

Product Description

Vibra-Tite 122 Oil Tolerant Threadlocker is a medium viscosity, thixotropic, anaerobic threadlocking adhesive for all types of metal, threaded fasteners. Cured performance shows controlled medium strength with good temperature and solvent resistance against water and nonpolar solvents. This product cures rapidly on plated, oily, metal surfaces or inactive surfaces.

Typical Applications

Replaces lock washers and plastic inserts. Locks machine tool access bolts, studs, and hydraulic system bolts. Used on gear box bolts/drive shaft, bearing cover cap screws, countersunk screws, conveyor roller bolts and construction equipment.

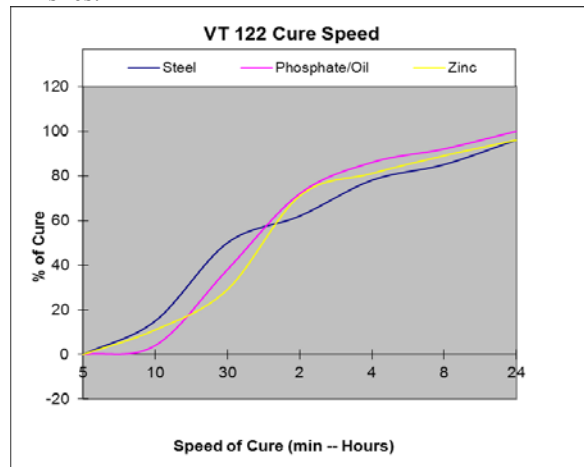
Technical Features

Resin: Modified acrylate
 Color: Blue
 Fixture Speed w/Primer: <1 seconds
 Fixture Speed w/o Primer: 5-10 min @ 77°F
 Viscosity: 2250-12000 cps
 Gap Fill: 0.0015"
 Max. Operating Temp: -65°F to +300°F

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 | 10-20 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 | 100-170 lb _f -in |
| 3/8" Zinc nut and bolt @ 24 hr | 120-170 lb _f -in |
| 3/8" Phos-oil nut and bolt @ 24 hr | 120 - 170 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 | 85% |
| Water @ 100°C | 80% |
| Gasoline @ 25°C | 95% |
| Diesel fuel @ 25°C | 100% |
| Ethyl Alcohol @ 25°C | 95% |

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).

Instructions for Use

Although this threadlocker is oil tolerant, for best performance, clean and dry parts to minimize the amount of surface oil and grease before applying product.

Compatible Primers

Primers such as Vibra-Tite Excel 611 (Primer N) or Excel 612 (Primer T) can be used. The use of primers can result in lower strength and performance should be tested after full cure.