

# Weiconlock AN 305-74 **Liquid Gasket Adhesive**

## Technical Data Sheet

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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/mm²	
Handling Strength At	15 – 30 Minutes	
Room Temperature		
Final Strength At	12 Hours	
Room Temperature	12 110015	
Temperature Resistance	-60°C to +180°C	



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## Weiconlock Anaerobic Adhesives General Chemical Resistance Table

Acetack Solvent	Acetaldehyde	+	Ethylene Dichloride	+	Perchloroethylene (Dry)	+
Acetic Acid (10%)		+		+		
Acetone		%+		+	\ /	
Alcohols		%O		+		+
Alcohols	Acetone	+	Formaldehyde (Cold)	+	Peroxy	-
Alkaline Solution	Alcohols	+		+	Persulphuric (10%)	%+
Ammonium Hydroxide O Fuming Nitric Acid - Phosphoric Acid 10% Cold + Fuming Sulphuric Acid - Phosphoric Acid 10% Cold + Anyllane + Gasoline + Phosphoric Acid 50% Cold O Aromatic Gasoline + Glycolic Acid + Phosphoric Acid 50% Cold O Aromatic Solvent + Glycerine + Phosphoric Acid 50% Cold O Aromatic Solvent + Glycerine + Phosphoric Acid 50% Cold O Aromatic Solvent + Glycerine + Phosphoric Acid 85% Cold O Aromatic Solvent + Glycerine + Phosphoric Acid 85% Cold O Barium Sulphate + Hydrogen Bromide (10%) %+ Phthalic + Phosphoric Acid 85% Cold O Barium Sulphate + Hydrogen Bromide (10%) %+ Phthalic + Potassium Acetate + Hydrogen Peroxide O Concentrate O Pyridine + Potassium Acetate + Potassium Acetate + Hydrogen Peroxide O Concentrate O Pyridine + Potassium Hydroxide - Pyridine + Hydrofluoric Acid - River Water + Butylic (10%) %+ Hydrazine + Sewage + Butyric (10%) %+ Hydrazine + Sewage + Butylic (10%) %+ Hydrazine + Sewage + Butylaldehyde + Hydrochloric Acid O Silicone Oils + Butylamine + Isoocyanate Resin + Sorbitol + Butyl Acetate + Isooctane + Steam Sterilisation + Butyl Chloride + Ketones + Styrene + Cadmium Sulphate + Lithium Chloride + Sulfones + Sulfonic Acid (10%) %+ Castor Oil + Malelc + Sulfones + Sulfonic Acid (10%) %+ Methane + Carbon Disulphide + Chlorine Alcohol + Methyl Ethyl Ketone + Sulphuric Acid (75*100%) %-Chlorine Dixide O Methyl Acetate + Turpentine + Turpentine + Turpentine + Naphtha, Petroleum + Tichloromethane + Toulene, Methylbenzene + Toulene, Methylbenzene + Toulene, Methylbenzene + Tichloromethane + Naphtha, Petroleum + Tichloromethane + Dichlorothylether + Natronhydroxyd 20% cold %-O Vinyl Acetate + Dichlorothylether + Natronhydroxyd 50% hot %-O Vinyl Acetate + Dichlorothylether + Natronhydroxyd 50% hot %-O Vinyl Acetate + Dichlorothylether + Natronhydroxyd 50% cold %-O Vinyl Acetate + Dichlorothylether + Natronhydroxyd 70% hot %-O Tioxane + Dichlorothylether + Natronhydroxyd 70% cold %-O Vinyl Acetate + Dichlorothylether + Natronhydroxyd 70% cold %-O Vinyl Acetate + Dichlorothylether + N	Alkaline Solution	+		+	Phenol	+
Amyl Acetate	Ammoniac Anhydride	-	Fuel Oil	+	Phenolic Resins	+
Amyl Acetate	Ammonium Hydroxide	0	Fuming Nitric Acid	-	Phosphoric Acid 10% Hot	0
