


















## THREADLOCKERS

## Technical Information

### Lockfast® Threadlockers

Anaerobic threadlockers are a type of adhesive that will cure in the absence of oxygen between close fitting metal parts. As a result, they can be used on all threaded fasteners to prevent corrosion, leaking and loosening caused by vibration, shock and thermal expansion.

	UV Positive	Viscosity Range (cP)	Breakaway Torque (N.m)	Prevail Torque (N.m)	Service Temp (°C)	Fixture Time/ Full Cure	Scan QR Code for SDS
 <p><b>T22</b> Low Strength Non-Permanent Bond</p> <p><b>SCREWLOCK</b></p> <p>A purple, low strength, low viscosity thread locker. Ideal for small diameter screws and low strength materials.</p>	Yes	900-1500 Thixotropic	6	4	-54 to 150	<15min/ 24hr	
 <p><b>T42</b> Medium Strength Semi-Permanent Bond</p> <p><b>NUTLOCK</b></p> <p>A blue, medium strength, general purpose thread locker. Particularly suited for less active substrates such as stainless steel.</p>	Yes	900-1400 Thixotropic	8-19	3-7	-54 to 150	<5min/ 24hr	
 <p><b>T43</b> Medium-High Strength Oil Tolerant</p> <p><b>NUTLOCK</b> </p> <p>A blue, medium strength, oil-tolerant nutlock. Useful on 'as received' fasteners, where cleaning is not possible or minor oil contaminants.</p>	Yes	1300-3000 Thixotropic	26	5	-54 to 150	<10min/ 24hr	
 <p><b>T70</b> High Strength Permanent Bond</p> <p><b>STUDLOCK</b></p> <p>A green, high strength studlock designed for the permanent locking of threaded fasteners in heavy duty applications such as motor housings.</p>	Yes	500-900	26-50	>15	-54 to 150	<10min/ 24hr	
 <p><b>T71</b> High Strength Permanent Bond</p> <p><b>STUDLOCK</b></p> <p>A red, high strength studlock designed for the permanent locking of large threaded studs and bolts (M25+) heavy duty industrial applications.</p>	Yes	400-600	17-40	23-40	-54 to 150	<10min/ 24hr	
 <p><b>T72</b> High Strength High Temperature</p> <p><b>STUDLOCK</b> </p> <p>A red, high strength, high temperature resistant (230°C) studlock designed for the permanent locking of threaded fasteners.</p>	No	4000-15000 Thixotropic	34	36	-54 to 230	<30min/ 24hr	
 <p><b>T90</b> High Strength Penetrating Grade</p> <p><b>PRE-ASSEMBLED THREADLOCK</b> </p> <p>A green, high strength, very low viscosity Threadlocker designed for the locking of threaded fasteners, suits pre-assembled parts.</p>	Yes	20-55	10	29	-54 to 150	<20min/ 24hr	

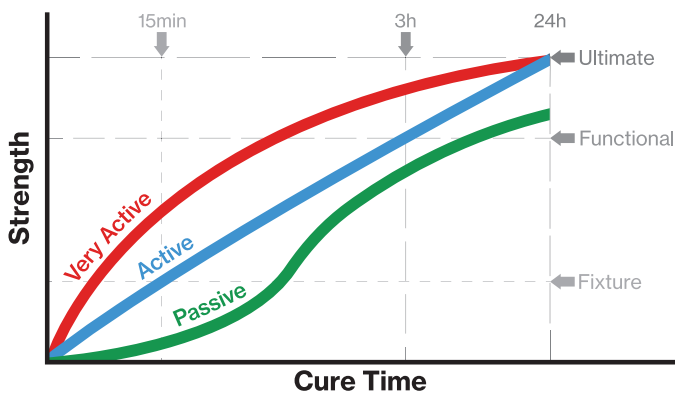
## Directions For Use

1. For optimum performance surfaces should be clean and free of grease.
2. If the material is an inactive metal consider using activator.
3. Shake the product thoroughly before use. Apply several drops to the bolt & nut.
4. Assemble and tighten as required.
5. To prevent the clogging of the nozzle, do not let the tip touch metal surface during application.

### Fixture Time vs. Substrate

There may be a difference in fixture speed and strength based on the substrate. As opposed to passive materials such as stainless steel or zinc dichromate, anaerobic adhesives will reach full strength more rapidly with active materials such as mild steel and brass.

See the graph below for an example of how this may affect fixture and functional strength times, ultimate strength may be achieved in 24 hours, or occasionally longer.



The graph depicted is for illustrative purposes and is for guidance only.

### Substrate Reactivity

The table below lists substrates by reactivity.

Very Active	Passive	
Brass	High-alloy Steel	Stainless Steel
Copper	Aluminium	Oxide Films
Active	Nickel	Chromate Films
Mild Steel	Zinc	Anodic Coatings
Bronze	Silver	Plastics
Iron	Gold	Ceramics

### Fixture Time vs. Temperature

Fixture times will be longer at lower temperatures. It is possible to accelerate the fixture time of assembled parts by heating them or using an activator.

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### Fixture Time vs. Bond Gap

Fixture speed of anaerobic adhesives is greatly affected by bond gap size. Fastener size and thread type determine bond gap. A larger gap between threads can result in a prolonged fixture time.

### Fixture Time vs. Activator

When the cure time is too slow or the bond gap is too large, activators can be used to accelerate the fixture time. Activators can reduce bond strength by up to 30%.

### Chemical Resistance

The chemical resistance of anaerobic adhesives to various oils and solvents, including motor oil, leaded petroleum, brake fluids, acetone, ethanol, propanol, and water, is exceptional.

### Disassembly and Cleanup

Remove with standard hand tools. In circumstances where hand tools do not work, use localised heat to bolt or nut, disassemble while hot. To remove cured product use a combination of solvent and abrasion such as a wire brush.

### Storage

Store in a cool area and out of direct sunlight. Keep product between 8°C and 21°C to give optimum storage stability.

### General Information

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be used with chlorine or other strong oxidising materials. Where washing systems are used to clean the surfaces before bonding, it is important to check the compatibility of the washing solution with the adhesive. In some cases these solutions can affect the cure and performance of the adhesive. This product is not recommended for use on certain plastics. **For information on safe handling of this product consult the Safety Data Sheet (SDS).**

SCAN FOR FULL LOCKFAST RANGE

