

Product Description

Vibra-Tite 122 Oil Tolerant Threadlocker is a medium viscosity, thixotropic, anaerobic thread locking adhesive for all types of metal, threaded fasteners. Cured performance shows controlled medium strength with good temperature and solvent resistance against water and nonpolar solvents. This product cures rapidly on plated, oily metal surfaces or inactive surfaces.

Typical Applications

Replaces lock washers and plastic inserts. Locks machine tool access bolts, studs, and hydraulic system bolts. Used on gear box bolts/drive shaft, bearing cover cap screws, counter sunk screws, conveyor roller bolts and construction equipment.

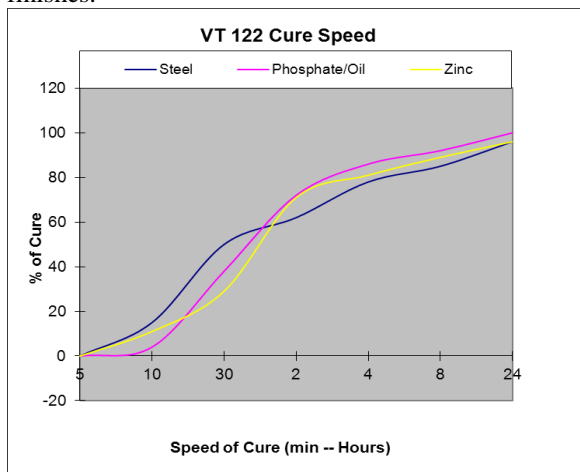
Technical Features

Resin: Modified acrylate
 Color: Blue
 Fixture Speed w/Primer: <1 seconds
 Fixture Speed w/o Primer: 5-10 min @ 77°F
 Viscosity: 2250-12000 cps
 Gap Fill: 0.0015"
 Max. Operating Temp: -65°F to +300°F

Typical Curing Performance

Cure Speed

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



Performance of Cured Material

	Typical Values
Fixture Time	10-20 min @ 72°F
Full Cure Time	24 hrs @ 72°F
Temperature Range	-60°F to 300°F (-51°C to 150°C)

Breakaway Strength

3/8" Plain Steel nut and bolt @1 hr	50-150 lb _f -in
3/8" Plain Steel nut and bolt @24 hr	100-170 lb _f -in
3/8" Zinc nut and bolt @ 24 hr	120-170 lb _f -in
3/8" Phos-oil nut and bolt@24 hr	120 – 170 lb _f -in

Environmental and Fluid Resistance (Shear strength values)

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

Presentation

Bottles.....10ml, 50ml, 250ml and liter

General Information

Storage

Product should be stored in a cool and dry location at temperatures between 14°F (-10°C) to 86°F (30°C). Shelf life is 2 years from date of manufacture when stored at 72±8°F (22±4°C).

Note

Using Vibra-Tite 122 is easy, the product is color coded blue and once cured, it seals and vibration proofs the assembly, giving controlled break loose and prevailing torque. When force is applied, the parts break loose (first movement) but it will take several turns before the cured film will stop resisting the turning action, thus ensuring accidental component disassembly.



Instructions for Use

Ensure parts are clean, dry and free from oil and grease.

Procedure for Application

Product is normally hand applied from the bottle onto threaded parts.

Compatible Primers

Primers such as Vibra-Tite Excel 611 (Primer N) or Excel 612 (Primer T) can be used. The use of primers can result in lower strength and performance should be tested after full cure.