MASTIKOL®
TOTALE ADESIONE ALL'INNOVAZIONE

CERTIFIED QUALITY MANAGEMENT SYSTEM
CQY CERTIQUALITY
UNI EN ISO **9001:2015**

TECHNICAL DATA SHEET – FEBRUARY 2023

MK 7270

One-component anaerobic adhesive suitable for braking or locking threaded parts against loosening caused by vibrations. It cures spontaneously if in the absence of air and between metal surfaces with reduced gap.

TECHNOLOGY	ACRYLIC RESIN
APPLICATION	THREADLOCKER
STRENGTH	HIGH
COLOUR	GREEN

PROPERTIES

Technology	Methacrylate resin
Colour	Green
Density @ 23°C	1.06 ± 0,02 g/ml
Viscosity @ 23°C	300 ÷ 500 cps
Flash point	>100°C

PERFORMANCE

ISO – 10964

Breakaway torque	45 ÷ 55 N·m
Residual Breakaway torque	40 ÷ 50 N·m
Operating Temperature	- 55 ÷ +150 °C
Maximum gap filling	0.10 mm

CHEMICAL RESISTANCE

Test method DIN-54454
Breakaway torque % evaluated after immersion

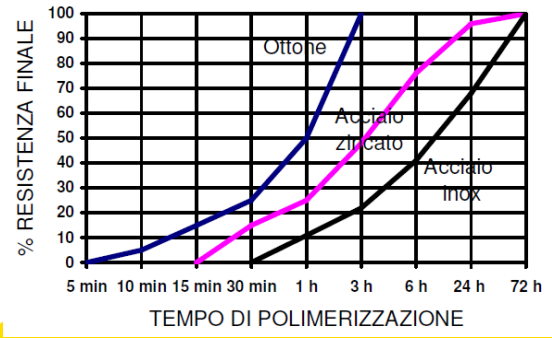
	T° C	100 h	500 h	1000 h
H_2O/Glycol	85	100	90	90
Brake fluid	22	100	90	90
Motor oil	125	100	90	90
Acetone	22	100	90	90

DESCRIPTION

MK 7270 is a one-component anaerobic product suitable for permanent braking of screws and nuts and other threaded parts against loosening caused by vibrations. The product polymerizes spontaneously when it is in the absence of air within metal surfaces with little play. The strong mechanical resistance offered by MK 7270 does not allow disassembly after application with normal tools. Fluid braking for small diameter threads.

Ambient temperature affects the reaction rate. The ideal polymerization temperature is between 20 °C and 25 °C. Temperatures between 5 °C and 20 °C slow down the reaction, higher temperatures speed it up.

VELOCITA' DI POLIMERIZZAZIONE



The curing speed is influenced by two main factors: the nature of the materials, the temperature at which the reaction takes place. The graph demonstrates the behaviour of the product on some types of metal.
The tests were conducted using galvanized M10 screws and evaluated according to ISO 10964 standards.

MASTIKOL SRL
STRADA CIRCONVALLAZIONE, 186/8 - 10026 SANTENA (TORINO) - ITALY
P: +39 0119493746 W: WWW.MASTIKOL.COM E: MASTIKOL@MASTIKOL.IT

PROFESSIONAL BONDING SOLUTION

APPLICATION

- Before proceeding with bonding, prepare the substrates (see paragraph "recommendations")
- Apply the adhesive on one of the two surfaces to be bonded and assemble the components with great care.
- Remove excess glue before it cures.
- Allow the adhesive to react for the time necessary for it to develop sufficient resistance to handling.
- If the curing rate is too slow, use an activator. Allow the activator to dry as long as necessary
- To prevent the product from obstructing the spout, prevent it from coming into contact with metal surfaces during dispensing.
- For through holes, apply the product to the bolt in the area of engagement with the nut.
- In the presence of blind holes, apply a few drops of product directly into the hole.
- For sealing, apply 360° beads of product to the guide threads of the male, leaving the first one empty. For large diameter fittings, apply the product evenly distributing it on the female.
- Assemble and tense as required.

PROPERTIES AND USES

- This product is not suitable for metal-plastic couplings and in oxygen circuits as well as for sealing systems with basic products or strongly oxidizing acids.
- For best performance it is recommended to work on clean, dry and degreased surfaces.
- Apply the product over the entire engaged surface and tighten thoroughly.
- Fast polymerization.
- Excellent resistance to fatigue, shocks and high loads.
- Good resistance to acids and bases and hydrocarbon solvents
- This product offers the best performance with contained gap.
- On passivated metal surfaces use the product in combination with an activator.

RECOMMENDATIONS

Substrate preparation

The substrates must be thoroughly clean, dry and free of oil, grease and dust which can certainly affect the quality of the bonding. Best cleaning by use of isopropyl alcohol MK-WIPES, MK Sol-Neo or MK Sol-13 in accordance with local regulations. Degrease the PVC and metal surfaces with a non-greasy solvent. Always check the compatibility of your solvents with the substrate to be bonded. If necessary, slightly sand or strongly abrade the surfaces to be bonded.

PRECAUTIONS FOR USE

Mastikol® products should be used following the normally precautions adopted during chemical substances handling. It is recommended to wear rubber or latex gloves and to protect the eyes adequately. Thoroughly clean the skin at the end of the work shift with warm soapy water. The use of solvents is not recommended. Dry yourself with paper wipes. It is recommended to ventilate the work area well.
These precautions are detailed in the Safety Data Sheets relating to the individual products and should be referred to for a complete information.

STORAGE AND PACKAGING

It can be stored for nine months in the original and sealed containers kept in a cool and dry environment.

Storage temperatures must be between 11°C and 23°C. Prolonged storage at a temperature above 23°C will reduce shelf life and the expiration date. Avoid direct contact with sunlight.

Bottles of 50 | 250 ml

20 LT Pails | 200 LT for industrial usage.

NOTES

The information, in particular, the recommendations relating to the applications and use of Mastikol® products, are given in good faith and are based on current knowledge and experience of the products, when properly stored, handled and applied under normal conditions. Mastikol® assumes no responsibility for the results obtained by third parties for which there is no control over the method.

It is the customer's responsibility to confirm the suitability of the product for the application. As it is not possible to control the application, use or processing of the products; no liability is assumed in this regard. The customer must ensure that the use of the products does not infringe any third party intellectual property rights. Specifically, Mastikol® disclaims all express or implied warranties, including warranties of merchantability or fitness for specific purposes, arising from the sale or use of Mastikol® products. No liability is accepted for consequential or incidental damages of any kind, including loss of profit.

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