



Weiconlock AN 302-21 Threadlocker

Weiconlock AN 302-21 is a high quality grade of anaerobic adhesive designed specifically for threadlocking and sealing applications. This grade is violet in colour and has a low viscosity which allows for very fast application. It cures with low strength to form bonds that can be easily disassembled when required.

AN 302-21 is typically used on smaller gauge threads (up to M 12).

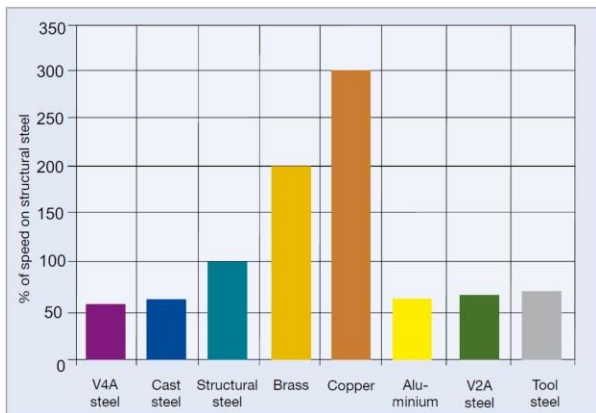
Properties

Colour	Violet
For Threaded Joints Up To	M 12
Viscosity at 25°C Brookfield	125 MPa
Gap Filling Capacity (Max.)	0.1mm
Breakaway Strength (Thread)	7 – 10 Nm
Prevailing Strength (Thread)	3 – 6 Nm
Shear Strength (DIN 54452)	4 – 7 N/mm ²
Handling Strength At Room Temperature	10 – 20 Minutes
Final Strength At Room Temperature	3 – 6 Hours
Temperature Resistance	-60°C to +150°C

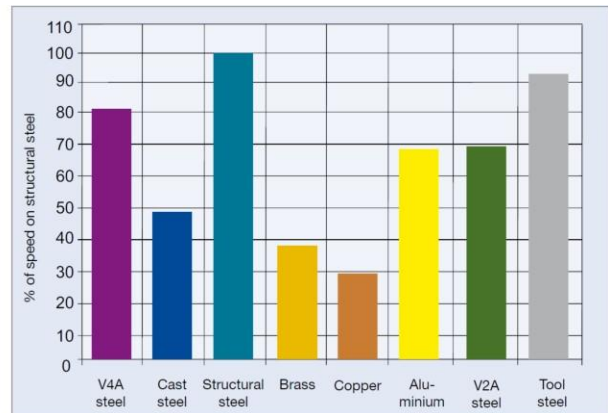
Weiconlock Adhesives General Information

All grades of Weiconlock are high quality anaerobic adhesives based on specialised methacrylate resins. While the grades differ in cure time, temperature resistance, cure strength, colour, viscosity and more; one thing that unites them is the fact that they only cure when in contact with metal and deprived of air. This special feature allows Weiconlock adhesives to be very easy to use as there's essentially no pot life.

As liquid adhesives, Weiconlock adhesives completely fill any gaps and thus protect against leakage and fretting corrosion. Once cured, these high quality adhesives form a shock and vibration resistant joint with excellent resistance to chemicals and solvents.



General Curing Speed of Weiconlock Depending on Material



Compression Shear Strength of Weiconlock Depending on the Metal (DIN 544521)

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Important

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Weiconlock General Chemical Resistance Table

