



# Technical Datasheet T22

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## Description

Holdtite T22 Screwlock is a Thixotropic Anaerobic Threadlocker of Low Strength designed for easy disassembly of treated components. Holdtite T22's Anaerobic nature allows it to cure only when confined between metal parts.

## Applications

All fasteners smaller than 1/4", where vibration loosening prevention and non leakage through threaded fastening is required. Ideal on small set screws, brass and most types of small threaded nuts, bolts, screws, hex and slot driven components including keyed fasteners etc.

Not recommended without trials on certain Plastics, as stress cracking can sometimes result.

Some anti-corrosion chemicals inhibit the cure system in this type of Anaerobic. Trials are recommended where cleaning is necessary to establish performance.

## 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 A471 Standard Anaerobic Activator or A649 Structural 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.

## Storage

Holdtite T22 should be stored in a dry cool area, out of direct sunlight. Optimal Storage temperature: 8°C to 21°C. Stored correctly, this product has a 24 month shelf life from manufacture.

## Properties of Uncured Material.

Resin	Dimethacrylate
Colour	Purple
Viscosity @ 25°C	1,200 to 5,000 cps
Viscosity 2	Thixotropic
Cure System	Anaerobic

## Performance of Cured Material

Fixture Speed without Primer	10-30 Min @ 25°C
Fixture Speed with Primer	<10 min
Full Cure	24 Hours @ 20°C
Typical Breakaway Strength	6 to 10 Nm
Typical Prevailing Strength	3 to 6 Nm
Gap Fill	0.18mm
Temperature Range	-50°C to 150°C
Product Conformity	MIL-S-46163A
Product Conformity	ASTM D-5363
Product Conformity	NSF

## Elevated Temp/Retained Strength

M10MSNB cured @ 22°C for one week	
150°C	35%
100°C	50%
50°C	80%

## Solvent Resistant Over 1000 Hours

iii Trichloroethane	100 %
Brake Fluid	>95%
Motor Oil @ 125°C	95%
Petrol	>95%
Glycol Mixture 87°C	80%

## Presentation

Holdtite T22 is available in 10ml, 50ml and 250ml Bottles

## 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.

## 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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