

KT702

Thread Locker

Description

KT702 is a permanently green colored general purpose adhesive for permanent threaded assemblies. KT702 locks bolts and studs up to 1" in diameter, sealing against leakage and corrosion. It is chemical resistant, resisting fuels, lubricants and most industrial liquids and gases.

KT702 eliminates double nutting and or welding of critical assemblies. Using KT702 permits reduced casting thickness, and eliminates cracked castings due to interference fit stresses. The product's viscosity allows usage on fine to medium threads on parts that will not require periodic disassembly.

Technical Features

Resin:	Dimethacrylate
Appearance:	Green
Cure Speed with Activator:	<5 minutes
Cure Speed w/o Activator:	20 minutes @ 77°F
Viscosity:	450-550 cps
Gap Fill:	.007"
Flash Point:	>212°F
Specific Gravity:	1.1-1.15 @ 75°F
Max. Operating Temp:	-65°F to +300°F

Cured Performance

Full Cure Time:	24hrs @ 68°F
Typical Breakaway Strength:	200-300 psi
Typical Prevailing Strength:	250-350 psi

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.



CHEMENCE®

KT702

Thread Locker

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.

Information presented herein has been compiled from sources considered to be accurate and reliable, but is not guaranteed to be so. Nothing herein shall be considered as recommending practices or products in violation of any patent, law or regulation. It is the user's responsibility to determine the suitability of any material for a specific purpose and to adopt such safety precautions as may be necessary. **WE MAKE NO WARRANTIES REGARDING THE PRODUCTS AND DISCLAIM ALL EXPRESS OR IMPLIED WARRANTIES, INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.**



CHEMENCE®