



Pre-Applied Adhesives

Advantages

High Breakaway Torque

Low Installation Torque

Fast Curing

Plate and Patch service

Easy identification

Not effected by most oils and solvents

Working temperatures -56°C to +200°C

Controlled Patch Position

Replaces Liquid Adhesives

Replaces mechanical locking devices

PRELOK®

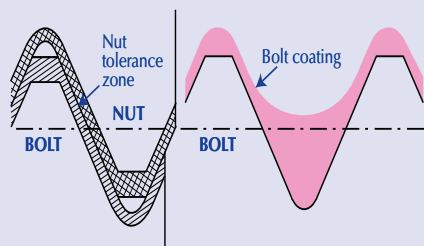
PRELOK® is the European market leader for pre-applied locking and sealing solutions for threaded components. We are constantly working closely with our material suppliers to develop new products and processes, which offer innovative jointing solutions to meet the ever changing demands from our customer base.

Pre-Applied Adhesives

Our pre-applied adhesive products contain micro-encapsulated components of the adhesive material, which are coated onto the screw threads, forming a brightly coloured identifiable, dry to touch ready to use high performance adhesive coating.

The thread coated with the pre-applied adhesive develops the desired locking and sealing properties, when compression or shear stress ruptures the micro-capsules upon assembly of the screw into the corresponding mating component. The adhesive components are released and within a short time the compound hardens, with the threads becoming locked, bonded together and forming a reliable seal.

The Micro Encapsulated Adhesive Principle



A. The Pre-applied process consists of applying the micro-encapsulated adhesive onto a defined area of the male thread surface.

B. The adhesive coating is inert, dry to touch, ready to use.

C. Upon assembly into the mating threaded component the micro-capsules rupture, developing a secure locking of the 2 components with a high strength adhesive bond.

Industry Approvals

The PRELOK® pre-applied adhesive products are approved to a wide range of industry standards including:

DIN 267 Part: 27

IFI 125/525

BS 7795 : 1995

Ford (WX200 & WX201)

GM 6175M

Perkins Engines

Jaguar/Landrover STJLR.60.5020.X200

and many more...



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Pre-Applied Adhesives

Product Guide

Product	Colour	Type	Max Patch Length	Standard Patch Length	Standard Patch Lead	Storage Life	Operating Temp (°C)	Sealing Capacity (M10 Thread)	Coefficient of Friction	Full Cure Time (hrs)	Size Range
Precote® 80	Pink	Acrylic	50mm	4-6 Pitches	1-2 Pitch Lead	4 Years	-50 + 170	>200 Bar	0.25/0.28	12	M4-M30
Precote® 85	Turquoise	Acrylic	50mm	4-6 Pitches	1-2 Pitch Lead	4 Years	-50 + 170	>200 Bar	0.1/0.15	12	M4-M30
Precote® 30	Yellow	Acrylic	50mm	4-6 Pitches	1-2 Pitch Lead	4 Years	-50 + 150	>200 Bar	0.1/0.15	12	M4-M30
Scotchgrip® 2353	Dark Blue	Epoxy Resin	50mm	4-6 Pitches	1-2 Pitch Lead	2 Years	-60 + 116	>200 Bar	0.16/0.18	48	M4-M30
Scotchgrip® 2510	Orange	Epoxy Resin	50mm	4-6 Pitches	1-2 Pitch Lead	2 Years	-40 + 200*	>200 Bar	0.26/0.28	72	M4-M30

* Designed for applications where the service temperature might reach continuously up to 149°C or intermittently up to 204°C.

Table: extract from BS 7795:1995

Thread size	Breakaway torque Nm	
	Maximum	Minimum
M6 x 1	8	2
M8 x 1.25	24	4
M10 x 1.5	44	10
M12 x 1.75	80	15
M14 x 2	130	20
M16 x 2	160	30

Note: Adhesive performance to BS 7795 - 1995 standard is based on Precote 80 & 85, and Scotchgrip 2353 & 2510

- We currently process a range of Headed Components, Studs, Plugs and similar parts.
- We can apply our coating to ferrous or non-ferrous materials (Steel, Aluminium, Brass or Stainless Steel and some plastic materials).
- With our strategic Plating alliances we offer a complete one-stop-shop Plate and Patch service.
- This is a general guide to the products we currently process.
- We are able to process other components subject to evaluation.
- Re-usability of micro-encapsulated adhesives is not recommended.

PRE-PRODUCTION SAMPLES ARE EVALUATED AND THEN PROCESSED FREE OF CHARGE

Recommendations

Hole Preparation

In all cases the female thread of the mating components should have the lead thread de-burred or countersunk to avoid damage to the patch material upon assembly.

Thread Preparation

To obtain optimum adhesive performance both male and female threads should be in accordance with class 6g/6H (metric) or class 2 a/b (unified).

Finishes

Pre-applied adhesives can be applied to most popular plated finishes, as well as polymer and organic coatings. Epoxy products should be avoided with Aluminium as the resultant reaction can cause assembly problems.

Scotchgrip® 2353

Uses a hardening product which is hydroscopic, and therefore contact with moisture (which may exhibit a whitening effect) prior to assembly should be avoided.

