



Product code : C9823A

## EMFILOK JB20

### DESCRIPTION

EMFILOK JB20 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 JB20 is a product designed for sealing of mechanical pieces (in steel, cast iron, aluminium) with low disassembly resistance for medium size gaps.

### TECHNICAL DATA

Appearance before curing	Thixotropic viscous liquid
Appearance after curing	Solid, semi-rigid plastic, light blue
Colour	Fluorescent blue
Odor	Soft, characteristic
Viscosity at 25 °C	Brookfield RVT / spindle 6 / 2 rpm : 67,000 ± 18,000 mPa.s Brookfield RVT / spindle 6 / 20 rpm : 30,000 ± 10,000 mPa.s
Density at 25 °C	1.11 ± 0.03
Solubility	Organic solvents
Maximum gap for application	0.15 mm
Cure speed without activator	30 to 40 min
Final setting without activator	24 h
Cure speed with activator	15 to 20 min
Final setting with activator	6 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 (grade A, M10 nuts and bolts with fine pitch threads) : 60 to 120 daN.cm (ISO 10964) Prevail torque (average of torque readings at 90, 180, 270 and 360 °C) : 30 to 90 daN.cm (ISO 10964)

### ADVICE

See also material safety data sheet

## INSTRUCTIONS FOR USE

### Substrate preparation :

Clean and dry parts using CLEANER L, removing dirt, grease and other residues. 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 galvanic 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 a continuous bead of EMFILOK JB20 along one of both surfaces, in the quantity necessary to fill clearance between parts. Surround holes, studs and pins.

Because of its consistency, this adhesive may be used with an automatic gun, by serigraphy, brush or roller.

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 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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