



TECHNICAL DATA SHEET

2701-50

Product Description

Low viscosity, high strength, cures fast and reliably on most metal surfaces. Fit for parts that do not require disassembly. Seal threads against industrial fluids.

Typical Applications

Designed for the permanent locking and sealing of threaded fasteners. Typical applications include the locking and sealing of large bolts and studs (M25 and larger).

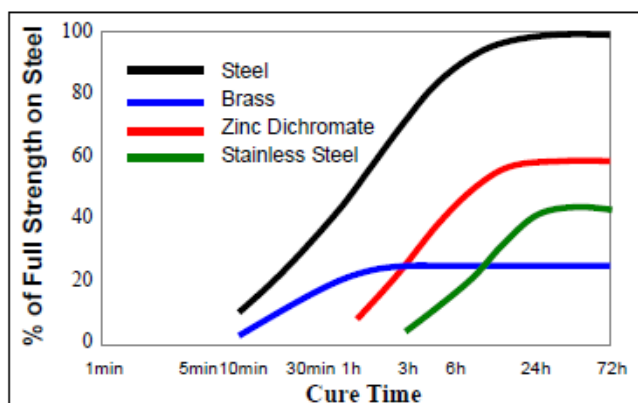
Uncured Properties

Base Resin	:	Dimethacrylate Ester
Color	:	Green
Viscosity (cps @22°C)	:	500
Cure Speed (Fixture/Full, min./hrs. @22°C)	:	10 / 24
Gap Fill (mm)	:	0.13
Specific Gravity @25°C	:	1.1
Flash Point (°C)	:	>93

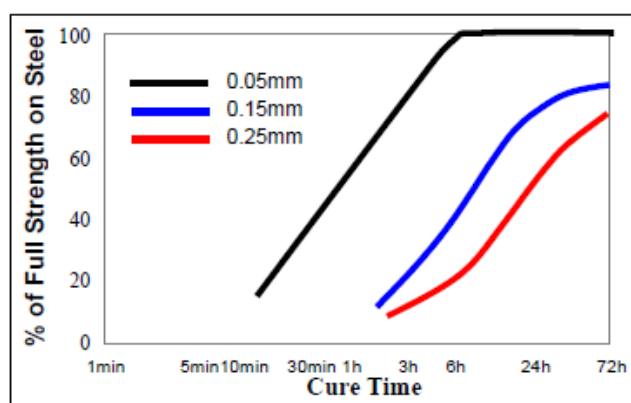
Cured Properties

Operating Temperature Range	:	- 60 to 150
Locking Strength (Break / Prevail N.m @22°C)	:	26 / 32
Solvent Resistance	:	Good
Test Standard	:	JB / T7311 - 2001

Cure Speed VS. Substrate



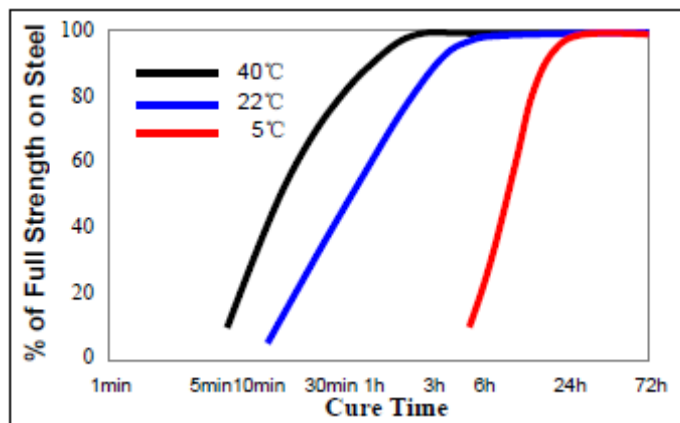
Cure Speed VS. Bond Gap





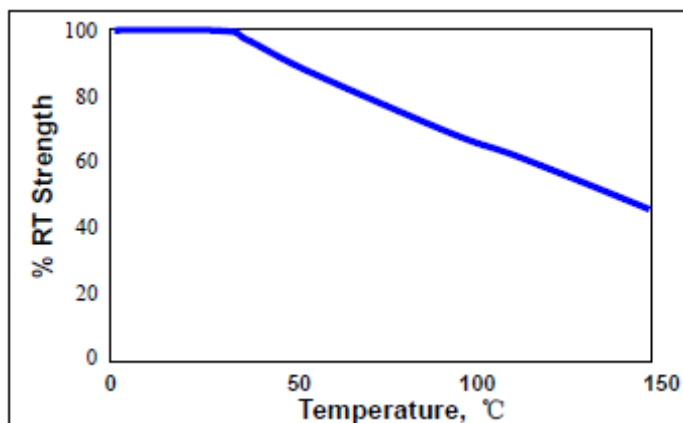
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Cure Speed VS. Temperature

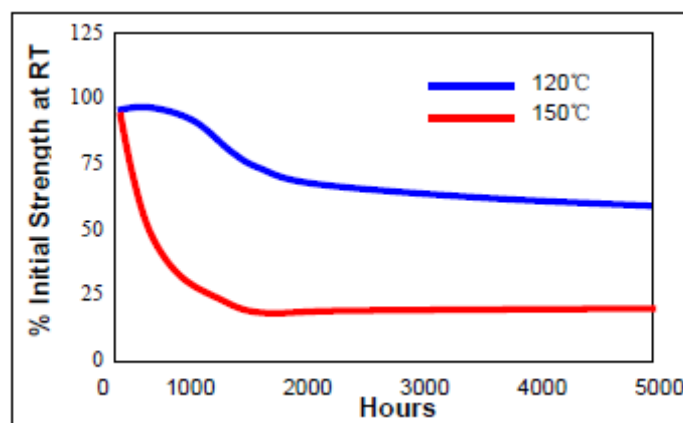


Typical Environmental Resistance

Hot Strength



Heat Aging



Chemical / Solvent Resistance

Aged under condition indicated and tested at 22°C

Solvent	Temperature (°C)	% Initial Strength retained after		
		100hr	500hr	1000hr
Motor Oil	125	85	85	75
Leaded Petrol	22	100	100	100
Brake Fluid	22	100	100	100
Water / Glycol (50% / 50%)	87	100	85	85
Ethanol	22	95	95	95
Acetone	22	95	95	95



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Application Method

- For through holes : Proper application requires filling male, female, or both threads with adhesive. A minimum of 3 threads is suggested.
- For blind holes : Adhesive should be applied into the bottom of the hole. Installation of fastener will displace the air and force the adhesive upward into the threads.
- For assembly : Assemble and tighten as required.
- For disassembly : heat the nut or bolts to 260°C and disassemble while hot.

Storage and Shelf Life

Store in a cool, dry location at a temperature between 10°C to 25°C for a maximum shelf life of 1 year. Do not return unused material to container, as it would result in contamination and/or premature hardening of contents.

CAUTION

Anaerobic products such as 2701-50 should NOT be used in pure oxygen and/or oxygen rich systems and in direct contact with food and should NOT be selected as a sealant for chlorine or other strong oxidizing materials. One 50ml bottle can lock over 500 bolts of M12 if used as directed. Thread lockers have a methacrylate ester base with low toxicity and odor. They contain no solvents or aggressive acidic adhesive agents. However, thread lockers are an eye irritant and may also irritate Skin. Therefore, skin should be washed after contact with these products. In case of eye contact, flush with water and seek medical attention. Keep out of the reach of children.