



$l_0 \approx$ length of thread

$l_1 \approx$ from 2 to 3 times the pitch (p) of the thread

$l_2 \approx$ 1.5 times the diameter (d) of the thread

MVK

Fixing the threads (by self-gluing).

Coating with microencapsulated hardener (red).

d	l_1	$l_2 \approx$	Max screwing torque (Nm)	Min craking torque (Nm)	Max unscrewing torque (Nm)
M5	1.5 ÷ 2.5	7.5	1	1	6.5
M6	2 ÷ 3	9	1.5	1.8	10
M8	2.5 ÷ 4	12	3	4	26
M10	3 ÷ 4.5	15	5.5	10	55
M12	3.5 ÷ 5	18	7.5	16	95
M16	4 ÷ 6	24	14	35	250
M20	5 ÷ 7.5	30	22	45	500

The torque values respect the DIN 267 standard, part 27, and are based on clamping tests without preloading, with a 6H nut and at ambient temperature.

For a thread of $l_0 < l_2$, the length l_2 is reduced to the point that one or two of the last thread turns are left uncovered (l_1).

The glue is made up of a liquid plastic and a hardener contained in microcapsules of polymer coated with a red film visible on a part of the thread.

During the screwing operation, the capsules open under the pressure caused by the friction between the two threads.

The liquid plastic and the hardener react chemically with one another to lock the thread in position.

The setting and positioning operations must be completed within a period of about 5 minutes, as the glue will start to set after about 10-15 minutes. An initial hardening sufficient to fix the thread is reached after about 30 minutes while complete hardening of the fixture will take place over a period of 24 hours.

The threaded element glued in this way may be unlocked by applying a torque equivalent to the one indicated in the table for each thread or by heating the element up to a temperature of over 180°C.

Reuse after unlocking is not recommended.

Threads free of oil and grease guarantee the maximum fixing effect of the glue.

Elements treated with this glue may be stored for a period of up to 4 years, without any deterioration in their properties.

Threads with MVK microencapsulated glue are generally used on machines subjected to vibrations, in order to prevent spontaneous unscrewing.

Not suitable for adjusting bolts or screws.

This security aspect may be essential for certain applications of standard parts. Stock holding of liquid glue is eliminated.

Low torque.

The working temperature range is from -40°C to +170°C.

To order an article with microencapsulated glue, add the abbreviation MVK to the product description.

Example:

Spring plunger

GN 615.3-M8-K-MVK