

## WEICON螺纹锁固胶 AN 306-48



中粘度  
高强度  
不易拆除

固持胶，耐高温



## 技术参数

最大螺纹尺寸	M 20 R ¾ "
依据 Brookfield 在温度+25°C时的粘度	550 nt mPa·s
最大粘接缝隙	0,15 mm
断裂扭矩 ( 螺纹 )	30 - 35 Nm
紧固扭矩 ( 螺纹 )	55 - 77 Nm
剪切强度Nmm <sup>2</sup> (依据 DIN 54452)	25 - 35 N/mm <sup>2</sup>
达到初始强度所需时间(室温下)	5 h
达到最终强度 ( 100% ) 所需时间	2 - 4 h

\*强度测试的样品螺栓为：M 10，8.8级，螺母厚度0.8d

压力与剪切力的测试样品为：圆柱体部件，直径为13 mm，偏差 ( D-d ) 为0,05 mm，l/d = 0,88

## 表面预处理

为了达到最佳效果，涂胶表面需保持清洁、干燥。可使用 WEICON 表面清洁剂进行清洁（有必要的话可以对部件表面做粗糙处理）。该系列产品也可用于不完全清洁的部件，如新采购的螺栓（螺栓上还带有油渍）。但需注意：涂胶表面越干净，效果就越好。

## 操作

使用时将产品挤出笔状胶管即可，均匀将胶水涂抹在金属部件上。涂胶时请注意尽量避免胶嘴与金属的直接接触。在大面积平面密封或圆柱体固持时，请将胶水轻薄地涂抹在需要粘接的部件上，双侧涂胶。

针对螺纹盲孔，需要往钻孔中填充足量密封胶。针对螺钉和螺栓，则仅需在螺纹圆周涂抹一圈即可。请勿将已经与金属发生接触的胶水重新倒回胶瓶内。在流水线生产时，建议使用自动点胶机进行涂胶。

## 储藏

未拆封的WEICONLOCK可在室温环境下保存至少24个月。避免热源和阳光直射。胶瓶内的空气让WEICONLOCK保持其液态质地。

## 安全与健康

使用WEICON产品时，需注意产品的物理性、安全性、毒性、生态性的详细参数以及我们EG材料安全数据表 ( www.weicon.com ) 的具体信息。

## 包装

30648020 WEICON螺纹锁固胶 AN 306-48 20 ml  
30648150 WEICON螺纹锁固胶 AN 306-48 50 ml  
30648200 WEICON螺纹锁固胶 AN 306-48 200 ml

## 产品配件

30700200 催化剂 F型, 200 ml  
30955172 精密胶嘴, 1号

## 提示

本资料中列出的所有产品，其参数和建议是我们在实验室的测试结果及经验总结，不得被视为对产品特性的保证。由于每一个用的实际应用情况并不在我们的认知、控制及责任范围内，我们对这些信息并不承担任何义务。我们保证我们的产品符合并遵守我们销售条款中承诺的高品质、无瑕疵的要求。我们建议用户通过自行试验来论证其希望选用的产品是否完全符合预期。因用户未遵照指定的操作方法使用产品而造成损失的情况，用户将独自承担全部责任。

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# 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 h
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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