

2770 Threadlocker

I. PRODUCT DESCRIPTION

Have high strength, medium viscosity and excellent resistance to chemicals. Be suitable to use on active metallic surfaces and can be adjusted. Suitable for fasteners between M24 and M36. Heat the locked parts to disassembly.

II. TYPICAL APPLICATIONS

Designed for the permanent locking and sealing of threaded fasteners.

- Mounting bolts on motors, pumps, etc.
- Rocker nuts
- Drive shaft fasteners
- Gear box bolts
- Conveyor bolts
- Construction equipment bolts

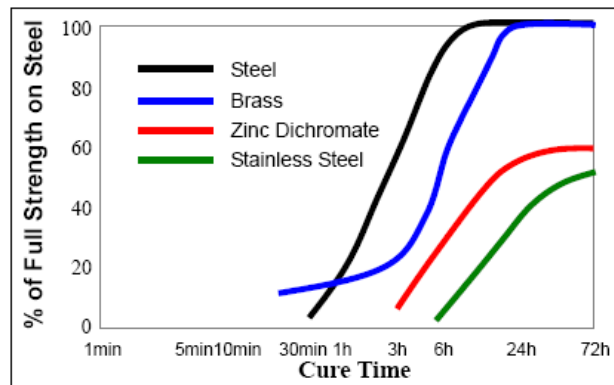
III. UNCURED PROPERTIES

Base Resin ----- Dimethacrylate Ester
 Color ----- Red
 Viscosity (cps @ 22°C) ----- 7,000
 Cure Speed (Fixture/Full, min. / hrs. @ 22°C) ----- 20-60/24
 Gap fill (mm) ----- 0.25
 Specific Gravity @ 22°C ----- 1.12
 Flashpoint (°C) ----- >93

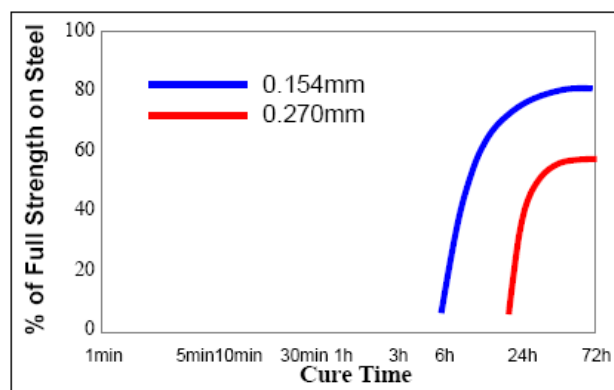
IV. CURED PROPERTIES

Operating Temperature Range(°C) ----- -60 to 150
 Locking Strength (Break/Prevail, Kgf·cm @ 22°C) ----- 360/300
 Solvent Resistance ----- Good
 Test Standard ----- JB/T7311-2001

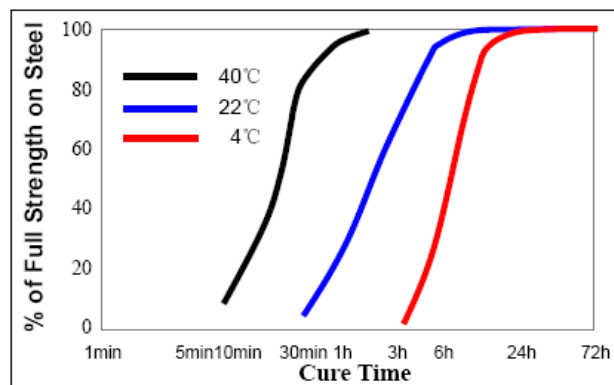
Cure speed vs. substrate



Cure speed vs. bond gap



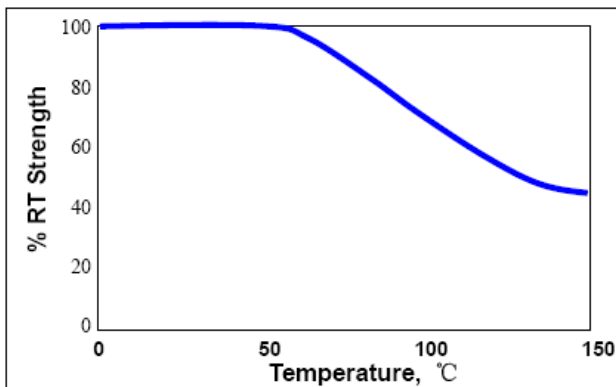
Cure speed vs. temperature



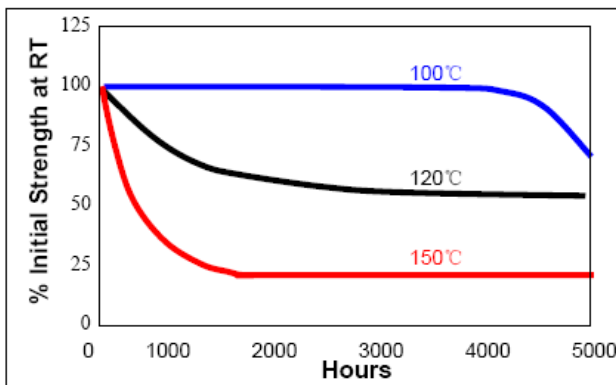
V. TYPICAL ENVIRONMENTAL RESISTANCE

2770 Threadlocker

Hot Strength



Heat Aging



VI. CHEMICAL / SOLVENT RESISTANCE

Aged under condition indicated and tested at 22°C.

Solvent	Temperature (°C)	% Initial Strength Retained		
		100hr	500hr	1000hr
Motor Oil	125	100	100	100
Leaded Petrol	22	100	100	100
Brake fluid	22	100	100	100
Water/Glycol	87	90	90	90

(50%/50%)

Ethanol	22	95	95	95
Acetone	22	95	95	95

VII. APPLICATION METHOD

1. For best performance clean all surfaces with suitable solvent.
2. If the material is an inactive metal or the cure speed is too slow, use 7640 to spray all threads.
3. For through holes: Proper application requires filling male, female, or both threads with adhesive. A minimum of 3 threads is suggested.
4. For blind holes: adhesive should be applied into the bottom of the hole. Installation of fastener will displace the air and force the adhesive upward into the threads.
5. For assembly: assemble and tighten as usual.
6. For disassembly: heat nut or bolts to 260°C and disassemble while hot

VIII. STORAGE AND SHELF LIFE

The product should be stored in a cool, dry location at a temperature between 10°C to 25°C for a maximum shelf life of one year. Do not return unused material to container, as it would result in contamination and/or premature hardening of contents.

IX. CAUTION

Anaerobic products such as 2770 should NOT be used in pure oxygen and/or oxygen rich systems and in direct contact with food and should NOT be selected as a sealant for chlorine or other strong oxidizing materials. One 50ml bottle can lock over 500 bolts of M12 if used as directed. Threadlockers have a dimethacrylate ester base

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with low toxicity and odor. They contain no solvents or aggressive acidic adhesive agents. However, threadlockers are an eye irritant and may also irritate skin. Therefore, skin should be washed after

contact with these products. In case of eye contact, flush with water and seek medical attention. Keep out of the reach of children.

For complete safety and handling information, please refer to the appropriate Material Safety Data Sheets prior to using this product.

For technical assistance, please call 82-31-663-8150.

Warranty: The data contained herein are obtained in the standard conditions according to the appointed methods and believed to be reliable. AXIA guarantees the product.

Because the storage, handling and application of this material are beyond our control, we can accept no liability for the results obtained.

X. ORDERING INFORMATION

Stock No.	Unit Size
277001	50ml
277005	250ml