Aromatic Gasoline + Glycolic Acid + Phosphoric Acid 50% Cold O Aromatic Solvent + Glycerine + Phosphoric Acid 35% Hot - Ash Slurry + Grease Lubrication + Phosphoric Acid 35% Hot - Phosphoric Acid 4 + Hydrogen Peroxide O Discount Acetate + Potassium Acetate + Potassium Acetate + Potassium Acetate + Phosphoric Acid 4 + Hydrogen Peroxide O Discount Acid 4 + Hydrogen Peroxide O Discount Acetate + Pyridine + Py	Amyl Acetate	+		-	Phosphoric Acid 10% Cold	+
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 Peroxide O Concentrate + Hydrogen Peroxide O Concentrate + Hydrogen Peroxide O Concentrate + Hydrofluoric Acid - River Water + Brake Fluid + Hydrofluoric Acid - River Water + Butyfacine + Heptane + Sea Water + Butyfacine + Hydrochloric Acid O Silicone Oils + Hydrochloric Acid O Silicone Oils + Butylaldehyde + Hydrochloric Acid O Silicone Oils + Butylaldehyde + Isooctane + Steam Sterilisation + Butyl Chloride + Ketones + Styrene + Cadmium Sulphate + Lithium Chloride + Sulfonic Acids (10%) %+ Allela Castor Oil + Malelc + Sulfonic Acids (10%) %+ Cellulose Acetate + Melamine Resin + Sulphuric Acid (75-100%) %- Chinon + Mercaptan, Thioalcohol + Sulphuric Acid (75%) %- Chlorine Alcohol + Methyl Ethyl Ketone + Sulphuric Acid (75%) %- Chlorine Dioxide O Methyl Acetate + Tripentine + Carbon Disulphide + Chlorine Dioxide O Methyl Acetate + Tripentine + Copper Chloride + Naphthalene + Trichloromethane + Copper Sulphate + Natronhydroxyd 20% hot More Acetate + Natronhydroxyd 20% hot More Acetate + Natronhydroxyd 20% hot More Acetate + Natronhydroxyd 50% cold More Acetate + Natronhydroxyd 50% hot More Acetate + Natronhydroxyd 50% hot More Acetate + Diehlore Hydrocarbon + Natronhydroxyd 50% hot More Acetate + Diehlore Hydrocarbon + Natronhydroxyd 50% cold More Acetate + Diehlore Hydrocarbon + Natronhydroxyd 50% hot More Acetate + Diehlore Hydrocarbon + Natronhydroxyd 50% hot More Acetate + Diehlore Hydrocarbon + Natronhydroxyd 50% hot More Acetate + Diehlore Hydrocarbon + Natronhydroxyd 50% cold More Acetate + Diehlore Hydrocarbon + Natronhydroxyd 50% hot More Acetate + Diehlore Hydrocarbon + Natronhydroxyd 50% hot More Acetate + Diehlore Hydrocarbon + Natronhydroxyd 50% hot More Acetate + Diehlore Hydrocarbon + Natronhydroxyd 50% hot More Acetate + Diehlore Hydrocarbon + Natr	Aniline	+	Gasoline	+	Phosphoric Acid 50% Hot	0
Ash Slurry + Grease Lubrication + Phosphoric Acid 85% Cold O Barium Sulphate + Hydrogen Bromide (10%) %+ Photalic + Battery Acid (10%) %+ Hydrogenic Acid (10%) %+ Potassium Acetate + Benzore + Hydrogen + Potassium Acetate + Benzoic Acid + Hydrogen Peroxide OConcentrate OConcentrate 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 + Isocotane + Steam Sterilisation + Butyl Chloride + Ketones + Styrene + Cadmium Sulphate + Lithium Chloride + Sulfonic Acids (10%) %+ Castor Oil + Malelc + Sulfonic Acids (10%) %+ Callulose Acetate + Melamine Resin + Sulphuric Acid (75-100%) %- Chinon + Mercaptan, Thioalcohol + Sulphur Mud Solution in