LOCKING 338– TECHNICAL DATA SHEET

PRODUCT DESCRIPTION

Maximum strength at room temperature is ideal for filling the desired gaps. It is suitable for locking slots and bushings on shafts and housings. It has the property of excellent retention, sealing and fastening bolts. it is a high-strength clamping device that makes it possible to fix cylindrical joints without being particularly cleaned.

PRODUCT USAGE AREA

When the product is applied between metal connections and reacts in an airless environment, it Decures. It fixes stud bolts, rolling bearings and roller bearings that do not need to be loosened normally. It is especially suitable for screw connections subjected to excessive load. It takes the gap in the worn connections. Clamps the bearings into place, prevents them from being displaced. It clamps the rotor to the shaft. He clamps the sleeve, the shirts on their beds and on the shaft.

TECHNICAL SPECIFICATIONS

Resistance : *High*
Viscosity: *Medium-High*
Color: *Green*
Appearance (uncured): *Liquid*
Basic ingredient: *Methacrylate ester*

PHYSICAL PROPERTIES

Specific gravity Conditions: 22°C: *1.040*
Flash point Method: ASTM D56-05: *>93°C*
Temperature December: *from -50°C to +150°C*
Corrosion property: *Not corrosive*
Gap filling: *up to 0.25mm*
Viscosity: *4000- 4500 cPs (@20*

The curing times of the adhesive on various surfaces are indicated below. Please note that the results may vary depending on the temperature and the amount of Decoupling between the surfaces to be bonded
Note: Average functional curing time: 1- 3 hours
Average fully curing time: 8 - 12 hours

Curing speed on different surfaces

The curing speed of the anaerobic adhesive largely depends on what material the surface to be glued is made of. The curing rate that occurs over time is determined by measuring the breakaway torque of the samples of bolts and nuts. The graphs showing the test details and results are given below.
Test method: ISO 10964

The curing rate according to the distance between the surfaces

The distance between the two surfaces to be bonded can seriously affect the curing speed of the adhesive. Dec. The curing rate formed over time was determined by measuring the shear stress on the surface of the sample. The graphs showing the test details and results are given below.

The performance of the adhesive after curing

Test method: ISO 10123
Samples: Different kinds of pins and rings

24-hour curing	
Sample type	*Shear strength (N/mm2)*
Steel	*26 N.m*
Stainless steel	*28 N.m*
Aluminium	*17 N.m*
1 week curing	
Sample type	*Cutting strength (N/mm2)*
Steel	*32 N.m*
Stainless steel	*30 N.m*
Aluminum	*19 N.m*

Environmental resistance of the adhesive after curing

The environmental resistance of the cured adhesive was measured by applying the ISO 10123 preloaded assembly test at different temperatures after curing took place.

Test metodu	*ISO 10123*
Pim ve halka numunerli	*Çelik*
Kürleşme koşulları ve süresi	*22°C, 1 hafta*
Test koşulları (yüksek sıcaklıktaki dayanım testi hariç)	*22°C*

High temperature resistance

Temperature resistance has been studied at various temperatures. The reference value of "Full strength on steel surface" is taken from the 24-hour curing values given in the previous sections.

Thermal aging

The strength was examined on samples aged at different temperatures. The reference value of "Full

strength in steel coating" is taken from the 24-hour curing values given in the previous sections.

INSTRUCTIONS FOR USE

-Before joining the parts, clean them with an absorbent cloth or handkerchief to thoroughly clean the cutting oil.

-Apply the adhesive to the surfaces.

-Wipe off excess product with an absorbent cloth or tissue.,

-Assemble the parts and leave them at 22- 24°C for 24 hours to make sure that complete curing has taken place.

-To disassemble, use hand tools when separating the joined parts. If disassembly is not possible at room temperature, apply district heating until it reaches 250°C and disassemble while it is hot. Then, if there is any remaining cured adhesive, mechanically clean it and replace the parts with a suitable solvent, (e.g. acetone) clean up.

Storage and shelf life

Keep the product in its original container at 22°C and do not expose it to direct sunlight. Storage at temperatures less than 5°C and more than 30°C may adversely affect product properties. The product removed from its original container may become contaminated during use, which may affect the adhesion performance and shelf life of the product. Therefore, do not return the contaminated product to its original container. Metsan does not accept responsibility for products that have been contaminated or stored differently from the specified storage conditions. Shelf life: 24 months at 22°C

FIRST AID MEASURES

The product contains methacrylate ester. For more detailed information, please check the Safety before use Please apply to the Information Form (SDS)

DISPOSAL INFORMATION

The product must be disposed of in accordance with official regulations. Do not allow the product to be disposed of together with household garbage.
It is strictly forbidden to mix the product into sewers and underground waters. In such cases, inform the official authorities.

TRANSPORTATION INFORMATION

THE APPROPRIATE UN TRANSPORT NAME AND UN NO	*There is no hazard class under the ADR legislation.*
SYMBOL	
TRANSPORTATION HAZARD CLASS	
PACKAGING GROUP	
CLASSIFICATION CODE	
LABELING NO	
HAZARD IDENTIFICATION NO (HIN NO)	
TUNNEL RESTRICTION CODE	

NOTE:

For safety information, see the safety data sheet (MSDS).

The information has been prepared based on laboratory studies and applications.

Our company is not responsible for the problems that may arise from applications made in adverse conditions.

Akfa Endüstri San. Ve Tic. A.Ş.

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