



TECHNICAL DATA SHEET

Studlock

ThistleBond 'Studlock' is a high performance adhesive designed to permanently seal threaded assemblies.

ThistleBond 'Studlock' is based on a special blend of methacrylate resins which produces a system with optimum adhesion properties which seals out moisture to prevent corrosion of threads, resists loosening due to vibration and provide ultimate chemical protection.

ThistleBond 'Studlock' is simple, safe and easy to use and when applied to threads it gives an instant seal which allows systems to be started up after a minor delay, and is therefore an ideal sealant for refrigerations plant, air conditioning, big plant and processing equipment.

ThistleBond 'Studlock' eliminates double nutting and or welding of critical assemblies, permits reduced casting thickness and prevents cracked castings due to interference fit stresses.

ThistleBond 'Studlock' allows usage on fine to medium threads (bolts and studs up to 25 mm in diameter) on parts that will not require periodic disassembly.

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

Note: ThistleBond 'Nutlock' is colour coded red to assist in selection. The application of heat may be required to assist in dismantling of parts.

PHYSICAL CONSTANTS

Mixing Ratio Supplied ready for use.

Appearance Thixotropic red 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). Store out of direct sunlight.

PHYSICAL PROPERTIES

Typical Strength Values

Typical Breakaway Strength	25 Nm
Typical Prevailing Strength	35 Nm
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 'Studlock'** 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.

FOR FURTHER INFORMATION PLEASE CONTACT

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.



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