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SW 824

Permanent effect threadlocker

DESCRIPTION

SW824 is used to obtain the permanent lock of studs, nuts, screws and other threaded components. It can be used on all kind of metals, either for free or for tight coupling. The product is temperature proof, resistant to thermal shock, vibrations, oils and fuels, refrigerants fluids and other chemicals. **SW824** is recommended by Faiveley Transport to lock the studs of reciprocating compressors and flanged pneumatic equipments.

DIRECTIONS FOR USE

Clean and degrease the surfaces carefully using a specific product. Apply the right quantity of **SW824** required to fill completely the gap between the coupled parts avoiding product excess. Wait for the curing time. Liquid product can damage coating and elastomers. Its contact with some kind of thermoplastics, even accidental, might induce delayed stress-cracking events. **For applications on non-metal materials, please contact BB Technical Service.** To disassemble use common tools. If possible, heat at 150-250 °C to make the dismantling easiest. Remove mechanically any residue of cured product and clean parts with acetone.

CURING PERFORMANCE

The curing rate depends on the backlash existing between the coupled components, on the surfaces condition and on temperature. The functional strength is usually reached in 1 – 3 hours and the final strength in 24 – 36 hours. Applying on surfaces coated with protective and/or at low temperature, a shortest cure time can be obtained using a proper activator (please contact BB Technical Service).

CURING PROPERTIES

Zinc plated bolt M 10 x 20 - quality 8.8 - Nut h = 0,8.d at 25 °C

Handling cure time	10 - 20 minutes
Functional cure time	1 - 3 hours
Full cure time	5 - 10 hours
Shear strength (ISO 10123))	15 - 20 N/mm ²
Locking torque (ISO 10964) breakaway	25 - 35 Nm
Locking torque (ISO 10964) prevailing	50 - 65 Nm
Temperature range	-55 °C ↔ +150 °C

PHYSICAL PROPERTIES

Composition	anaerobic methacrylate
Colour	green
Viscosity (25°C - mPas)	500
Specific gravity (g/ml)	1,1
Fluorescence	under UV light
Flash point	> 100 °C
Shelf life 25°C	1 year
Max thread diameter / Max machining tolerance	M20 / 0,15mm

HANDLING AND STORAGE

Keep product in a cool and dry storage at no more than +25°C. To avoid contaminations do not refill containers with used product. For more information on applications, storage and handling please contact BB Technical Service.

SAFETY AND HANDLING

Please consult Material Safety Data Sheet.

PACKAGING

SW824 is supplied in 50ml bottle in 10 pcs box.

Note

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