



TECHNICAL DATA SHEET

2431-50

Product Description

A medium strength, cures fast, can work on lightly oiled surface, for locking M6 ~ M20 bolts, also for locking middle to large bolts requiring low locking strength. Locked parts can be disassemblies with common wrench.

Typical Applications

- ♦ Mounting bolts on motors, pumps, etc.
- ♦ Drive shaft fasteners
- ♦ Construction equipment bolts
- ♦ Conveyor bolts
- ♦ Gear box bolts
- ♦ Rocker nuts

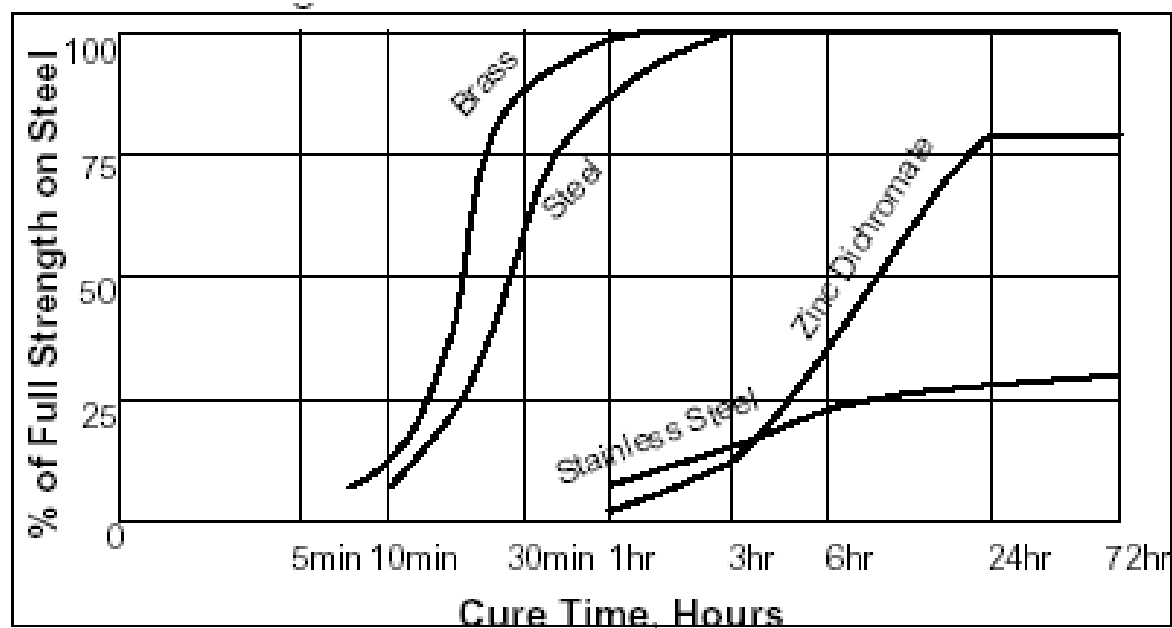
Uncured Properties

Base Resin	: Dimethacrylate
Color	: Blue
Viscosity (cps@22°C)	: 2,500
Cured Speed (Fixture / Full)	: 10 min. / 24 hrs.
Gap - Filling Ability	: 0.13 mm
Specific Gravity	: 1.05
Flashpoint	: >93°C

Cured Properties

Operating Temperature Range	: - 60 to 150°C
Locking Strength (Break / Prevail N.m)	: 20.5 / 8.0
Solvent Resistance	: Good
Mil Spec.	: JB / T7311 - 2001

