KT902

Wicking Grade Anaerobic Threadlocker

Description

KT902 is a medium-high strength, very low viscosity, anaerobic threadlocker with wicking capabilities.

KT902 is formulated to prevent vibration loosening, to seal against leaks through threaded components and to prevent corrosion of assembled parts.

KT902 cures rapidly when confined in the absence of air on close-fitting metal surfaces.

Typical Applications

The very low viscosity of KT902 makes it particularly suitable as a post-assembly adhesive to wick into pre-assembled parts, due to its very low viscosity, KT902 can also be used for some interference fit retaining applications.

KT902 can also be used a porosity sealant for cast components.

Typical Curing Performance

Typical curing speed [1] as % of final strength.

Time	Value %
15 Minutes:	Finger Tight
1 hour:	~50
24 hours (Full cure):	100

1 *ISO 10964*

Factors Affecting Cure Speed

Cure speed can be negatively influenced by very large gaps, low temperatures and can be dependent on the substrates being bonded.

Maximum recommended gap for KT902 is 0.15mm, which will give approximately the cure schedule as detailed in the properties table above.

All figures relating to cure speed are tested at 21°C.

Heating the assembled parts accelerates the curing process.

Anaerobic adhesives only cure in the absence of air and with metal part activation.

Anaerobic activator KP6497 should be used on plated parts or when the temperature is less than 5°C. The use of an activator can reduce bond strength.

Some anti corrosion chemicals inhibit the cure system in this type of anaerobic. Trials are recommended to establish whether cleaning of the parts is necessary.

Chemence recommends testing the suitability of Krylex products for any specific application.

When used on mild steel and brass components, anaerobic adhesives will reach full strength more rapidly than more inert materials such as stainless steel and zinc dichromate.

Technical Features

Chemical type:	Dimethacrylate
Appearance:	Light Green
State:	Liquid
Specific Gravity:	~1.07
Viscosity [1]:	7 - 12 cPs
Breakaway Torque [2]:	7- 21 Nm
Prevail Torque [2]:	25 - 44 Nm
Initial Fixture Time [3]:	≤15 minutes
Max. Gap Fill:	0.15 mm
Full Cure:	24 hours
Flash Point:	> 100 °C
Shelf Life:	12 months @ 20 °C
Operating Temp. Range:	-50 to +150 °C

1 *ISO 3104/3105*

2 *On M10 black oxide steel bolt and M10 bright steel nut, ISO 10964*

3 *ISO 10964*

Typical Environmental Resistance

Hot strength: KT902 is suitable for use at temperatures up to 150°C. At 130°C the bond strength will be ~70% of the strength at 21°C.

Heat ageing: KT902 retains ~60% full strength when heated to 100°C for 90 days then cooled and tested at 21°C.

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Chemical / Solvent Resistance

KT902 has good environmental resistance to water and other organic solvents including motor oil, ethanol and glycols.

Limitations

KT902 is not recommended on certain plastics as stress cracking can sometimes result.

KT902 is not recommended for use in pure Oxygen or Chlorine lines.

Instructions For Use

KT902 is suitable for most medium and coarse pitch threaded screws, nuts, bolts and studs.

For best results, ensure parts are clean, dry and free from oil and grease.

Apply KT902 threadlocker to all engaged threads.

Assemble parts and allow to cure.

Wipe excess adhesive from outside of joint.

Alternatively assemble the product then apply KT902 to the assembly. The product will penetrate into the threads by capillary action.

Product is normally hand applied from the bottle.

KT902 is suitable for use in dispensing systems for high volume assembly applications.

Presentation

Bottles: ..... 10ml, 50ml and 250ml.

Available in bulk for use with dispensing systems.

Storage

Optimal storage conditions are between 8°C and 21°C out of direct sunlight. Storage outside this temperature range can adversely affect product properties and may reduce the stated shelf life.

Please Note: When packed, KT902 requires an air space above the product to maintain stability.

Important: Bulk stock (≥5kg) must be repacked into suitable containers within 3 months from date of shipment.

General Information

For safe handling of this product consult the Safety Data Sheet.

Adhesive outside the joint will remain uncured and may be wiped away with a cloth.

This product can be used as a porosity sealant on cast components. Please contact us for details.

Notes

The data contained in this data sheet may be reported as typical value and / or range. Values are based on actual test data and are verified on a regular basis.

Disclaimer

KX-01-600-2508 V2