

# iBiotec®

**MANUFACTURER OF TECHNICAL AEROSOLS AND PRODUCTS FOR INDUSTRY  
PROCESSES - MRO - MAINTENANCE  
ALTERNATIVE SOLVENTS 100% SAFE**

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## LOCK IT! Threaded locks

**Low, medium and high resistance**

**LOCK B 15** Low Resistance Locking

**LOCK R 25** Medium Resistance Locking

**LOCK V 29** High Resistance Locking



## APPLICATIONS

Locking on threaded elements: threaded joints, screwed joints, rigid, removable or non-removable, bolts (screws + nuts), blind or threaded through holes, studs, axes including through pins.

The threadlock polymerises in the absence of air and in the presence of metal particles. Once set, the threadlock holds the fastener firm against loosening forces, vibration and shock.

## PHYSIOCHEMICAL FEATURES

FEATURES	LOCK B 15	LOCK R 25	LOCK V 29
Chemical basis	Dimethacrylate	Dimethacrylate	Dimethacrylate
Density at 20°C	1,04	1,08	1,04
Brookfield viscosity at 25°C	5000 mPa.s (cPs)	7000 mPa.s (cPs)	500 mPa.s (cPs)
Flash point	>100°C	100°C	100°C
POLYMERISATION	LOCK B 15	LOCK R 25	LOCK V 29
Type of reaction	Anaerobic	Anaerobic	Anaerobic
Setting time for steel-to-steel bonding: . Partial . Total	15 minutes 24 hours	15 minutes 24 hours	15 minutes 24 hours
Polymerisation speed is influenced by the type of materials, the play of the joint and the temperature			
PERFORMANCE	LOCK B 15	LOCK R 25	LOCK V 29
Unlocking coupler on M10 steel bolt no preload	15 N.m	25 N.m	29 N.m
Maximum play	0.25 mm	0.25 mm	0.2 mm
Temperature resistance	-50/+150°C	-50/+150°C	-50/+150°C
Good resistance to fuels, oils, brake fluids and coolants			

## RESTRICTIONS

Anaerobics should not be used in oxygen-carrying circuits that could interfere with the polymerisation reaction. These adhesives are generally intended for metal joints because the metal ions act as a catalyst in the polymerisation.

## IMPLEMENTATION AND HOW TO USE

Surfaces to fix must be clean, dry and grease-free. For ultra-thorough cleaning and degreasing, use **BIOSANE NF 100** [www.nettoyantfreins.com](http://www.nettoyantfreins.com). For untreated parts, adhesion of the adhesive to the substrates is favoured by mechanical or chemical etching. The adhesive must be liberally applied to fill the joint gap. Excess adhesive can be wiped off with a rag because it does not polymerise in the air.

Shake the bottle thoroughly before use.

Don't let the end of the application nozzle touch the surface of the metal after removal.

(this results in plugging the end of the nozzle, LOCK being an anaerobic chemical adhesive).

Apply several drops of the product on the joint at the point of entry into the nut, if there are blind holes apply the product all along the thread up to the bottom of the hole. When the desired tightness is reached, apply on 360°C, including on the female part.

Before starting, choose the proper resistance class needed to unlock the LOCK by determining if the piece will need to be disassembled at some point in the future.

## SHELF LIFE - STORAGE

The shelf life of the product is 1 year under standard storage conditions: original packaging, dry room, temperatures between 8 and 20°C.

## OCCUPATIONAL HEALTH AND SAFETY CONCERNS

Anaerobic resins are irritants to the eyes and skin. Use the proper personal protection gear when handling. See the safety data sheet for more information.

Made in France

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### USAGE RESERVE AUX UTILISATEURS PROFESSIONNELS

Consulter la fiche de données de sécurité.

Les renseignements figurant sur ce document sont basés sur l'état actuel de nos connaissances relatives au produit concerné. Ils sont donnés de bonne foi. Les caractéristiques y figurant ne peuvent être en aucun cas considérées comme spécifications de vente. L'attention des utilisateurs est en outre attirée sur les risques éventuellement encourus lorsqu'un produit est utilisé à d'autres usages que ceux pour lequel il est conçu. Parallèlement, le client s'engage à accepter nos conditions générales de marché de fournitures dans leur totalité, et plus particulièrement la garantie et clause limitative et exonératoire de Responsabilité. Ce document correspond à des secrets commerciaux et industriels qui sont la propriété de Tec Industries Service et, constituant un élément valorisé de son actif, ne saurait être communiqué à des tiers en vertu de la loi du 11 juillet 1979.