

Weiconlock AN 305-74 is a fast and easy to use alternative to paper, cork, rubber, fibre or metal gaskets for close fitting metallic flange connections. It can be applied directly to the flange face and will cure to form a strong, high strength bond and seal between the surfaces.

Weiconlock AN 305-74 is an anaerobic adhesive that will only cure when it is deprived of air and in contact with metal. This means you have a basically unlimited pot life to apply it as curing will only begin when the flanges are assembled.

AN 305-74 is orange in colour and has a high viscosity (thickness) so that it can be accurately applied to complex and/or narrow flange faces. It creates high strength and long lasting bonds that will be hard to disassemble and withstands temperatures up to 180°C.



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Applications

Typical applications for this high quality anaerobic adhesive include:

- Sealing gearboxes and compressor housings
- Sealing motor and pump housings
- Sealing all kinds of metallic, close fitting flanges and assemblies
- As a replacement for thin cork, fibre or metal cut gaskets

Technical Details

Properties	
Colour	Orange
For Threaded Joints Up To	---
Viscosity at 25°C Brookfield	30,000 – 100,000 MPa
Gap Filling Capacity (Max.)	0.5mm
Breakaway Strength (Thread)	18 – 24 Nm
Prevailing Strength (Thread)	5 – 10 Nm
Shear Strength (DIN 54452)	5 – 10 N/mm ²
Handling Strength At Room Temperature	15 – 30 Minutes
Final Strength At Room Temperature	12 Hours
Temperature Resistance	-60°C to +180°C

Important

The values listed here and the information presented should not be treated as a substitute for specific technical advice. We cannot warrant the products performance or suitability for particular applications.

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Weiconlock Anaerobic Adhesives General Chemical Resistance Table

Acetaldehyde	+	Ethylene Dichloride	+	Perchloroethylene (Dry)	+
Acetate Solvent	+	Ethylene Glycol	+	Perchloric Acid (10%)	%+
Acetic Acid (10%)	%+	Fatty Acids	+	Permanganic	-
Acetic Acid (80%)	%O	Ferrous Sulphate	+	Peroxide Bleaching	+
Acetone	+	Formaldehyde (Cold)	+	Peroxy	-
Alcohols	+	Formic Acid (Cold)	+	Persulphuric (10%)	%+
Alkaline Solution	+	Freon	+	Phenol	+
Ammoniac Anhydride	-	Fuel Oil	+	Phenolic Resins	+
Ammonium Hydroxide	O	Fuming Nitric Acid	-	Phosphoric Acid 10% Hot	O
Amyl Acetate	+	Fuming Sulphuric Acid	-	Phosphoric Acid 10% Cold	+
Aniline	+	Gasoline	+	Phosphoric Acid 50% Hot	O
Aromatic Gasoline	+	Glycolic Acid	+	Phosphoric Acid 50% Cold	O
Aromatic Solvent	+	Glycerine	+	Phosphoric Acid 85% Hot	-
Ash Slurry	+	Grease Lubrication	+	Phosphoric Acid 85% Cold	O
Barium Sulphate	+	Hydrogen Bromide (10%)	%+	Phthalic	+
Battery Acid (10%)	%+	Hydrocyanic Acid (10%)	%+	Potash Alum	+
Benzene	+	Hydrogen	+	Potassium Acetate	+
Benzoic Acid	+	Hydrogen Peroxide	O	Potassium Hydroxide	-
Boric Acid	+	Concentrate		Pyridine	+
Brake Fluid	+	Hydrofluoric Acid	-	River Water	+
Butadiene	+	Heptane	+	Sewage	+
Butyric (10%)	%+	Hydrazine	+	Sea Water	+
Butylaldehyde	+	Hydrochloric Acid	O	Silicone Oils	+
Butylamine	+	Isocyanate Resin	+	Sorbitol	+
Butyl Acetate	+	Isooctane	+	Steam Sterilisation	+
Butyl Chloride	+	Ketones	+	Styrene	+
Cadmium Sulphate	+	Lithium Chloride	+	Sulfones	+
Castor Oil	+	Maleic	+	Sulfonic Acids (10%)	%+
Cellulose Acetate	+	Melamine Resin	+	Sulphuric Acid (75-100%)	%-
Chinon	+	Mercaptan, Thioalcohol	+	Sulphur Mud Solution in Carbon Disulphide	+
Chlorine (Dry)	-	Methane	+	Sulphurous Acid	O
Chlorine Alcohol	+	Methylamine	+	Sulphuric Acid (75%)	%O
Chloramine	+	Methyl Ethyl Ketone	+	Turpentine	+
Chlorine Dioxide	O	Methyl Acetate	+	Thiourea	+
Chlorinated Hydrocarbon	+	Mineral Oil, White	+	Toulene, Methylbenzene	+
Chloroform (Dry)	+	Mine Water	+	Trichloroethane	+
Coal Tar	+	Naphtha, Petroleum	+	Trichloromethane	+
Copper Chloride	+	Naphthalene	+	Trioxane	+
Copper Sulphate	+	Natronhydroxyd 20% hot	%O	Vapor Pressure (Low)	+
Cold Salt Water	+	Natronhydroxyd 20% cold	%+	Vaseline	+
Developer Liquid	+	Natronhydroxyd 50% hot	%-	Vinyl Acetate	+
Dichloroethylether	+	Natronhydroxyd 50% cold	%O	Wax	+
Diethyl ether	+	Natronhydroxyd 70% hot	%-	Xylene, Dimethylbenzene	+
Diglycollic	+	Natronhydroxyd 70% cold	%O		
Dioxane (Dry)	+	Nitric Acid (20%)	%+		
Emulsified Oils	+	Oils	+		
Ethyl Acetate	+	Oxalic Acid	+		
Ethylenediamine	+	Paraffin Oil, Kerosene	+		

