



# Technical Datasheet HOLDIT T22

Revised Date: June 2011

## Description

HOLDIT T22 Screwlock is a low strength, anaerobic thread locking compound. T22 is designed for locking threaded fasteners that require disassembly with standard hand tools. The product performs on aluminium, steel, plated, stainless steel, and special alloy parts. T22 exhibits good temperature and solvent resistance.

## Applications

T22 will lock and seal small screws (less than 1/4"), set screws that have long engagement length.

## Instructions for Use

1. For best results clean all surfaces with a cleaning solvent and allow to dry.
2. If the metal is inactive or the cure speed is too slow apply HOLDIT AA471 Activator or HOLDIT AA649 Accelerator. Please see table below for information on Active and Inactive metals.
3. Before application shake the product thoroughly.
4. Apply the adhesive to the fixing position of the fastener or onto the internal threads of a blind hole.
5. Assemble components, and tighten to require torque level.
6. Allow to fully cure before applying load.

## Properties of Uncured Material.

Chemical Type	Anaerobic
Colour	Purple
Toxicity	Low
Solid	100%
Viscosity @ 25°C, cPs Brookfield RVT, Spindle 3 @ 20rpm	900-1,500 cps
Specific Gravity	1.05

## Performance of Cured Material

Fixture Speed	15-20 Min @ 22°C
Full Cure	24 Hours @ 22°C
Shelf Life	18 months
Temperature Range	-50°C to 150°C
Product Conformity	MIL-S-46163A
Product Conformity	ASTM D-5363
Product Conformity	NSF

## Breakaway Strength

3/8" Plain Steel nut & bolt @ 1 hr	1Nm – 9Nm
3/8" Plain Steel nut & bolt @ 24 hrs	5Nm – 11Nm
3/8" Zinc nut & bolt @ 24 hrs	1Nm – 4Nm

## Prevailing Strength

M10 Steel Nuts and Bolts @ 24hrs	4Nm
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## Environmental and Fluid Resistance (Shear Strength Values)

Heat Age	100%
Engine oil @ 150°C	85%
Brake Fluid @ 150°C	85%
ATF @ 150°C	85%
50/50 water / ethylene glycol @ 120°C	80%
Water @ 100°C	80%
Gasoline @ 25°C	95%
Diesel Fuel @ 25°C	100%
Ethyl Alcohol @ 25°C	90%

## ACTIVE & INACTIVE METAL TABLE

Super Active Very Fast Cure	Active Fast Cure	Inactive Slow Cure	Passive Primer Necessary
Brass, Copper, Magnesium	Iron, Steel, Nickel, Aluminium	Stainless Steel, Titanium, Zinc, Anodized Aluminium, Galvanised Steel	Ceramics, Glass, Plastics, Painted Finishes



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## Compatible Primers

Primer such as HOLDIT AA649 Accelerator and HOLDIT AA471 Activator can be used to speed the fixture time of the adhesive. Fixtures times can improve by as much as 50%. The use of primers can result in lower strength and performance and should be tested after full cure.

## Storage

HOLDIT T22 should be stored in a dry cool area, out of direct sunlight in temperatures between -10°C and 30°C. Optimal Storage temperature is 22±4°C. This product has a 18 month shelf life from manufacture when stored at 22±4°C.

## Presentation

HOLDIT T22 is available in 10ml, 50ml and 250ml Bottle

## Note

HOLDIT T22 is suitable for most small diameter, fine threaded screws, nuts and bolts. Not recommended on certain plastics as stress cracking may occur. Some anti-corrosion chemicals inhibit the cure system in this type of anaerobic and use of primer may be required under these conditions.

## Health & Safety in Use

IRRITANT: Contains Methacrylate Esters and some products contain small amounts of Acrylic Acid. Irritates eyes, the respiratory organs and the skin. In case of contact with the skin wash immediately with plenty of water.

## Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$   
 $\text{N/mm} \times 5.71 = \text{lb/in}$   
 $\text{MPa} \times 145 = \text{psi}$   
 $\text{N/mm}^2 \times 145 = \text{psi}$   
 $\text{N} \times 0.225 = \text{lb}$   
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$   
 $\text{N}\cdot\text{mm} \times 0.738 = \text{lb}\cdot\text{ft}$   
 $\text{mPa}\cdot\text{s} = \text{cP}$

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<b>Super Active</b> Very Fast Cure	<b>Active</b> Fast Cure	<b>Inactive</b> Slow Cure	<b>Passive</b> Primer Necessary
Brass, Copper, Magnesium	Iron, Steel, Nickel, Aluminium	Stainless Steel, Titanium, Zinc, Anodized Aluminium, Galvanised Steel	Ceramics, Glass, Plastics, Painted Finishes

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