



Technical Datasheet HOLDIT T71

Revised Date: June 2011

Description

HOLDIT T71 Threadlock is a high strength, anaerobic thread locking compound. T71 is designed for the permanent locking of threaded fasteners. The product performs on aluminium, steel, plated fasteners, stainless steel and special alloy parts. T71 exhibits good temperature stability and is solvent resistant.

Applications

T71 will lock and seal large fasteners. T71 is used in applications where shock and vibration may cause the fasteners to loosen.

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	Red
Toxicity	Low
Solid	100%
Shelf Life	18 months
Viscosity @ 25°C, cPs Brookfield RVT, Spindle 3 @ 20rpm	400-600
Specific Gravity	1.10

Performance of Cured Material

Fixture Speed	15-20 min @ 22°C
Full Cure	24hrs @ 22°C
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 @ 24 hr	15Nm – 34Nm
3/8" Zinc Plate nut & bolt @ 24 hr	22Nm – 39Nm

Prevailing Strength

M10 Steel Nuts and Bolts @ 24hrs	17Nm-40Nm
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Environmental and Fluid Resistance (Shear Strength Values)

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

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 T71 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 an 18 month shelf life from manufacture when stored at 22±4°C.

Presentation

HOLDIT T71 is available 10ml, 50ml and 250ml Bottle

Note

HOLDIT T71 is recommended for threaded components under 1”in diameter. Components can be disassembled using conventional hand tools. It is colour coded red and once cured, seals and vibration proofs the assemble giving controlled breakaway and prevailing torques.

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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