

Grade HVV Threadlocking Compound *Technical Data Sheet*

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 mating metal parts, forming a resilient, vibration-proof bonded seal. *SAF-T-LOK* adhesive/sealants provide the user with additional performance characteristics, including resistance to corrosion or galvanic attack, as well as solvent resistance; while allowing disassembly with normal tools, if desired.

PRODUCT DESCRIPTION: *SAF-T-LOK Grade HVV* was developed to meet MIL-S-22473E for use where higher viscosity is needed to fill gaps and low strength threadlocking is required.

PRODUCT CHARACTERISTICS: (Liquid)

Color	:	Brown
Specific Gravity	:	1.07 gm/cc
Viscosity	:	1,000 - 10,000 cps
Flash Point	:	>250° F
Temperature Range:	:	-65°F to +300°F
Fluorescence	:	Visible
Storage Stability	:	+12 months at <75°F

PERFORMANCE CHARACTERISTICS: (Cured)

Locking Torque		
Range Prevailing	:	10-25 psi
Gap Filling	:	.003 - .010
Full Cure	:	8-24 Hours

Cure speed is dependant upon the gap to be filled. While MIL-S-22473 calls for cure in 24 Hrs. at 75°F, this product is generally cured at 8 Hrs. on the 3/8-24 UNF steel fasteners specified. Somewhat longer cure would result if 3/8-16 UNC steel fasteners or plated fasteners were used. This product fully satisfies the requirements of MIL-S-22473E however.

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.