



## Technical Datasheet

### HOLDIT T77

Revised Date: June 2011

#### Description

HOLDIT T77 Studlock large diameter high strength threadlocker is a red general purpose adhesive for permanent threaded assemblies. T77 locks fasteners 1" and larger in diameter, sealing against leakage and corrosion. It resists attack from lubricants and most industrial liquids and gases.

#### Applications

Eliminates double nutting and/or welding of critical assemblies. Using T77 permits reduced casting thickness, and eliminates cracked castings due to interference fit stresses. It is recommended for larger diameter studs with coarse threads and is used to reclaim worn stud holes. Primers are recommended for large gaps and poor fitting parts.

#### 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.

Resin	Dimethylacrylate
Colour	Red
Shelf Life	18 months
Viscosity @ 25°C	7,000 cps

#### Performance of Cured Material

Fixture Speed without Primer	60 Minutes @ 25°C
Fixture Speed with Primer	<10 second
Full Cure	24 Hours @ 20°C
Typical Breakaway Strength	28 to 39 Nm
Typical Prevailing Strength	28 to 39 Nm
Gap Fill	0.254mm
Temperature Range	-50°C to 150°C
Product Conformity	MIL-S-46163A
Product Conformity	ASTM D-5363
Product Conformity	NSF

#### Compatible Primers

Primers such as HOLDIT AA649 Accelerator and HOLDIT AA471 Activator can be used. The use of primers can result in lower strength and performance and should be tested after full cure.

#### 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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## Storage

Product should be stored in a dry, cool area out of direct sunlight within the temperature range of 0°C to 35°C. Optimal storage temperature is 25±2. Shelf life is 18 months from date of manufacture when store at 25±2.

## Presentation

HOLDIT T77 is available in 10ml, 50ml and 250ml Bottle

## NOTE

Using HOLDIT T77 is easy to apply and colour coded red to assist in selection. Because of its chemical resistance it is ideal for applications such as sealing for refrigeration environments, air conditioning applications and plant processing equipment using corrosive chemicals.

## 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

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

**ACTIVE & INACTIVE METAL TABLE**

<b>Super Active</b> Very Fast Cure	<b>Active</b> Fast Cure	<b>Inactive</b> Slow Cure	<b>Passive</b> Primer Necessary
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