Technical Data Sheet Vibra-Tite® 325 Low Strength Threadlocker

March 2016

Product Description

Vibra-Tite 325 is a low strength threadlocking adhesive designed for use on metal and plastic parts. 325 is fast curing to rapidly fixture parts with full cure being achieved within 24 hours. Fixture speed or full cure strength can be achieved in less time with the use of 621 Excel Accelerator. Fasteners locked with 325 can be removed with the use of standard tools without the use of excessive heat or other nonstandard methods.

Typical Applications

Typical applications for 325 include tamper-proofing the heads of screws, elimination of fastener clamp load loss due to vibration and thread locking applications that may require removal of the fastener.

Instructions for Use

For best performance surfaces should be relatively free of dirt and grease. 325 provides optimal performance in properly fitting parts with relative thin bondlines (0.05 mm) Apply 325 to the threaded portion of the fastener assembly to be locked. Promptly engage the coated fastener into the mating

Technical Features

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Technology	Cyanoacrylate
Composition	Ethyl Cyanoacrylate/ Aliphatic Ester
System	One-part/No mixing
Activation	Humidity
Operating Range	55 to +85 °C
Color	Dark Blue
Viscosity	Approximately 100 cps
Target ApplicationLow	v-strength thread locking on metals and plastics

Performance

Fastener Size	Typical Torque Strengths	Vibra-Tite 325 Low Strength Thread Locker
2-56	Break Away, in.lb	0.577
	Prevail, in.lb	0.426
4-40	Break Away, in.lb	0.922
	Prevail, in.lb	0.869
6-32	Break Away, in.lb	1.35
	Prevail, in.lb	1.37
8-32	Break Away, in.lb	1.69
	Prevail, in.lb	1.44
10-32	Break Away, in.lb	3.29
	Prevail, in.lb	3.41
3/8 x 24	Break Away, in.lb	16.0
	Prevail, in.lb	18.7

Break Condition: Room temperature

Cure Conditions: 24 hours at room temperature

Substrates: Zinc plated bolts and nuts

General Information

Safe Handling and Storage

Store unused 325 in the original container in a dry location. Be sure applicator cap is firmly sealed after use. Optimal storage temperature is between about 2 to 10 °C

Shelf Life

One year from date of manufacture.

Note

The data are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is recommended that the product be tested in the application for which it is to be used.