

ThreeBond 1401B

Locking Agent

ThreeBond **1401B** is a synthetic resin locking agent. It prevents screws and bolts from loosening, leaking or rusting. It can replace conventional low strength anaerobic thread locking adhesives and tamper-proof paints and unlike some anaerobic resins, it can also be used safely on plastic components.

1. Features

- Vinyl acetate based
- One component with solvent
- Drying at room temperature
- Service temperature -40 ~ 150°C

2. Properties

Before drying

Test	Results	Units
Colour	Green	-
Viscosity at 25°C	350	mPa.s
Specific gravity at 25°C	0.88	-
Non-volatile matter	31	%
Solvent	Methanol	-

Relation between torque and locking force

Time	1 day	2 days	3 days	7 days
Loosening torque (N.m)	0.8	1.5	3.0	10.5

Initial tightening torque = 0 N.m

Heat resistance

Temperature	25°C	50°C	70°C
Loosening torque (N.m)	10.5	6.0	4.0

Initial tightening torque = 0 N.m

Loosening torque of different size bolt

Size	M3	M4	M6	M8	M10
Loosening torque (N.m)	0.3	0.6	3.5	5.5	10.5

Initial tightening torque = 0 N.m

3. Handling

- Before use, please refer to the safety data sheet.
- Flammable product. Do not expose to heat source.
- Prior to opening the container, let it reach room temperature to avoid condensation inside.
- To obtain optimal results, remove humidity, grease and other impurities from the surfaces to be assembled.
- Depending on the materials (dimensions and surface roughness), apply an appropriate and uniform amount of liquid gasket on the surface, then assemble rapidly.
- The product once transferred into another container should not be returned to the original one. Any excess product should be wiped out using a cloth.
- Keep the product in its original container tightly sealed and store it in a dark, dry and well ventilated place at **10 ~ 25°C**.