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## Technical Data Sheet

### Permatex® High Strength Threadlocker RED

AAM Revised 11/15

#### PRODUCT DESCRIPTION

Permatex® High Strength Threadlocker RED is a **high strength** anaerobic threadlocking material that cures between engaged threads to form a unitized assembly that resists virtually all leakage, shock and vibration. The product is a single component, anaerobic liquid which cures when confined in the absence of air between close fitting metal surfaces. Ideal for all 3/8 inch to 1 inch diameter nut and bolt assemblies where future disassembly is improbable. Excellent chemical resistance with a temperature resistance range of -54°C to 150°C (-65°F to 300°F). OEM Specified.

#### PRODUCT BENEFITS

##### Improved Reliability

- Eliminates vibration issues
- Seals against leakage
- Prevents rusting of threads
- Cures without cracking or shrinking

##### Easy Application

- No mixing
- No curing outside of joint
- No torque compensation required during assembly

#### TYPICAL APPLICATIONS

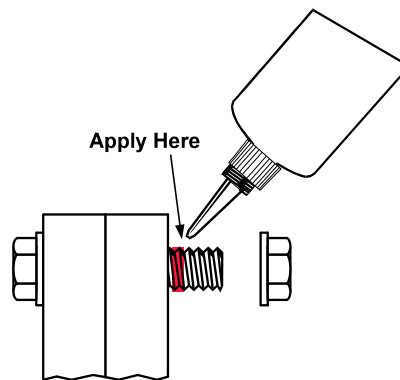
Prevents loosening and leakage of threaded fasteners. Particularly suitable for applications such as:

- Cylinder block
- Rocker arm studs
- Ring gear bolts
- Fan hub bolts
- Frame bolts
- Shock absorber bolts

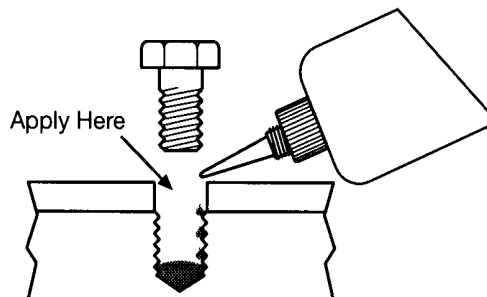
#### DIRECTIONS FOR USE

##### For assembly

1. Clean all threads (Bolt and Hole) with a cleaning solvent such as Permatex® Brake and Parts Cleaner and allow to dry.
2. Determine if the threads to be bonded are **Active** or **Inactive Metals** (Ref: Cure Speed vs. Substrate on the second page). If material is an **Inactive Metal**, spray all threads with Permatex® Surface Prep (24163) and allow 30 seconds to dry. Priming is not required if the material is an **Active Metal**. If unknown, it is always best to use the primer.
3. Shake the product thoroughly before use.
4. **For Thru Holes**, apply several drops of product onto the bolt at the nut engagement area.



5. **For Blind Holes**, apply several drops down female threads into the bottom of the hole. As threads are engaged, compressed air forces the product upwards into the threads.



6. Assemble and tighten as usual. When tightening to established torque values, torque compensation is not required.

##### For Cleanup

1. Residual liquid films and/or fillets outside the joint are readily soluble in Permatex® Brake and Parts Cleaner.
2. Cured product can be removed with a combination of soaking in Permatex® Gasket Remover and mechanical abrasion such as a wire brush.

##### For Disassembly

1. Apply localized heat to nut or bolt to approximately 260°C (500°F). Disassemble while hot.

##### For Reassembly

1. Remove loose product from nut and bolt.
2. Apply primer to all threads, regardless of metal type.
3. Assemble and tighten as usual.

