



Product Description

Tigerhawk 363 is a medium strength, anaerobic thread locking compound. Tigerhawk 363 is designed for locking threaded fasteners that require disassembly with standard hand tools. The product performs on aluminum, steel, plated parts, stainless steel, and special alloy parts. Tigerhawk 363 exhibits good temperature and is solvent resistant.

Typical Applications

Tigerhawk 363 will lock and seal fasteners, and set screws. Tigerhawk 363 is used in applications where shock and vibration may cause the fastener to loosen.

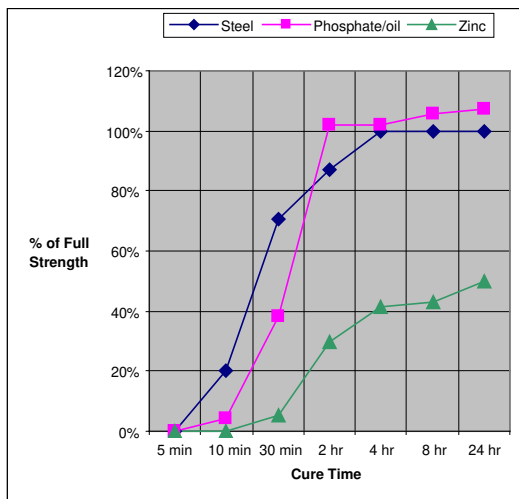
Properties of Uncured Material

Chemical Type: Anaerobic
Appearance: Blue
Toxicity: Low
Solids: 100%
Viscosity @ 25°C, cPs
 Brookfield RVT,
 Spindle 3 @ 20 rpm: 900-1500
Specific Gravity: 1.07

Typical Curing Performance

Cure Speed

The cure speed is dependent 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 @ 1 hr 50-150 lb_F-in
3/8" Plain Steel nut and bolt @ 24 hr 75-150 lb_F-in
3/8" Zinc nut and bolt @ 24 hr 60-100 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 100%
Brake fluid @ 150°C 100%
ATF @ 150°C 85%
50/50 water/ethylene glycol @ 120°C 80%
Water @ 100°C 80%
Gasoline @ 25°C 95%
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 8115 (Primer N) or (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.



TIGERHAWK

Technical Data Sheet
Vibra-Tite® 121
Threadlocker
June 2018

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 363 is recommended for threaded components under 1" in diameter. Components can be disassembled using conventional hand tools. It is color coded blue and once cured, seals and vibration proofs the assembly giving controlled breakaway and prevailing torques.

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.