# Technical Datasheet T43

September 2009

## Description

Holdtite Optimum OPT43 is an Anaerobic formulation designed to be used on parts in an "As Received" condition, such as those with protective films (oils) etc.
Use as a conventional medium strength locker, for fasteners ¼" to ¾", on cleaned parts with strengths up to 12N/mm(2) or as a convenient all purpose locker on oily parts with 8-10/mm(2) typical strength depending on oil type and film.

## Applications

Holdtite Optimum Oil Tolerant OPT43 is designed for direct application onto as received parts where a light oily film exists or where surrounding parts contamination is a problem in maintenance.
Where possible, remove thick deposits of grease or dirt, however Optimum will penetrate the film once it has been tightened.

## Instructions for Use

1. For best results clean all surfaces with a cleaning solvent and allow to dry. Please see table below for information on Active and Inactive metals.
2. Before application shake the product thoroughly.
3. Apply the adhesive to the fixing position of the fastener or onto the internal threads of a blind hole.
4. Assemble components, and tighten to require torque level.
5. Allow to fully cure before applying load.

## Storage

Holdtite T43 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 | Modified Acrylate |
| Colour | Blue |
| Viscosity @ 25°C | 2,000-12,000 cps |
| Viscosity 2 | Thixotropic |

## Performance of Cured Material

| | |
|---|---|
| Fixture Speed without Primer | 5-15 Minutes @ 25°C |
| Fixture Speed with Primer | <10 min |
| Full Cure | 24 Hours @ 20°C |
| Typical Breakaway Strength | 18 to 22 Nm |
| Typical Prevailing Strength | 6 to 8 Nm |
| Gap Fill | 0.38mm |
| Temperature Range | -53°C to 150°C |
| Product Conformity | MIL-S-46163A |
| Product Conformity | ASTM D-5363 |

## Conversions

(°C x 1.8)+32 = °F
N/mm x 5.71 = lb/in
MPa x 145 = psi
N/mm2 x 145 = psi
N x 0.225 = lb
N·m x 8.851 = lb·in
N·mm x 0.738 = lb·ft
mPa·s = cP

## Presentation

Holdtite T43 is available in 10ml, 50ml and 250ml Bottles

## Heath & 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 |