TECHNICAL DATA SHEET

MEDIUM STRENGTH BLUE GEL THREADLOCKER

PART NO. **AT60GEL**

DESCRIPTION

AT60GEL is a single-component, blue, medium-strength, threadlocking adhesive. Gel formula provides a 'no-mess application' without drips, mess or waste, allowing for easy overhead and vertical applications. This formula is designed to prevent the loosening of threaded fasteners and 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.

PHYSICAL PROPERTIES

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

TECHNICAL DATA

Property	Value	Method/Condition
Rheology		
Viscosity	500,000 +/- 150,000 cps	Brookfield at 25°C, Spindle 7, 2 rpm
Density		
Specific Gravity	1.10	N/A
Uncured Materials Characteristics		
Flash Point	> 93°C (200°F)	N/A
Gap Fill	0.5 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	Blue Solid	N/A
RoHS Compliant	Yes	N/A
Cured Mechanical Properties		
Locking Strength	Medium	N/A
Breakaway Torque	70 to 150 in-lb	ASTM D5649
Prevailing Torque	40 to 100 in-lb	ASTM D5649
Service Temperature	-55°C to 150°C (-65°F to 300°F)	N/A

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.

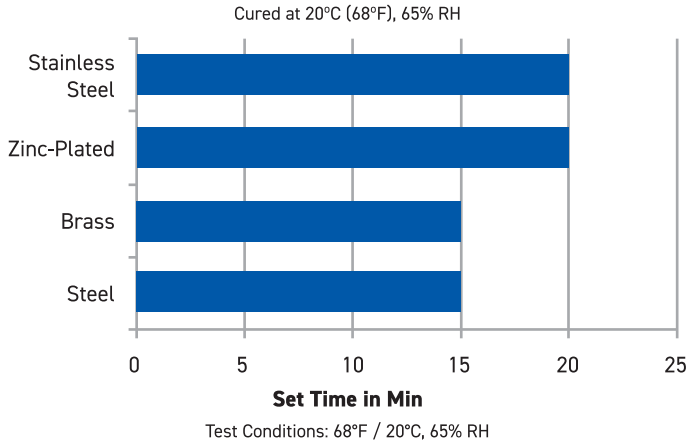
STORAGE

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



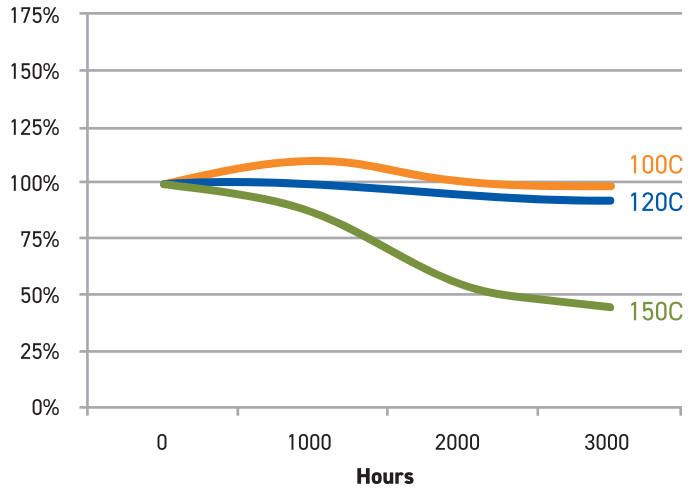
Test Conditions: 68°F / 20°C, 65% RH

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)

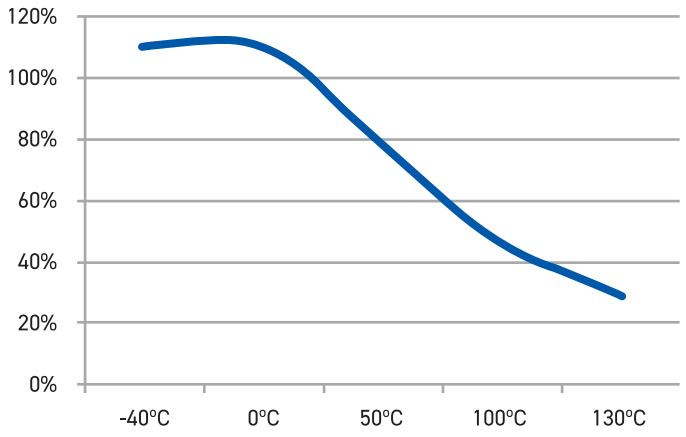
HEATING AGING

Aged at Temperature Indicated & Tested at 22°C



HOT STRENGTH

%RT Strength, Tested at Temperature



DISCLAIMER

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