

SAF-T-LOK®

Threadlocker T77

Technical Data Sheet

Part # 27721, 27731, 27741, 27743

GENERAL INFORMATION:

SAF-T-LOK anaerobic adhesive/sealants are a specialized series of single component, solvent free compounds that are individually formulated for locking, sealing, retaining and bonding metal parts and assemblies.

Stable in the presence of air, these products cure when placed between two mating metal parts where metal is present and oxygen is excluded. They form a resilient, vibration-proof, polymer shim between the parts. **SAF-T-LOK** products provide the user with additional performance characteristics, including not only fluid sealing, but resistance to corrosion or galvanic attack of the mated parts, as well as solvent resistance. Furthermore, after curing **SAF-T-LOK T77** provides permanent assembly.

PRODUCT DESCRIPTION:

SAF-T-LOK T77 is a high strength locking and sealing grade, developed primarily for sealing strong solvent system, and similar permanent applications.

SAF-T-LOK T77 studlocking sealant grade was developed for use where specific viscosities are needed and high strength threadlocking is required. This product satisfies many application requirements by providing high strength. Selection of the proper product thickness assures the sealing of parts as well as the most reliable reproducible threadlocking strength possible.

BENEFITS:

IMPROVED EQUIPMENT RELIABILITY

Improves reliability by providing more holding power under vibration than lock screws and lock washers etc.

Offers precision torque for the exact degree of holding required.

Also provides substantial cost savings over mechanical locking methods.

APPLICATION EASE

No mixing (one part adhesive), wide variety of application methods designed to suit your specific needs.

Low odor product for a safe work place, and easy clean-up after the job is completed.

TORQUE TENSION RELATION:

SAF-T-LOK threadlockers generally increase bolt tension. That is for a given torque on a bolt a greater tension will result with the use of the threadlocker, due to the lubricating qualities of the liquid. However, us of **SAF-T-LOK T77** will result in torque tension values within 10 percent of as received fasteners, and it will also provide a more consistent relationship between tension and torque than is provided by “as received” fasteners. Tension in the fasteners can be controlled by regulating the applied torque. The relationship between tension and torque can be expressed as follows:

$$T = CDF$$

- T = Torque (Nm)
- C = Constant for specific nuts and bolts used
- D = Bolt diameter (m)
- F = Tension or clamping force (N)

“C” values for various metals follow:

Steel	.16	Phosphate	.14	Cadmium	1.4
Zinc	.18	Stainless	.22	Aluminum	.17

If tension of a bolt is critical, testing with the precise method and fastener should be considered.

SOLVENT RESISTANCE:

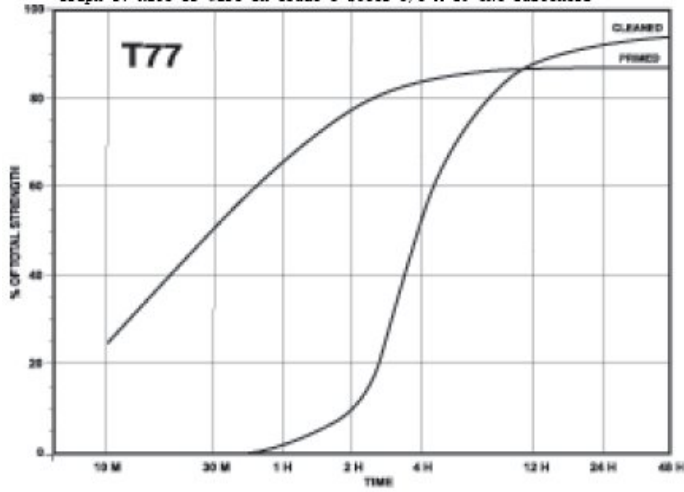
Fasteners or piping connections to which **SAF-T-LOK T77** has been applied and allowed to cure were immersed in various fluids at elevated temperatures. A reduction in strength frequently occurs. As a general guide the following percent of strength was obtained after 30 days at 188°F or (87°C):

Air Reference @ 188°F	100%
Motor Oil (% of Ref)	113
Water (% of Ref)	158
Glycol / Water (% of Ref)	118
Transmission fluid (% of Ref)	115
Gasoline (% of Ref)	86
Skydrol (% of Ref)	78

