



## Technical Datasheet

### Holdtite T70

#### Product Description

Holdtite T70 is a high strength anaerobic thread locker, designed to permanently lock metal threaded components. T70 locks fasteners up to 25mm in diameter, sealing against leakage and corrosion. T70 is thixotropic, which reduces the migration of the liquid adhesive following application. Once cured, the T70 resists attack from most fuels, lubricants and even most industrial gasses.

#### Typical Applications

Holdtite T70 is designed for ultimate strength metal fastener applications such as studs into motor housings. The T70 can eliminate the need to double nut, or weld critical heavy duty assemblies. Due to the viscosity of T70, it is suited to both fine and medium threaded metal parts, that will not require periodic disassembly.

#### Instructions For Use

1. For best results clean all surfaces with a cleaning solvent and allow to dry.
2. If the metal is inactive (see compatibility chart) apply suitable Bondchem primer.
3. Shake the product thoroughly before application.
4. Apply the adhesive to the fixing position of the fastener or onto the internal threads of a blind hole.
5. Use suitable methods to assemble components, and tighten to required torque level.
6. Allow to fully cure before applying load.

#### Properties of Uncured Material

Resin	Dimethacrylate
Colour	Red
Viscosity @ 25°C	
Brookfield Sp 3 @ 20rpm	500cps
Viscosity 2	Thixotropic
Cure System	Anaerobic

#### Performance of Cured Material

Fixture Speed	30 Minutes @ 20°C
Fixture Speed with Primer	<5 Seconds
Full Cure Time	24 hours @ 20°C
Typical Breakaway Strength	22.5 to 34 Nm
Typical Prevailing Strength	28 to 40 Nm
Gap Fill	0.018mm
Temperature Range	-53°C to 148°C

#### Packaging

Holdtite T70 is available in 10ml, 50ml, 250ml LDPE bottles. In addition, we can offer automated dispensing lines for the bulk dispensing of this material.

#### Storage & Shelflife

Holdtite T70 should be stored in a cool dry area, out of direct sunlight. Stored correctly, this grade can offer a 12 month shelf life from manufacture.

#### Health and Safety in Use

**Irritant:** Contains Methacrylate Esters which may irritate eyes, respiratory organs and skin. In case of contact with the skin, wash immediately with plenty of water. For full Health and Safety information please consult the MSDS.

The data, information and values contained in this Technical Data Sheet have been obtained by specific tests conducted in a controlled environment, and should be used for guidance purposes only. Although we believe them to be reliable and accurate, users should always conduct their own tests in their specific working conditions to ensure that the product is suitable and effective for use. It is the user's sole responsibility to determine the suitability of the product for the application. Bondchem Ltd cannot be held responsible for the results of procedures undertaken elsewhere, nor for the safeguarding of personnel or property, all of which is the duty of the user. Suitability of products or methods is discretionary. Therefore, warranties or implied usage obligations should not be attributed to, and are not the responsibility of, Bondchem Ltd. Bondchem Ltd are not liable for any financial loss or other damages incurred by the user as a result of the use of this product.