**Technical Datasheet**

**Holdtite T22**

**Product Description**

Holdtite T22 is a low strength anaerobic threadlocker, designed to allow easy disassembly of metal threaded components. T22 is thixotropic, which reduces the migration of the liquid adhesive following application. Once applied, the T22 only cures when confined between the two mating metal parts. Despite the controlled low torque disassembly that the T22 provides, the AT02 still maintains excellent vibration and shock resistance.

**Typical Applications**

Bondchem T22 is well suited to metal fastener applications, where prevention of vibrational loosening is required. T22 is ideal on set screws, threaded nuts, bolts, screws, hex and slot driven components, including keyed fasteners.

**Instructions For Use**

1. For best results clean all surfaces with a cleaning solvent and allow to dry.
2. If the metal is inactive (see Compatibility Chart) apply suitable Bondchem primer.
3. Shake the product thoroughly before application
4. Apply the adhesive to the fixing position of the fastener or onto the internal threads of a blind hole.
5. Use suitable methods to assemble components, and tighten to required torque level.
6. Allow to fully cure before applying load

**Properties of Uncured Material**

|  |  |
| --- | --- |
| Resin | Dimethacrylate |
| Colour | Purple |
| Viscosity @ 250C |  |
| Brookfield Sp 3 @ 20rpm | 1,200 to 5,000cps |
| Viscosity 2 | Thixotropic |
| Cure System | Anaerobic |

**Performance of Cured Material**

|  |  |
| --- | --- |
| Fixture Speed  | 20 Minutes @ 250C |
| Fixture Speed with Primer | <5 Seconds |
| Full Cure Time | 24 hours @ 200C |
| Typical Breakaway Strength | 5.5 to 11.5 Nm |
| Typical Prevailing Strength | 2 to 5.5 Nm |
| Gap Fill | 0.018mm |
| Temperature Range | -530C to 1480C |

**Packaging**

Holdtite T22 is available in 10ml, 50ml, 250ml LDPE bottles. In addition, we can offer automated dispensing lines for the bulk dispensing of this material.

**Storage & Shelflife**

Bondchem AT02 should be stored in a cool dry area, out of direct sunlight. Stored correctly , this grade can offer a 12 month shelf life from manufacture.

**Health and Safety in Use**

**Irritant**: Contains Methacrylate Esters which may irritate eyes, respiratory organs and skin. In case of contact with the skin, wash immediately with plenty of water. For full Health and Safety information please consult the MSDS.