

# MEDIUM STRENGTH BLUE THREADLOCKER

PART NO. AT75

## **DESCRIPTION**

AT75 is a single-component, blue, medium-strength, anaerobic threadlocking adhesive. This formula is designed to prevent the loosening of threaded fasteners and is suitable for applications where disassembly with hand tools is required for servicing.

## **PHYSICAL PROPERTIES**

| Technology / Base  | Dimethacrylate Ester               |  |
|--------------------|------------------------------------|--|
| Type of Product    | Adhesive and Sealant               |  |
| Components         | One Component                      |  |
| Curing             | Anaerobic with Secondary Heat Cure |  |
| Appearance / Color | Blue                               |  |
| Consistency        | Thixotropic Liquid                 |  |

## **TECHNICAL DATA**

| Duanantu   | Valera   | Made of /Oan distan                    |  |
|--|--|--|--|
| Property   | Value  | Method/Condition                       |  |
| Rheology   |  |  |  |
| Viscosity  | 1,200 +/- 400 cps<br>@20rpm<br>7500 +/- 2500 cps<br>@2rpm                          | Brookfield at 25°C<br>Spindle 3        |  |
| Density  |  |  |  |
| Specific Gravity   | 1.10   | N/A                                    |  |
| Uncured Materials Ch   | aracteristics  |  |  |
| Flash Point<br>Gap Fill<br>Shelf Life<br>Storage Condition                       | > 93°C (200°F)<br>0.007 inch<br>12 months unopened<br>20°C (68°F)                  | N/A<br>N/A<br>N/A                      |  |
| Cured Materials Characteristics  |  |  |  |
| Full Cure Conditions<br>Cure Appearance<br>RoHS Compliant                        | 24 hours at 25°C<br>Blue Solid<br>Yes  | N/A<br>N/A<br>N/A                      |  |
| Cured Mechanical Properties  |  |  |  |
| Locking Strength<br>Breakaway Torque<br>Prevailing Torque<br>Service Temperature | Medium<br>70 to 150 in-lb<br>30 to 100 in-lb<br>-55°C to 150°C<br>(-65°F to 300°F) | N/A<br>ASTM D5649<br>ASTM D5649<br>N/A |  |

## **SPECIFICATIONS AND APPROVALS**

Mil-S-46163A, Type II Grade N; ASTM D-5363 AN 0321



## **INSTRUCTIONS**

Surfaces to be bonded should be clean, 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 voids that 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 per the cure schedule indicated. 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.

### **CURING PERFORMANCE**

The rate of cure will depend on environmental conditions and the substrates used. The gap of the bond line will affect set speed. Smaller gaps tend to increase set speed. Activators may be applied to further improve set speed, but may also impair overall adhesive performance.

#### **STORAGE**

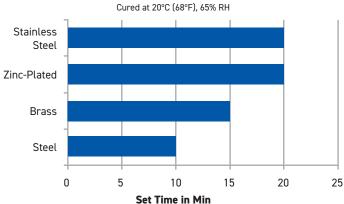
Products should be stored unopened in a cool, dry place out of direct sunlight. Products may be refrigerated for improved shelf life, but should be brought back to room temperature before use.

## **SAFETY & DISPOSAL**

For safe handling information on this product, consult the Safety Data Sheet (SDS).



### **SET TIME ON VARIOUS SUBSTRATES**



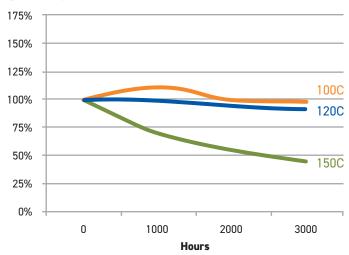
Test Conditions: 68°F / 20°C, 65% RH

#### Ketone (arc

|  | Solvent                               | Example   | Resistance                       |
|--|---------------------------------------|---|----------------------------------|
|  | Alcohol                               | Ethanol, methanol   | Excellent                        |
|  | Ester (aromatic)                      | Ethylacetate  | Poor                             |
|  | Ketone (aromatic)                     | Acetone, benzophenone   | Poor                             |
|  | Aliphatic<br>hydrocarbon<br>(alkanes) | Petrol, heptanes, hexane                                      | Good                             |
|  | Aromatic<br>hydrocarbons              | Benzyl, toluol, xylol   | Good                             |
|  | Halogenated hydrocarbons              | Methylenchloride, chloroform, chlorobenzol                    | Poor                             |
|  | Weak aqueous acid                     | Nitrite, muriatic acid,<br>sulphuric acid,<br>phosphoric acid | Excellent (poor if concentrated) |
|  | Weak aqueous base                     | Sodium hydroxide solution, caustic potash                     | Excellent (poor if concentrated) |

## **HEATING AGING**

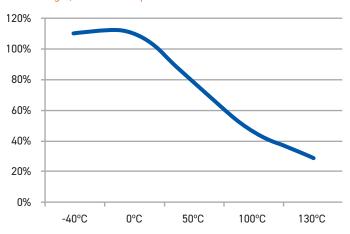
Aged at Temperature Indicated & Tested at 22°C



## **HOT STRENGTH**

%RT Strength, Tested at Temperature

SOLVENT RESISTANCE



#### **DISCLAIMER**

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