+ = Good Resistance

O = Preliminary Tests or Resistance Tests are Recommended

% = Weiconlock adhesives are resistant only up to the indicated concentration

- = Weiconlock adhesives are not suitable, or may be used only after thorough preliminary tests

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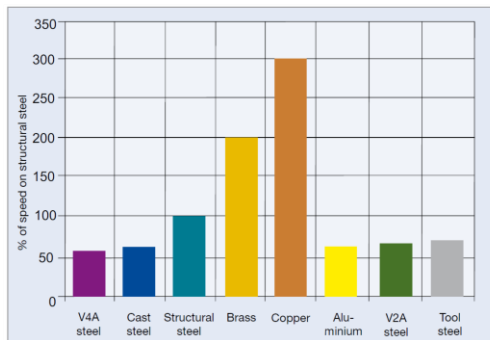
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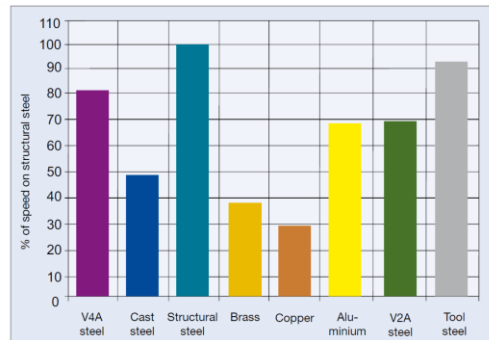
Weiconlock Adhesives General Information

All grades of Weiconlock are high quality anaerobic adhesives based on specialised methacrylate resins. While the grades differ in cure time, temperature resistance, cure strength, colour, viscosity and more; one thing that unites them is the fact that they only cure when in contact with metal and deprived of air. This special feature allows Weiconlock adhesives to be very easy to use as there's essentially no pot life.

As liquid adhesives, Weiconlock adhesives completely fill any gaps and thus protect against leakage and fretting corrosion. Once cured, these high quality adhesives form a shock and vibration resistant joint with excellent resistance to chemicals and solvents.



Approximate Curing Speed of Weiconlock
By Material



Compression Shear Strength of Weiconlock
Varying according to Metal (DIN 544521)

Preparation of the Surface

In general, Weiconlock adhesives do not require special surface pre-treatment as slightly oil surfaces (e.g. on 'as received' parts) will be tolerated. However, best results will be achieved if Weiconlock is used on parts that are cleaned and degreased (Cleaner S may be ideal). If required, the parts should be slightly roughened.

Application

Weiconlock AN 305-74 is ready for use as soon as the bottle is opened and should be applied evenly and directly from the bottle/tube with the dispensing tip (avoid direct contact of tip with metal). On press fitted parts and larger cylindrical assemblies a thin uniform layer should be applied to both surfaces. AN 305-74 is not designed for use as a thread locking adhesive.

Do not pour any Weiconlock fluid that has had contact with metal back into the bottle. Even the smallest quantity of metal particles will cause the content of the bottle to cure. In series construction, the use of manual or automatic applicators is possible.

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Physiological properties / health and safety at work

Weiconlock adhesives generally do not cause allergic reactions to the skin. However, in isolated cases where skin is continuously bruised or micro-lacerated, sensitisation may occur. Therefore, extensive and direct contact with the skin should be avoided (e.g. by the use of Weicon Hand Protective Foam). For more information on this topic, please refer to the appropriate SDS.

Weiconlock Activator F

The cure time of all grades of Weiconlock adhesives can be reduced by pre-treating surfaces with Weiconlock Activator F which is recommended for all passive surfaces (such as high alloyed steel, chromate layers, plastics, ceramics, aluminium, zinc or nickel) and which is indispensable when working in low temperature (+10°C and below) environments or when covering large gaps. On non-metallic surfaces, Weiconlock AN 305-74 is made effective by the activator.

Cure

Weiconlock remains liquid as long as it is in contact with the air. Curing starts when Weiconlock is in contact with metal and deprived of air. Observable cure time is influenced not only by the type of Weiconlock, but also the material(s) it is exposed to and the environmental temperature.

Dismantling

Weiconlock AN 305-74 cures with medium strength. Connections locked and sealed with this grade will be able to be dismantled through the use of normal tools.

Storage

Weiconlock AN 305-74 can be stored in its unopened original container for at least 12 months at room temperature. Keep away from heat sources and direct sunlight.

Availability

Weiconlock AN 305-74 Liquid Gasket Adhesive is available in 50ml Pens.

Other, larger sizes are also available on special request.

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