Technical Data Sheet

Thread-Lok™ 70

incure™
ADHESIVES, EPOXIES AND COATINGS

High-Temp Anaerobic Thread-locker for Porous Welds and Castings

PRODUCT DESCRIPTION

Incure Thread-Lok™ 70 is a single component, high-temp grade anaerobic thread-locker designed for filling of porosities in castings and welds. Low in viscosity, it wicks into threads of pre-assembled components, developing medium to high strength over 24hrs. Ideal for small gaps of between 5um to 30um, it is prevents leakages resulting from loosening of threaded fasteners. Incure Thread-Lok™70 can be used for applications in environments subjected to temperature range (-55ºC to 150ºC) where ease of disassembly work is necessary from time to time. Meets Mil S-46163A for military requirements.

UNCURED PROPERTIES

Chemical Type	Dimethacrylate Ester			
Appearance	Dark Green			
Density, g/ml	1.09	Flash Point	> 93ºC (> 200ºF)	
Viscosity, cP (rpm)	20	10 - 50	Spindle	0
Other viscosities are available upon request. If the viscosity range requested is not our standard offering, this product may be produced with a small lab fee. Email us at: support@uv-incure.com or your nearest local distributor for more information.			ASTM D2556	

Viscosity (cP) taken at 25ºC (77ºF) - Call to enquiry for other viscosities.

SET / FULL CURE TIME ON MATERIALS

MATERIAL	SET TIME	FULL CURE TIME
Steel	12 min	24 hr
Brass	12 min	24 hr
Zinc-Plated	15 min	24 hr
Stainless Steel	15 min	24 hr

CURED PROPERTIES

Service Temperature	-55ºC to 150ºC (-67ºF to 302ºF)

MAXIMUM TORQUE

Working	42 N-m (372 in-lbs)
Running	55 N-m (487 in-lbs)

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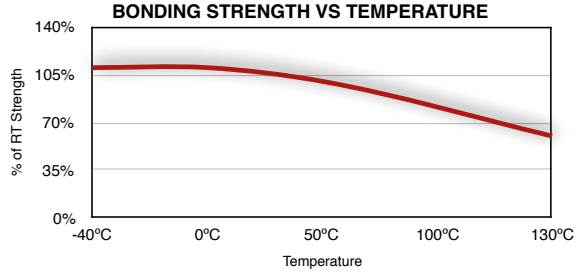
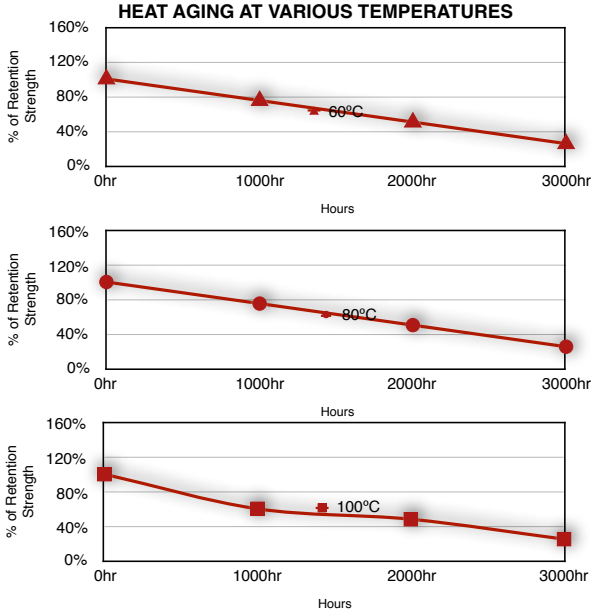
RoHS COMPLIANT Pb LEAD FREE HF HALOGEN FREE

BONDING STRENGTH VS TEMPERATURE



HEAT AGING AT VARIOUS TEMPERATURES



SOLVENT RESISTANCE TABLE

Alcohol	Ethanol, Methanol	Good
Aromatic Ester	Ethylacetate	Poor
Aromatic Ketones	Acetone, Benzophenone	Poor
Alkanes, Aliphatic Hydrocarbons	Petrol, Heptanes, Hexane	Fair
Alkanes, Aromatic Hydrocarbons	Benzyl, Toluol, Xylol	Fair
Halogenated Hydrocarbons	Methylenchloride	Poor
	Cholorobenzol	Poor
Aqueous Acid, Weak	Nitrite, Sulphuric, Phosphoric Acid (Weak)	Good
	Nitrite,Sulphuric, Phosphoric Acid (Concentrated)	Poor
Aqueous Base, Weak	Sodium Hydroxide Solution, Caustic Potash (Weak)	Good
	Sodium Hydroxide Solution, Caustic Potash (Concentrated)	Poor

SHELF-LIFE, STORAGE, USE AND HANDLING

Shelf–Life of this unopened product is a minimum of 12 mths from date of manufacture. Avoid direct exposure of bottle to visible light at all times. Containers should remained covered when not in use. Product should be stored 15ºC to 25ºC (59ºF to 77ºF). Transfer of product into other packages void all warranties. Users should ensure all bonding surfaces are free of grease, mold release, or any contaminants, as bonding performance will be compromised. Dispense onluy to one surface only. Bonding parts should be firmed held together for a few seconds before releasing. All tests for cured bonds should be carried out at ambient temperature. For safe handling of this product, please read Material Safety Data–sheet (MSDS) prior to use. Organic solvents, such as IPA, may be used to wipe away uncured material from surfaces.

EtO and GAMMA STERILIZATION (Not Applicable)

All Incure Medical products are formulated to subject to standard sterilization methods, such as EtO and Gamma Radiation of 25 to 50 kGrays (cumulative). Enhanced moisture and thermal resistance of this product show excellent adhesion and bonding strength after one cycle of steam auto-clave test. Depending on bond design and structure of the application, users should test specific assemblies after subjecting them to the test requirements. Please consult Incure Support Team for assistance, if your devices are subjected to more than one sterilization cycles.

NOTE

The data contained in this document are furnished for information only. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein. INCURE will not be liable for any indirect, special, incidental or consequential loss or damage arising from this INCURE product, regardless of the legal theory asserted. INCURE recommends that each user adequately test its proposed use and application before repetitive use, using this data as a guide.