



Technical Datasheet HOLDIT T43

Revised Date: January 2015

Description

HOLDIT T43 Nutlock is an oil tolerant, medium viscosity, Thixotropic, anaerobic thread locking adhesive for all types or metal, threaded fasteners. Cured performance shows controlled medium strength with good temperature and solvent resistance against water and nonpolar solvents. This product cures rapidly on plated, oily metal surfaces or inactive surfaces.

Applications

Replaces lock washes and plastic inserts. Locks machine tool access bolts, studs, and hydraulic system bolts. Used on gear box bolts/drive shaft, bearing cover cap screws, counter sunk screws, conveyor roller bolts and construction equipment.

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.

Procedure for Application

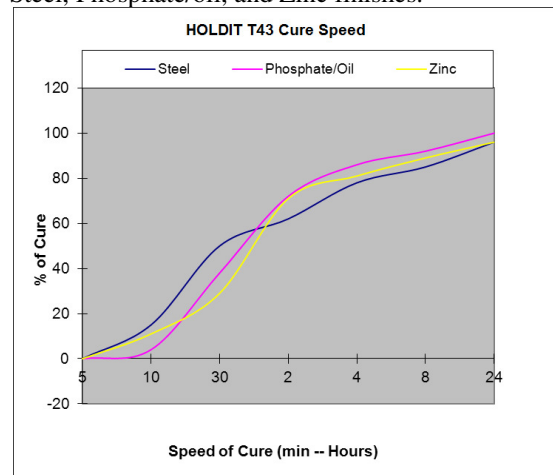
Product normally is hand applied from the bottle onto threaded parts.

Technical Features

Resin	Modified Acrylate
Colour	Blue
Fixture Speed w/Primer	< 1 second
Fixture Speed w/o Primer	5-10 @ 25°C
Gap Fill	0.038mm
Max Operating Temp	-50°C to 150°C
Viscosity @ 25°C	2,250-12,000 cps
Shelf Life	24 months

Cure Speed

The cure speed is dependent on temperature and substrate. The graph below shows the Breakaway Strength on M-10 Steel, Phosphate/oil, and Zinc finishes.



Performance of Cured Material

Fixture Speed	10-20 Mins @ 22°C
Full Cure	24 Hours @ 22°C
Temperature Range	-50°C to 150°C

Breakaway Strength

3/8" Plain Steel Nut & Bolt @ 1hr	5 to 17Nm
3/8" Plain Steel Nut & Bolt @ 24hr	11 to 19Nm
3/8" Zinc Nut & Bolt @ 24hr	14 to 19Nm
3/8" Phos-oil Nut & Bolt @ 24hr	14 to 19 Nm

Enviromental & Fluid Resistance (Shear Strength)

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

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.

Storage

Product should be stored in a dry, cool area out of direct sunlight within the temperature range of -10°C to 30°C. Optimal storage temperature is 25±2. Shelf life is 24 months from date of manufacture when store at 22±4°C.

Presentation

HOLDIT T43 is available in 10ml, 50ml and 250ml Bottles.

NOTE

Using HOLDIT T43 is easy, the product is colour coded blue and once cured, it seals and vibration proofs the assembly, giving controlled break loose and prevailing torque. When force is applied, the parts break loose (first movement) but it will take several turns before the cured film will stop resisting the turning action, thus ensuring accidental component disassembly.

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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