

2710 Threadlocker

I. PRODUCT DESCRIPTION

Have high strength, good resistance to chemicals, permanent locking, suitable to use on active metallic surfaces. For locking and sealing M16-26 bolts.

II. TYPICAL APPLICATIONS

Designed for the permanent locking and sealing of threaded fasteners. Typical applications include the locking and sealing of the following parts:

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

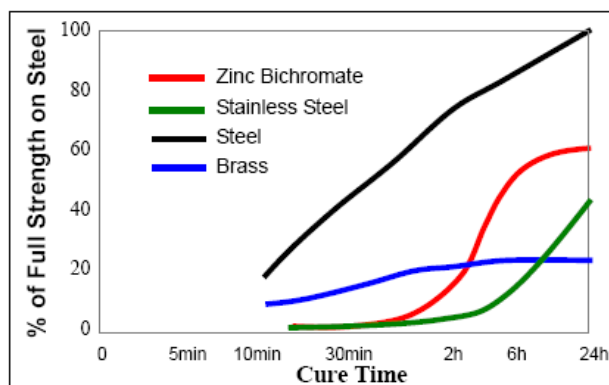
III. UNCURED PROPERTIES

Base Resin	-----	Dimethacrylate Ester
Color	-----	Red
Viscosity (cps @ 22°C)	-----	500
Cure Speed (Fixture/Full, min. / hrs. @ 22°C)	-----	3-15/24
Gap fill (mm)	-----	0.13
Specific Gravity @ 22°C	-----	1.11
Flashpoint (°C)	-----	>93

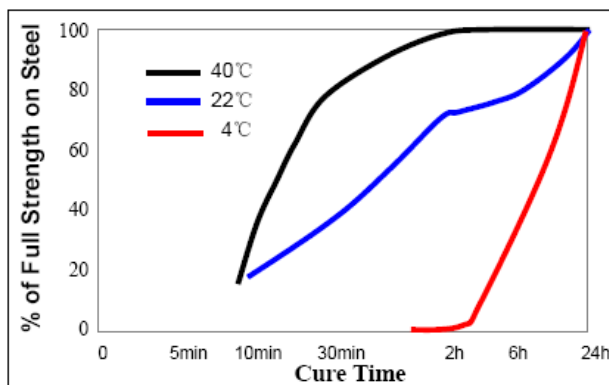
IV. CURED PROPERTIES

Operating Temperature Range(°C)	-----	-60 to 150
Locking Strength (Break/Prevail, Kgf·cm @22°C)	---	320/245
Solvent Resistance	-----	Good
Test Standard	-----	JB/T7311-2001

Cure speed vs. substrate

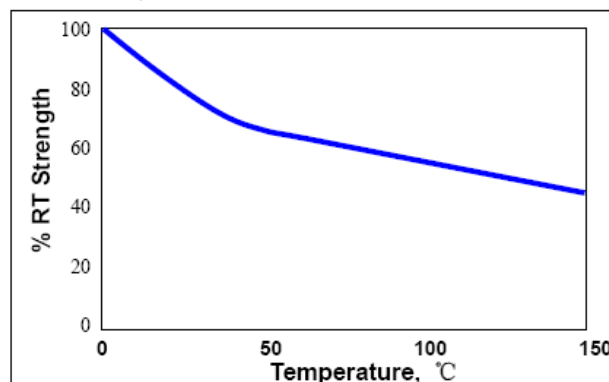


Cure speed vs. temperature



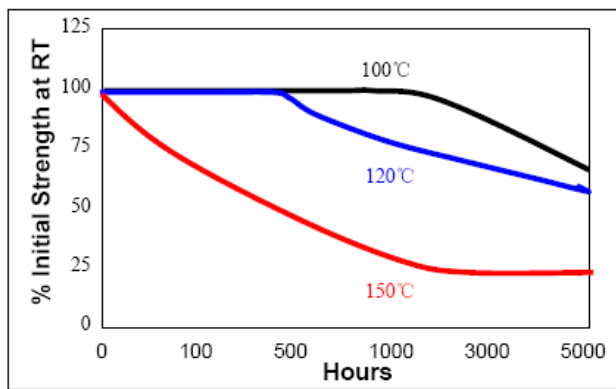
V. TYPICAL ENVIRONMENTAL RESISTANCE

Hot Strength



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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	85	85	75
Leaded Petrol	22	100	100	100
Brake fluid	22	100	100	100
Water/Glycol (50%/50%)	87	100	85	85
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 2710 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 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

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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
271001	50ml
271005	250ml