



TECHNICAL DATA SHEET

Nutlock

ThistleBond 'Nutlock' is a high performance adhesive designed for locking and sealing threads of nuts and bolts.

ThistleBond 'Nutlock' is based on a specially selected methacrylate resin system reacted with an organic peroxide to produce a system with optimum adhesion properties which seals out moisture to prevent corrosion of threads and resists loosening due to vibration.

ThistleBond 'Nutlock' is simple, safe and easy to use and when applied to nuts and bolt threads it gives an instant seal which allows systems to be started up after minimum delay, and is therefore ideal for replacing lock washers and plastic inserts. Locks, machine tool access bolts, studs and hydraulic system bolts, gear box bolts/drive shaft bearing cover cap screws, counter sunk screws etc.

ThistleBond 'Nutlock' is thixotropic, thus the product does not run off or drip, this thixotropic nature prevents migration of the product after application. Once applied, parts slip together easily, lubricated by the adhesive. It will hold all metric and imperial or conventional sized nuts and bolts, meeting the requirements of over 80% of fastening applications.

Before proceeding, please read the following information carefully to ensure that the correct application procedure is fully understood.

SURFACE PREPARATION

Remove all heavy deposits of grease, oil, dirt and other contaminants by either solvent wiping, cleaning with industrial degreasers or by using hot aqueous baths.

MIXING

ThistleBond 'Nutlock' is supplied ready for use and requires no mixing, however shaking the product to incorporate any slight separation is advised before use.

APPLICATION

Apply the **ThistleBond 'Nutlock'** directly to the threads in an even film. Assemble with the mating part within the recommended working time.

Note: ThistleBond 'Nutlock' is colour coded blue and once cured, seals and vibration proofs the assembly, giving controlled break loose and prevailing torques. Using conventional tools parts can be disassembled easily. When force is applied, the parts break loose (first movement) but it will take several turns before the cured film will stop resisting the turning action.

PHYSICAL CONSTANTS

Mixing Ratio Supplied ready for use.

Appearance Thixotropic blue liquid.

Drying and Cure Times at 20°C/68°F

Cure time	20 mins
	< 5 mins with activator*
Full cure time	24 hours

*Accelerators or primers may be needed for use in plastics.

Volume Solids 100%

V.O.C. Nil

Shelf Life Use within 12 months of purchase. Store in original sealed containers at temperatures between 5°C (40°F) and 30°C (86°F)

PHYSICAL PROPERTIES

Typical Strength Values

Typical Breakaway Strength	100-200lbs"
Typical Prevailing Strength	30-60 lbs"

ISO 10964

Maximum Operating Temperature - 54 to 149°C (-65 to 300°F)

HEALTH AND SAFETY

As long as normal good practices are observed **ThistleBond 'Nutlock'** can be safely used.

Safety glasses should be worn.

A fully detailed **Material Safety Data Sheet** is either included with the material or is available on request.

PACKAGING

Supplied in 50 ml units.

The information provided in this Product Data Sheet is intended as a general guide only and should not be used for specification purposes. The information is given in good faith but we assume no responsibility for the use made of the product or this information because this is outside the control of the company. Users should determine the suitability of the product for their own particular purposes by their own tests. Detailed specifications are available on request from the company.

FOR FURTHER INFORMATION PLEASE CONTACT



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