Acetaldehyde	+	Ethylene Dichloride	+	Perchloroethylene (Dry)	+
Acetate Solvent	+	Ethylene Glycol	+	Perchloric Acid (10%)	%+
Acetic Acid (10%)	%+	Fatty Acids	+	Permanganic	-
Acetic Acid (80%)	%O	Ferrous Sulphate	+	Peroxide Bleaching	+
Acetone	+	Formaldehyde (Cold)	+	Peroxy	-
Alcohols	+	Formic Acid (Cold)	+	Persulphuric (10%)	%+
Alkaline Solution	+	Freon	+	Phenol	+
Ammoniac Anhydride	-	Fuel Oil	+	Phenolic Resins	+
Ammonium Hydroxide	O	Fuming Nitric Acid	-	Phosphoric Acid 10% Hot	O
Amyl Acetate	+	Fuming Sulphuric Acid	-	Phosphoric Acid 10% Cold	+
Aniline	+	Gasoline	+	Phosphoric Acid 50% Hot	O
Aromatic Gasoline	+	Glycolic Acid	+	Phosphoric Acid 50% Cold	O
Aromatic Solvent	+	Glycerine	+	Phosphoric Acid 85% Hot	-
Ash Slurry	+	Grease Lubrication	+	Phosphoric Acid 85% Cold	O
Barium Sulphate	+	Hydrogen Bromide (10%)	%+	Phthalic	+
Battery Acid (10%)	%+	Hydrocyanic Acid (10%)	%+	Potash Alum	+
Benzene	+	Hydrogen	+	Potassium Acetate	+
Benzoic Acid	+	Hydrogen Peroxide Concentrate	O	Potassium Hydroxide	-
Boric Acid	+	Hydrofluoric Acid	-	Pyridine	+
Brake Fluid	+	Heptane	+	River Water	+
Butadiene	+	Hydrazine	+	Sewage	+
Butyric (10%)	%+	Hydrochloric Acid	O	Sea Water	+
Butylaldehyde	+	Isocyanate Resin	+	Silicone Oils	+
Butylamine	+	Isooctane	+	Sorbitol	+
Butyl Acetate	+	Ketones	+	Steam Sterilisation	+
Butyl Chloride	+	Lithium Chloride	+	Styrene	+
Cadmium Sulphate	+	Maleic	+	Sulfones	+
Castor Oil	+	Melamine Resin	+	Sulfonic Acids (10%)	%+
Cellulose Acetate	+	Mercaptan, Thioalcohol	+	Sulphuric Acid (75-100%)	%-
Chinon	+	Methane	+	Sulphur Mud Solution in Carbon Disulphide	+
Chlorine (Dry)	-	Methylamine	+	Sulphurous Acid	O
Chlorine Alcohol	+	Methyl Ethyl Ketone	+	Sulphuric Acid (75%)	%O
Chloramine	+	Mineral Oil, White	+	Turpentine	+
Chlorine Dioxide	O	Mine Water	+	Thiourea	+
Chlorinated Hydrocarbon	+	Naphtha, Petroleum	+	Toulene, Methylbenzene	+
Chloroform (Dry)	+	Naphthalene	+	Trichloroethane	+
Coal Tar	+	Natronhydroxyd 20% hot	%O	Trichloromethane	+
Copper Chloride	+	Natronhydroxyd 20% cold	%+	Trioxane	+
Copper Sulphate	+	Natronhydroxyd 50% hot	%-	Vapor Pressure (Low)	+
Cold Salt Water	+	Natronhydroxyd 50% cold	%O	Vaseline	+
Developer Liquid	+	Natronhydroxyd 70% hot	%-	Vinyl Acetate	+
Dichloroethylether	+	Natronhydroxyd 70% cold	%O	Wax	+
Diethyl ether	+	Nitric Acid (20%)	%+	Xylene, Dimethylbenzene	+
Diglycollic	+	Oils	+		
Dioxane (Dry)	+	Oxalic Acid	+		
Emulsified Oils	+	Paraffin Oil, Kerosene	+		
Ethyl Acetate	+				
Ethylenediamine	+				

+ = Good Resistance

O = Preliminary Tests or Resistance Tests are Recommended

% = Weiconlock adhesives are resistant only up to the indicated concentration

- = Weiconlock adhesives are not suitable, or may be used only after thorough preliminary tests

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Preparation of the Surface

In general, Weiconlock adhesives do not require special surface pre-treatment as slightly oil surfaces (e.g. on 'as received' parts) will be tolerated. However, best results will be achieved if Weiconlock is used on parts that are cleaned and degreased (Cleaner S may be ideal). If required, the parts should be slightly roughened.

Application

Weiconlock AN 302-21 is ready for use and should be applied evenly directly from the bottle/tube with the dispensing tip (avoid direct contact of tip with metal). On press fitted parts and larger cylindrical assemblies a thin uniform layer should be applied to both surfaces. In the case of blind threaded holes, dispense a sufficient quantity into the bore hole. On screws and bolts, apply AN 302-21 around the thread.

Do not pour any Weiconlock fluid that has had contact with metal back into the bottle. Even the smallest metal particles will cause the content of the bottle to cure. In series construction, the use of manual or automatic applicators is possible.

Physiological properties / health and safety at work

Weiconlock adhesives generally do not cause allergic reactions to the skin. However, in isolated cases where skin is continuously bruised or micro-lacerated sensitisation may occur. Therefore, extensive and direct contact with the skin should be avoided (e.g. by the use of Weicon Hand Protective Foam). For more information on this topic, please refer to the appropriate SDS.

Weiconlock Activator F

The cure time of all grades of Weiconlock adhesives can be reduced by pre-treating surfaces with Weiconlock Activator F which is recommended for all passive surfaces (such as high alloyed steel, chromate layers, plastics, ceramics, aluminium, zinc or nickel) and which is indispensable when working in low temperature (+10°C and below) environments or when covering large gaps. On non-metallic surfaces, Weiconlock AN 302-21 is made effective by the activator.

Cure

Weiconlock remains liquid as long as it is in contact with the air. Curing starts when Weiconlock is in contact with metal and deprived of air. Observable cure time is influenced not only by the type of Weiconlock, but also the material(s) it is exposed to and the environmental temperature.

Dismantling

Weiconlock AN 302-21 cures with low strength. This is so that bonds formed with AN 302-21 can be easily disassembled when required.

Storage

Weiconlock AN 302-21 can be stored in its unopened original container for at least 12 months at room temperature. Keep away from heat sources and direct sunlight.

Availability

Weiconlock AN 302-21 is available in 20ml and 50ml Pens as well as 200ml bottles.

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