

RED HIGH STRENGTH BOLTLOCKER HIGH VISCOSITY PART NO. 49454

PHYSICAL PROPERTIES

Monomer (Liquid)

Base Compound	Dimethacrylate Ester
Color.....	Red
Viscosity (cP @ 68°F)	2500 cP
Flash Point (TCC).....	>200°F
Gap Fill010"
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 O
Curing Properties	Depends on environmental conditions and the substrates used

Polymer (Cured)

Locking Strength	Medium
Service Temperature Range	-75°F to 300°F
Appearance.....	Red liquid
Shear Strength (steel nuts and bolts)	3000 psi
Full Cure Time	24 hours



DESCRIPTION

Dynatex® Red High Strength Boltlocker is a single component, anaerobic liquid which cures when confined in the absence of air between close fitting metal surfaces. **Dynatex® Red High Strength Boltlocker** is a high strength anaerobic threadlocking material that cures between engaged threads to form a unitized assembly that resists virtually all leakage, shock and vibration. Ideal for all ¼ inch to ¾ inch diameter nut and bolt assemblies where future disassembly is improbable. Provides a positive seal that resists most fluids. Prevents nuts, bolts and other fasteners from loosening due to vibration. Works in temperatures from -65°F to 350°F (-54°C to 177°C). Fixture tight in minutes. Protects against thread corrosion.

FEATURES

- Eliminates vibration issues
- Cures without cracking or shrinking
- Prevents rusting of threads
- Seals against leakage
- No mixing
- No curing outside of joint

TYPICAL APPLICATIONS

- Shock absorber bolts
- Frame bolts
- Cylinder block
- Rocker arm studs
- Ring gear bolts
- Fan hub bolts

SETTING TIME (68°F, 65% R.H.)

Substrate	Set time/Full cure
Steel	15 min/24 hrs
Brass	30 min/24 hrs
Zn Dichromate	25 min/24 hrs
Stainless Steel	35 min/24 hrs

CHEMICAL RESISTANCE

Sheer strength on steel after 500 hours.

Solvent	% Strength Retained
Motor Oil	90
Unleaded Gasoline	100
Trichloroethane	90
Brake Fluid	100
Ethanol	90
Acetone	95
Water/Glycol Mix	95

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	190 in. lbs.	130-250 in. lbs.
Prevailing Torque	230 in. lbs.	140-275 in. lbs.

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® Red High 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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