Chlorine (Dry) - Methane + Sulphuric Acid (75%) %- Chlorine Dioxide O Methyl Acetate + Turpentine + Chlorine Hydrocarbon + Maler + Thiourea + Coal Tar + Naphtha, Petroleum + Trichloromethane + Copper Sulphate + Natronhydroxyd 20% hot Modes + Natronhydroxyd 50% hot Modes + Natronhydroxyd 50% hot Modes + Natronhydroxyd 50% hot Modes + Natronhydroxyd 70% hot Modes + Natronhydroxyd 70% cold Modes + Natronhydroxyd 70% co	Aromatic Gasoline	+	Glycolic Acid	+	Phosphoric Acid 50% Cold	0
Barium Sulphate	Aromatic Solvent	+	Glycerine	+	Phosphoric Acid 85% Hot	-
Battery Acid (10%)	Ash Slurry	+	Grease Lubrication	+	Phosphoric Acid 85% Cold	0
Benzene + Hydrogen Peroxide - Potassium Acetate + Benzoic Acid + Hydrogen Peroxide - O Potassium Hydroxide - Potassium Acetate - Potassium Acetate - Potassium Hydroxide - Potassium Acetate	Barium Sulphate	+	Hydrogen Bromide (10%)	%+	Phthalic	+
Benzoic Acid + Hydrogen Peroxide Concentrate + Pyridine	Battery Acid (10%)	%+	Hydrocyanic Acid (10%)	%+	Potash Alum	+
Boric Acid + Concentrate	Benzene	+	Hydrogen	+	Potassium Acetate	+
Bonc Acid + Loncentrate Pyridine + Hydrofluoric Acid - River Water + Butake Fluid + Hydrofluoric Acid - River Water + Butyric (10%) %+ Hydrazine + Sewage + Hydrochloric Acid O Silicone Oils + Butylaldehyde + Hydrochloric Acid O Silicone Oils + Butylamine + Isocyanate Resin + Sorbitol + Butyl Acetate + Isococtane + Steam Sterilisation + Butyl Chloride + Ketones + Styrene + Cadmium Sulphate + Lithium Chloride + Sulfones + Sulfones + Cadmium Sulphate + Lithium Chloride + Sulfones + Sulphuric Acid (75-100%) %-Cellulose Acetate + Melamine Resin + Sulphuric Acid (75-100%) %-Chlorine (Dry) - Methane + Carbon Disulphide + Carbon Disulphide + Chlorine Alcohol + Methyl Ethyl Ketone + Sulphuric Acid (75%) %O Chlorine Dioxide O Methyl Acetate + Turpentine + Chlorinated Hydrocarbon + Mineral Oil, White + Thiourea + Coal Tar + Naphtha, Petroleum + Trichloromethane + Copper Chloride + Naphthalene + Trichloromethane + Copper Chloride + Naphthalene + Trichloromethane + Copper Chloride + Naphthalene + Trichloromethane + Cod Salt Water + Natronhydroxyd 20% hot %- Vaseline + Diethyl ether + Natronhydroxyd 50% cold %O Trioxane + Diethyl ether + Natronhydroxyd 50% cold %O Trioxane + Diethyl ether + Natronhydroxyd 70% cold %O Trioxane + Diethyl ether + Natronhydroxyd 70% cold %O Trioxane + Diethyl ether + Natronhydroxyd 70% cold %O Trioxane + Diethyl ether + Natronhydroxyd 70% cold %O Trioxane + Diethyl ether + Natronhydroxyd 70% cold %O Trioxane + Diethyl ether + Natronhydroxyd 70% cold %O Trioxane + Diethyl ether + Natronhydroxyd 70% cold %O Trioxane + Diethyl ether + Natronhydroxyd 70% cold %O Trioxane + Diethyl ether + Natronhydroxyd 70% cold %O Trioxane + Diethyl ether + Natronhydroxyd 70% cold %O Trioxane + Diethyl ether + Natronhydroxyd 70% cold %O Trioxane + Diethyl ether + Natronhydroxyd 70% cold %O Trioxane + Diethyl ether + Natronhydroxyd 70% cold %O Trioxane + Diethyl ether + Natronhydroxyd 70% cold %O Trioxane + Diethyl ether + Natronhydroxyd 70% cold %O Trioxane + Diethyl ether + Natronhydroxyd 70% cold %O Trioxane + Di	Benzoic Acid	+	Hydrogen Peroxide	)	Potassium Hydroxide	-
