

## TECHNICAL DATA SHEET

### SILOCK™ THREADLOCKER 3243

#### DESCRIPTION:

**SILOCK™** THREADLOCKER 3243 IS DESIGNED FOR THE SEALING AND LOCKING OF THREADED FASTENERS WHICH MAY REQUIRE EASY DISASSEMBLY WITH STANDARD HANDTOOLS. THE PRODUCT IS A SINGLE COMPONENT ANAEROBIC, MEDIUM STRENGTH THIXOTROPIC, ACRYLIC BASED THREADLOCKER. THE PRODUCT CURES WHEN CONFINED IN THE ABSENCE OF AIR BETWEEN CLOSE FITTING METAL SURFACES AND PREVENTS LEAKAGE AND LOOSENING FROM VIBRATION AND SHOCK.

THREADLOCKER 3243 OFFERS THE FOLLOWING CHARACTERISTICS:

<b>TECHNOLOGY</b>	ACRYLIC
<b>APPEARANCE</b>	BLUE LIQUID
<b>CHEMICAL FORM</b>	DIMETHACRYLATE ESTER
<b>FLUORESCENCE</b>	POSITIVE UNDER UV
<b>CURE</b>	ANAEROBIC
<b>SECONDARY CURE</b>	ACTIVATOR
<b>COMPONENTS</b>	SINGLE – REQUIRES NO MIXING
<b>VISCOSITY</b>	THIXOTROPIC, MEDIUM
<b>STRENGTH</b>	MEDIUM
<b>APPLICATION</b>	THREADLOCKING

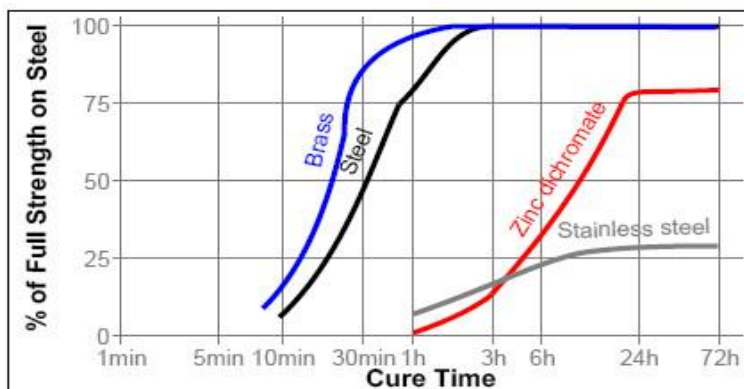
THREADLOCKER 3243 IS PARTICULARLY SUITABLE FOR USES ON LESS ACTIVE SUBSTRATES SUCH AS PLATED SURFACES AND STAINLESS STEEL, WHERE DISASSEMBLY IS REQUIRED WITH HANDTOOLS.

#### PROPERTIES OF UNCURED MATERIAL:

	TYPICAL VALUE
SPECIFIC GRAVITY @ 25 °C	1.08
VISCOSITY @ 25 °C	1200-3000 CPS
FLASH POINT	SEE MSDS
FIXTURE TIME	10-15 MINS

#### CURE SPEED VS SUBSTRATE:

THE RATE OF CURE IS DEPENDENT ON SUBSTRATE USED. THE GRAPH SHOWS THE BREAKAWAY STRENGTH DEVELOPED WITH THE TIME ON M10 STEEL BOLTS AND NUTS COMPARED TO DIFFERENT MATERIALS AND TESTED ACCORDING TO ISO 10964.

