

KT0222

Thread Locker

Description

Krylex KT0222 is a low strength, thixotropic anaerobic thread-locker. The low removal torque allows easy disassembly yet provides maximum vibration and shock resistance for threaded parts.

Krylex KT0222 is formulated to prevent vibration loosening and to seal against leaks through treaded components. The low removal torque makes Krylex KT0222 especially suitable for use on small threaded parts (6mmØ) and where regular disassembly is envisaged. Krylex KT0222 is ideal for small set screws and most types of small threaded nuts, bolts, screws and hex and slot driven components, including keyed fasteners. The low strength allows disassembly without stripping the heads off screws or bolts, so Krylex KT0222 is particularly recommended for use on softer, non-ferrous metals, e.g. brass.

Typical Properties of Uncured Material

| | | |
|---------------------------|------------------------------|----------------|
| Chemical Type | | Dimethacrylate |
| Appearance | | Purple |
| Specific Gravity | | 1.02 |
| Viscosity cPs | (Range) | 4,000-6,000 |
| | (Typical Value) | 5,000 |
| | (Range) ² | 1,000-2,000 |
| | (Typical Value) ² | 1,500 |
| Breakaway Torque (N.m) | range | 5-11 |
| | typical | 8 |
| Prevail Torque (N.m) | range | 1-5 |
| | typical | 3 |
| Fixture Time (mins) | | <15 |
| Full Cure @20°C (hours) | | 24 |
| Flash Point (°C) | | >100 |
| Max Gap Fill (mm) | | .25 |
| Operating Temp Range (°C) | | -50 to +150 |

Typical curing speed⁴, % of final strength:-

| | |
|----------|---------------|
| 15 mins | Finger tight |
| 1 hour | ~50% strength |
| 24 hours | 100% strength |

Cure Speed Influence

Cure speed and strength vary according to the substrates. When used on mild steel and brass components, anaerobic adhesives will reach full strength more rapidly than more inert materials such as stainless steel and zinc dichromate. Krylex Activators may be used to accelerate cure speed.

The size of the bond gap greatly affects the speed of cure of anaerobic adhesives. Bond gap varies with tread type and size of the fastener. The larger the gap between threads, the slower the cure speed.

All figures relating to cure speed are tested at 22°C. Lower temperatures will result in a slower cure. Heating the assembled parts accelerates the curing process. Krylex Activators should be used when the temperature is less than 5°C.

When speed of cure is too slow or the bond gap is very large, Krylex Activators may be used to accelerate cure speed. The use of an accelerator may reduce bond strength by up to 30%. Chemence recommends testing on the parts to measure the effect.

Typical Environmental Resistance

Krylex anaerobic adhesives exhibit excellent chemical resistance to most oils and solvents including motor oil, leaded petroleum, brake fluid, acetone, ethanol, propanol and water. Anaerobic adhesives and sealants are not recommended for use in pure oxygen or chlorine lines.



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Instructions for Use

Ensure parts are clean, dry and free from oil and grease.

Apply adhesive to all engaged threads. Assemble parts and allow curing. Wipe excess adhesive from outside of joint.

Product is normally hand applied from the container. Dispensing systems are available for high volume assembly applications. Please contact your Krylex representative for further advice on dispensing solutions.

Storage

Store in a cool area out of direct sunlight. Refrigeration to 5° gives optimum stability.

General Information

For safe handling of this product consult the Material Safety Data Sheet.

Anaerobic adhesives only cure in the absence of air and with metal part activation. Adhesive outside the joint will remain uncured and may be wiped away with a cloth.

Anaerobic adhesives are not recommended on certain plastics as stress cracking can sometimes result. Some anticorrosion chemicals inhibit the cure system in this type of anaerobic. Trials are recommended to establish whether cleaning of the parts are necessary. Krylex Activators may be required on plated parts and inactive metals.

Notes

The data contained in this data sheet may be reported as typical value and/or range. Values are based on actual test data and area verified on a regular basis.

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