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Butyric (10%)  %+ Hydrazine	Brake Fluid	+	Hydrofluoric Acid	-	River Water	+
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Butylamine	Butyric (10%)	%+	Hydrazine	+	Sea Water	+
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Cadmium Sulphate + Lithium Chloride + Sulfones + Castor Oil + Malelc + Sulfonic Acids (10%) %+ Cellulose Acetate + Melamine Resin + Sulphuric Acid (75-100%) %-Chinon + Mercaptan, Thioalcohol + Sulphur Mud Solution in Chlorine (Dry) - Methane + Carbon Disulphide + Carbon Disulphide Chlorine Alcohol + Methylamine + Sulphurous Acid O Chloramine + Methyl Ethyl Ketone + Sulphuric Acid (75%) %O Chlorine Dioxide O Methyl Acetate + Turpentine + Turpentine + Chlorinated Hydrocarbon + Mineral Oil, White + Thiourea + Chlorinated Hydrocarbon + Minew Water + Toulene, Methylbenzene + Coal Tar + Naphtha, Petroleum + Trichloroethane + Copper Chloride + Naphthalene + Trichloromethane + Copper Sulphate + Natronhydroxyd 20% cold %+ Vapor Pressure (Low) + Developer Liquid + Natronhydroxyd 50% cold %O Vinyl Acetate + Dichyl ether + Natronhydroxyd 70% cold %O Vinyl Acetate + District Acid (20%) %+ Emulsified Oils + Oils + Oils + Oils + Oxalic Acid + Vapor Acetate + Oxalic Acid + Vapor Acetate + Ethyl Acetate + Oxalic Acid + Vapor Acetate + Oxalic Acid + Vapor Pressure (Low) + Ethyl Acetate + Oxalic Acid + Acetate +	Butyl Acetate	+	Isooctane	+	Steam Sterilisation	+
Castor Oil + Malelc + Sulfonic Acids (10%) %+ Cellulose Acetate + Melamine Resin + Sulphuric Acid (75-100%) %- Chinon + Mercaptan, Thioalcohol + Sulphur Mud Solution in Chlorine (Dry) - Methane + Carbon Disulphide + Chlorine Alcohol + Methylamine + Sulphurous Acid O Chloramine + Methyl Ethyl Ketone + Sulphuric Acid (75%) %O Chlorine Dioxide O Methyl Acetate + Turpentine + Chlorinated Hydrocarbon + Mineral Oil, White + Thiourea + Chloroform (Dry) + Mine Water + Toulene, Methylbenzene + Coal Tar + Naphtha, Petroleum + Trichloroethane + Copper Chloride + Naphthalene + Trichloromethane + Copper Sulphate + Natronhydroxyd 20% hot %O Trioxane + Cold Salt Water + Natronhydroxyd 20% cold %+ Vapor Pressure (Low) + Developer Liquid + Natronhydroxyd 50% cold %O Vinyl Acetate + Dichloroethylether + Natronhydroxyd 70% hot %- Diethyl ether + Natronhydroxyd 70% cold %O Dioxane (Dry) + Nitric Acid (20%) %+ Emulsified Oils + Oils + Ethyl Acetate + Oxalic Acid +	Butyl Chloride	+	Ketones	+	Styrene	+
Cellulose Acetate	Cadmium Sulphate	+	Lithium Chloride	+	Sulfones	+
