

RITE **LOK TL 22**

TECHNICAL

PRODUCT DESCRIPTION

RiteLok TL22 Screwlock is a low strength, thixotropic anaerobic threadlocker. The low removal torque allows easy disassembly yet provides maximum vibration and shock resistance for threaded parts

TYPICAL APPLICATIONS

RiteLok TL22 is formulated to prevent vibration loosening and to seal against leaks through threaded components. The low removal torque makes TL22 especially suitable for use on small threaded parts (<6mmØ) and where regular disassembly is envisaged. TL22 is ideal for small set screws and most types of small threaded nuts, bolts, screws and hex and slot driven components, including keyed fasteners. The low strength allows disassembly without stripping the heads off screws or bolts, so TL22 is particularly recommended for use on softer, non-ferrous metals, e.g. brass.

PROPERTIES OF MATERIAL

	Value
Chemical type	Dimethacrylate
Appearance	Purple
Specific Gravity	1.02
Viscosity cPs	(Range) ¹ 4,000-6,000
	(Typical value) ¹ 5,000
	(Range) ² 1,000-2,000
	(Typical value) ² 1,500
Breakaway Torque ³	range 5-11
(N.m)	typical 8
Prevail Torque ³	range 1-5
(N.m)	typical 3
Fixture Time ⁴	(mins) ≤15
Full Cure @20°C	(hours) 24
Flash Point	(°C) > 100
Shelf Life @ 20°C	(months) 12
Max Gap Fill	(mm) 0.25
Operating Temp Range	(°C) -50 to +150

¹ Brookfield RVT, spindle 2, 2.5rpm

² Brookfield RVT, spindle 2, 20rpm

³ On M10 black oxide steel bolt and M10 bright steel nut, ISO10964

⁴ ISO 10964

Typical curing speed⁴, % of final strength:-

15 mins	Finger tight
1 hour	~50% strength
24 hours	100% strength

Cure speed vs. substrate

Cure speed and strength vary according to the substrates. 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. Rite Lok AC64 activator may be used to accelerate cure speed.

Cure speed vs. bond gap

The size of the bond gap greatly affects the speed of cure of anaerobic adhesives. Bond gap varies with thread type and size of the fastener. The larger the gap between threads, the slower the cure speed. Maximum recommended gap for TL22 is 0.25mm.

Cure speed vs. temperature

All figures relating to cure speed are tested at 22°C. Lower temperatures will result in slower cure. Heating the assembled parts accelerates the curing process. Activator AC64 should be used when the temperature is less than 5°C.

Cure speed vs. activator

Where speed of cure is too slow or the bond gap is very large, RiteLok AC64 Anaerobic Activator may be used to accelerate cure speed. The use of an accelerator may reduce bond strength by up to 30%. Chemence recommends testing on the parts to measure the effect.

TYPICAL ENVIRONMENTAL RESISTANCE

Hot strength

RiteLok TL22 is suitable for use at temperatures up to 150°C. At 130°C the bond strength will be ~20% of the strength at 21°C.

Heat ageing

RiteLok TL22 retains ~90% full strength when heated to 100°C for 90 days then cooled and tested at 21°C.

TECHNICAL DATA

Chemical / Solvent Resistance

RiteLok anaerobics exhibit excellent chemical resistance to most oils and solvents including motor oil, leaded petrol, brake fluid, acetone, ethanol, propanol and water. Anaerobic adhesives and sealants are not recommended for use in pure oxygen or chlorine lines.

GENERAL INFORMATION

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

Anaerobic adhesives only cure in the absence of air and with metal part activation. Adhesive outside the joint will remain uncured and may be wiped away with a cloth.

TL22 is suitable for most smaller diameter, fine, medium and coarse-threaded screws, nuts and bolts. Not recommended on certain plastics as stress cracking can sometimes result. 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.

AC64 Activator may be required on plated parts.

DIRECTIONS FOR USE

Ensure parts are clean, dry and free from oil and grease.

Apply adhesive to all engaged threads. Assemble parts and allow to cure. Wipe excess adhesive from outside of joint.

Product is normally hand applied from the bottle. Dispensing systems are available for high volume assembly applications. Please contact your Rite Lok representative for further advice on dispensing solutions.

STORAGE

Store in a cool area out of direct sunlight. Refrigeration to 5° C gives optimum storage stability.

PRESENTATION

Bottles:10ml, 50ml and 250ml. Available in bulk for use with dispensing systems.

DATA RANGES

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.

NOTES

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