



# Technical Data Sheet

## B290 Penetrating Threadlock

December 2021

### PRODUCT DESCRIPTION

B290 Penetrating Threadlock is a very low viscosity, medium to high strength penetrating grade threadlocker that is suitable for pre-assembled threads or for post-application. The wicking action ensures holes and porosities in castings and welds can be filled and sealed. Ideal for locking instrumentation fasteners, electrical connectors and set screws.

### THREADLOCKERS

Bondloc threadlockers are single-component liquids that cure at room temperature to a hard, solid thermoset plastic when applied between steel, aluminium, brass and most other metal surfaces. They cure with the absence of air and when in contact with metal ions, the adhesive completely fills the gaps between mating threads to lock threads and joints. This prevents unwanted movement, loosening, leaks and corrosion.

### ANAEROBIC KEY FEATURES

- Single-component – clean and easy to apply
- Prevent unwanted loosening, leaks, and corrosion
- Reduces costs over mechanical fittings
- Resists vibration
- Can be used on all sizes of fasteners – reduces inventory costs
- Seals threads and increases friction.

### TECHNICAL FEATURES

|                                       |                     |
|---------------------------------------|---------------------|
| Base technology                       | Acrylic             |
| Colour                                | Green (UV Positive) |
| Cure                                  | Anaerobic           |
| Viscosity Brookfield Sp3 @20rpm@25°C  | 20-55 cps           |
| Cure speed without Activator          | 7 minutes @ 22°C    |
| Max Thread Size                       | M2-M12              |
| Shelf Life                            | 24 months @ 22°C    |
| Specific Gravity ASTM D1475-13 (2020) | 1.08                |
| Temperature Range                     | -55°C to +150°C     |

### TEST PERFORMANCE

|  |                         |
|--|-------------------------|
| Full Cure Time                               | 12 hours @ 22°C         |
| Strength – ISO 10964 Breakaway Prevailing    | Unseated >12Nm 28Nm     |
| Strength – ISO 10964 Breakloose: Prevailing: | Pre – torqued 30Nm 40Nm |

### TEST CRITERIA

The test performance data reported was measured according to ISO 10964 using M10 mild steel bolts and cured 24 hours at 22°C (71.6°F) before testing.

### PACKAGING FORMAT

Bottles.....10ml, 25ml, 50ml, 250ml

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### INSTRUCTIONS FOR USE

- Clean surfaces to be bonded with B7063 Solvent Cleaner and allow to dry
- Apply adhesive to the threads, apply sufficient adhesive to fill the voids and then assemble and tighten as required
- When the cure speed is slow use B7649 Anaerobic activator for increased cure and set times.

### LIMITATIONS

- This product is not recommended for use in pure oxygen and/or oxygen-rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials. Material removed from containers may be contaminated during use. Do not return product to the original container. Bondloc UK Ltd will not assume responsibility for product that has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact our office, and report the problem
- Anaerobic products are not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). Users are recommended to confirm compatibility of the product with such substrates.

### STORAGE

Store product in the unopened container in a dry area out of direct sunlight. Storage below 7°C or greater than 28°C can adversely affect product performance. If stored properly, this product has a shelf life of 24 months.

### HEALTH & SAFETY

This technical information sheet does not constitute a Safety Data Sheet (SDS). Before using this product ensure you have read and fully understood this products SDS.

### PRODUCT DISCLAIMER

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