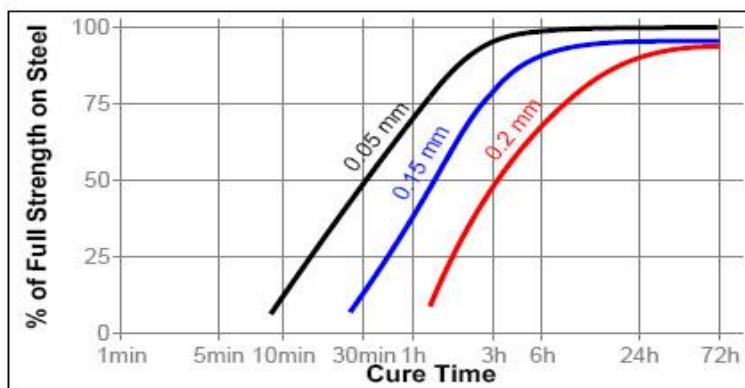


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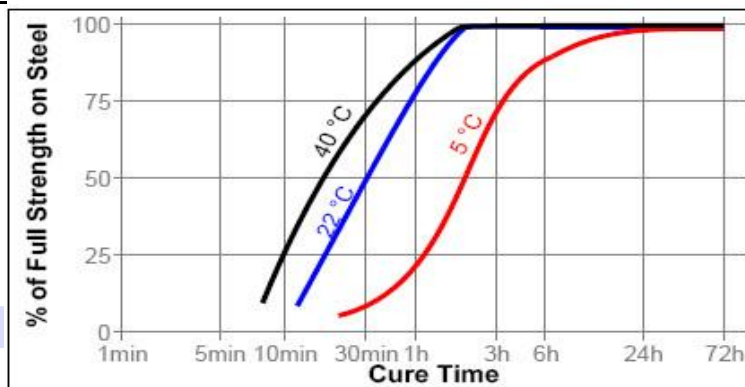
#### CURE SPEED VS BOND GAP:

THE RATE OF CURE WILL DEPEND ON THE BOND GAP. THREADED FASTENERS GAP SIZE IS DEPENDING ON THREAD TYPE AND QUALITY. THE GRAPH SHOWS SHEAR STRENGTH DEVELOPED WITH TIME ON STEEL COLLARS AND PINS AT DIFFERENT CONTROLLED GAPS AND TESTED ACCORDING TO ISO 10123.



#### CURE SPEED VS TEMPERATURE:

THE RATE OF CURE IS DEPENDENT ON THE AMBIENT TEMPERATURE. THE GRAPH SHOWS THE BREAKAWAY STRENGTH DEVELOPED WITH TIME AT DIFFERENT TEMPERATURES ON M10 STEEL BOLTS AND NUTS AND TESTED ACCORDING TO ISO 10964.



#### CURE SPEED VS ACTIVATOR:

WHERE THE CURE SPEED IS UNACCEPTABLY LONG OR LARGE GAPS ARE PRESENT. AN ACTIVATOR CAN BE APPLIED TO THE SURFACE WHICH WILL IMPROVE CURE SPEED.

#### TYPICAL PERFORMANCE OF CURED MATERIAL:

	TYPICAL VALUE
OPERATING TEMP, °C	-54 °C TO +150 °C

(AFTER 24HR AT 20-25 °C) ON M10 STEEL BOLTS AND NUTS

	TYPICAL VALUE
BREAKAWAY TORQUE M10 STEEL BOLTS AND NUTS ISO 10964	20 Nm
PREVAIL TORQUE M10 STEEL BOLTS AND NUTS ISO 10964	7 Nm

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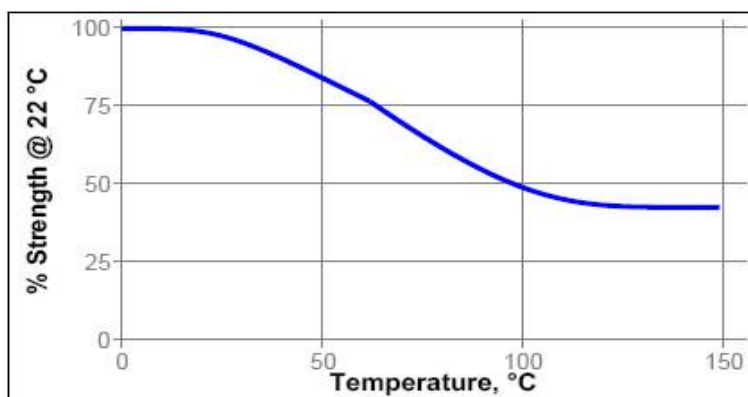


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#### TYPICAL HEAT RESISTANCE:

