



TECHNICAL DATA SHEET

2421-50

Description	2421-50 is a single component anaerobic adhesive with high bonding strength on metal surfaces without air.
Application	Ideal for bonding to prevent loosening and leakage of pump or motor.
Full Cure Speed	Steel : 22 - 24 hours Brass : 22 - 24 hours Zinc Dichromate : 18 - 24 hours (The test was determined according to ISO 10964 on M10 steel bolts and nuts)

General Properties

Uncured monomer

Main Component	Dimethacrylate Ester
Appearance	Opaque Red, Fluorescent liquid
Specific gravity, 25°C	1.10
Viscosity 25°C (CPS)	400 - 600 CPS
Brookfield LV	
Spindle 1 @ 10 rpm	>90°C
Flash point	
Shelf life (20°C) months	12
(Stored at 8 - 28°C & out of direct sunlight)	

Typical Properties of Cured Material

Strength on M10 steel bolts & nuts @22°C (0.05mm) 12 hours	
Breakaway torque, ISO-10964, N.m	8 - 16
Prevail torque, ISO-10964, N.m	3 - 7

Storage	Best to store in a cool and dry location with containers being sealed at temperature from 8 - 28°C
Direction for use	For best performance, surface should be clean and free of grease. Product should be applied to the bolt in sufficient quantity to fill the engaged threads. The best bond gap is 0.05mm.
General Information	This product is not recommended for use in pure oxygen and / or oxygen rich systems and should not be used as a sealant for chlorine or other strong oxidizing materials.