



**Large Diameter
High Strength Threadlocker (Red)**

I. Product Description

CRC Large Diameter Threadlocker is a high strength, high viscosity threadlocking anaerobic adhesive with high temperature resistance. CRC Large Diameter Threadlocker cures between close fitting metal parts where there is an absence of air. The product prevents loosening and leakage of threaded fasteners caused by shock and vibration.

II. Applications

Suitable for extreme environments where high levels of shock, vibration and stress are present. This adhesive is excellent for 1" and larger diameter fasteners. Used in hydraulic press, locomotive and large coarse bolt applications.

III. Features & Benefits

- Compare to Loctite 277
- Designed for the permanent locking and sealing of threaded fasteners
- High strength, thermally resistant sealant
- Resists temperature up to 475°F
- Prevents loosening and leakage
- Fast cure time

IV. Physical Properties

| | | | |
|------------------------------|---------------------|--|-----------------|
| Base Compound | Dimethcrylate Ester | Toxicity | Low |
| Appearance | Red Liquid | Shelf Life @ 40°F | 1 year unopened |
| Specific Gravity | 1.1 | Shear Strength (Steel nuts & bolts) | 4000 psi |
| Viscosity (cP @ 68°F) | 7000 cP | Flash Point (TCC) | >200°F |
| Service Temperature | -75°F to 475°F | Locking Strength | Heavy Duty |
| Full Cure Time | 24 hours | | |
| Gap Fill | .016 | | |
| Corrosivity | None | | |

V. Performance of Cured Material

Bond Strength after 24 hours at 20°C to 25°C on steel nuts and bolts

| | Avg. Value | Range |
|--------------------------|-------------------|------------------|
| Breakaway Torque | 255 in. lbs. | 160-340 in. lbs. |
| Prevailing Torque | 260 in. lbs. | 190-330 in. lbs. |

VI. Specifications and Approvals

- MIL-S-46163A Type II Grade K

VI. Directions

For Assembly:

1. For best results, clean all surfaces (external and internal) with a CRC cleaning solvent and allow to dry.
2. Shake the product well before use.
3. Apply product to both parts and assemble.
4. Product should be applied in enough quantity to fill all engaged threads.
5. Allow assembly to cure for a minimum of 15 minutes before handling.
6. An adequate bond develops in 15 to 45 minutes and maximum strength is attained in 24 hours.

For Disassembly:

1. Apply localized heat to nut or bolt to approximately 250° C. Disassemble while hot.

For Cleanup:

1. Cured product can be removed with a combination of soaking in a CRC solvent and mechanical abrasion such as a wire brush.

NOTE: This product is not recommended for use in pure oxygen environments and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials. This product is not designed for plastics, particularly thermoplastics where stress cracking of the plastic could result. It is recommended to confirm compatibility of the product with all substrates prior to use.

VII. Package Description

| Part Number | Container Size |
|-------------|----------------|
| 04522 | 1 oz Bottle |
| 04520 | 4 oz Bottle |
| 04521 | 16 oz Bottle |

VIII. Disposal

Disposal requirements vary by state and local jurisdiction. All used and unused product should be disposed of in conformance with local, state and federal regulations.

IX. Special Use Warnings

General

Use only in well ventilated area. Ventilation may be improved by opening a window or door or providing mechanical assistance. Vapors will accumulate readily and may ignite. Avoid continuous breathing of vapor and spray mist. Avoid contact with skin and eyes. If ventilation is not adequate, respiratory protection should be worn. For more information regarding short term and long term exposure, review this product's Material Safety Data Sheet.

DISCLAIMER: This information is accurate to the best of CRC Industries' knowledge or obtained from sources believed by CRC to be accurate. Before using any product, read all warnings and directions on the label. All products should be tested for suitability on a particular application prior to actual use. CRC Industries, Inc. makes no representations or warranties of any kind concerning this data.

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