

WINKEL PRO 2W77

HIGH STRENGTH THREADLOCKER



Technical Bulletin

WINKEL PRO 2W77 is a high-strength and universal threadlocker for fastening and sealing metal materials. The product curing (polymerisation) is carried out under the exclusion of atmospheric oxygen (anaerobic) and the catalytic action of the metal (metal contact). High-strength product for highly stressed screw connections. The product is used to fixate and seal screws, stud bolts, nuts, thread inserts and thread plugs against impact, vibration and corrosion. Depending on the thread diameter, the product is difficult to dismantle or even impossible to dismantle.

Technical properties uncured product

Chemical base:	Methacrylate, anaerobic resin
Colour:	red, fluorescent
Viscosity ¹⁾ [mPas]:	6.000-8.000
Density ²⁾ [g/ml]	1,05-1,09
Max. clearance:	M36
Flash point ³⁾ [°C]:	>+100
Application temperature [°C]:	optimal at +23

1) At 25 °C, Brookfield viscometer

2) Measured according to DIN 53217, part 2 density sphere model 475/III

3) Measured according to DIN 51775

Technical properties hardened product

Breakaway torque [Nm]:	>20
Prevailing torque [Nm]:	30-45
Temperature range [°C]:	-55 to +180

Information about application

This product is not suitable for metal-plastic couplings and oxygen facilities as well as for the sealing of basic products or systems with strong oxidizing acids. Use only on standard metal threads. Surface must be clean and free of grease. For this, use degreaser agent WINKEL PRO FAST CLEANER. Apply product to fill the gap completely (male and female parts), assembly parts and shut completely. A bland or superficial closure may cause leakage over time. Don't move after tightening. Before operating the system wait for 24 hours to allow complete curing time. In case of serial products lock the joint with a pipe wrench to avoid breaking the previous film in its formative stages. In case of passive surfaces and/or low temperature a fast cure can be obtained using WINKEL PRO Anaerobic Activator. Consult the MSDS before use. By usage of an activator the curing values may drop by 15%.

Art. Nr. :	Packaging:
20312	50 mL
20313	250 mL
20314	1 L

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Cured*

Handling cure time [min]:	< 15
Functional cure time [h]:	3-6
Final strength after [h]:	12-24

Storage & Durability

The shelf life is, at the optimum storage temperature of +5°C to +23°C in the closed original container, a maximum of 24 months. A higher storage temperature leads to a significantly lower durability. The storage temperature must not fall below +5°C.