



Product Description

Very high temperature (+230° C) resistant, high strength anaerobic adhesive for locking and sealing thread connections and fitted parts.

High viscosity and thixotropic effect allows larger tolerances.

Highly resistant to corrosion, vibrations, water, gases, oils, hydrocarbons, and many chemicals.

Typical Applications

Superloc 399 is specified for the high strength locking and retention of fitted parts, studs, grub screws and bolts where regular disassembly is not usual.

Product Benefits

Prevents leakage through porosity's and cracks.

Excellent resistance against solvents and gases.

Locks pre-assembled fasteners against vibration.

Excellent thixotropic nature, preventing migration.

Eliminates re-work where leaks are found in inspection.

High strength.

This product simplifies product design and reduces production costs. It enables free running standard studs to be used instead of selected oversize studs. Thus parts such as castings can be thinner and lighter because of reduced assembly stress. This product is recommended for the locking and sealing of threaded parts, which do not normally require dismantling.

Performance Properties of Cured Truloc Superloc 399 (24 hrs @ 25°C)

<u>Strength</u>	<u>Locking torque Nm ISO10964</u>
Breakaway torque	20-35
Prevailing torque	40-70
Retained torque @ 150°C	70-80%
Shear strength DIN 54452	10-20 N.mm ²
Handling minutes	20-40
Functional hours	3-6

Physical Properties of uncured Truloc Superloc 399

Monomer	di-Methacrylate ester
Colour	opaque red
Fluorescence	under blue light
Viscosity, Brookfield 25°	6000-15,000 mPa.s
Flash Point (CoC)	>100°C
Max. Diameter of thread/gap fill	M56 2" 0.30mm
Shelf life at 5 - 25°	1 year min
Temperature Range	-55°C to +230°C

**Solvent Resistance**

Truloc Superloc 399 has excellent solvent resistance for the majority of locking and sealing applications. After 30 days immersion at 85 degrees centigrade in oil, transmission fluid, gasoline and glycol the strength retained was between 80-90% of original strength.

Temperature Performance

Truloc Superloc 399 is recommended for use at operating temperatures ranging from minus 55° to plus 230°.

Resistance to Vibration Loosening

Loosening of the assembly by transverse dynamic loads generally causes assembly failure. Truloc Superloc 399 completely fills the void within the joints and thus prevents movement in the assembly, eliminating vibration loosening. The product provides 100% contact between the locking surfaces.

Packaging

Truloc Superloc 399 is available in 50ml and 250ml polythene containers.

Storage

Materials should be stored in original containers, which provide air space to maintain the product in a liquid state. Store between 5°C and 25°C for maximum shelf life.

Caution

These products are generally non-toxic and are not common allergenic materials. They can however cause skin sensitising when used continuously where skin is bruised or micro-lacerated. Contact with skin in such conditions should be avoided. Adhesive can be removed from the skin with soap and water.



IRRITANT

Note

The information given in this Data sheet is the result of controlled laboratory tests and experience. It is intended only as a guide to the user in selecting the appropriate grade of Truloc product. Users must satisfy themselves by appropriate tests that the grades they propose to use are suitable for their specific application. Truloc Ltd is not responsible for loss, claim or damages resulting from the use of their products.