



Product code : C9805A

## EMFILOK JH20

### DESCRIPTION

EMFILOK JH20 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 JH20 is a high strength product designed to form gaskets in mechanized metal surfaces.

### TECHNICAL DATA

Appearance before curing	Thixotropic gel
Appearance after curing	Semi-rigid
Colour	Blue
Odor	Soft, characteristic
Viscosity at 25 °C	Brookfield RVT / spindle 6 / 2 rpm : 280,000 ± 80,000 mPa.s Brookfield RVT / spindle 6 / 20 rpm : 50,000 ± 10,000 mPa.s
Density at 25 °C	1.11 ± 0.01
Solubility	Chlorinated solvents
Maximum gap for application	0.25 mm
Cure speed without activator	20 to 30 min
Final setting without activator	24 h
Cure speed with activator	10 to 15 min
Final setting with activator	8 h
Temperature resistance	-50 to +150 °C
Resistance to lubricant oils and organic solvents	Good
Resistance to water, hydrolic fluids, acids and bases	Good
Resistance to pure oxygen and other strong oxidizers	Exposure not recommended
Specific data	Break torque (ISO 10964) : 75 to 150 daN.cm (bolts and nuts, M 10, level A, fine thread) Prevail torque (ISO 10964) : 80 to 150 daN.cm (average of the readings of torque 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, light alloys), or a material with a metal treatment (nickel, zinc, chromium, 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 EMFILOK JH20 to one of the surfaces in the amount necessary to fill the gap between the parts, forming a continuous cord throughout all the gasket. Surround the holes and bolts.

Gel consistency allows its application by automatic applicators, by serigraphy, brush or roller.

- Mount pieces.

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

Not classified as hazardous. Read material safety data sheet.

## PRECAUTIONS FOR USE

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

Avoid any exposition to radiations produced by electric welding.

Do not return the product to the original bottle.

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

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