

# THREADLOCKER PC 271 #2478

## High Strength Permanent Threadlocker



### Features:

- Prevents movement of screw threads & eliminates self-loosening in areas where shock and vibration may be present
- Seals against leakage
- Protects threads from rust and corrosion
- Eliminates double nutting and/or welding of critical assemblies
- Good temperature stability
- Solvent resistant
- Conforms to MIL-S-46163A, ASTM D-5363, NSF

### Description:

THREADLOCKER PC 271 is a high strength adhesive for locking and sealing all fasteners up to 1" in diameter. It is used where severe applications are evident or for tamper-proofing where a difficult removal is desired. It is especially suited for permanently locking studs and press fits. Curing occurs only when adhesive is confined between mating surfaces. The cured adhesive will withstand temperatures up to 300°F and exposure to most fuels, lubricants and most industrial gases. Requires extra or special tools for removal. Suitable for fasteners up to 1" diameter. Performs well on aluminum, steel, plated fasteners, stainless steel and special alloy parts.



### Applications:

- Bearing retainer nuts on conveyors
- Studs on marine motor housing
- Automobile front suspension bolts
- Hydraulic press studs (large diameter)
- Water pump studs and nuts
- Nuts on ice crushers
- Locking and Sealing
- Cylinder Liner Studs
- Door closer plugs
- Snow plow blade bolts

### Product Characteristics:

|                                   |  |
|-----------------------------------|--|
| Appearance:                       | Red, fluid   |
| Odor:                             | Characteristic   |
| Vapor Pressure at 68°C (154.4°F): | ≤ 1.3 hPa (≤ 1 mm Hg)  |
| Boiling Point/Range:              | >195°C (> 383°F)   |
| Melting/Freezing Point/Range:     | Undetermined   |
| Vapor Density:                    | Not determined   |
| Solubility (water):               | Not miscible or difficult to mix   |
| Solids Content:                   | 56.5%  |
| Flash Point:                      | 94°C (201.2°F)   |
| Ignition Temperature:             | n.a. °C  |
| Density at 20°C (68°F):           | ~ 1.1 g/cm <sup>3</sup> (~ 9.1795 lbs/gal)   |
| Specific Gravity:                 | 1.10   |
| Storage:                          | Store in cool, dry conditions. Protect from heat and direct sunlight. Keep container tightly closed. |
| <b>Transport Information:</b>     |  |
| Proper Shipping Name:             | Not regulated  |
| UN Number:                        | Not regulated  |
| Class:                            | Not regulated  |
| Packing Group:                    | Not regulated  |

### Directions:

Ensure parts are clean, dry and free from oil and grease. Twist off white cap and snip nozzle to desired length. Hand apply from the bottle onto threaded parts and assemble. High strength special tools are required for removal. The application of heat may be required to assist in removal.

**\*Not recommended for plastics.**

### Product Properties:

|   |  |
|---|--|
| Fixture Time:   | 15-20 minutes @ 72°F                                   |
| Full Cure Time:   | 24 hours @ 72°F  |
| Shelf Life:   | 18 months from date of manufacture if stored at 72°F   |
| Temperature Range:  | -60°F to 300°F (-51°C to 150°C)                        |
| Breakaway Strength:                                       | 3/8" Plain Steel nut and bolt @24 hr<br>140-300 lbf-in |
| Breakaway Strength:                                       | 3/8" Zinc plate nut and bolt @ 24 hr<br>200-350 lbf-in |
| Viscosity @25°C, cPs, Brookfield RVT, Spindle 3 @20 rpm): | 400-600  |

### Pictograms:



### Signal Word:

Warning.

### Personal Protective Equipment Required:



### DOT Placard:

Not regulated.

**Environmental and Fluid Resistance:**  
**Share strength values after 1000 hours)**

|                                      |      |
|--------------------------------------|------|
| Heat Age:                            | 100% |
| Engine oil @ 150°C:                  | 80%  |
| Brake fluid @ 150°C:                 | 100% |
| ATF @ 150°C:                         | 100% |
| 50/50 water/ethylene glycol @ 120°C: | 85%  |
| Water @ 100°C:                       | 85%  |
| Gasoline @ 25°C:                     | 100% |
| Diesel fuel @ 25°C:                  | 100% |
| Ethyl Alcohol @25°C:                 | 95%  |

**Cure Speed:**

The cure speed is depended on temperature and substrate. The graph below shows the Breakaway Strength on M-10 Steel, Phosphate/oil and Zinc finishes.

