

## TECHNICAL DATA SHEET STUD BOLT FIXER IT170

### DESCRIPTION

Stud Bolt Fixer is a single component anaerobic product suitable for threaded metal parts against loosening from shock and vibrations. Product cures spontaneously and rapidly when confined in absence of air between close fitting metal surfaces with small gap fill. It seals and blocks all kinds of screw connections. It develops a very high resistance against de-installing.

### PROPERTIES OF UNCURED MATERIAL

Nature: met acrylic resin  
Colour: Green  
Viscosity: 300-500 mPas  
Specific gravity: 1,04  
Flash point: 110°C

### PROPERTIES OF CURED PRODUCT

Setting time (minutes): 15  
Total healing at 20° (hours): 24  
Product life at 20° (months): 12  
Max filling gap (mm): 0,20  
Operates between temperatures (°C): -50 to +150  
Normal curing time % of final resistance  
1 hour: Approx. 40% resistance  
24 hours: 100% resistance

### HEALING IN RELATION TO THE SUBSTRATE

The healing speed and resistance vary according to the substrate. When used in hardened steel and brass components, anaerobic adhesives will achieve maximum strength faster than in other inert materials such as stainless steel and dichromatic zinc.

### HEALING SPEED IN RELATION TO SLACK

The size between the two materials to be joined directly affects the healing speed of the anaerobic adhesive. The gap to be glued varies according to the type of screw and the size of the bolt. The larger the gap in the coupling of the surfaces, the slower the healing. The maximum recommended hole for fixing screws is 0.20mm.

### HEALING SPEED IN RELATION TO TEMPERATURE

All figures related to the healing speed have been made at 22°C. Lower temperatures will lead to slower healing. Heating the mounted parts accelerates the healing process. The Activator can be used if the temperature is less than 5°C.

### CURING SPEED IN RELATION TO THE ACTIVATOR

Where the healing speed is very low or the gap very large, the Activator can be used to accelerate the process. The use of an activator can reduce resistance by 30%. It is recommended to test the parts to be joined.

## **HABITUAL RESISTANCE TO THE ENVIRONMENT RESISTANCE TO THE HEAT**

Suitable for use at temperatures above 150°C. At 130°C the resistance shall be approximately 50 % of its resistance at 21°C.

## **AGING DUE TO HEAT**

It maintains a 90% maximum strength when heated to 100°C for 90 days and then left to cool and tested at 21°C.

## **CHEMISTRY / RESISTANCE TO SOLVENT**

Anaerobics have excellent chemical resistance to most oils and solvents including the oil engine, leaded petrol, brake fluid, acetone, ethanol, propane and water. Anaerobic adhesives and sealants are not recommended for use in pure oxygen or chlorine lines.

## **GENERAL INFORMATION**

For more safety in the use of the product, refer to the safety data sheet. Anaerobic adhesives heal only in the absence of air and with metallic elements for activation. The adhesives outside the gasket will not heal and can be cleaned with a cloth. Suitable for high strength applications on standard nuts and screws. It is not suitable for certain plastics in which it can end up with a strong break. Some anti-corrosion chemicals inhibit the healing system of this type of anaerobic. Tests are recommended to establish when parts need to be cleaned.

## **FORM OF THE EMPLOYMENT**

Make sure the parts are clean, dry and free of oil and grease. Apply the adhesive throughout the desired area. Assemble the parts and let it heal. Clean the excess adhesive off the joint. The product is usually applied by hand with the bottle. Automatic dosing systems can be supplied for large mounting volumes. Please contact your dealer at to solve your dosage problem.

## **STORAGE**

Keep it in a cool place, out of direct sunlight. Refrigerate it at 5° gives the maximum storage stability.

## **SHEET OF THE RANGES**

The details contained in this data sheet can be taken into account as standard values. The values are based on current tests and are verified on regular bases.

## **PRESENTATION**

Bottle 50ml.      10 Units/Box

## **RECOMMENDATIONS OF MANAGEMENT RESIDUES**

Recommending for reason at the content of recipient, to deliver this recipient at a management residues person authorized for its destruction or its recuperation, as well as anything element to throw out that it was with contact with this product.

## **NOTE**

The information supplied in this Specification Sheet is of general type following our experience. We cannot take responsibility by an inadequate use of the product.