

# WEICONLOCK® AN 306-48 Retaining Cylindrical Assemblies



**medium viscosity**  
**high strength**  
**hard to disassemble**

Retaining cylindrical assemblies, high temperature resistant



## Technical Data

For threaded joints up to	M 20 R ¾"
Viscosity at 25°C (+77°F) according to Brookfield	550 nt mPa·s
Max. Gap Bridging	0,15 mm
Breakaway strength (Thread)	30 - 35 Nm
Prevailing strength	55 - 77 Nm
Shear strength Nmm <sup>2</sup> (DIN 54452)	25 - 35 N/mm <sup>2</sup>
Handling strength at room temperature	5 min.
Final strength (100%) after	2 - 4 h

\*Strength values based on M 10 screws, 8.8 grade, thickness of nut 0,8.d Static shear strength based on cylindrical parts of abt. Ø 13 mm, tolerance (D-d) = 0,05 mm, l/d = 0,88

## Surface pre-treatment

In general, WEICONLOCK does not require special pre-treatment as slightly oily surfaces (e.g. on as received parts) will be tolerated. However, best results will be achieved on cleaned, degreased parts (use WEICON Surface Cleaner). If required, the parts should be slightly roughened.

## Processing

WEICONLOCK is ready for use and should be applied evenly direct from the bottle/tube with the dispensing tip (avoid direct contact

of dispensing tip with metal). On press fitted parts and larger cylindrical assemblies a thin and uniform layer should be applied on both surfaces. Join parts quickly. For sliding seats, turn the parts against each other when joining for an optimal distribution of the adhesive. Joint parts should not be moved until handling strength is reached. Do not pour back into the bottle any WEICONLOCK fluid which had contact with metal; even smallest metal particles will cause the content of the bottle to cure. In series construction, the use of manual or automatic applicators is recommended.

## Storage

WEICONLOCK can be stored in the unopened original container for at least 24 months at room temperature. Keep away from heat sources and direct sunlight. The air in the bottle/tube keeps WEICONLOCK liquid.

## Safety and health

When using WEICON products, the physical, safety technical, toxicological and ecological data and regulations in our EC safety data sheets ([www.weicon.com](http://www.weicon.com)) must be observed.

## Available sizes:

30648020	WEICONLOCK® AN 306-48 Retaining Cylindrical Assemblies 20 ml
30648150	WEICONLOCK® AN 306-48 Retaining Cylindrical Assemblies 50 ml
30648200	WEICONLOCK® AN 306-48 Retaining Cylindrical Assemblies 200 ml

## Accessories:

30700200	Activator F, 200 ml
30955172	Dosing Tips, Size 1

## 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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