

KT0222

Low Strength Anaerobic Threadlocker

Description

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

KT0222 is formulated to prevent vibration loosening, to seal against leaks through threaded components and to prevent corrosion of assembled parts.

KT0222 cures rapidly when confined in the absence of air on close-fitting metal surfaces.

Typical Applications

KT0222 is especially suitable for use where regular disassembly is envisaged, on small threaded parts (<Ø6mm) and on softer, non-ferrous metals, e.g. brass.

Parts can be disassembled easily, without stripping the heads off screws or bolts, due to the low strength / low removal torque formulation.

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.

Typical Curing Performance

Typical curing speed ¹ as % of final strength.

Time	Value %
30 Minutes:	~10
3 hours:	~50
24 hours (Full cure):	100

¹ ISO 10964

Factors Affecting Cure Speed

Cure speed can be negatively influenced by very large gaps, low temperatures and can be dependent on the substrates being bonded.

Heating the assembled parts accelerates the curing process.

Anaerobic adhesives only cure in the absence of air and with metal part activation.

Anaerobic activator KP6497 should be used on plated parts or when the temperature is less than 5°C. The use of an activator can reduce bond strength.

Some anti corrosion chemicals inhibit the cure system in this type of anaerobic. Trials are recommended to establish whether cleaning of the parts is necessary.

All figures relating to cure speed are tested at 21°C.

Chemence recommends testing the suitability of Krylex products for any specific application.

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.

Technical Features

Chemical type:	Dimethacrylate
Appearance:	Purple
State:	Liquid
Specific Gravity:	~1.02
Viscosity ² :	4,000 - 6,000 cPs
Viscosity ³ :	1,000 - 2,000 cPs
Breakaway Torque ⁴ :	5 - 11 Nm
Prevail Torque ⁴ :	1 - 5 Nm
Initial Fixture Time ¹ :	≤15 minutes
Max. Gap Fill:	0.25 mm
Full Cure:	24 hours
Flash Point:	> 100 °C
Shelf Life:	12 months @ 20 °C
Operating Temp. Range:	-50 to +150 °C

¹ ISO 10964

² Brookfield RVT, spindle 2, Speed 2.5 rpm

³ Brookfield RVT, spindle 2, Speed 20 rpm

⁴ On M10 black oxide steel bolt and M10 bright steel nut, ISO10964

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Typical Environmental Resistance

Hot strength: KT0222 is suitable for use at temperatures up to 150°C. At 130°C the bond strength will be ~20% of the strength at 21°C.

Heat ageing: KT0222 retains ~90% full strength when heated to 100°C for 90 days then cooled and tested at 21°C.

Chemical / Solvent Resistance

KT0222 has good environmental resistance to water and other organic solvents including motor oil, ethanol and glycols.

KT0222 is not recommended for use in pure Oxygen or Chlorine lines.

Limitations

KT0222 is not recommended on certain plastics as stress cracking can sometimes result.

Storage

Optimal storage conditions are between 8°C and 21°C. Storage outside this temperature range can adversely affect product properties and may reduce the stated shelf life.

Please Note: When packed, KT0222 requires an air space above the product to maintain stability.

Important: Bulk stock (≥5kg) must be repacked into suitable containers within 3 months from date of shipment.

Presentation

Bottles: 10ml, 50ml and 250ml.
Available in bulk for use with dispensing systems.

Instructions For Use

KT0222 is suitable for most smaller diameter, fine, medium and coarse-threaded screws, nuts and bolts.

For best results, ensure parts are clean, dry and free from oil and grease.

Apply KT0222 threadlocker to all engaged threads. Assemble parts and allow to cure.

Wipe excess adhesive from outside of joint.

Product is normally hand applied from the bottle.

KT0222 is suitable for use in dispensing systems for high volume assembly applications.

General Information

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

Adhesive outside the joint will remain uncured and may be wiped away with a cloth.

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 are verified on a regular basis.

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