WEICONLOCK®
Anaerobic Adhesives and Sealants

WEICONLOCK® AN 302-80 Pipe and thread sealing

Pipe and thread sealing for passive materials | drinking water approval

· higher viscosity

· high strength

· hard to disassemble

Technical Data

Colour		green
Fluorescent		yes
For thread connections up to		M 36
Viscosity	+25 °C Brookfield	3.000 - 6.000 mt mPa·s
Gap bridging up to max.		0,2 mm
Breakaway torque		15 - 20 Nm
Prevail torque		25 - 30 Nm
Shear strength Nmm² (DIN 54452)		20 - 30 N/mm²
Handling strength	at room temperature	5 - 10 min.
Final strength	(100 % strength)	6-12 h
Temperature resistance		-60°C to +200°C
Compressive strength (free cutting steel / grub screw = 8.8)		
M_3x6	max.	1500 bar
M_4x6	max.	1500 bar
M_5x8	max.	1300 bar
M_6x10	max.	800 bar
M_8x12	max.	600 bar
M_10x16	max.	300 bar

Approvals / Guidelines

Hygiene Institute	UBA KTW-BWGL
ISSA Code	53.402.05
IMPA Code	450805

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.

Processing

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.

Storage

WEICONLOCK has a shelf life of at least 24 months, when stored at room temperature in closed original container. Protect from heat sources and direct sunlight. The air contained in the Pen keeps WEICONLOCK liquid.

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.

Accessories

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

Available sizes

10019991 WEICONLOCK® AN 302-80 Pipe and thread sealing, 200 ml, green
10019903 WEICONLOCK® AN 302-80 Pipe and thread sealing, 20 ml, green
10017875 WEICONLOCK® AN 302-80 Pipe and thread sealing, 50 ml, green

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