



Blue Gel

Blue Gel Threadlocker is a single component anaerobic threadlocking adhesive, which is a gel and develops medium strength. Blue Gel Threadlocker prevents loosening of threaded fasteners. It is suitable for applications where disassembly with hand tools is required for servicing. Its innovative pump design improves dispensing ease and accuracy, while also limiting cleanup.

Technology / Base	Threadlocking Adhesive and Sealant
Type of Product	Threadlocking Adhesive
Components	One Component
Curing	Anaerobic
Appearance / Color	Blue
Consistency	Thixotropic Gel

Technical Data

Property	Value	Method/Condition
Rheology		
Viscosity	150,000 +/- 50,000 cps @ 0.50 rpm	Brookfield at 20°C to 25°C (68°F to 77°F)
Density		
Specific Gravity	1.10	
Uncured Materials Characteristics		
Flash Point	> 93°C (200°F)	
Gap Fill	0.5 inch	
Shelf Life	12 months unopened	
Storage Condition	20°C (68°F)	
Cured Material Characteristics		
Full Cure Conditions	24 hours at 25°C	
Cure Appearance	Blue Solid	
RoHS Compliant	Yes	
Cured Mechanical Properties		
Locking Strength	Medium	
Breakaway Torque	120 to 170 in-lb	
Prevailing Torque	40 to 100 in-lb	
Pin/Collar Shear Strength		
Service Temperature	-55°C to 150°C (-65°F to 300°F)	

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 that 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.

Specifications and Approvals

Curing Performance

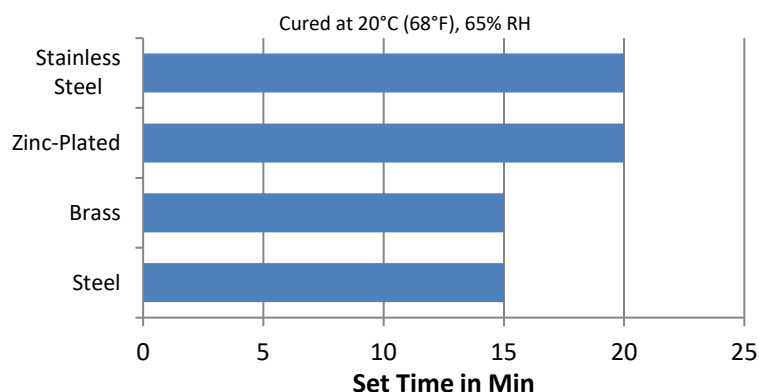
The rate of cure will depend on environmental conditions and the substrates used. The gap of the bond line will affect set speed. Smaller gaps tend to increase set speed. Activators may be applied to further improve set speed, but may also impair overall adhesive performance.

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.

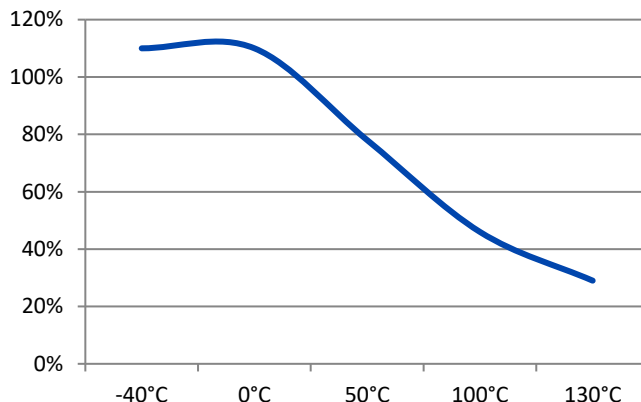


Set Time on Various Substrates

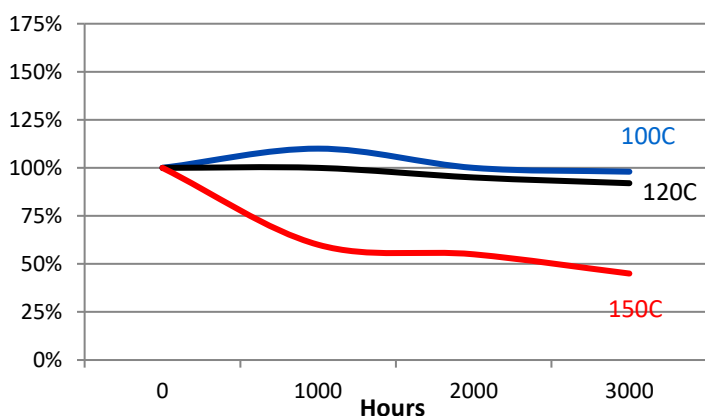


Test Conditions: 68°F / 20°C, 65% RH

Hot Strength (%RT strength, tested at temperature)



Heat Aging (aged at temp. indicated and tested @ 22°C)



Safety and Disposal Advice

For safe handling information on this product, consult the Safety Data Sheet (SDS)

H.B. Fuller Company
 9001 W. Fey Drive
 Frankfort, IL 60423
 +1.630.761.8900

www.hbfuller.com

Solvent Resistance

Solvent	Example	Resistance
Alcohol	Ethanol, Methanol	+++
Ester (aromatic)	Ethylacetate	---
Ketone (aromatic)	Acetone, Benzophenone	---
Aliphatic hydrocarbon (alkanes)	Petrol, Heptanes, Hexane	++-
Aromatic hydrocarbons	Benzyl, Toluol, Xylol	++-
Halogenated hydrocarbons	Methylenchloride, Chloroform, Chlorobenzol	---
Weak aqueous acid	Nitrite, muriatic acid, sulphuric acid, phosphoric acid	+++ (--- if concentrated)
Weak aqueous base	sodium hydroxide solution, caustic potash	+++ (--- if concentrated)

Date Modified: 01 January 2018

www.hbfullerengineering.com

Connecting what matters.™

IMPORTANT: Information, specifications, procedures and recommendations provided ("information") are based on our experience, and we believe this information to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

® and ™ are trademarks of H.B. Fuller Company or one of its affiliated entities.

NOTE TO USER: by ordering/receiving product you accept the **H.B. Fuller General Terms and Conditions of Sale** applicable in the region. Please request a copy if you have not received these. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, the total aggregate liability of H.B. Fuller for any claim or series of related claims however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill or any indirect or consequential losses arising out of or in connection with product supply.



H.B. Fuller
www.hbfuller.com