TIGERHAWK

Technical Data Sheet

TIGERHAWK® 393 Threadlocker

November 2016

Product Description

Tigerhawk 393 is a high strength, anaerobic thread locking compound. Tigerhawk 393 is design for permanent locking of threaded fasteners. The product performs on aluminum, steel, plated, stainless steel, and special alloy parts. Tigerhawk 393 exhibits good temperature and solvent resistant.

Typical Applications

Tigerhawk 393 will lock and seal large fasteners (up to 1"). Tigerhawk 393 is used in applications where shock and vibration may cause the fastener to loosen.

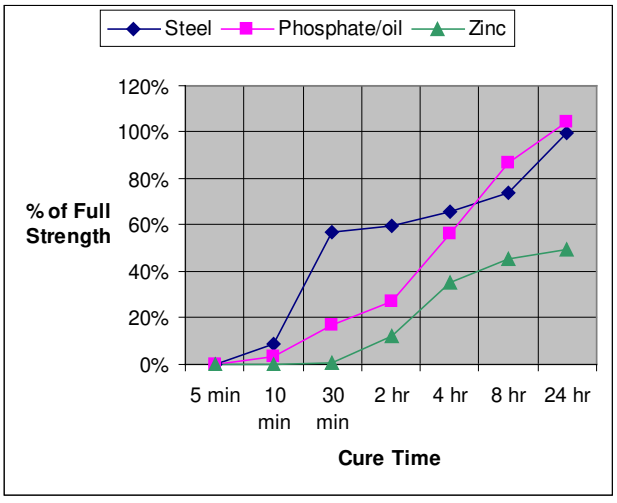
Properties of Uncured Material

Chemical Type	Anaerobic
Appearance	Red
Toxicity	Low
Solids	100%
Viscosity @ 25ºC, cP Brookfield RVT, Spindle 3 @ 20 rpm	1200-2400
Specific Gravity	1.10

Typical Curing Performance

Cure Speed

The cure speed is depended on temperature and substrate. The graph below shows the Breakaway Strength on M-10 Steel, Phosphate/oil, and Zinc finishes.



Performance of Cured Material

	Typical Values
Fixture Time	15-20 min @ 72°F
Full Cure Time	24 hrs @ 72°F
Temperature Range	-60°F to 300°F (-51°C to 150°C)

Breakaway Strength

3/8" Plain Steel nut and bolt @24 hr	140-300 lb_f-in

Environmental and Fluid Resistance

(Shear strength values after 1,000 hours.)

	Typical Values
Heat age @ 150°C	100%
Engine oil @ 150°C	80%
Brake fluid @ 150°C	90%
ATF @ 150°C	90%
50/50 water/ethylene glycol @ 120°C	85%
Water @ 100°C	85%
Gasoline @ 25°C	100%
Diesel fuel @ 25°C	100%
Ethyl Alcohol @25°C	95%

Instructions for Use

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

Compatible Primers

Primers such as Tigerhawk Excel 611 (Primer N) or Excel 612 (Primer T) can be used to speed the fixture time of the adhesive. Fixture times can improve by as much as 50%. The use of primers can result in lower strength and performance should be tested after full cure.

Presentation

Bottles…..2ml, 10ml, 50ml, 250ml and liter

Technical data contained within this document is intended for reference only
For assistance and recommendations on specifications for this product, contact AMV
ventas@amv.com.mx

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

Tigerhawk 393 is color coded red and once cured, seals and vibration proofs the assembly, giving controlled break loose and prevailing torque. When force is applied, the parts break loose (first movement) but it will take several turns before the cured film will stop resisting the turning action, thus ensuring accidental component disassembly.

Not recommended for use with most plastics as stress cracking can occur. Excellent environmental and chemical resistance. Product conforms to MIL-S-46163A , ASTM D-5363, NSF.

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.