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154 high strength anaerobic adhesive for locking and sealing thread connections and fitted parts. High viscosity and thixotropic effect allows larger tolerances. Highly resistant to heat, corrosion, vibrations, water, gases, oils, hydrocarbons, and many chemicals. Refrigerant sealant, excellent solvent resistance, and for pipes up to 3 inch in diameter.

Technology / Base	Methacrylate Ester
Type of Product	Pipe, Fitting and Thread Sealant
Components	One Component
Curing	Anaerobic with Secondary Heat Cure
Appearance / Color	Red
Consistency	Liquid

Features and Benefits

- High Resistance to Heat, Corrosion, Vibration, Water, Gases, Oils, Hydrocarbons, and Many Chemicals
- Refrigerant Sealant
- Excellent Solvent Resistance
- Pipes Up To 3 inch Diameter

Technical Data		
Physical Property	Value	Condition/Method
Uncured Material Characteristics		
Viscosity	2500 cPs	Brookfield at 25°C, Spindle 3, 20 rpm
Specific Gravity	1.02	
Flash Point	> 93°C	
Shelf Life	12 months unopened	
Storage Condition	8 to 28°C	
Full Cure Conditions	24 hours at 22°C	
Cured Material Properties		
Coefficient of Thermal Expansion	0.1 ppm/K	ASTM D696
Thermal Conductivity	0.1 W/mK	ASTM C177
Specific Heat	0.3 kJ/kgK	
Service Temperature	-55°C to 150°C	



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 or gap. The product performs best in thin bond gaps. Very large gaps may create gaps that will affect the cure speed and overall strength. Good contact is essential. 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. It is recommended to confirm compatibility of the product with all substrates prior to use.

Specifications

Curing Performance

The rate of cure will depend on environmental conditions and the substrates used. The gap of the bond line will affect set speed. Smaller gaps tend to increase set speed. Activators may be applied to further improve set speed, but may also impair overall adhesive performance.

Storage

Products should be stored unopened in a cool, dry place out of direct sunlight. Products may be refrigerated for improved shelf life, but should be brought back to room temperature before use.

Safety and Disposal

For complete safety and handling information, please refer to the appropriate Safety Data Sheets prior to using this product.

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