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PRODUCT DATA SHEET

Permanent Thread Lock

Pacer Technology Permanent Thread Lock is formulated for use in locking, sealing, joining, and fastening of threaded metal components. Permanent Thread Lock fills gaps to 0.01". Resistant to oil, gasoline, solvents and automotive fluids, Permanent Thread Lock resists temperatures to 300^{0}F (149^{0}C).

PROPERTIES

Liquid State	Permanent Thread Lock
Chemical Base	Anaerobic compound
Color	Red Liquid
Specific Gravity (25^{0}F/4^{0}C)	1.1
Flashpoint COC ^{0}F (^{0}C)	>200 (>93)
Viscosity, cP	200-800
Typical Gap (Inches)	.008
Fixture Time, minutes	<25
Working Time, hours	2
Full Cure, hours	24
Corrosivity: MIL-S-22473D	none
Toxicity	low
Soluble In:	Acetone, MEK, Nitromethane

Cured State

Service Temperature Range		-60^{0}F to +300^{0}F (-51^{0}C to +149^{0}C)
Locking Torque*		
(in-lbs)	Breakaway	130-330
	Prevailing	190-450
Shore D Hardness		>70
Soluble In:		Pacer X-8 Debonder, Acetone, Nitromethane

* Breakaway & prevailing torque tested on 3/8 zinc nuts and bolts.

STORAGE AND SHELF LIFE

For optimum results, store below 90^{0}F (32^{0}C) in original containers. Stored under these conditions, a one year shelf life can be expected.

APPLICATION AND CURE CHARACTERISTICS

For best results, parts should be clean and free from oil and grease, or other contaminants. Recommended surface finish is 30-80 inches. Smoother surfaces will result in lower bond strength, rougher surfaces may provide excess gap.

Fixture and cure speed is dependent upon surface activity of the metal being utilized. Steel, brass, copper, iron, and aluminum alloys containing copper will fixture faster than plated surfaces, stainless steel, and pure aluminum. Primer can be used to speed up cure. Product can be fully cured at 200^0 F (93^0 C) for 30 minutes or at 250^0 F (121^0 C) for 25 minutes.

Apply a bead around part to be bonded and assemble with a twisting motion to spread adhesive. Liquid adhesive will not center the part automatically, and additional fixture is recommended until adhesive reaches handling strength. Excess adhesive on the outside of the joint will not cure, and can be removed with a solvent-soaked cloth.

SAFETY AND HANDLING PRECAUTIONS:

Liquid adhesive can irritate skin and eyes. Vapor In case of eye contact, flush with water for 15 minutes, see a physician if symptoms persist. If swallowed, do not induce vomiting. Get immediate medical attention. Use of safety glasses, protective clothing and gloves recommended for prolonged exposure to liquid adhesive.

For more information, refer to Material Safety Data Sheet, available upon request. In case of emergency, call Pacer Technology at 800-538-3091 (outside CA only), or 909-987-0550.

PRODUCT NUMBER: N27106, N27150

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