**PROPERTIES OF UNCURED MATERIAL**

|                             | Typical Value                  |
|-----------------------------|--------------------------------|
| Chemical Type               | Anaerobic Dimethacrylate Ester |
| Appearance                  | Opaque Red Fluorescent Liquid  |
| Specific Gravity, g/ml      | 1.10                           |
| Viscosity @ 25°C, mPas (cP) | 400 to 600                     |
| Flash Point (TCC), °C (°F)  | >93 (>200)                     |

**TYPICAL CURING PERFORMANCE****Cure speed vs. substrate**

The rate of cure will depend on the material used. Permatex® High Strength Threadlocker RED will react faster and stronger with **Active Metals**. However, **Inactive Metals** will require the use of a primer (Surface Prep) to obtain maximum strength and cure speed at room temperature.

| Active Metals   | Inactive Metals   |
|-----------------|-------------------|
| Soft Steel Iron | Bright Platings   |
| Copper          | Anodized Surfaces |
| Brass           | Titanium          |
| Manganese       | Zinc              |
| Bronze          | Pure Aluminum     |
| Nickel          | Stainless Steel   |
| Aluminum Alloy  | Cadmium           |

**Cure speed vs. temperature**

The rate of cure will depend on the ambient temperature. **Full cure** is attainable in 24 hours at room temperature, 22°C (72°F), or 1 hour at 93°C (200°F).

**Cure speed vs. primer**

To shorten cure time or if an inactive surface is present, applying a primer (Surface Prep) to the surface will improve cure speed. A 3/8-16 steel nut and bolt assembly will fixture in 5 minutes using a primer, while fixturing will occur in 20 minutes without a primer. Full cure in 24 hours for both procedures.

**PERFORMANCE OF CURED MATERIAL**

(After 24 hr at 72°F on 3/8-16 steel Grade 8 Nuts and Grade 5 bolts)

|                                   | Typical Value |
|-----------------------------------|---------------|
| Breakaway Torque, Nm,<br>(in.lbs) | 28<br>(250)   |
| Prevail Torque, Nm<br>(in.lbs)    | 28<br>(250)   |

Where Breakaway Torque is the force required to initiate the fastener movement and Prevail Torque is the force required to disassemble the fastener once Breakaway Torque has occurred.

**TYPICAL ENVIRONMENTAL RESISTANCE****Temperature Resistance**

Product temperature range from -54°C to 150°C (-65°F to 300°F). The Breakaway and Prevailing Torque values decrease as temperature increases, however the assembly remains effective against vibration and leakage.

**Chemical / Solvent Resistance**

The product retains effective properties in contact with automotive fluids, such as motor oil, gasoline, brake fluids, transmission fluids, alcohol, and antifreeze solutions.

**GENERAL INFORMATION**

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

This product is not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). It is recommended to confirm compatibility of the product with such substrates.

**ORDERING INFORMATION**

| Part Number | Container Size       |
|-------------|----------------------|
| 19968       | 0.5 ml pipette       |
| 27100       | 6 ml tube, carded    |
| 27110       | 10 ml bottle, carded |
| 27140       | 36 ml bottle, carded |
| 27150       | 50 ml bottle         |
| 27183       | 90 ml bottle         |

**OEM Interchange**

| Manufacture      | OEM Specifications Numbers     |               |
|------------------|--------------------------------|---------------|
| Agrale           | 2031.000.006.000               |               |
| Chrysler (Mopar) | 4318032                        |               |
| Fiat             | 976033480                      |               |
| Ford             | EOAZ-19554-BA                  | WSK-M2G351-A3 |
| G.M.             | 1773.00000065                  | 998 5300      |
| Isuzu            | 1-8844-6373-0<br>9-8893-2602-0 | 9-8893-2601-0 |
| Maxion           | 1506033<br>0710115             | 710115        |
| Mercedes Benz    | A3459890271                    | A3459890171   |
| Mitsubishi       | MZ100360                       |               |
| Scania           | 814282                         |               |
| Toyota           | 00001-01004                    |               |
| Valmet           | 078723001                      |               |
| Volvo            | 078723001                      |               |

**STORAGE**

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° and 28°C (46° and 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container.

**NOTE**

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