

Instructions for using ergo.® anaerobic thread-locking adhesives

Area of application

ergo.® thread-locking adhesives are liquid, single-component adhesives that harden at room temperature to form a plastic that adheres to metal surfaces in the absence of oxygen/air. The adhesive completely fills the gaps between the interfacing threads, locks the threaded parts and maintains a uniform clamp force.

Instructions

Assembly

Clean the male and female threads with ergo.® 9190 Cleaner and allow to dry.

If the surface material is an inactive metal or the curing process is very slow, spray either the male or the female thread with ergo.® 4900 Accelerator and allow to dry.

To prevent the nozzle from being clogged by cured material, do not let the tip come into contact with the metal surfaces when the adhesive is being dispensed.

For through holes, apply a sufficient amount of the product to the bolt at the nut engagement area.

For blind holes, apply several drops of adhesive down the inside of the thread to the bottom of the hole.

Assemble and tighten the parts as usual.

If used in contact with potable water, please follow the additional instructions, given by the German Industrieverband Klebstoffe e.V. (IVK e.V):

- Apply the sealant sparingly; use only as much as really needed.
- Avoid any excess or remove it.
- Pay attention to the cure time figures, mentioned in the concerned Technical Data Sheet.
- In order to avoid excess in the inner part, leave at least one, or if possible even two, threads of the male part free of sealant.
- Before first real commissioning, rinse the system with water.

Attention:

Because of the high accelerating property of copper and its alloy, it might happen, that curing starts already while the joining-process is still running. This can cause micro-cracks, which might lead to leakage later on. Due to this and in order to make the process safe, we seriously recommend tests in advance, if copper-containing parts (pure copper or its alloy) are used in long-term contact with hot (> 40°C) water. The end-user is responsible to clarify the suitability for his certain application and process.

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Disassembly

Remove bolt or nut by using standard hand tools.

On rare occasions when hand tools do not work due to excessive engagement and/or because a high-strength adhesive has been used, disassemble by applying localized heat to the bolt or the nut of ≥ 250 °C.

Disassemble parts while hot.

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