



HOLDIT[®]

**Technical Datasheet
HOLDIT T43**

Revised Date: June 2011

Description

HOLDIT T43 Nutlock is an oil tolerant, medium viscosity, Thixotropic, anaerobic thread locking adhesive for all types of 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 A471 Activator or HOLDIT A649 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.

Properties of Uncured Material.

Resin	Modified Acrylate
Colour	Blue
Viscosity @ 25°C	2,250-12,000 cps

Performance of Cured Material

Fixture Speed without Primer	5-10 Minutes @ 25°C
Fixture Speed with Primer	<1 second
Full Cure	24 Hours @ 20°C
Typical Breakaway Strength	11 to 15 Nm
Typical Prevailing Strength	4 to 7 Nm
Gap Fill	0.038mm
Temperature Range	-50°C to 150°C
Product Conformity	MIL-S-46163A
Product Conformity	ASTM D-5363

Compatible Primers

Primers such as HOLDIT A649 Accelerator and HOLDIT A471 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 T43 is available in 10ml, 50ml and 250ml Bottles.

Conversions

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

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.

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