

Technical Data Sheet

FM 70 – Studlock

70 Studlock

PRODUCT DESCRIPTION

FM70 Studlocker is a permanent Green coloured general purpose adhesive for permanent threaded assemblies. FM70 locks studs up to 1", sealing against leakage and corrosion. It is chemical resistant, resisting fuels, lubricants and most industrial liquids and gases.

APPLICATIONS

FM70 Studlocker eliminates double nutting and/or welding of critical assemblies. Using FM70 Studlocker permits reduced casting thickness and ultimate lightness, reduced assembly stress and eliminates cracked castings due to interference fit stresses.

USEFUL NOTES

- Easy to use
- Ideal for refrigeration plant, air conditioning, equipment using corrosive chemicals
- Cured adhesive is vibration proof

INSTRUCTIONS FOR USE

- Clean and dry surfaces to be bonded
- Apply adhesive to threads and assemble parts.
- Parts should be left for 15 minutes to reach handling strength, working strength 1 hour
- B7471 (Standard) or B7649 (Fast) Activators can be used, however 30% strength loss can occur when using accelerators.

TECHNICAL FEATURES

Resin	Dimethacrylate
Colour	Green
Fixture Speed No Activator	10 mins
Fixture Speed With Activator	5 mins
Viscosity Brookfield Sp2 @20rpm @ 25°C	500 cps
Gap fill	0.25mm
Flash Point	>100°C
Shelf Life	12 month min
Specific Gravity	1.06
Max Operating Temperature	-55°C to + 150°C

CURED PERFORMANCE

Full Cure Time	12 hours
Cure Time with good % of final strength	2 hours
Typical Breakaway Strength DIN	40 N.m (25/55)
Typical Prevailing Strength DIN	55 N.m (45/70)
Typical Breakaway ISO 10964	26 N.m (16/36)
Typical Prevailing ISO 10964	36 N.m (22/50)

STORAGE

Store in a cool area out of direct sunlight. Shelf life is 12 months @ 20°C

HEALTH & SAFETY

Not recommended for use in pure oxygen and oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

This technical information sheet does not constitute a Material Safety Data Sheet (MSDS). Before using this product ensure you have read and fully understood FM70 MSDS.