

ThreeBond 1324

Medium Strength Nutlock

ThreeBond **1324** is a one component anaerobic resin. It cures at room temperature in the absence of air and when in contact with metallic ions. It is used to completely fill the gap between parts, to lock and seal threads and joints.

1. Features

- One component solvent free acrylic base
- Anaerobic curing
- Strength : **Medium**
- Service temperature : -40 / +150°C
- Application: Threadlocking

2. Properties

Test	Results	Units
Colour	Red	-
Viscosity at 25°C	600	mPa.s
Specific gravity at 25°C	1.13	-
Fixing time (15%)	< 20	min
Final hardening time (100%)	24	h
Break loose torque (Tightening torque 0 N.m)	> 15	N.m
Prevailing torque (Tightening torque 0 N.m)	> 15	N.m
Optimum clearance	0.01 - 0.02	mm
Maximum clearance	0.3	mm
Maximum bolt size	M36	-

3. Handling

- Before use, please refer to the safety data sheet.
- Prior to opening the container, let it reach room temperature to avoid condensation inside.
- To obtain optimal results, remove humidity, grease and other impurities from the surfaces to be assembled.
- Depending on the materials (dimensions and surface roughness), apply an appropriate and

uniform amount of thread lock on the surface, then assemble immediately.

- Allow specified fixture time before disturbing the parts.
- If needed, the use of our activator TB 3095C may reduce the curing time and improve the adhesion.
- The product once transferred into another container should not be returned to the original one. Any excess product should be wiped out using a cloth.
- Excess product may be removed using TB2890D cleaner.
- Keep the product in its original container tightly sealed and store it in a dark, dry and well ventilated place at 5 ~ 25°.