



# Technical Datasheet T77

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## Description

Holdtite T77 is an Anaerobic Locking Compound in the form of a Viscous Paste and it is used to give High Strength Locking Action. To speed cure or to help cure in cold condition, use Activator on parts.

High Torque: 210 inch/1lb.

Breakloose/Prevailing Torque: 300 on Rotation through 180 degrees.

## Applications

Mostly for Fasteners of 25 mm (1" size) and above.

- Studs on Pressure Vessels
- Studs on Locomotive Units
- Hydraulic Studs on Presses
- Rock Crusher Studs
- Cat Track Studs

## 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.

## Properties of Uncured Material.

Resin	Dimethacrylate
Colour	Red
Viscosity @ 25°C	7000 cps
Viscosity 2	Anaerobic

## Performance of Cured Material

Fixture Speed without Primer	10-20 minutes @ 25°C
Fixture Speed with Primer	<10 min
Full Cure	24 hours @ 20°C
Typical Breakaway Strength	30 to 35 Nm
Typical Prevailing Strength	28 to 34 Nm
Gap Fill	0.25mm
Temperature Range	-55°C to 150°C
Product Conformity	MIL-S-46163A
Product Conformity	ASTM D-5363

## Storage

Holdtite T77 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.

## Presentation

Holdtite T77 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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