

# Technical Data Sheet

TDS B271 STUDLOCK

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## PRODUCT DESCRIPTION

B271 Studlock is a permanent red coloured general purpose adhesive for permanent threaded assemblies. B271 locks studs up to 1", sealing against leakage and corrosion. It is chemical resistant, resisting fuels, lubricants and most Industrial Liquids and Gases.

## CHARACTERISTICS

Resin	Dimethacrylate
Colour	Red
Fixture No Activator	10 minutes
Fixture with Activator	5 minutes
Viscosity	500 cps
Gap Fill	0.25mm
Flash Point	>100°C
Shelf Life	12 months minimum
Specific Gravity	1.06
Max Operating Temp	-55 to +150°C

## APPLICATIONS

B271 Studlocker eliminates welding of critical assemblies. Permits reduced casting thickness, reduced assembly stress and eliminates due to interference fit stresses.

## USEFUL HINTS/NOTES

Using B271 Studlocker is easy, it is colour coded red to assist in selection. Because of its chemical resistance it is ideal in applications such as a sealant for refrigeration plant, air conditioning, big plant and process equipment using corrosive chemicals.

## PROPERTIES

Fast acting securing compound, giving retention strength and vibration proofing typically 3000psi.

## INSTRUCTIONS FOR USE

Ensure parts are clean, dry and free from oil and grease.

## PROCEDURE FOR APPLICATION

Product is normally hand applied from the bottle.

## CURED PERFORMANCE

Full Cure Time	12 hours
Cure time with good % of final strength	2 hours
Typical Breakaway Strength DIN	40N.m (25/55)
Typical Prevailing Strength DIN	55N.m (45/70)
Typical Breakaway ISO 10964	26N.m (16/36)
Typical Prevailing ISO 10964	36N.m (22/50)

## COMPATIBLE ACCELERATORS/PRIMERS

Primers such as B7471 (Standard Anaerobic Activator) or the faster B7649 (Structural Accelerator) can be used, however, up to 30% strength loss can occur when using.

## STORAGE

Store in a cool area out of direct sunlight. Shelf Life >12 months @ 20°C.

## PRESENTATION

Bottles - 10ml, 25ml, 50ml, 250ml

## HEALTH AND SAFETY IN USE

**IRRITANT:** Contains Methacrylate Esters and some products contain small amounts of Acrylic Acid.

Irritates eyes, the respiratory organs and the skin. In case of contact with skin wash immediately with plenty of water.