cool and dry	
Shelf life:	12 months at optimum temperature 23°C	

Physical Properties (Cured state)

Measured on M10 x 20 - quality 8.8 zinc nut - and bolt 0.8d (without initial load), after 24 hours.

Handling cure time:	20 – 40 minutes
Functioning:	3 – 6 hours
Full cure time:	12 – 24 hours
Breakaway torque:	30 – 50 Nm
Prevailing torque:	30 – 50 Nm
Temperature range:	- 50°C up to + 200°C

Chemical Resistace

Due to the huge amount of data, you can find a wide range of proved materials on our homepage www.gluetec-industrieklebstoffe.de. In this overview you can find several chemicals and gases which are commonly used in industry.

The list of resistance is based on years of practical experience, on laboratory experiments and on the behaviour of similar plastics. The list should just give a hint, if the probability of resistance is given. Self tests by the end-consumer can not be replaced by the list, due to the different operating conditions.

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Instruction For Use

This product is not suitable for metal-plastic couplings and oxygen facilities as well as for the sealing of basic products or systems with strong oxidizing acids. Use only on standard metal threads. Surface must be clean and free of grease. For this, use the degreaser product WIKO Industrial Fast Cleaner. Apply product to fill the gap completely (male and female parts), assemble parts and shut completely. A bland or superficial closure may cause leakage over time. Don't move after tightening. Before operating the system to wait 24 hours to allow complete curing time. In the case of serial products, locking the joint with a pipe wrench to avoid breaking the previous film in its formative stages. In case of passive surfaces and/or low temperature a fast cure can be obtained using WIKO Activator Anaerobic. Consult the MSDS before use. By usage of an activator the curing values may drop by 15%.

The information contained in this data sheet, especially the suggestions for processing and application of products, is based on our experience and newest expertise. Due to the facts that materials can be very diverse and that we have no influence on the working conditions, we recommend to perform sufficient tests to validate the compatibility of the products. Our company shall neither be held liable for this information nor for a verbal or written consultation. Additionally, please consider the information of our safety data sheets.