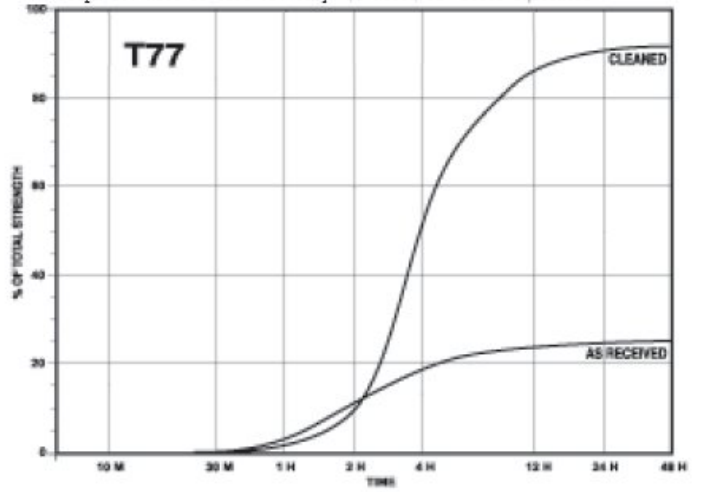
IMPORTANT NOTICE: All statements and technical data contained herein are based on tests we believe to be reliable, but the accuracy of completeness thereof is not guaranteed. It is recommended that the buyer test this product to determine its suitability for his application before use. **SAF-T-LOK** International Corporation is not responsible for loss, claim or damages resulting from use of its products.

FACTORS AFFECTING CURE RATE AND STRENGTH

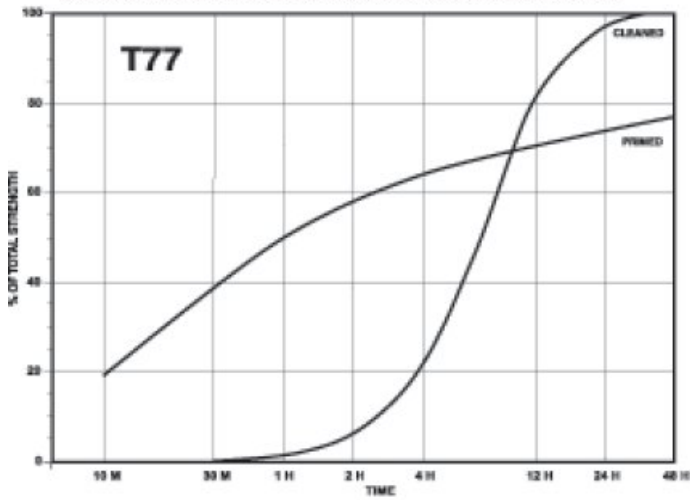
Graph I: Rate of cure on Grade 5 Steel 3/8 x 16 UNC fasteners



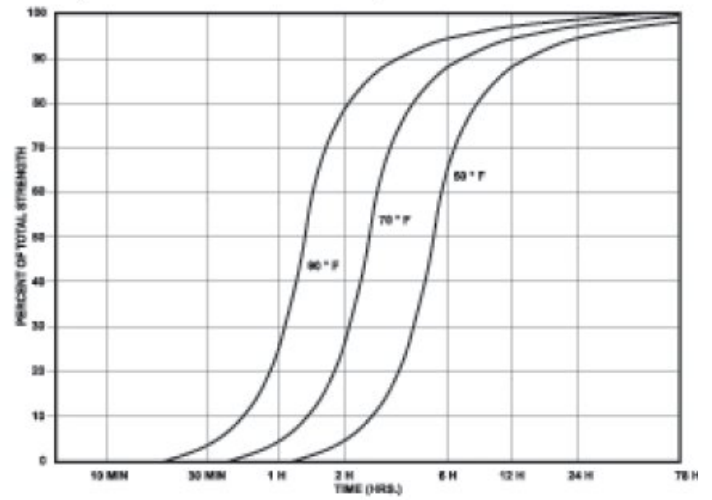
Graph IV: Rate of cure vs. Oily "As Received" steel fasteners



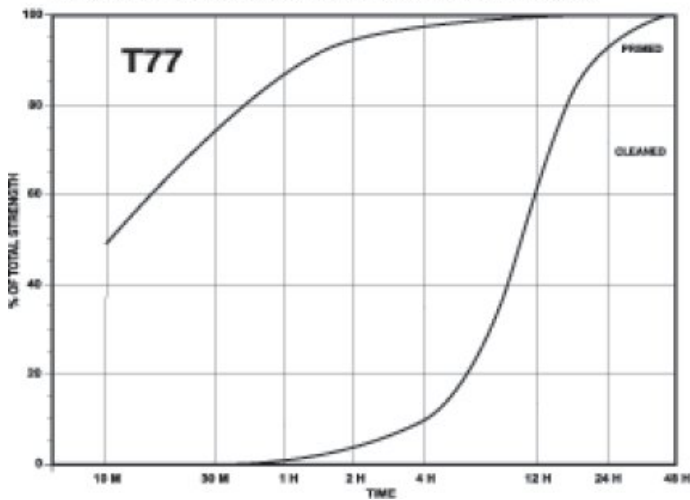
Graph II: Rate of cure on Cadmium plated 3/8 x 16 UNC fasteners



Graph V: Rate of cure at various temperatures



Graph III: Rate of cure on Zinc plated 3/8 x 16 UNC fasteners



Graph VI: Percent of reported strength vs. fastener diameter

