PRODUCT DESCRIPTION
S.I.N.: 834-300
Permatex® High Temperature Threadlocker RED is a high temperature, high strength anaerobic threadlocking material, whichcures between engaged threads to form a unitized assembly that resists virtually all leakage, shock and vibration. The product is a single component, anaerobic liquid thatcureswhen confined in the absence of air between close fitting metal surfaces. Ideal for all 3/8 inch to 1 inch diameter nut and bolt assemblies. Excellent chemical resistance and temperature resistance range of -54°C to +232°C (-65°F to +450°F). OEM Specified.

PRODUCT BENEFITS
Improved Reliability
• Eliminatest vibration issues
• Seals against leakage
• Prevents rusting of threads
• Cures without cracking or shrinking
• Thixotropic: resists dripping from threads during assembly
• Performs at elevated temperatures

Easy Application
• No mixing
• No curing outside of joint
• No on-torque adjustments needed

TYPICAL APPLICATIONS
Prevents loosening and leakage of threaded fasteners. Particularly suitable for applications such as:
• Frame brackets
• Hydraulic press studs
• Idler Bearings
• Shock absorber mounts
• Frame bolts
• Ring gear bolts
• Axle support studs
• Studs in wheel hub
• Flywheel bolts

DIRECTIONS FOR USE
For assembly
1. Clean all threads (Bolt and Hole) with a cleaning solvent such as Permatex® Brake and Parts Cleaner and allow to dry.
2. Determine if the threads to be bonded are Active or Inactive Metals (Ref: Cure Speed vs. Substrate on the second page). If material is an Inactive Metal, spray all threads with Permatex Surface Prep (24163) and allow 30 seconds to dry. Priming is not required if the material is an Active Metal. If unknown, it’s always best to use the activator.
3. Shake the product thoroughly before use.
4. To prevent the product from clogging in the nozzle, do not allow the tip to touch metal surfaces during application.
5. For Thru Holes, apply several drops of product onto the bolt at the nut engagement area.
6. For Blind Holes, apply several drops down the female threads into the bottom of the hole. As threads are engaged, compressed air forces the product upwards into the threads.
7. Assemble and tighten as usual. When tightening to established torque values, torque compensation is not required.

For Cleanup
1. Residual liquid films and/or fillets outside the joint are readily soluble in Permatex® Brake and Parts Cleaner.
2. Cured product can be removed with a combination of soaking in Permatex® Gasket Remover and mechanical abrasion such as a wire brush.

For Disassembly
1. Apply localized heat to nut or bolt to approximately 260°C
For Reassembly
1. Remove loose product from nut and bolt.
2. Apply primer to all threads, regardless of metal type.
3. Assemble and tighten as usual.

PROPERTIES OF UNCURED MATERIAL

<table>
<thead>
<tr>
<th>Chemical Type</th>
<th>Typical Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Chemical Type</td>
<td>Anaerobic Dimethacrylate Ester</td>
</tr>
<tr>
<td>Appearance</td>
<td>Opaque Red-Orange Liquid</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td>1.11</td>
</tr>
<tr>
<td>Viscosity @ 25°C, mPa.s (cP)</td>
<td>4,000 to 15,000</td>
</tr>
<tr>
<td>Flash Point (TCC), °C (°F)</td>
<td>&gt;93 (200)</td>
</tr>
</tbody>
</table>

TYPICAL CURING PERFORMANCE

Cure speed vs. substrate
The rate of cure will depend on the material used. Permatex® High Temperature Threadlocker RED will react faster and stronger with Active Metals. However, Inactive Metals will require the use of a activator (Surface Prep) to obtain maximum strength and cure speed at room temperature.

<table>
<thead>
<tr>
<th>Active Metals</th>
<th>Inactive Metals</th>
</tr>
</thead>
<tbody>
<tr>
<td>Soft Steel Iron</td>
<td>Bright Platings</td>
</tr>
<tr>
<td>Copper</td>
<td>Anodized Surfaces</td>
</tr>
<tr>
<td>Brass</td>
<td>Titanium</td>
</tr>
<tr>
<td>Manganese</td>
<td>Zinc</td>
</tr>
<tr>
<td>Bronze</td>
<td>Pure Aluminum</td>
</tr>
<tr>
<td>Nickel</td>
<td>Stainless Steel</td>
</tr>
<tr>
<td>Aluminum Alloy</td>
<td>Cadmium</td>
</tr>
</tbody>
</table>

The graph below shows the breakaway strength developed with time on 3/8” - 16 Grade 5 bolts and Grade 2 nuts compared to different materials.

Cure speed vs. temperature
The rate of cure will depend on the ambient temperature. Full cure is attainable in 24 hours at room temperature, 22°C (72°F), or 1 hour at 93°C (200°F).

Cure speed vs. activator
To shorten cure time or if an inactive surface is present, applying a primer (Surface Prep) to the surface will improve Permatex is a trademark of Permatex, Inc. © 2002 All rights reserved
This product is not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). It is recommended to confirm compatibility of the product with such substrates.

ORDERING INFORMATION

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Container Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>27250</td>
<td>50 ml bottle</td>
</tr>
</tbody>
</table>

STORAGE

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C to 28°C (46°F to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container.

NOTE

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