

# **LOCK-A-NUT**

## **Medium Strength Threadlocker**

LOCK-A-NUT is a medium strength, medium viscosity threadlocking compound designed for metal fasteners of up to  $\frac{3}{4}$ " in diameter. Fast-cure and moderate chemical resistance.

- ✓ **Medium strength, medium viscosity for fasteners up to  $\frac{3}{4}$ "**
- ✓ **Parts can be separated using hand tools**
- ✓ **Moderate chemical resistance**
- ✓ **Fast cure**

## DIRECTIONS

Shake can well before use. Substrates should be cleaned and degreased with a solvent such as BRAKE-SOLV II or BLAST-OFF. Do not use mineral spirits or Stoddard solvent. Allow substrates to dry completely before applying sealing compound. Apply sealing compound to both surfaces and assemble and torque as required. Allow material to cure before use. Once fixturing has occurred, no adjustments should be made as this will decrease the sealing compound's total locking strength once the fixture bond is broken.

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be used with a sealant for chlorine-containing constituents or other strong oxidizing materials. This product is not suitable for use on plastic parts. Refer to Material Safety Data Sheet for instructions on safe handling of this material.

## TECHNICAL DATA

<b>Specification:</b>	MIL-S-46163 Type II Grade N/ASTM D 5363-03 AN0321
<b>Color:</b>	Blue
<b>Viscosity 25°C:</b>	1200 cPs
<b>Specific Gravity, 25°C</b>	1.1
<b>Flash Point:</b>	>200°F
<b>Set Time: Unprimed Steel</b>	
<b>@ 25°C (77°F):</b>	5-10 Minutes
<b>Full Cure: Unprimed Steel</b>	
<b>@ 25°C (77°F):</b>	18 Hours
<b>Breakaway Torque, 24 Hours</b>	
<b>@ 25°C (77°F):</b>	13.6 N-m (120 lb-in)
<b>Prevailing Torque, 24 Hours</b>	
<b>@ 25°C (77°F):</b>	9 N-m (80 lb-in)
<b>Hot Strength, 2 Hours</b>	
<b>@ 93°C (200°F):</b>	12.2 N-m (breakaway torque) (108 lb-in)
<b>Temperature Range:</b>	-65 - 300°F



C-9/PC-4394/1013