



Technical Datasheet HOLDIT T62

Revised Date: January 2015

Description

HOLDIT T62 Lubricated Thread Locker is a medium strength, anaerobic thread locking compound. T62 is designed for permanent locking of threaded fasteners. The product performs on aluminium, steel, plated, stainless steel, and special alloy parts. T62 exhibits good temperature and solvent resistance.

Applications

T62 will lock and seal large fasteners (1" and larger). T62 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.

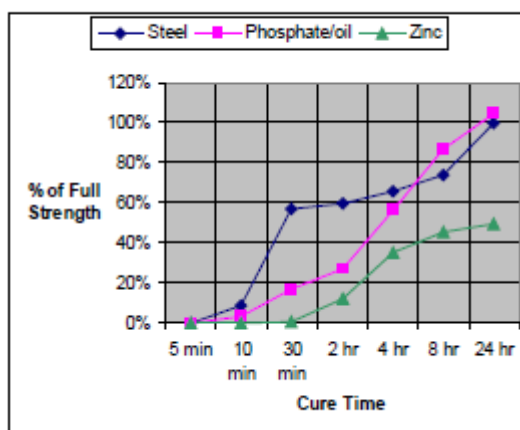
Properties of Uncured Material.

Chemical Type	Anaerobic
Colour	Red
Shelf Life	24 months
Toxicity	Low
Solid	100%
Viscosity @ 25°C, cPs Brookfield RVT, Spindle 3 @ 20rpm	1,200 – 2,400
Specific Gravity	1.10

Cure Speed

The Cure Speed is dependent on temperature and substrate. The graph below show the Breakaway Strength on M-10 Steel, Phosphate/oil, and Zinc finishes.

HOLDIT T62 Cure Speed



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
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Environmental and Fluid Resistance (Shear Strength Values)

Heat Age	100%
Engine oil @ 150°C	80%
Brake Fluid @ 150°C	90%
ATF @ 150°C	90%
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 T62 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 24 month shelf life from manufacture when stored at 22±4°C.

Presentation

HOLDIT T62 is available in 2ml, 10ml, 50ml and 250ml Bottle

Note

HOLDIT T62 lubricates during assembly and results in medium to high locking strength. Not recommended for use with most plastics as stress cracking can occur. Excellent environmental and chemical resistance.

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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