



Locking of screwed fastenings

Note: When inquiring about 5 digit part numbers beginning with 8, please preface the number with R264-. Example: 88111 should be R264-88111.

Table 3: Overview of form-fitting locking devices against unscrewing in the Maryland Metrics product range

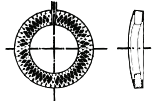
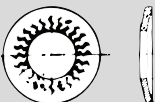
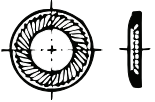

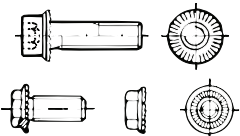
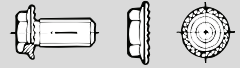
R264 - article		Special features
88130 – 88131	Lock rings	 <p>Duplex structured surface and bulging → this also balances out small intrusions of parts into materials</p>
88123 – 88126	Lock washers	 <p>To a certain extent, bulging also balances out intrusions of parts into materials, similar to conical spring washers.</p>
88120 – 88121	SCHNORR safety washers	 <p>Duplex serrated surface and bulging → this also balances out small intrusions of parts into materials</p>
88132	Nord-Lock washers	 <p>Each consisting of one washer pair, stuck as a pair for simple assembly. The external surfaces have ridges which are embossed into the surface of the components. The interior surfaces are wedge-shaped. During assembly, the interior surfaces only slide on top of each other → this means that the friction coefficient remains constant, which makes it possible to determine a precise specification for the tightening torque</p>
88912 88913 88914	Flange screws/Flange nuts with ribs	 <p>The assembly process is made easier thanks to the pressed flange with ribs as individual washers do not need to be used.</p>
88933 88934	Locking screws/Locking nuts with serrations	 <p>The assembly process is easier thanks to the pressed flange with serrations as individual washers do not need to be used. The special design of the flange balances out intrusions of parts into materials to a limited degree.</p>

Table 4: Product recommendation for anaerobic adhesives for locking screwed fastenings into place.

Material	Strength classification according to ISO 10964 - M10		
	Low strength screw locking	Medium strength screw locking	High strength screw locking
Steel	Loctite 221, 222, 225	Loctite 241, 243, 245	Loctite 270, 272, 275
Brass	Loctite 222	Loctite 243	Loctite 270, 278
Stainless steel (A2 to A5)	Loctite 222	Loctite 243	Loctite 2701, 278
Aluminium	Loctite 222	Loctite 243	Loctite 2701
Zinc plated and chromated	Loctite 221, 222, 225	Loctite 241, 243, 245	Loctite 270, 272, 275
Hot dip galvanized	Loctite 222	Loctite 243	Loctite 2701
Browned	Loctite 221, 222, 225	Loctite 241, 243, 245	Loctite 270, 272, 275
Nickel plated	Loctite 222	Loctite 243	Loctite 276
Geomet 321 Plus ML	Loctite 222	Loctite 243	Loctite 2701
Geomet 321 Plus VL	Loctite 222	Loctite 243	Loctite 2701
Geomet 500	Loctite 222	Loctite 243	Loctite 2701
Delta Protect KL 100-301 GZ	Loctite 222	Loctite 243	Loctite 2701
Delta Protect KL 105	Loctite 222	Loctite 243	Loctite 2701, 278
Delta Tone 9000 +DS GZ	Loctite 222	Loctite 243	Loctite 2701

Viscosities and further details can be found in the data sheets - www.loctite.de

Service temperature: -55 °C - 150 °C, exception: Loctite 278: -55 °C - 200 °C
 Reducing the break-off strength of coatings and inactive materials is possible.

→ Preliminary experiments are recommended.

Source: **LOCTITE**