Chinon + Mercaptan, Thioalcohol + Sulphur Mud Solution in Chlorine (Dry) - Methane + Carbon Disulphide + Chlorine Alcohol + Methylamine + Sulphurous Acid O Chloramine + Methyl Ethyl Ketone + Sulphuric Acid (75%) %O Chlorine Dioxide O Methyl Acetate + Turpentine + Chlorinated Hydrocarbon + Mineral Oil, White + Thiourea + Chloroform (Dry) + Mine Water + Toulene, Methylbenzene + Coal Tar + Naphtha, Petroleum + Trichloroethane + Copper Chloride + Naphthalene + Trichloromethane + Copper Sulphate + Natronhydroxyd 20% hot Cold Salt Water + Natronhydroxyd 20% cold %+ Vapor Pressure (Low) + Developer Liquid + Natronhydroxyd 50% cold %- Vaseline + Dichloroethylether + Natronhydroxyd 70% hot %- Dischlore (Dry) + Nitric Acid (20%) %+ Emulsified Oils + Oils + Oxalic Acid + Oxalic Acid + Oxalic Acid	Castor Oil	+	Malelc	+	Sulfonic Acids (10%)	%+
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Chlorine (Dry) - Methane + Carbon Disulphide  Chlorine Alcohol + Methylamine + Sulphurous Acid O  Chloramine + Methyl Ethyl Ketone + Sulphuric Acid (75%) %O  Chlorine Dioxide O Methyl Acetate + Turpentine +  Chlorinated Hydrocarbon + Mineral Oil, White + Thiourea +  Chloroform (Dry) + Mine Water + Toulene, Methylbenzene +  Coal Tar + Naphtha, Petroleum + Trichloroethane +  Copper Chloride + Naphthalene + Trichloromethane +  Copper Sulphate + Natronhydroxyd 20% hot %O Trioxane +  Cold Salt Water + Natronhydroxyd 20% cold %+ Vapor Pressure (Low) +  Developer Liquid + Natronhydroxyd 50% hot %- Vaseline +  Dichloroethylether + Natronhydroxyd 50% cold %O Vinyl Acetate +  Diethyl ether + Natronhydroxyd 70% hot %-  Dioxane (Dry) + Nitric Acid (20%) %+  Emulsified Oils + Oils +  Ethyl Acetate + Oxalic Acid +	Chinon	+	Mercaptan, Thioalcohol	+	Sulphur Mud Solution in	
Chloramine + Methyl Ethyl Ketone + Sulphuric Acid (75%) %O Chlorine Dioxide O Methyl Acetate + Turpentine + Chlorinated Hydrocarbon + Mineral Oil, White + Thiourea + Chloroform (Dry) + Mine Water + Toulene, Methylbenzene + Coal Tar + Naphtha, Petroleum + Trichloroethane + Copper Chloride + Naphthalene + Trichloromethane + Copper Sulphate + Natronhydroxyd 20% hot %O Trioxane + Cold Salt Water + Natronhydroxyd 20% cold %+ Vapor Pressure (Low) + Developer Liquid + Natronhydroxyd 50% hot %- Vaseline + Dichloroethylether + Natronhydroxyd 50% cold %O Vinyl Acetate + Diethyl ether + Natronhydroxyd 70% hot %- Dioxane (Dry) + Nitric Acid (20%) %+ Emulsified Oils + Oils + Ethyl Acetate + Oxalic Acid +	Chlorine (Dry)	-	Methane	+	Carbon Disulphide	
Chlorine Dioxide O Methyl Acetate + Turpentine + Chlorinated Hydrocarbon + Mineral Oil, White + Thiourea + Chloroform (Dry) + Mine Water + Toulene, Methylbenzene + Coal Tar + Naphtha, Petroleum + Trichloroethane + Copper Chloride + Naphthalene + Trichloromethane + Copper Sulphate + Natronhydroxyd 20% hot %O Trioxane + Cold Salt Water + Natronhydroxyd 20% cold %+ Vapor Pressure (Low) + Developer Liquid + Natronhydroxyd 50% hot %- Vaseline + Dichloroethylether + Natronhydroxyd 50% cold %O Vinyl Acetate + Diethyl ether + Natronhydroxyd 70% hot %- Diglycollic + Natronhydroxyd 70% cold %O Dioxane (Dry) + Nitric Acid (20%) %+ Emulsified Oils + Oils + Ethyl Acetate + Oxalic Acid +	Chlorine Alcohol	+	Methylamine	+	Sulphurous Acid	
