

TECHNICAL DATA SHEET FOR LOCKFAST T22

PRODUCT DESCRIPTION

Lockfast T22 is designed for the sealing and locking of threaded fasteners which may require easy disassembly with standard handtools. The product is a single component anaerobic, low strength thixotropic, acrylic based threadlocker. The product cures when confined in the absence of air between close fitting metal surfaces and prevents leakage and loosening from vibration and shock.

LOCKFAST T22 CHARACTERISTICS	
Technology	Acrylic
Appearance (uncured)	Purple liquid
Chemical Form	Dimethacrylate ester
Fluorescence	Positive under UV
Cure	Anaerobic
Secondary cure	Activator
Components	Single – requires no mixing
Viscosity	Thixotropic, low
Strength	Low
Application	Threadlocking

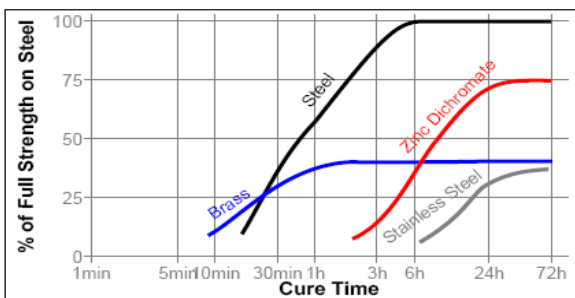
Lockfast T22 is particularly suitable for uses such as adjustment of set screws, small diameter or long length fasteners where easy disassembly is required without shearing the screw.

PROPERTIES OF UNCURED MATERIAL

	Typical Value
Specific Gravity @ 25°C	1.05
Viscosity @ 25°C	1200-1500 cPs
Flash Point	See MSDS
Fixture Time	15 mins

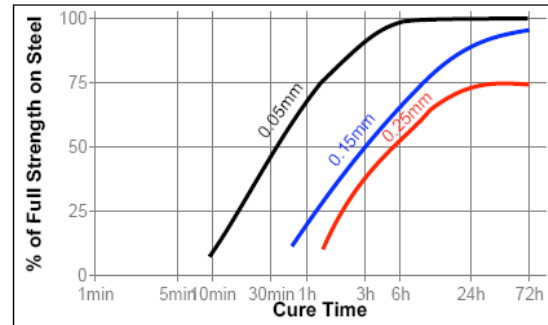
CURE SPEED VS. SUBSTRATE

The rate of cure is dependant on substrate used. The graph below shows the breakaway strength developed with time on M10 steel bolts and nuts compared to different materials and tested according to ISO 10964.



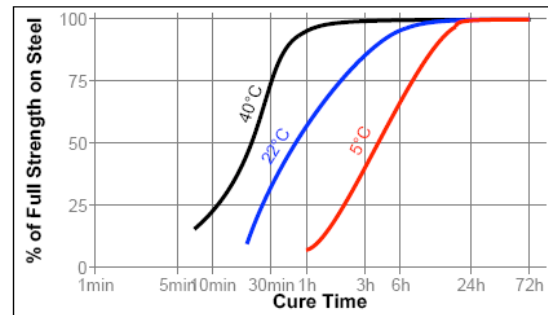
CURE SPEED VS. BOND GAP

The rate of cure will depend on the bond gap. Threaded fasteners gap size is depend on thread type and quality. The graph below shows shear strength developed with time on steel collars and pins at different controlled gaps and tested according to ISO 10123.



CURE SPEED VS. TEMPERATURE

The rate of cure is dependent on the ambient temperature. The graph below shows the breakaway strength developed with time at different temperatures on M10 steel bolts and nuts and tested according to ISO 10964.



CURE SPEED VS. ACTIVATOR

Where the cure speed is unacceptably long or large gaps are present. An activator can be applied to the surface which will improve cure speed.

TYPICAL PERFORMANCE OF CURED MATERIAL

	Typical Value
Operating Temp °C	-54°C - 150°C

(After 24 hr at 20-25°C) on M10 steel nuts & bolts)

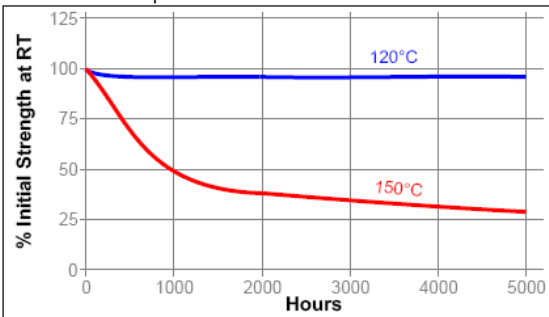
	Typical Value
Breakaway Torque M10 steel bolts & nuts ISO 10964	8Nm
Prevail Torque M10 steel bolts & nuts ISO 10964	4Nm

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TYPICAL HEAT RESISTANCE

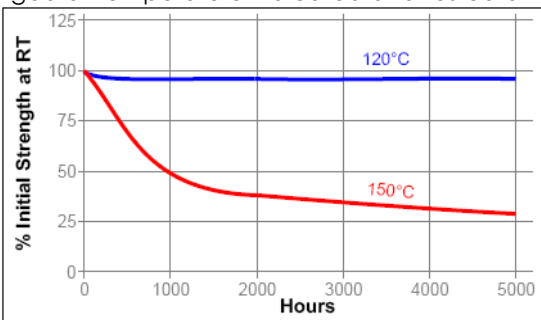
Hot Strength

Tested at temperature



Heat aging

Aged at temperature indicated and tested at 22°C



Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 22 °C.

Environment	°C	% of initial strength			
		100h	500 h	1000 h	5000 h
Motor oil (MIL-L-46152)	125	100	95	90	85
Leaded Petrol	22	95	95	95	95
Brake Fluid	22	95	95	95	90
Water/Glycol 50/50	87	80	80	80	80
Acetone	22	100	90	90	90
Ethanol	22	95	95	90	90

DIRECTIONS FOR USE

1. For optimum performance surfaces should be clean and free of grease.
2. If the material is an inactive metal consider using activator.
3. Shake the product thoroughly before use.
4. Apply several drops to the bolt & nut.
5. Assemble and tighten as required.
6. To prevent the clogging of the nozzle, do not let the tip touch metal surface during application.

FOR DISASSEMBLY

1. Remove with standard hand tools.
2. In circumstances where hand tools do not work, use localized heat to bolt or nut, disassemble while hot.

FOR CLEANUP

1. To remove cured product use a combination of solvent and abrasion such as a wire brush.

PRECAUTION

1. Use proper ventilation, avoid contact with skin and eyes.
2. If contact with skin occurs, rinse with warm water or dissolve gradually with appropriate debonder.
3. Do not try to remove forcibly.
4. If adhesive gets into eye, keep eye open and rinse thoroughly. Seek medical attention immediately.
5. Keep well out of reach of children.

STORAGE

Keep adhesive in a cool, dry place (20-25°C). For long term storage, refrigeration (5°C or 40°F) is recommended unless otherwise labelled. To prevent contamination of unused material, do not return any product to its original container. For specific shelf life information, contact Cyanotec Ltd

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