

PURPLE LOW STRENGTH BOLTLOCKER MEDIUM VISCOSITY PART NO. 49482

PHYSICAL PROPERTIES

Monomer (Liquid)

| | |
|-------------------------------|---|
| Base Compound | Dimethacrylate Ester |
| Color | Purple |
| Viscosity (cP @ 68°F) | 1200 cP |
| Flash Point (TCC) | >200°F |
| Gap Fill | .007" |
| Corrosivity | None |
| Toxicity | Low |
| Specific Gravity (g/cc) | 1.09 |
| Shelf Life @ 40°F | 1 year unopened |
| Military Specifications | Mil-S-46163A |
| | Type II Grade M |
| Curing Properties | Depends on environmental conditions and the substrates used |

Polymer (Cured)

| | |
|---|----------------|
| Locking Strength | Low |
| Service Temperature Range | -75°F to 300°F |
| Appearance | Purple solid |
| Shear Strength (steel nuts and bolts) | 600 psi |
| Full Cure Time | 24 hours |



DESCRIPTION

Dynatex® Purple Low Strength Boltlocker is a low strength anaerobic threadlocking material that cures between engaged threads to form a unitized assembly that resists virtually all leakage, shock and vibration. Ideal for all nut and bolt fasteners under ¼ inch. Excellent chemical resistance. Easily removable with hand tools for servicing requirements.

FEATURES

- Eliminates vibration issues
- Prevents rusting of threads
- Cures without cracking or shrinking
- Can be adjusted or disassembled
- Seals against leakage
- No torque compensation required during assembly

TYPICAL APPLICATIONS

- Small bolts in distributor
- Dash board assembly bolts
- Relay lock screws
- Idle control screws
- Small bolts in ignition systems
- Throttle body assembly bolts
- Set screw for rear view mirror

CHEMICAL RESISTANCE

Shear strength on steel after 500 hours.

| Solvent | % Strength Retained |
|-------------------|---------------------|
| Motor Oil | 100 |
| Unleaded Gasoline | 95 |
| Trichloroethane | 90 |
| Brake Fluid | 95 |
| Ethanol | 95 |
| Acetone | 95 |
| Water/Glycol Mix | 80 |

CURING PERFORMANCE

The gap of the bond line will affect set speed. Smaller gaps tend to increase the speed. Activators can be applied to improve set speed but may also impair overall adhesive performance.

SETTING TIME (68°F, 65% R.H.)

| Substrate | Set time/Full cure |
|-----------|--------------------|
| Steel | 15 min/24 hrs |
| Brass | 20 min/24 hrs |

PERFORMANCE OF CURED MATERIALS

Bond strength after 24 hours at 20°C to 25°C on steel nuts and bolts

| | Average Value | Range |
|-------------------|---------------|----------------|
| Breakaway Torque | 58 in. lbs. | 25-80 in. lbs. |
| Prevailing Torque | 30 in. lbs. | 10-50 in. lbs. |

GENERAL INSTRUCTIONS

Surfaces to be bonded should be clean and dry and free of grease.

Product should be applied in enough quantity to fill all engaged threads. The product performs best in thin bond gaps. Very large gaps may create gaps, which will affect the cure speed and overall strength. Good contact is essential. An adequate bond develops in 15 to 45 minutes and maximum strength is attained in 24 hours.

This product is not recommended for use in pure oxygen environments and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

This product is not designed for plastics, particularly thermoplastics where stress cracking of the plastic could result. It is recommended to confirm compatibility of the product with all substrates prior to use.

STORAGE AND SHELF LIFE

When stored in the original unopened containers at or below 90°F (32°C), *Dynatex® Purple Low Strength Boltlocker* has a shelf life of 12 months from date of shipment.

In Countries where high heat and humidity are a factor, special precautions must be taken. Store product in a covered, well-ventilated warehouse and avoid excessive heat conditions. Storage in high heat, high humidity conditions may reduce shelf life by up to 30%. Rotation of stock is an absolute necessity. Cartons should always be stacked upright. DO NOT stack cartons on their side. **NEVER** stack cartons more than 8 high. DO NOT store within 1 meter (4 feet) of roofline of the warehouse or storage building.

USERS PLEASE READ

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