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Technical Data Sheet **Titan 8242**

Product Description

Titan 8242 is a single component anaerobic threadlocking adhesive, which is thixotropic and develops medium strength. The product cures between close fitting metal parts where there is an absence of air.

Typical Applications

Prevents loosening of threaded fasteners. Suitable for applications where disassembly with hand tools is required for servicing.

Physical Properties

Monomer (Liquid)

Base Compound	Dimethacrylate Ester
Appearance	Blue liquid
Viscosity (cP @ 68°F)	1000 cP
Specific Gravity (g/cc)	1.1
Gap Fill	.007"
Corrosivity	None
Flash Point (TCC)	>200°F
Toxicity	Low
Shelf Life @40°F	1 year unopened

Military Specifications

Mil-S-46163A

Type II, Grade N

Curing Properties

The rate of cure will depend on environmental conditions and the substrates used.

Setting Time (68°F, 65% R.H.)

Substrate	Set time/Full Cure
Steel	10 min/24 hrs
Brass	15 min/24 hrs
Zn Dichromate	20 min/24 hrs
Stainless Steel	20 min/24 hrs

Curing Performance

The gap of the bond line will affect set speed. Smaller gaps tend to increase the speed. Activators can be applied to improve set speed but may also impair overall adhesive performance.

Polymer (Cured)

Locking Strength	Medium
Appearance	Blue Solid
Service Temperature Range	-75°F to 300°F
Full Cure Time	24 Hours
Sheer Strength (steel nuts and bolts)	1200 psi

Performance of Cured Materials

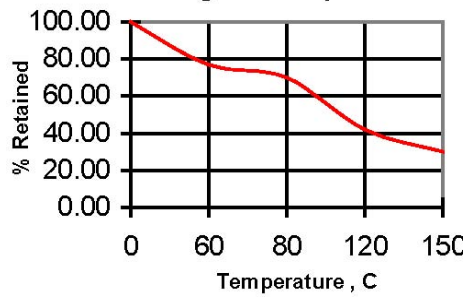
Bond strength after 24 hours at 20° to 25°C on steel nuts and bolts.

	Avg. Value	Range
Breakaway Torque	125 in. lbs.	100-150 in. lbs.
Prevailing Torque	70 in. lbs.	35-100 in. lbs.

Temperature Resistance

% Retained strength when tested at temperature

Strength at Temperature



For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS)

Chemical Resistance

Sheer strength on steel after 500 hours

Solvent	% Strength Retained
Motor Oil	100
Unleaded Gasoline	100
Trichloroethane	100
Brake Fluid	100
Ethanol	100
Acetone	100
Water/Glycol Mix	80

NOTE

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General Instructions

Surfaces to be bonded should be clean and dry and free of grease.

Product should be applied in enough quantity to fill all engaged threads. The product performs best in thin bond gaps. Very large gaps may create gaps which will affect the cure speed and overall strength.

Good contact is essential. An adequate bond develops in 15 to 45 minutes and maximum strength is attained in 24 hours.

This product is not recommended for use in pure oxygen environments and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

This product is not designed for plastics, particularly thermoplastics where stress cracking of the plastic could result. It is recommended to confirm compatibility of the product with all substrates prior to use.

Storage

Products should be stored unopened in a cool, dry place out of direct sunlight.

Products can be refrigerated for improved shelf life but should be

brought back to room temperature
before use.