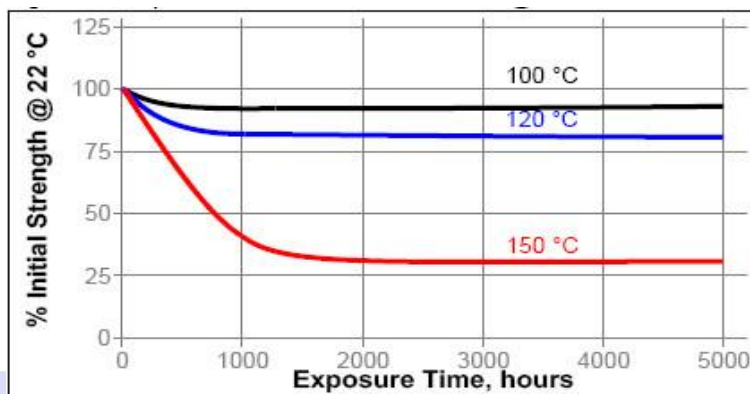
##### HOT STRENGTH

TESTED AT TEMPERATURE:



##### HEAT AGING

AGED AT TEMPERATURE  
INDICATED AND TESTED AT  
22°C:



#### DIRECTIONS FOR USE:

1. FOR OPTIMUM PERFORMANCE SURFACES SHOULD BE CLEAN AND TESTED AT TEMPERATURE FREE OF GREASE.
2. IF THE MATERIAL IS AN INACTIVE METAL CONSIDER USING ACTIVATOR.
3. APPLY SEVERAL DROPS TO THE BOLT & NUT.
4. ASSEMBLE AND TIGHTEN AS REQUIRED.
5. SHAKE THE PRODUCT THOROUGHLY BEFORE USE.
6. TO PREVENT THE CLOGGING OF THE NOZZLE, DO NOT LET THE TIP TOUCH METAL SURFACE DURING APPLICATION.

#### FOR DISASSEMBLY

1. REMOVE WITH STANDARD HAND TOOLS.
2. IN CIRCUMSTANCES WHERE HAND TOOLS DO NOT WORK, USE LOCALIZED HEAT TO BOLT OR NUT, DISASSEMBLE WHILE HOT.

#### FOR CLEANUP

1. TO REMOVE CURED PRODUCT USE A COMBINATION OF SOLVENT AND ABRASION SUCH AS A WIRE BRUSH.



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#### **PRECAUTION:**

1. USE WITH PROPER VENTILATION. AVOID CONTACT WITH SKIN AND EYES.
2. IF CONTACT WITH SKIN OCCURS, RINSE WITH WARM WATER OR DISSOLVE GRADUALLY WITH APPROPRIATE DEBONDER.
3. DO NOT TRY TO REMOVE FORCIBLY.
4. IF ADHESIVE GETS INTO EYE, KEEP EYE OPEN AND RINSE THOROUGHLY. SEEK MEDICAL ATTENTION IMMEDIATELY.
5. KEEP WELL OUT OF REACH OF CHILDREN.

#### **GENERAL INFORMATION:**

THIS PRODUCT IS NOT RECOMMENDED FOR USE IN PURE OXYGEN AND/OR OXYGEN RICH SYSTEMS AND SHOULD NOT BE USE WITH CHLORINE OR OTHER STRONG OXIDIZING MATERIALS. **FOR INFORMATION ON THE SAFE HANDLING OF THIS PRODUCT, CONSULT THE MATERIAL SAFETY DATA SHEET (MSDS).**

WHERE WASHING SYSTEMS ARE USED TO CLEAN THE SURFACES BEFORE BONDING, IT IS IMPORTANT TO CHECK THE COMPATIBILITY OF THE WASHING SOLUTION WITH THE ADHESIVE. IN SOME CASES THESE SOLUTIONS CAN AFFECT THE CURE AND PERFORMANCE OF THE ADHESIVE. THIS PRODUCT IS NOT RECOMMENDED FOR USE ON CERTAIN PLASTICS.

#### **STORAGE:**

KEEP ADHESIVE IN A COOL, DRY PLACE OPTIMAL STORAGE 8<sup>0</sup>C-21<sup>0</sup>C IS RECOMMENDED UNLESS OTHERWISE LABELLED, AT LEAST 12 MONTHS OF SHELF LIFE CAN BE REASONABLE EXPECTED. TO PREVENT CONTAMINATION OF UNUSED MATERIAL, DO NOT RETURN ANY PRODUCT TO ITS ORIGINAL CONTAINER.

*This information is provided in good faith and is believed accurate based on a review of current composition and information supplied by vendors. No warranty is expressed or implied. Liability is expressly disclaimed.*