



# L222

## THREADLOCKER (MEDIUM STRENGTH)

**Akfix L222** is a medium-strength, easy to remove screw lock. Works on all metals, especially good on low strength metals which could damage during disassembly, e.g. brass or aluminium.

### FIELD OF APPLICATION AND PROPERTIES

- Ideal for low-strength thread-locking of adjusting screws.
- Easy to remove screw lock.
- Especially good on low strength metals which could damage during disassembly, e.g. brass or aluminium.

### INSTRUCTIONS

- Clean male and female threads before assembly with an absorbent tissue paper to remove any cutting oil.
- Apply the adhesive with a 360 turn to leading threads of the male and female fittings.
- Use an absorbent tissue paper to wipe off excess jointing compound in the direction of the thread.
- Assembly parts and hold on for 24 hours at 22-24°C to ensure full curing of jointing compound.
- For disassembly, use hand tools to remove mating parts. When it is hard to disassemble at room temperature, apply local heat until reaching 250°C and disassemble while hot. Then, remove any residual cured adhesive mechanically and clean parts with a proper solvent, acetone.

### Resistance against Environmental Conditions

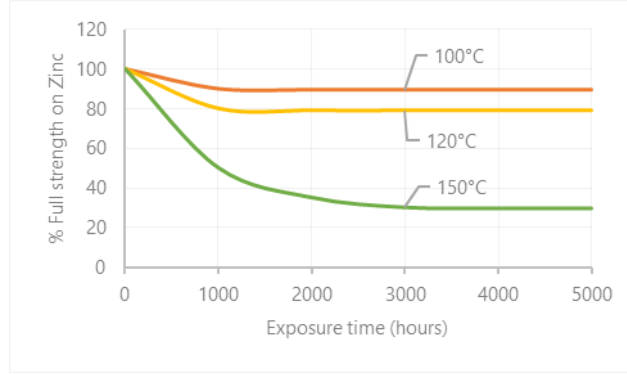
Environmental resistance of cured adhesive is measured after curing by applying ISO 10964 preloaded assembly test at different conditions.

Test method	:	ISO 10964
Bolt and nut specs.	:	Zinc plated, M10x25
Curing condition and duration	:	22°C, 1 week
Torque test conditions (exception is hot strength test)	:	22°C
Torque type	:	Breakloose Torque ( $T_{BL}$ )



## Heat Aging

Strength is examined on specimens that are aged at different temperatures. The reference value of '% Full strength on zinc plated' is taken from previous tables corresponding 24 hours curing.



## STORAGE AND SHELF LIFE

Keep product in its original container at 22°C and avoid to contact with direct sunlight. Storage below 5°C and above 30°C can negatively affect product properties.

Material removed from its original container can be contaminated during usage which affects both adhesive performance and storage life. Therefore, do not return contaminated product to the original container.

Shelf life: 36 months at 22°C.

## TECHNICAL PROPERTIES

### General properties

Main constituent	:	Methacrylate ester
Appearance (uncured)	:	Liquid
Colour	:	Purple
Viscosity	:	Medium and thixotropic
Strength	:	Low

### Physical properties of uncured adhesive

Specific gravity Conditions: 22°C	:	1.01
Flash point Method: ASTM D56-05	:	>93°C
Temperature range	:	-50°C to 150°C
Corrosivity	:	Non-corrosive
Gap filling	:	up to 0.25mm
Viscosity Conditions: 22°C Method: ISO 2555 Apparatus: Brookfield RVT, spindle 3	:	4000 - 7000 cPs (@2.5 rpm)



## Typical curing performance of adhesive

### Curing time at room conditions

Various type of curing time of adhesive on several substrates are given as follows. Note that results can differ due to distance of bond gap and temperature.

<b>Specimens</b>	:	M10x25 bolt and proper nut
<b>Conditions</b>	:	22°C

#### Handling time

Material of specimen	Duration
Brass	<60 secs
Steel	5 to 7 mins
Stainless steel	6 to 8 mins
Zinc plated steel	5 to 10 mins
Aluminium	20 to 35 mins

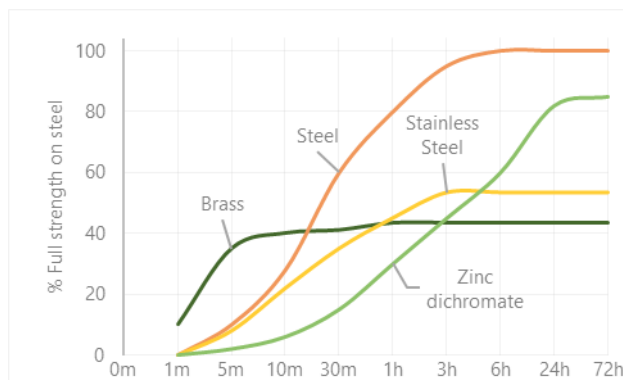
Average functional curing time: 1 to 3 hours

Average full curing time: 8 to 12 hours

### Curing speed with different substrates

The curing rate of anaerobic adhesive greatly depends on type of surface material, substrate. The curing rate developed in time is determined by measuring breakaway torque of bolt and nut specimens. Test details and resultant graphs are given below.

<b>Test method</b>	:	ISO 10964
<b>Bolt and nut specs.</b>	:	M10x25
<b>Conditions</b>	:	22°C

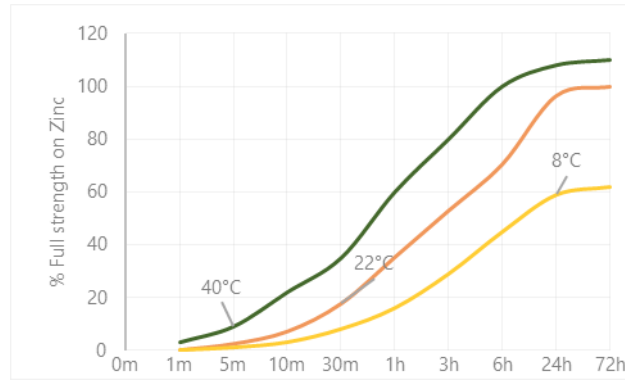




### Curing speed with different temperatures

Temperature of medium has great impact on curing performance of anaerobic adhesive. The curing rate developed in time is determined by measuring breakaway torque of bolt and nut specimens. Test details and resultant graphs are given below.

<b>Test method</b>	:	ISO 10964
<b>Bolt and nut specs.</b>	:	M10x25
<b>Conditions</b>	:	22°C



### Typical properties of cured adhesive

<b>Coefficient of thermal expansion (<math>\alpha</math>)</b> Method: ISO 11359-2	:	$3 \times 10^{-8} \text{ K}^{-1}$
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### Typical cured performance of adhesive

Performance of cured anaerobic adhesive is examined and resultant torque values are given below.

<b>Test method</b>	:	ISO 10964
<b>Conditions</b>	:	22°C
<b>Specimens</b>	:	Different type of nuts and bolts

#### Unseated assembly cured for 24 hours

Type of specimen	Breakaway Torque ( $T_{BA}$ )	Prevailing Torque ( $T_P$ )
Zinc plated, M10	4 N.m	1 N.m
Stainless steel, M10	5 N.m	1 N.m
Steel, M10	4 N.m	1 N.m



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## PACKAGING

Product	Volume	Package
Plastic Bottle	15mk/50ml/250ml	

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