

BLUE MEDIUM STRENGTH THREADLOCKER MEDIUM VISCOSITY PART NO. 49442

PHYSICAL PROPERTIES

Monomer (Liquid)

| | |
|-------------------------------|---------------------------------|
| Base Compound | Dimethacrylate Ester |
| Color..... | Blue |
| Viscosity (cP @ 68°F) | 1000 cP |
| Flash Point (TCC)..... | >200°F |
| Gap Fill | .007" |
| Corrosivity..... | None |
| Toxicity | Low |
| Specific Gravity (g/cc) | 1.1 |
| Shelf Life @ 40°F | 1 year unopened |
| Military Specifications..... | Mil-S-46163A Type II Grade N |

Curing Properties..... Depends on environmental conditions and the substrates used

Polymer (Cured)

| | |
|---|----------------|
| Locking Strength | Medium |
| Service Temperature Range | -75°F to 300°F |
| Appearance | Blue liquid |
| Shear Strength (steel nuts and bolts) | 1200 psi |
| Full Cure Time | 24 hours |



DESCRIPTION

Dynatex® Blue Medium Strength Threadlocker is a medium strength anaerobic threadlocking material, which cures between engaged threads to form a unitized assembly that resists virtually all leakage, shock and vibration. The product is a single component, anaerobic liquid that cures when confined in the absence of air between close fitting metal surfaces. Ideal for all ¼ inch to ¾ inch diameter nut and bolt assemblies. Fills gaps up to .006 inches. Applied prior to assembly. Eliminates need for stocking lock nuts and lock washers. Excellent chemical resistance with a temperature resistance range of -65°F to 350°F (-54°C to 177°C). Easily removable with hand tools for servicing requirements. Protects against thread corrosion.

FEATURES

- No mixing
- No curing outside of joint
- Eliminates vibration issues
- Seals against leakage
- Can be adjusted or disassembled
- Cures without cracking or shrinking
- Prevents rusting of threads
- No torque compensation required during assembly

TYPICAL APPLICATIONS

- Cup and core plugs
- Starter mounting bolts
- Alternator mounting bolts
- Oil pan bolts
- Intake manifold bolts
- Drive shaft bolts
- Pulley bolts
- Valve cover bolts and more.....

PERFORMANCE OF CURED MATERIALS

Bond strength after 24 hours at 20°C to 25°C on steel nuts and bolts

| | Average Value | Range |
|-------------------|---------------|------------------|
| Breakaway Torque | 125 in. lbs. | 100-150 in. lbs. |
| Prevailing Torque | 70 in. lbs. | 35-100 in. lbs. |

CURING PERFORMANCE

The gap of the bond line will affect set speed. Smaller gaps tend to increase the speed. Activators can be applied to improve set speed but may also impair overall adhesive performance.

SETTING TIME (68°F, 65% R.H.)

| Substrate | Set time/Full cure |
|-----------------|--------------------|
| Steel | 10 min/24 hrs |
| Brass | 15 min/24 hrs |
| Zn Dichromate | 20 min/24 hrs |
| Stainless Steel | 20 min/24 hrs |

CHEMICAL RESISTANCE

Shear strength on steel after 500 hours.

| Solvent | % Strength Retained |
|-------------------|---------------------|
| Motor Oil | 100 |
| Unleaded Gasoline | 100 |
| Trichloroethane | 100 |
| Brake Fluid | 100 |
| Ethanol | 100 |
| Acetone | 100 |
| Water/Glycol Mix | 80 |

GENERAL INSTRUCTIONS

Surfaces to be bonded should be clean and dry and free of grease.

Product should be applied in enough quantity to fill all engaged threads. The product performs best in thin bond gaps. Very large gaps may create gaps, which will affect the cure speed and overall strength. Good contact is essential. An adequate bond develops in 15 to 45 minutes and maximum strength is attained in 24 hours.

This product is not recommended for use in pure oxygen environments and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

This product is not designed for plastics, particularly thermoplastics where stress cracking of the plastic could result. It is recommended to confirm compatibility of the product with all substrates prior to use.

STORAGE AND SHELF LIFE

When stored in the original unopened containers at or below 90°F (32°C), *Dynatex® Blue Medium Strength Threadlocker* has a shelf life of 12 months from date of shipment.

In Countries where high heat and humidity are a factor, special precautions must be taken. Store product in a covered, well-ventilated warehouse and avoid excessive heat conditions. Storage in high heat, high humidity conditions may reduce shelf life by up to 30%. Rotation of stock is an absolute necessity. Cartons should always be stacked upright. DO NOT stack cartons on their side. **NEVER** stack cartons more than 8 high. DO NOT store within 1 meter (4 feet) of roofline of the warehouse or storage building.

USERS PLEASE READ

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It is the user's responsibility to thoroughly test any proposed use of our products and independently conclude satisfactory performance in the application.

Likewise, if the application, product specifications or manner in which our products are used requires government approval or clearance, it is the sole responsibility of the user to obtain sure authorization.

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