



HOLDIT[®]

**Technical Datasheet
HOLDIT T72**

Revised Date: June 2011

Description

HOLDIT T72 Studlock is a High Strength-High Temperature Threadlocker red single component anaerobic Threadlocker. T72 joins threaded parts exposed to operating temperatures up to 232°C. It offers excellent performance at temperatures more than 150° higher than other threaded locking products because of its enhanced chemistry.

Applications

Application include high temperature locking and sealing of studs, nuts, screws, bolts, and fittings. Parts are locked and sealed against leakage, contamination and corrosion. The higher viscosity is more suitable for larger diameter, coarse threaded parts. It is recommended for parts that do not require routine maintenance as disassembly is difficult and may require heat.

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.
5. Assemble components, and tighten to require torque level.
6. Allow to fully cure before applying load.

Properties of Uncured Material.

Resin	Dimethylacrylate
Colour	Red
Viscosity @ 25°C	9,500 cps

Performance of Cured Material

Fixture Speed without Primer	30 Minutes @ 25°C
Fixture Speed with Primer	<5 second
Full Cure	24 Hours @ 20°C
Typical Breakaway Strength	16 to 28 Nm
Typical Prevailing Strength	5 to 16 Nm
Gap Fill	0.178mm
Temperature Range	-55°C to 232°C
Product Conformity	MIL-S-46163A
Product Conformity	ASTM D-5363

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.

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.

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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Presentation

HOLDIT T72 is available in 10ml, 50ml and 250ml Bottles.

NOTE

Using HOLDIT T72 provides a lubricating ability during assembly and after curing results in medium to high locking strength. Not recommended for use with most plastics as stress cracking can occur. Excellent environmental and chemical resistance.

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 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.

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