Vibra-TITE®

VIBRA-TITE IS A REGISTERED TRADEMARK OF ND INDUSTRIES, INC.

Technical Data Sheet

Vibra-Tite® 135 Gel Threadlocker

November 2016

Product Description

Vibra-Tite 135 Gel Threadlocker is an anaerobic thread locking adhesive for all types of metal, threaded fasteners. Cured performance shows controlled medium strength with good temperature and solvent resistance against water and non-polar 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 caps screws, counter sunk screws, conveyor roller bolts and construction equipment.

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

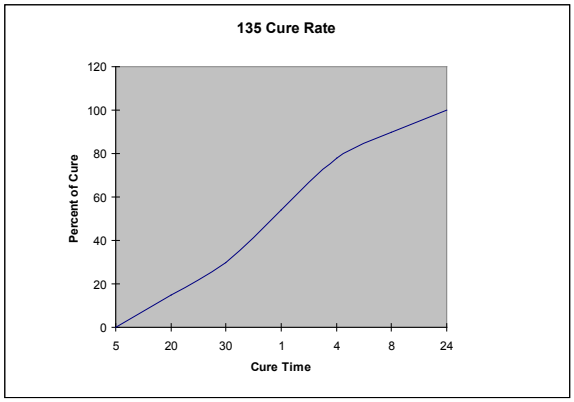
Primers such as Vibra-Tite Excel 611 (Primer N) or Excel 612 (Primer T) can be used. The use of primers can result in lower strength and performance should be tested after full cure.

Technical Features

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

Cured Performance

Full Cure Time: 24 hours @ 68°F
Typical Breakaway Strength:
3/8 Phos-oil 150 – 300 lb-ins
Typical Prevailing Strength:
3/8 Phos-oil 100 – 350 lb-ins



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	90%
ATF @ 150°C	85%
50/50 water/ethylene glycol @ 120°C	85%
Water @ 100°C	85%
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).

Note

Vibra-Tite 135 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.