



HOLDIT®

**Technical Datasheet
HOLDIT T90**

Revised Date: June 2011

Description

HOLDIT T90 Penetrant is a fast cure, low viscosity anaerobic compound which enables the material to seek voids in assembled components and cure anaerobically (absence of air) on close fitting metal parts.

Applications

T90 can be used as a post assembly application preventing loosening of metal threaded fasteners.

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. For porosity or hairline cracks in casting products, brush directly onto the parts.
5. Assemble components, and tighten to require torque level.
6. Allow to fully cure before applying load.

Properties of Uncured Material.

Resin	Dimethylacrylate
Colour	Green
Viscosity @ 25°C	12cps

Performance of Cured Material

Fixture Speed without Primer	10 Minutes @ 20°C
Fixture Speed with Primer	Not Recommended
Full Cure	24 Hours @ 20°C
Typical Breakaway Strength	2 to 11 Nm
Typical Prevailing Strength	22 to 39 Nm
Gap Fill	0.101mm
Temperature Range	-50°C to 150°C
Product Conformity	MIL-S-46163A
Product Conformity	ASTM D-5363
Product Conformity	NSF

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 T90 is available in 10ml, 50ml and 250ml Bottle

NOTE

Using HOLDIT T90 can also be used as a weld or porosity sealant which seeks out casting irregularities (hairline cracks). A unique capillary action allows the sealant to penetrate the smallest pores or cracks to provide a positive seal. The product is fluorescent under UV lamps for inspection purposes. Not recommended for use with most plastic fasteners

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.

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

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