

Technical Data Sheet

B243 THREADLOCKER

Bondloc B243 Oil Tolerant Anaerobic Threadlocker

PRODUCT DESCRIPTION

B243 is an Anaerobic formulation designed to be used on parts in an "as received" condition, such as those with protective films (oils) etc.

APPLICATIONS

Oil tolerant B243 is designed for direct application onto as received parts where a light oily film exists or where surrounding parts contamination is a problem in maintenance.

USEFUL NOTES

Where possible, remove thick deposits of grease or dirt, however B243 will penetrate the film once it has been tightened.

PROPERTIES

Use as a conventional medium strength locker on cleaned parts with strengths up to 12N/mm² or as a convenient all purpose locker on oily parts with 8-10mm² typical strength depending on oil type and film.

TECHNICAL FEATURES

| | |
|----------------------------|-----------------------|
| Resin | Mod Methacrylate |
| Colour | Blue Thixotropic |
| Cure speed | <15 mins @ 20°C |
| Viscosity | 1200-1800 thixotropic |
| Gap fill | 0.1mm |
| Flash Point | >85°C |
| Shelf life | 12 months @ 20°C |
| Specific gravity | 1.04 |
| Max. Operating Temperature | -53°C to + 150°C |

CURED PERFORMANCE

| | |
|-----------------------------|------------------------|
| Full Cure Time | 24 hours |
| Typical Breakaway Strength | 12 N/mm ² |
| Typical Prevailing Strength | 8-10 N/mm ² |

PROCEDURE FOR APPLICATION

Product is normally hand applied from the bottle

STORAGE

Store in a cool area out of direct sunlight. Shelf life > 12 months at ambient temperature.

HEALTH & SAFETY IN USE

IRRITANT: Contains Methacrylate Esters and some products contain small amounts of Acrylic Acid. Irritates eyes, the respiratory organs and the skin. In case of contact with the skin wash immediately with plenty of water.

This Technical information sheet does not constitute a Material Safety Data Sheet. Before using this product ensure you have read and fully understood Bondloc Material Safety Data Sheet B243.

PRESENTATION

B243 is available in 10ml, 25ml, 50ml & 250ml, bulk packs

PRECAUTIONS: This product and the auxiliary materials normally combined with it are capable of producing adverse health effects ranging from minor skin irritation to serious systemic effects. None of these materials should be used, stored, or transported until the handling precautions and recommendations as stated in the Material Safety Data Sheets (MSDS) for this and all other products being used are understood by all persons who will work with the product.

Warranty: All products purchased from or supplied by Bondloc are subject to terms and conditions set out in the contract. Bondloc warrants only that its product will meet those specifications designated as such herein or in other publications. All other information supplied by Bondloc is considered accurate but are furnished upon the express condition the customer shall make its own assessment to determine the product's suitability for a particular purpose. Bondloc makes no other warranty, either express or implied, including those regarding such other information, the data upon which the same is based, or the results to be obtained from the use thereof; that any product shall be merchantable or fit for any particular purpose; or that the use of such other information or product will not infringe any patent.



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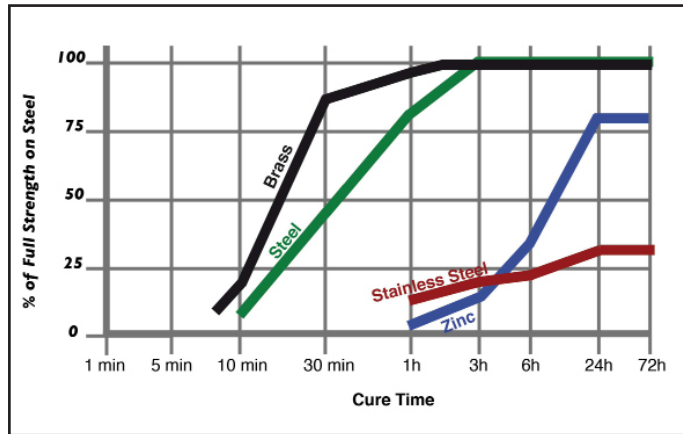
B243 THREADLOCKER



CURE SPEED vs SUBSTRATE

The rate of cure will depend on the substrate that is used.

