

BLUE MEDIUM STRENGTH BOLTLOCKER MEDIUM VISCOSITY PART NO. 49444

PHYSICAL PROPERTIES

Monomer (Liquid)

Base Compound	Dimethacrylate Ester
Color.....	Blue
Viscosity (cP @ 68°F)	1000 cP
Flash Point (TCC).....	>200°F
Gap Fill007"
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 Boltlocker 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 Boltlocker** 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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