



HOLDIT[®]

Technical Datasheet

HOLDIT S69

Revised Date: June 2011

Description

HOLDIT S69 High Pressure Thread sealant is a medium strength anaerobic sealant which seals hydraulic and pneumatic fittings up to 2”in diameter, resisting high pressure and vibrational loosening. This product has excellent solvent resistance and withstands temperatures to 148°C. The product does not shrink when curing and gives a positive seal against moisture and corrosion.

Applications

Typical applications are hydraulic and pneumatic fittings, servo mechanisms and fine filtration systems.

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.
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	Dimethylacrylate
Colour	Brown
Viscosity	300-500cPs

Performance of Cured Material

Fixture Speed with Activator	<10 mins
Fixture Speed without Activator	1 hour
Max Operating Temperature	-53°C to 148°C
Full Cure Time	24 hours @ 20°C
Pressure Resistance	10,000 psi

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

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

HOLDIT S69 should be stored in a dry cool area, out of direct sunlight in temperatures between -10°C and 30°C. Optimal Storage temperature is 22±4°C. This product has a 18 month shelf life from manufacture when stored at 22±4°C.

Presentation

HOLDIT S69 is available in 50ml and 250ml bottles.

Conversions

- $(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
- $\text{N/mm} \times 5.71 = \text{lb/in}$
- $\text{MPa} \times 145 = \text{psi}$
- $\text{N/mm}^2 \times 145 = \text{psi}$
- $\text{N} \times 0.225 = \text{lb}$
- $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
- $\text{N}\cdot\text{mm} \times 0.738 = \text{lb}\cdot\text{ft}$
- $\text{mPa}\cdot\text{s} = \text{cP}$

Health & Safety in Use

IRRITANT: Contains Methacrylate Esters which may irritate eyes, respiratory organs and skin. In case of contact with the skin wash immediately with plenty of water.

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