



Product code : C9809A

## EMFILOK EH30

### DESCRIPTION

EMFILOK EH30 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 EH30 is a high strength product designed for bonding of cylindrical fitting parts with maximum gaps.

### TECHNICAL DATA

Appearance before curing	Thixotropic liquid
Appearance after curing	Hard , green
Colour	Green
Odor	Soft, characteristic
Viscosity at 25 °C	Brookfield RVT / spindle 3 / 2 rpm : 12,000 ± 2,000 mPa.s Brookfield RVT / spindle 3 / 20 rpm : 5,500 ± 1,000 mPa.s
Density at 25 °C	1.125 ± 0.025
Solubility	Chlorinated solvents
Maximum gap for application	0.26 mm
Cure speed without activator	10 to 30 min
Final setting without activator	6 h
Cure speed with activator	5 to 10 min
Final setting with activator	2 h
Shearing resistance	12.7 mm diameter, 11.1 mm height, 0.05 mm gap, 8 µm roughness steel SAE 1212 cylindrical joints cured at room temperature during 24 h : 25 to 35 daN/cm <sup>2</sup> (ISO 10123)
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	Poor

### 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.

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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.

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