TIGERHAWK

Technical Data Sheet

Tigerhawk® 360 Threadlocker

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Product Description

Tigerhawk 360 Wicking Adhesive and Sealant is a fast cure, low viscosity anaerobic compound which enables the material to seek voids in assembled components and cure anaerobically (absence of air) on close fitting metal parts.

Typical Applications

Tigerhawk 360 can be used as a post assembly application preventing loosening of metal threaded fasteners.

Instructions for Use

Ensure parts are clean, dry and free from oil and grease.

Procedure for Application

Product is normally hand applied from the bottle directly onto threaded parts. For porosity or hairline cracks in casting products, brush directly onto the parts.

Compatible Primers

Primers such as Tigerhawk 8115 (Primer N) or 8116 (Primer T) can be used. The use ofprimers can result in lower strength and performance should be tested after full cure.

Technical Features

Resin:.....Dimethylacrylate
Color:.....Green
Fixture Speed w/Primer..Not Recommended
Fixture Speed w/out Primer…….10 minutes
Viscosity…….....12 cps
Gap Fill.....0.004"
Max. Operating Temp…… -65°F to +300°F

Cured Performance

Full Cure Time.....24 hours @ 68°F
Typical Breakaway Strength…20-100 in.lbs.
Typical Prevailing Strength...200-350 in.lbs.

General Information

Storage

Product should be stored in a cool and dry location at temperatures between 14°F (-10°C) to 86°F (30°C). Shelf life is 2 years from date of manufacture when stored at 72±8°F (22±4°C).

Note

Wicking Adhesive and Sealant can also be used as a weld or porosity sealant which seeks out casting irregularities (hairline cracks). A unique capillary action allows the sealant to penetrate the smallest pores or cracks to provide a positive seal. The product is fluorescent under UV lamps for inspection purposes. Not recommended for use with most plastic fasteners.

Health & Safety in use

IRRITANT: Contains Methacrylate Esters which may irritate eyes, respiratory organs and skin. In case of contact with the skin, wash immediately with plenty of water.