Chlorinated Hydrocarbon + Mineral Oil, White + Thiourea + Chloroform (Dry) + Mine Water + Toulene, Methylbenzene + Coal Tar + Naphtha, Petroleum + Trichloroethane + Copper Chloride + Naphthalene + Trichloromethane + Copper Sulphate + Natronhydroxyd 20% hot %O Trioxane + Cold Salt Water + Natronhydroxyd 20% cold %+ Vapor Pressure (Low) + Developer Liquid + Natronhydroxyd 50% hot %- Vaseline + Dichloroethylether + Natronhydroxyd 50% cold %O Vinyl Acetate + Diethyl ether + Natronhydroxyd 70% hot %- Wax + Diglycollic + Natronhydroxyd 70% cold %O Xylene, Dimethylbenzene + Dioxane (Dry) + Nitric Acid (20%) %+ Emulsified Oils + Oils + Oxalic Acid +	Chloramine	+	Methyl Ethyl Ketone	+	Sulphuric Acid (75%)	%O
Chloroform (Dry) + Mine Water + Toulene, Methylbenzene + Coal Tar + Naphtha, Petroleum + Trichloroethane + Copper Chloride + Naphthalene + Trichloromethane + Copper Sulphate + Natronhydroxyd 20% hot %O Trioxane + Cold Salt Water + Natronhydroxyd 20% cold %+ Vapor Pressure (Low) + Developer Liquid + Natronhydroxyd 50% hot %- Vaseline + Dichloroethylether + Natronhydroxyd 50% cold %O Vinyl Acetate + Diethyl ether + Natronhydroxyd 70% hot %- Wax + Diglycollic + Natronhydroxyd 70% cold %O Xylene, Dimethylbenzene + Dioxane (Dry) + Nitric Acid (20%) %+ Emulsified Oils + Oils + Ethyl Acetate + Oxalic Acid +	Chlorine Dioxide	0	Methyl Acetate	+		+
Coal Tar + Naphtha, Petroleum + Trichloroethane + Copper Chloride + Naphthalene + Trichloromethane + Copper Sulphate + Natronhydroxyd 20% hot %O Trioxane + Cold Salt Water + Natronhydroxyd 20% cold %+ Vapor Pressure (Low) + Developer Liquid + Natronhydroxyd 50% hot %- Vaseline + Dichloroethylether + Natronhydroxyd 50% cold %O Vinyl Acetate + Diethyl ether + Natronhydroxyd 70% hot %- Wax + Diglycollic + Natronhydroxyd 70% cold %O Xylene, Dimethylbenzene + Dioxane (Dry) + Nitric Acid (20%) %+ Emulsified Oils + Oils + Ethyl Acetate + Oxalic Acid +	Chlorinated Hydrocarbon	+	Mineral Oil, White	+	Thiourea	+
Copper Chloride + Naphthalene + Trichloromethane + Copper Sulphate + Natronhydroxyd 20% hot %O Trioxane + Cold Salt Water + Natronhydroxyd 20% cold %+ Vapor Pressure (Low) + Developer Liquid + Natronhydroxyd 50% hot %- Vaseline + Dichloroethylether + Natronhydroxyd 50% cold %O Vinyl Acetate + Diethyl ether + Natronhydroxyd 70% hot %- Wax + Diglycollic + Natronhydroxyd 70% cold %O Xylene, Dimethylbenzene + Dioxane (Dry) + Nitric Acid (20%) %+ Emulsified Oils + Oils + Ethyl Acetate + Oxalic Acid +	Chloroform (Dry)	+	Mine Water	+	Toulene, Methylbenzene	+
Copper Sulphate + Natronhydroxyd 20% hot %O Trioxane +  Cold Salt Water + Natronhydroxyd 20% cold %+ Vapor Pressure (Low) +  Developer Liquid + Natronhydroxyd 50% hot %- Vaseline +  Dichloroethylether + Natronhydroxyd 50% cold %O Vinyl Acetate +  Diethyl ether + Natronhydroxyd 70% hot %- Wax +  Diglycollic + Natronhydroxyd 70% cold %O Xylene, Dimethylbenzene +  Dioxane (Dry) + Nitric Acid (20%) %+  Emulsified Oils + Oils +  Ethyl Acetate + Oxalic Acid +	Coal Tar	+	Naphtha, Petroleum	+	Trichloroethane	+
