

TECHNICAL DATA SHEET

ORAPI 101-SCREWLOCK

Low Strength Anaerobic Threadlocker

Description

Orapi 101-Screwlock is a single component, low strength anaerobic threadlocking resin which cures to a tough, solid thermoset plastic when in contact with metal in the absence of air. The product is recommended for the locking and sealing of ferrous and non-ferrous metal fasteners (machine screws/nuts/bolts etc) replacing crown and “nylock” nuts, star and spring washers, wire retainers etc to prevent self-loosening.

Orapi 101-Screwlock is designed for use with smaller diameter fasteners (up to M3) or on larger diameter fasteners where the products low strength allowing easy dismantling is desirable.

Outstanding Features

- Resists loosening by shock loading and vibration
- Gives a fast and reliable cure on most metallic surfaces
- Seals and prevents “fretting” corrosion on threaded components
- Resistant to Water, Oils / greases, solvents and most industrial fluids
- Easy disassembly of locked components where necessary

Applications

- Suitable for use with most industrial / automotive metal fasteners
- Threaded components - Grub screws, nuts, bolts etc
- Components that require frequent disassembly
- Lightly oiled or slightly contaminated parts

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Directions for use

Ensure that surfaces to be bonded are clean and free from grease, dirt, dust and any other contamination. To ensure best cleaning results use **Orapi 503-Kleaner**. Unscrew cap and cut off the top of the nozzle using a sharp knife or similar implement taking care to point the blade away from the body at all times. Apply **Orapi 101-Screwlock** to the fastener in sufficient quantity to fill all engaged threads. Assemble the threaded components and tighten as required. Allow the bond to fully cure before putting equipment into service.

For reduced cure time or use with “inactive” metals / plastics.

Cure time(s) of anaerobic resins can be reduced by when the product is used in conjunction with **Orapi Anaerobic Activator**. When components manufactured from “inactive” metals and some plastics are encountered use of an **Orapi Anaerobic Activator** will primarily increase the effectiveness of the adhesive / sealant while also reducing cure times.

To reduce cure time

Apply the selected activator to one surface and allow to dry. Apply resin to the other surface and assemble components, tighten as required.

Use with “inactive” metals / plastics (i.e. stainless steel)

Apply the selected activator (**Orapi 3140 / 3141**) to both surfaces and allow to dry. Apply resin in the normal manner and assemble components, tighten as required.

Typical Characteristics

Appearance	:	Viscous purple liquid
Base	:	di-Methacrylate resin
Viscosity ((@ 20 ⁰ C)	:	1200 - 5000 cPs
SG (kg / ltr)	:	1.1

Cure speed

Handling*	:	10 to 25 mins
Full cure	:	24 hours
Gap filling capability	:	Upto 0.1mm
Temperature range	:	-55 ⁰ C to +150 ⁰ C

Bond Characteristics

Breakloose Torque*	:	5 - 15 Nm
Prevailing Torque*	:	2 - 18 Nm
Static Shear*	:	7 - 12 Nm

*Tested on M10 mild steel nut and bolt.

Health & Safety

Further Technical Data and Health & Safety (COSHH, MSDS) is available from the Technical Department Orapi Limited, Unit 1, Rosse Street, Bradford, BD8 9AS, West Yorkshire, England.

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The information contained in this bulletin is based on our experience and reports from customers.

Where stated the figures listed are typical of normal production only.

There are many factors outside our control, which can affect the products performance for which reason the information supplied is given without responsibility.