



HIGH STRENGTH RED THREADLOCKER

PART NO. **AT150**

DESCRIPTION

AT150 is a single-component, red, high-strength, threadlocking adhesive. It is designed to prevent the loosening of threaded fasteners less than 1", and is suitable for heavy duty applications where high levels of shock, vibration, and stress are present. This formula is recommended in applications where permanent adhesion is needed and may require heat to be disassembled.

PHYSICAL PROPERTIES

Technology / Base	Dimethacrylate Ester
Type of Product	Adhesive and Sealant
Components	One Component
Curing	Anaerobic with Secondary Heat Cure
Appearance / Color	Red
Consistency	Liquid

TECHNICAL DATA

Property	Value	Method/Condition
Rheology		
Viscosity	500 +/- 100 cPs	Brookfield at 25°C, Spindle 1, 10 rpm
Density		
Specific Gravity	1.10	N/A
Uncured Materials Characteristics		
Flash Point	> 93°C (200°F)	N/A
Gap Fill	0.007 inch	N/A
Shelf Life	12 months unopened	N/A
Storage Condition	20°C (68°F)	N/A
Cured Materials Characteristics		
Full Cure Conditions	24 hours at 25°C	N/A
Cure Appearance	Red Solid	N/A
RoHS Compliant	Yes	N/A
Cured Mechanical Properties		
Locking Strength	High	N/A
Breakaway Torque	140-320 in-lb.	ASTM D5649
Prevailing Torque	200-440 in-lb.	ASTM D5649
Service Temperature	-55°C to 150°C (-65°F to 300°F)	N/A

SPECIFICATIONS AND APPROVALS

MIL-S- 46163A, Type 1, Grade K;
ASTM D-5363 AN0221



INSTRUCTIONS

Surfaces to be bonded should be clean, 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 voids 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 per the cure schedule indicated. 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.

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

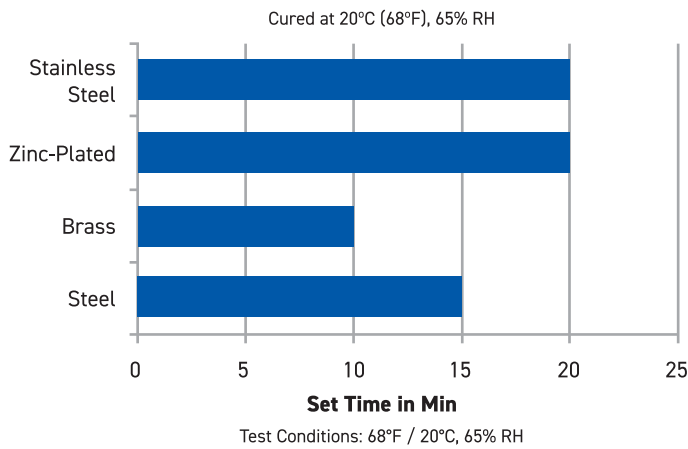
Products should be stored unopened in a cool, dry place out of direct sunlight. Products may be refrigerated for improved shelf life, but should be brought back to room temperature before use.

SAFETY & DISPOSAL

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



SET TIME ON VARIOUS SUBSTRATES

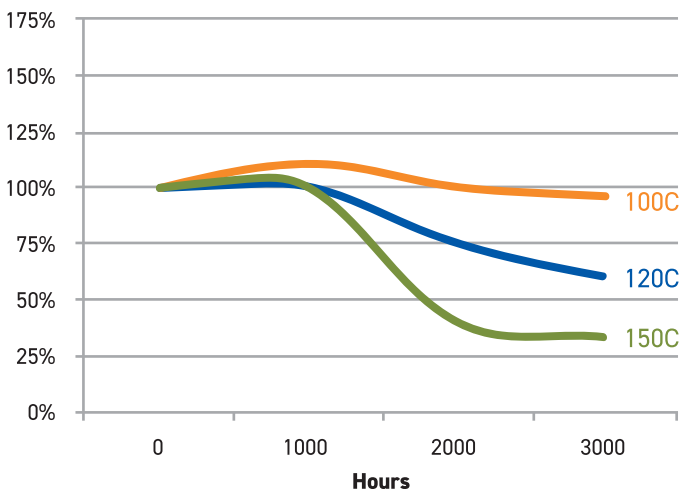


SOLVENT RESISTANCE

Solvent	Example	Resistance
Alcohol	Ethanol, methanol	Excellent
Ester (aromatic)	Ethylacetate	Poor
Ketone (aromatic)	Acetone, benzophenone	Poor
Aliphatic hydrocarbon (alkanes)	Petrol, heptanes, hexane	Good
Aromatic hydrocarbons	Benzyl, toluol, xylol	Good
Halogenated hydrocarbons	Methylenchloride, chloroform, chlorobenzol	Poor
Weak aqueous acid	Nitrite, muriatic acid, sulphuric acid, phosphoric acid	Excellent (poor if concentrated)
Weak aqueous base	Sodium hydroxide solution, caustic potash	Excellent (poor if concentrated)

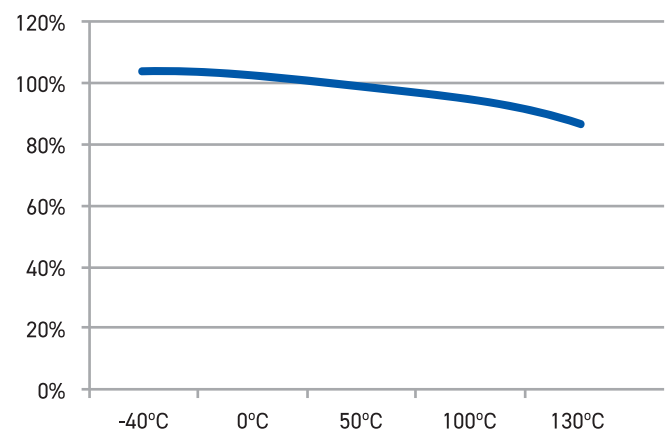
HEATING AGING

Aged at Temperature Indicated & Tested at 22°C



HOT STRENGTH

%RT Strength, Tested at Temperature



DISCLAIMER

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