

# HIGH TEMPERATURE THREADLOCKER 301350

## TECHNICAL DATA SHEET

### Product Description

301350 is a single component high strength, anaerobic threadlocker. 301350 cures when confined in the absence of air between close-fitting metal surfaces, providing excellent vibration, corrosion and shock resistance at high temperatures.

### Applications

301350 is formulated to provide a permanent locking of bolts and studs up to 1" in diameter. 301350 prevents vibration loosening at high temperatures (intermittently up to 205°C) and its thixotropic nature prevents dripping or migration of the liquid adhesive after assembly.

### Physical Properties

Chemical Type	Dimethacrylate
Appearance	Red / Orange
Specific Gravity	1.12
Viscosity (cps)	Range 4000 – 15000 (Typical value – 7000)

### Performance Characteristics

Maximum Gap Fill	0.20 mm
Fixture Time (ISO10964)	20 minutes (Range 10 – 30 mins)
Full Cure	24 hours
Breakaway Torque (N.m)	Range 17-39 (Typical value – 21)
Prevail Torque (N.m)	Range 17-57 (Typical value – 26)
Heat Resistance	Suitable for use at temperatures up to 205°C (80% of strength retained at 205 °C).
Operating Temperature Range	-50 to +200 °C

### Directions for Use:

Anaerobic adhesives only cure in the absence of air and with metal part activation. Adhesive outside the joint will remain uncured and may be wiped away with a cloth. 301350 is not recommended on certain plastics as stress cracking can sometimes result.

### For Assembly:

1. Ensure parts are clean, dry and free from oil, grease and dirt. For best results, clean and dry parts with solvent. (Activator can also be used on inactive surfaces or to accelerate the cure on active surfaces.)
2. If not sure of surface type, always use activator. Refer to Material surface Activity and Cure Speed section for more information.
3. Shake the adhesive bottle well before use.
4. Avoid touching the metal surfaces with the bottle tip since the metal ions may react with the adhesive upon contact and eventually may clog the bottle tip.
5. Apply adhesive onto the threaded part where the contact area will be in the final assembly. For larger parts, use more adhesive and rotate the threaded part to spread adhesive evenly around contact area.

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6. For through holes, apply several drops of adhesive onto the bolt at the nut engagement area. For blind holes, apply several drops of the adhesive down the internal threads to the bottom of the hole.
7. Assemble the nut / fastener and tighten as required.
8. Allow assemblies to set for sufficient time so that handling strength or full cure will occur before further processing or testing.

**For Disassembly:**

1. Loosen or remove with regular hand tools.
2. If hand tools do not work due to the assembled parts being well tightened, apply localised heat (approx. 250°C) to the nut or bolt and disassemble while parts are still hot. Use extreme caution when working with heat sources (e.g. heat gun, flames, etc.)

**Material Surface Activity and Cure Speed**

**Active (Fast cure)**

Brass  
Bronze  
Commercial aluminium  
Copper  
Iron  
Kovar®  
Manganese  
Monel®  
Nickel

**Inactive (Slow cure)**

Anodized Aluminum  
Cadmium  
Chemical black oxide  
Galvanized steel  
Gold  
Inconel®  
Magnesium  
Magnetite Steel  
Plated parts  
Pure aluminum  
Silver  
Stainless Steel  
Zinc

**Storage Conditions**

Keep the adhesive in a cool, dry place away from direct sunlight. Under such conditions shelf life at room temperature will be 12 months.  
Refrigeration to 5°C gives optimum storage stability.

**Shelf Life**

12 months from date of despatch when stored in the original container at 21°C.

**Precautionary Information**

Refer to product label and material Safety Data Sheet for health and safety information before using the product.

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