



$l_1 \approx 2 \text{ to } 3 \times \text{Thread pitch}$

$l_2 \approx 1,5 \times d$

d Thread Diameter	l_1	$l_2 \approx$	M_{in} Maximum Torque	M_{10} Minimum Cracking Torque	M_{OUT} Maximum Loosening Torque
M5	1.5 to 2.5	7.6	1	1	6.5
M6	2 to 3	9	1.5	1.8	10
M8	2.5 to 4	12	3	4	25
M10	3 to 4.5	15	5.5	10	55
M12	3.5 to 5	18	7.5	15	95
M16	4 to 6	24	14	35	250
M20	5 to 7.6	30	22	45	500

The torque values comply with DIN 237, Part 27. They are based on a test of a thread without preload, with a nut thread of 6H at room temperature.

Description

The principle of micro encapsulation consists of a liquid plastic material and a hardener encapsulated in a thin polymer film which is embedded in a lacquer like carrier deposited in patch form on a thread. This patch dries and the component can be stored and handled in a normal manner.

When fitting a bolt with this patch, the two capsules will burst under the pressure and friction between the two threads. The liquid plastic material and hardener will mix leading to a chemical reaction which will harden the glue, thus giving the required thread locking.

The setting of the mixture will start after 10-25 minutes. Sufficient hardness is achieved after about 30 minutes, but complete setting is reached after 24 hours.

Adjustment and setting process must be completed within about five minutes.

The thread locking can be cracked by applying the M_{out} torque on the thread or alternatively by heating the component to over 180°C. It is not recommended to reuse the thread.

Threads, free from oil and grease, give increased strength of locking action.

Components treated with this process can be stored for up to four years.

Features

- Thread locking to the highest order to prevent the self loosening and component loss even under vibration. Not suitable for adjusting bolts or screws.
- This security aspect may be essential for certain applications of standard parts. Stockholding of liquid glue is eliminated.
- Low insertion torque
- Temperature range: -40°C to -170°C
- Excellent chemical stability