**Technical Datasheet**

**Holdtite T42**

**Product Description**

Holdtite T42 is an oil tolerant medium strength threadlocker, that cures anaerobically to lock all types of metal threaded fasteners. T42 is designed for applications that require future disassembly with standard hand tools, and offers excellent temperature and solvent resistance once cured. T42 is also thixotropic, which aids assembly by reducing the migration of the liquid adhesive following application. This grade can even cure rapidly on plated, oily metal, or inactive surfaces.

**Typical Applications**

Holdtite T42 is well suited to a number of applications including:

* Replacing lock washers and plastic inserts.
* Locking machine tool access bolts.
* Locking and sealing gear box and drive shaft bolts.
* Securing conveyor roller bolts.
* Locking bearing cover cap screws

**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 cure fully before applying load.

**Properties of Uncured Material**

|  |  |
| --- | --- |
| Resin | Modified Acrylate |
| Colour | Blue |
| Viscosity @ 25⁰C |  |
| Brookfield Sp 3 @ 30rpm | 1300-3000 cps |

**Performance of Cured Material**

|  |  |
| --- | --- |
| Fixture Speed | 5 to 10 Minutes @ 25⁰C |
| Fixture Speed with Primer | <1 Second |
| Full Cure Time | 24 hours @ 20⁰C |
| Typical Breakaway Strength | 24 Nm |
| Typical Prevailing Strength | 5 to 7 Nm |
| Gap Fill | 0.04mm |
| Temperature Range | -53⁰C to 148⁰C |

**Packaging**

Holdtite T42 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**

Holdtite T42 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.