



Product code : C9803A

EMFILOK FH30

DESCRIPTION

EMFILOK FH30 is a one-component anaerobic curing adhesive based on acrylic ester. This product cures when confined in the absence of air between close fitting metal surfaces.

AREAS OF APPLICATION

EMFILOK FH30 is a product designed for locking and sealing of threaded fasteners with maximal gaps and which require high strength disassembly.

It prevents thread rusting.

EMFILOK FH30 can be used for bonding of large diameter pieces and prevents loosening and leakage from shock and vibration.

TECHNICAL DATA

Appearance before curing	Viscous
Appearance after curing	Hard
Colour	Red
Odor	Soft, characteristic
Viscosity at 25 °C	Brookfield RVT / spindle 3 / 10 rpm : 7,000 ± 700 mPa.s
Density at 25 °C	1.11 ± 0.03
Solubility	Chlorinated solvents
Maximum gap for application	0.45 mm
Cure speed without activator	5 to 20 min
Final setting without activator	6 h
Cure speed with activator	5 to 10 min
Final setting with activator	2 h
Temperature resistance	-50 to +150 °C
Resistance to lubricant oils and organic solvents	Good
Resistance to water, hydrolic fluids, acids and bases	Good
Specific data	Break torque (ISO 10964 standard) : 30 to 45 N.m (M10 nuts and bolts, grade A, fine thread) Prevail torque (ISO 10964 standard) : 25 to 40 N.m (torque readings average at 90, 180, 270 and 360 °)

ADVICE

See also material safety data sheet

INSTRUCTIONS FOR USE

Substrate preparation :

Clean and dry parts using CLEANER L, removing dirt and grease. Let evaporate.

Application :

Apply ACTIVATOR T only in the following cases :

- When one or both pieces are made of an inactive material (plastic), a low-activity material (stainless steel, pure aluminium, etc.), or a material with a treatment (nickel, zinc, etc.).
- When ambient temperature is lower than 8 °C.
- When the gap is near to the maximum allowable gap for application.
- When it is necessary to accelerate curing.

Apply the necessary quantity of adhesive to one surface and use a rotating motion during assembly to ensure good coverage.

Note: excess of product that remains in contact with air does not cure and does not contribute to bonding. It may be easily removed with a cloth or rinsed off with solvent.

STORAGE AND SHELF LIFE

18 months under 25 °C in closed original packaging

PACKAGING

50 g polyethylene bottles

SAFETY

Irritant. Read material safety data sheet before use.

PRECAUTIONS FOR USE

Avoid any contamination by preventing direct contact of the application nozzle with metal or pre-activated pieces.

Do not return the product to the original bottle.

Do not allow metal bits or shavings entering into the bottle.

The technical data contained herein is based on our present knowledge and experience and we cannot be held liable for any errors, inaccuracies, omissions or editorial failings that result from technological changes or research between the date of issue of this document and the date the product is acquired.

Before using the product, the user should carry out any necessary tests in order to ensure that the product is suitable for the intended application. Moreover, all users should contact the seller or the manufacturer of the product for additional technical information concerning its use if they think that the information in their possession needs to be clarified in any way, whether for normal use or a specific application of our product.

Our guarantee applies within the context of the statutory regulations and provisions in force, current professional standards and in accordance with the stipulations set out in our general sales conditions.

The information detailed in the present technical data sheet is given by way of indication and is not exhaustive. The same applies to any information provided verbally by telephone to any prospective or existing customer.