Technical Data Sheet

Tigerhawk® 398 Threadlocker

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Product Description

Tigerhawk 398 Large Diameter High Strength Threadlocker is a red general purpose adhesive for permanent threaded assemblies. Tigerhawk 398 locks fasteners 1" and larger in diameter, sealing against leakage and corrosion. It resists attack from lubricants and most industrial liquids and gases.

Typical Applications

Eliminates double nutting and/or welding of critical assemblies. Using Tigerhawk 398 permits reduced casting thickness, and eliminates cracked castings due to interference fit stresses. It is recommended for larger diameter studs with coarse threads and is used to reclaim worn stud holes. Primers are recommended for large gaps and poor fitting parts.

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 onto threaded parts.

Compatible Primers

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

Technical Features

Resin:.....Dimethylacrylate
Color:.....Red
Fixture Speed w/Primer…….<10 seconds
Fixture Speed w/out Primer 60 min. @ 77°F
Viscosity…….....7000 cps
Gap Fill.....0.010"
Max. Operating Temp…… -65°F to +300°F

Cured Performance

Full Cure Time.....24 hours @ 68°F
Typical Breakaway Strength..250-350 in.lbs.
Typical Prevailing Strength...250-350 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

Tigerhawk 398 is easy to apply and color coded red to assist in selection. Because of its chemical resistance it is ideal for applications such as sealing for refrigeration environments, air conditioning applications and plant and processing equipment using corrosive chemicals.

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.

Technical data contained within this document is intended for reference only
For assistance and recommendations on specifications for this product.
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