



# Technical Datasheet T90

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## Description

Holdtite Penetrator Type T90 is a Fast Cure anaerobic securing compound which is very low in viscosity, thus enabling the wicking action to search into the voids in assembled components and cure anaerobically in the absence of air on close fitting metal parts after assembly.

A Fast Setting Anaerobic which wicks into already assembled parts, searching into the voids to set strong.

## Applications

Holdtite Penetrator T90 prevents loosening of metal threaded fasteners and secures close fitting cylindrical parts, sealing the parts from leakage.

Holdtite Penetrator Type T90 can also be used as a weld sealant or porosity sealant, seeking out casting irregularities. The product can also fluoresce under UV lamps for inspection purposes.

## 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.

## Properties of Uncured Material.

Resin	Dimethacrylate
Colour	Green
Viscosity @ 25°C	3-12 cps
Cure System	Anaerobic
UV Fluorescence	Positive

## Performance of Cured Material

Fixture Speed without Primer	8-20 Minutes @ 20°C
Fixture Speed with Primer	10 minutes @ 20°C
Full Cure	24 hours @ 20°C
Typical Breakaway Strength	8 to 10 Nm
Typical Prevailing Strength	27 to 34 Nm
Gap Fill	0.1mm
Temperature Range	-55°C to 150°C
Product Conformity	MIL-S-46163A
Product Conformity	ASTM D-5363
Product Conformity	NSF

## Storage

Holdtite T90 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 T90 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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