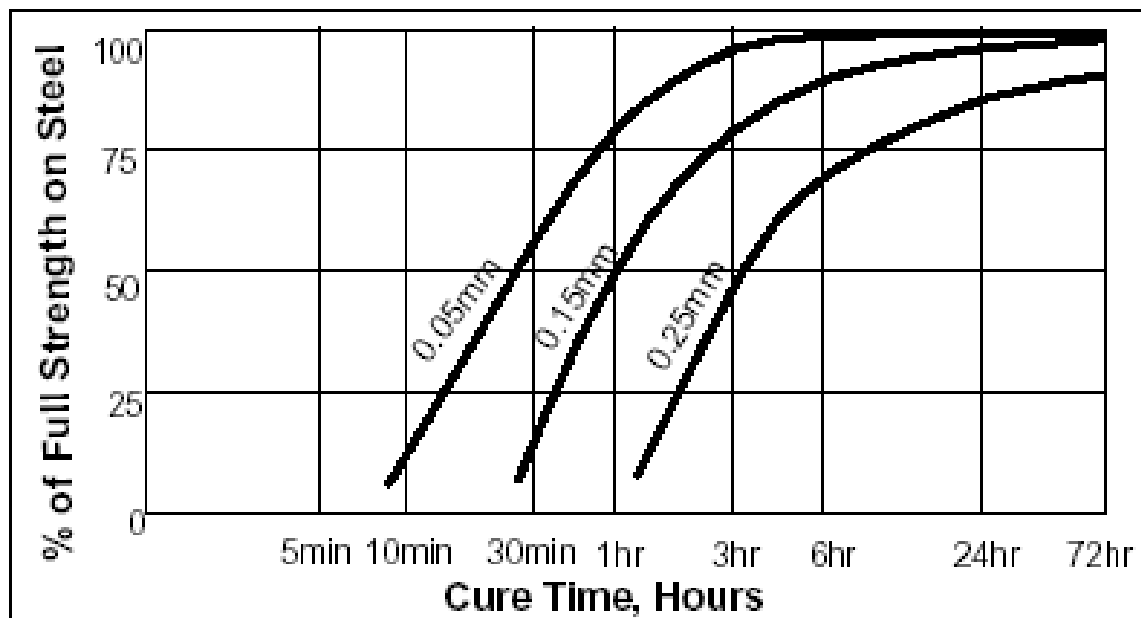
Cure speed VS. Substrate



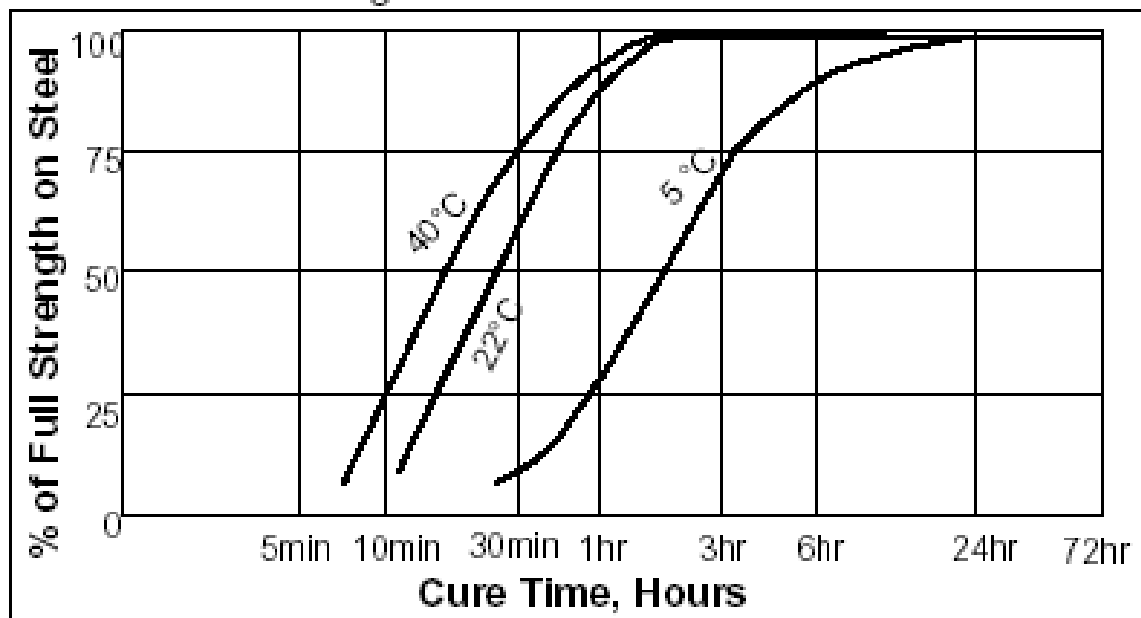


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Cure speed VS. Bond gap



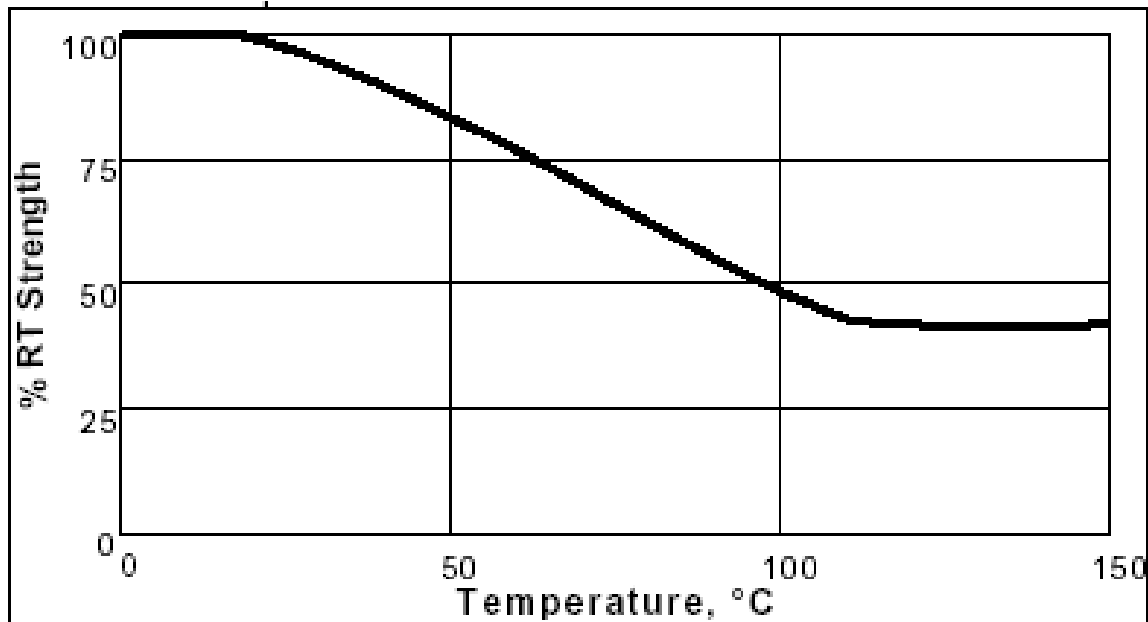
Cure speed VS. Temperature



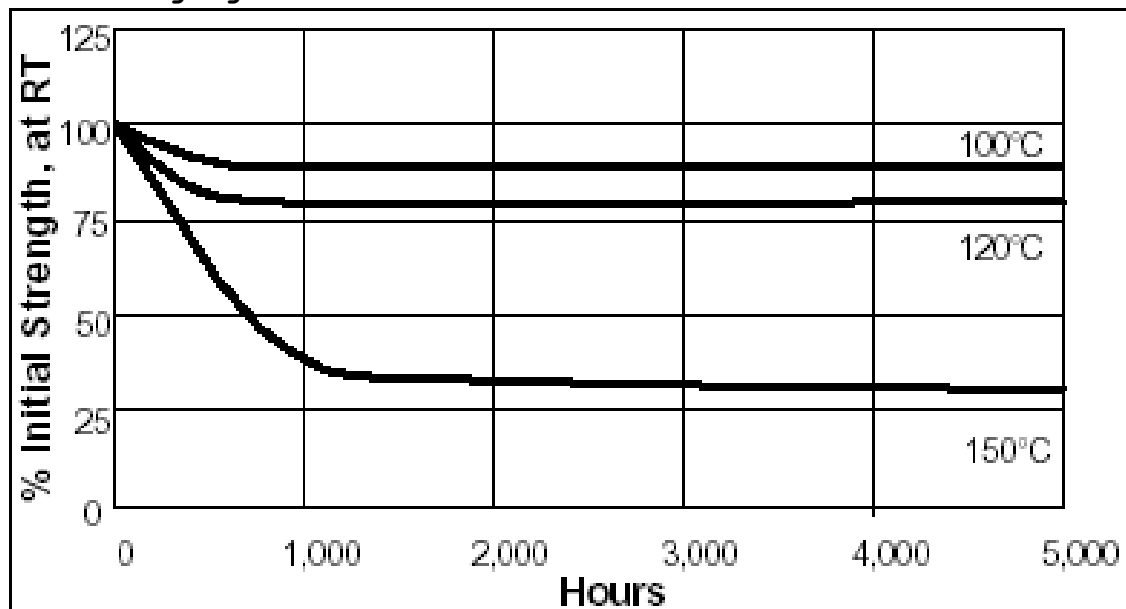
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Typical Environmental Resistance

1) Hot Strength



2) Heat Aging





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3) 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	95	95	95
Leaded Petrol	22	100	100	95
Brake Fluid	22	100	100	100
Water / Glycol (50% / 50%)	87	95	80	80
Ethanol	22	100	85	85
Acetone	22	100	100	85

Application Method

Proper application on through hole assemblies requires filling male, female, or both threads with adhesive. A minimum of 3 threads is suggested. For blind hole applications, 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.

Storage and Shelf Life

Store in a cool, dry area at a temperature of 20°C ($\pm 5^\circ\text{C}$) for a maximum shelf life of 1 years. Do not return unused material to container as it would result in contamination and/or premature hardening of contents.

CAUTION

Anaerobic products such as 2431-50 should NOT be used on oxygen systems, in direct contact with food. One 50ml bottle can lock over 500 M12 bolts 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 sealants 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.