



TECHNICAL DATA

GRADE X12-77 BOLTLOCK

Thread Locking High Strength

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Product Description

ROCOL Grade X12-77 is a single component, high viscosity anaerobic threadlocking material which develops high strength. This product cures when confined in the absence of air between close fitting metal surfaces.

Typical Applications

Prevents loosening and leakage of threaded fasteners. Typical applications include locking and sealing of large bolts and studs (M25 and larger).

Physical Properties

Liquid Product:

| | |
|--|-------------------------------|
| Chemical base: | Diester of Methacrylic Acid |
| Colour: | Red / Fluorescent |
| Viscosity mPas (25°C Brookfield RVT spindle rpm 4/20): | 6000-7000 |
| Density: | 1.1 g/cm ³ |
| Max. thread diameter: | 2 inches |
| Max. gap filling: | 0.30 mm |
| Flash point: | > +100°C |
| Shelf life: | 24 months at room temperature |

Cured Product:

Measured on M10 x 20 bolt - grade 8.8 zinc galvanised - nut 0.8d
(no on-torque)

| | |
|----------------------------|-----------------|
| Initial strength after: | 40 - 60 minutes |
| Functional strength after: | 6 - 12 hours |
| Final strength after: | 12 - 24 hours |

| | |
|------------------------------|---------------------------|
| Loose-break torque: | 25 – 35 Nm (M10) |
| Prevailing torque: | 35 – 45 Nm (M10) |
| Shear strength (DIN 54 452): | 15 – 25 N/mm ² |
| Thermal range: | - 55°C up to +150°C |

ROCOL Industrial Adhesives

ROCOL House, Swillington, Leeds LS26 8BS, England.

Tel: 0113 232 2600 Fax: 0113 232 2760

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The information in this publication is based on our experience and reports from customers.
There are many factors outside our control and knowledge which effect the use and performance of our products
for which reason the information in this publication is given without responsibility

X12-77

Pack size and part code

50ml part code 73033

Health and Safety

Health and Safety information (SDS) is available from the Customer Service Department, ROCOL Lubricants, Swillington, Leeds, LS26 8BS, England.

Telephone: 0113 232 2700. (When calling from outside UK: 44 113 232 2700).

Fax: 0113 232 2760. (When faxing from outside UK: 44 113 232 2760).

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