

ADHESIVE



77 RED™

THREADLOCKER HIGH STRENGTH

ADHESIVE R&D®'s anaerobic adhesives and sealants represent the latest generation in anaerobic chemistry. Anaerobic threadlockers remain liquid when they are exposed to the oxygen in air, but in the lack of air, (or anaerobic environment) these products quickly polymerize and fill the inner space between the surfaces. In a continuous quest to improve the performance of anaerobic adhesive's and sealants, ADHESIVE R&D® works with leading edge engineers to push the chemistry forward, to increase cure speeds and bond strengths, and to design products that are able to cure on contaminated or inert surfaces and yet remain stable without special handling.

77 RED™ is a very high viscosity, high strength threadlocker. It has good temperature resistance, and should be used on large fasteners, where a high break away torque is desired. Because it is high in viscosity, **77 RED™** will not run out of the joint before it cures and can be used in applications requiring good gap filling abilities.

* Per ASTM D5363 Specification.
3/8-16 plain finish cap screws and nuts.
Larger fasteners will increase surface area and breakaway torque.
77 Red™ meets ASTM D5363 AN0211 and Mil-S-46163 TYPE I Grade L.

Physical Properties

Composition Anaerobic Methacrylates
Color Red
Fluorescence Under Blue Light
Viscosity 6000-8000 cps
Specific Weight 1.05
Flash Point >100°F
Solvent Content None
Shelf Life @ 72°F 2 years

Curing Properties

Handling 20 minutes
Functional Cure Time 2-4 hours
Full Cure 8-10 hours
Locking Torque*
Breakaway 300-400 inch lb's
Prevailing 300-400 inch lb's
Temperature Range 150°C

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