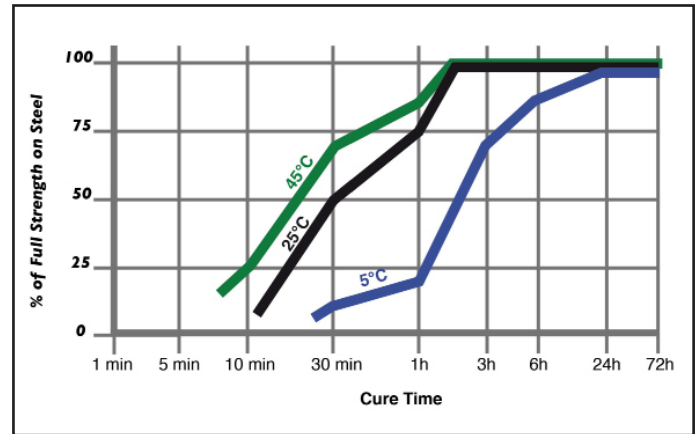
According to ISO 10964.



| Substrate | Initial cure time | Full cure time |
|-----------------|-------------------|----------------|
| Steel | 10 mins | 3 hours |
| Zinc | 1 hour | 24 hours |
| Brass | 7-8 mins | 2 hours |
| Stainless steel | 1 hour | 24 hours |

CURE SPEED vs TEMPERATURE

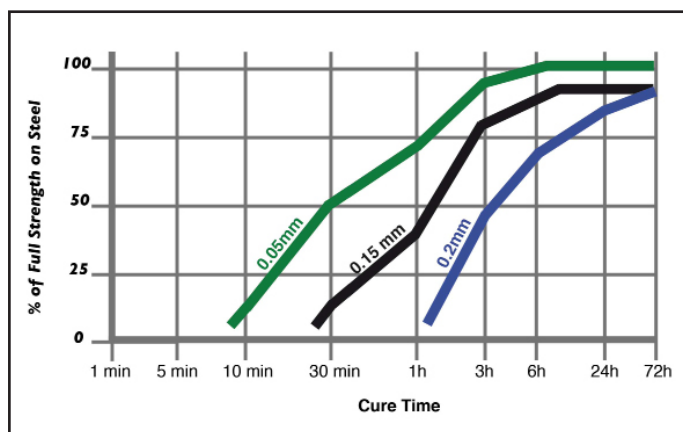
The rate of cure will depend on the temperature. According to ISO 10964.



| Temperature | Initial cure time | Full cure time |
|-------------|-------------------|----------------|
| 45°C | 7-8 mins | 2 hours |
| 25°C | 11-12 mins | 2 hours |
| 5°C | 40-45 mins | 24 hours |

CURE SPEED vs BOND GAP

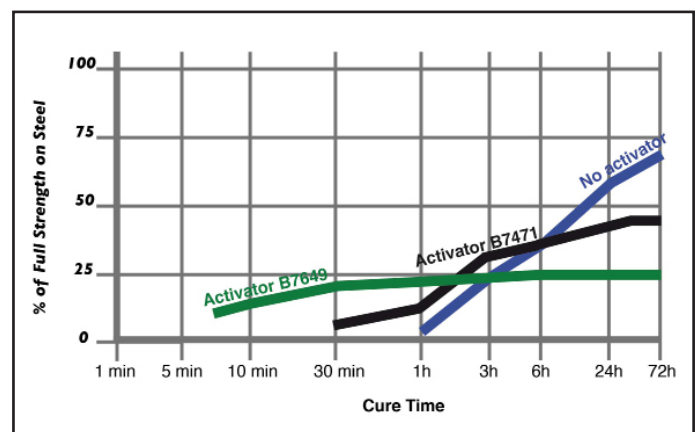
The rate of cure will depend on the bondline gap. According to ISO 10964.



| Gap | Initial cure time | Full cure time |
|--------|-------------------|----------------|
| 0.05mm | 8-9 mins | 7 hours |
| 0.15mm | 20-25 mins | 8-9 hours |
| 0.2mm | 1-2 hours | 72 hours |

CURE SPEED vs ACTIVATOR

Where cure speed is long or large gaps are present apply an activator to the surface. According to ISO 10964.



| Activator | Initial cure time | Full cure time |
|--------------|-------------------|----------------|
| B7649 | 6-7 mins | 6 hours |
| B7471 | 30 mins | 24-72 hours |
| No activator | 1 hour | 72 hours |

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