



# L270

## THREADLOCKER (HIGH STRENGTH)

**Akfix L270** is a single component, high strength (permanent) anaerobic thread locker. The product cures when confined in the absence of air between close-fitting metal surfaces.

### FIELD OF APPLICATION AND PROPERTIES

- Formulated to lock metal fasteners;
- Particularly suitable for larger threaded fasteners, e.g. studs and all applications where maximum strength is needed.
- Prevents corrosion of assembled parts.

### 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.

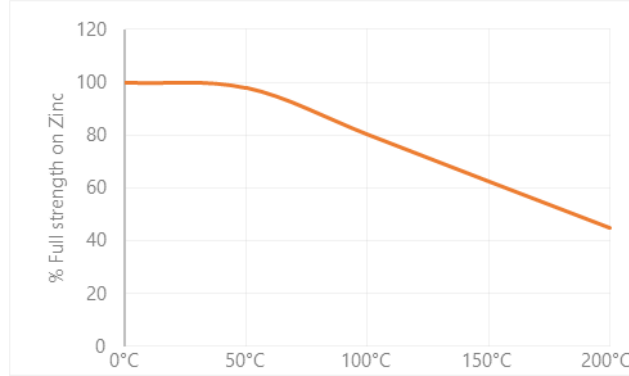
### Resistance against Environmental Conditions

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 ( $T_{BL}$ )

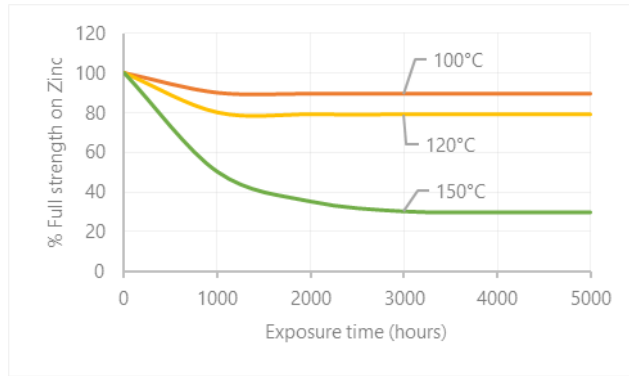
### Hot Strength

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



### 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: 35 months at 22°C.

## TECHNICAL PROPERTIES

### General properties

<b>Main constituent</b>	:	Methacrylate ester
<b>Appearance (uncured)</b>	:	Liquid
<b>Colour</b>	:	Green
<b>Viscosity</b>	:	Medium and thixotropic
<b>Strength</b>	:	High



### Physical properties of uncured adhesive

Specific gravity Conditions: 22°C	:	1.040
Flash point Method: ASTM D56-05	:	>93°C
Temperature range	:	-50°C to 150°C
Corrosivity	:	Non-corrosive
Gap filling	:	up to 0.15mm
Viscosity Conditions: 22°C Method: ISO 2555 Apparatus: Brookfield RVT, spindle 3	:	3000 - 4000 cPs (@20 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.

Specimens	:	M10x25 bolt and proper nut
Conditions	:	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

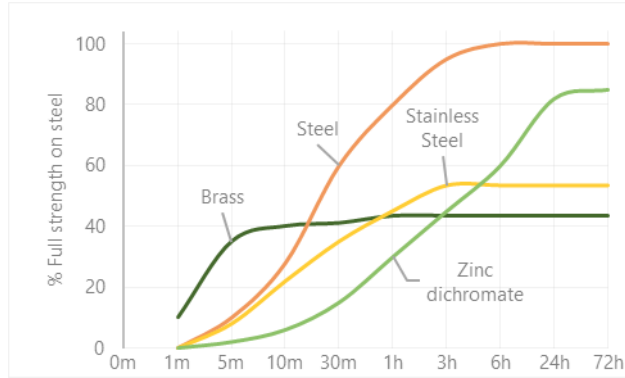
Average functional curing time: 1 to 3 hours

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.

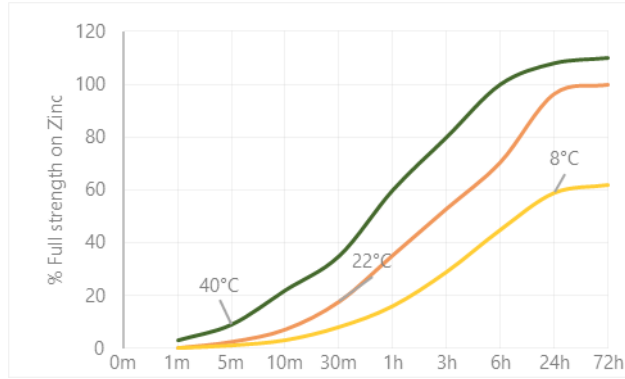
Test method	:	ISO 10964
Bolt and nut specs.	:	M10x25
Conditions	:	22°C



### 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 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	30 N.m	35 N.m
Stainless steel, M10	18 N.m	20 N.m

**Unseated assembly cured for 1 week**

Type of specimen	Breakaway Torque ( $T_{BA}$ )	Prevailing Torque ( $T_P$ )
Zinc plated, M10	33 N.m	39 N.m
Stainless steel, M10	18 N.m	20 N.m

**PACKAGING**

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

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