



**HOLDIT®**

**Technical Datasheet  
HOLDIT S54**

*Revised Date: June 2011*

**Description**

HOLDIT S54 Hydraulic Seal is a medium strength threadlocker, that cures Anaerobically to lock and seal all types of metal threaded fasteners. This grade has a unique balance of mechanical strength with chemical resistance, perfectly suited to hydraulic applications and assemblies.

**Applications**

HOLDIT S54 is well suited to a number of applications including:

- Locking and sealing hydraulic connections.
- Valve manufacture and assembly.

**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. Use suitable methods to assemble components, and tighten to require torque level.
6. Allow to fully cure before applying load.

**Properties of Uncured Material.**

Resin	Dimethacrylate
Colour	Brown
Viscosity @ 25°C	400-800 cps

**Performance of Cured Material**

Fixture Speed without Primer	30 Mins @ 25°C
Fixture Speed with Primer	<5 Secs
Full Cure	24 Hours @ 20°C
Typical Breakaway Strength	15 Nm
Typical Prevailing Strength	10 Nm
Temperature Range	-53°C to 148°C
Product Conformity	MIL-S-22473E

**Compatible Primers**

Primer such as A649 Accelerator and A471 Activator can be used to speed the fixture time of the adhesive. Fixtures times can improve by as much as 50%. The use of primers can result in lower strength and performance and should be tested after full cure.

**ACTIVE & INACTIVE METAL TABLE**

<b>Super Active</b> Very Fast Cure	<b>Active</b> Fast Cure	<b>Inactive</b> Slow Cure	<b>Passive</b> 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**

HOLDIT S54 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 12 month shelf life from manufacture.

**Presentation**

HOLDIT S54 is available in a 50ml bottle.

**Health & Safety in Use**

IRRITANT: Contains Methacrylate Esters which may irritate eyes, respiratory organs and skin. In case of contact with skin, wash immediately with plenty of water. For full Health and Safety information please consult the MSDS.

**Conversions**

- (°C x 1.8)+32 = °F
- N/mm x 5.71 = lb/in
- MPa x 145 = psi
- N/mm<sup>2</sup> 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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