Cold Salt Water + Natronhydroxyd 20% cold %+ Vapor Pressure (Low) + Developer Liquid + Natronhydroxyd 50% hot %- Vaseline + Dichloroethylether + Natronhydroxyd 50% cold %O Vinyl Acetate + Diethyl ether + Natronhydroxyd 70% hot %- Wax + Diglycollic + Natronhydroxyd 70% cold %O Xylene, Dimethylbenzene + Dioxane (Dry) + Nitric Acid (20%) %+ Emulsified Oils + Oils + Ethyl Acetate + Oxalic Acid +	Copper Chloride	+	Naphthalene	+	Trichloromethane	+
Developer Liquid + Natronhydroxyd 50% hot %- Vaseline +  Dichloroethylether + Natronhydroxyd 50% cold %O Vinyl Acetate +  Diethyl ether + Natronhydroxyd 70% hot %- Wax +  Diglycollic + Natronhydroxyd 70% cold %O Xylene, Dimethylbenzene +  Dioxane (Dry) + Nitric Acid (20%) %+  Emulsified Oils + Oils +  Ethyl Acetate + Oxalic Acid +	Copper Sulphate	+	Natronhydroxyd 20% hot	%0	Trioxane	+
Dichloroethylether + Natronhydroxyd 50% cold %O Vinyl Acetate + Diethyl ether + Natronhydroxyd 70% hot %- Wax + Diglycollic + Natronhydroxyd 70% cold %O Dioxane (Dry) + Nitric Acid (20%) %+ Emulsified Oils + Oils + Ethyl Acetate + Oxalic Acid +	Cold Salt Water	+	Natronhydroxyd 20% cold	%+	Vapor Pressure (Low)	+
Diethyl ether + Natronhydroxyd 70% hot %- Wax +  Diglycollic + Natronhydroxyd 70% cold %O  Dioxane (Dry) + Nitric Acid (20%) %+  Emulsified Oils + Oils +  Ethyl Acetate + Oxalic Acid +	Developer Liquid	+	Natronhydroxyd 50% hot	%-	Vaseline	+
Diethyl ether+Natronhydroxyd 70% hot%-Wax+Diglycollic+Natronhydroxyd 70% cold%OXylene, Dimethylbenzene+Dioxane (Dry)+Nitric Acid (20%)%+Emulsified Oils+Oils+Ethyl Acetate+Oxalic Acid+	Dichloroethylether	+	Natronhydroxyd 50% cold	%O		+
Dioxane (Dry) + Nitric Acid (20%) %+ Emulsified Oils + Oils + Ethyl Acetate + Oxalic Acid +	Diethyl ether	+		%-		+
Dioxane (Dry) + Nitric Acid (20%) %+  Emulsified Oils + Oils +  Ethyl Acetate + Oxalic Acid +		+		%O		
Emulsified Oils + Oils + Ethyl Acetate + Oxalic Acid +		+	Nitric Acid (20%)	%+	•	
Ethyl Acetate + Oxalic Acid +						
		+	Paraffin Oil, Kerosene	+		

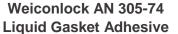
<sup>+ =</sup> Good Resistance

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O = Preliminary Tests or Resistance Tests are Recommended

<sup>% =</sup> Weiconlock adhesives are resistant only up to the indicated concentration

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



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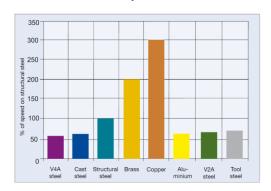
**Technical Data Sheet** 

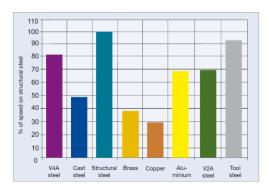
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#### **Weiconlock Adhesives General Information**

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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# Weiconlock AN 305-74 Liquid Gasket Adhesive

Technical Data Sheet

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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.