Technical Data Sheet

Higlue 272

PRODUCT DESCRIPTION

Higlue 272 provides the following product characteristics:

Technology	Acrylic
Chemical Type	Dimethacrylate ester
Appearance (uncured)	Red-orange liquid
Components	One component - requires no mixing
Viscosity	Medium
Cure	Anaerobic
Secondary Cure	Activator
Application	Threadlocking
Strength	High

Higlue 272 is designed for the permanent locking and sealing of threaded fasteners. The product cures when confined in the absence of air between close fitting metal surfaces and prevents loosening and leakage from shock and vibration. Typical applications include the locking and sealing of large bolts and studs (M25 and larger).

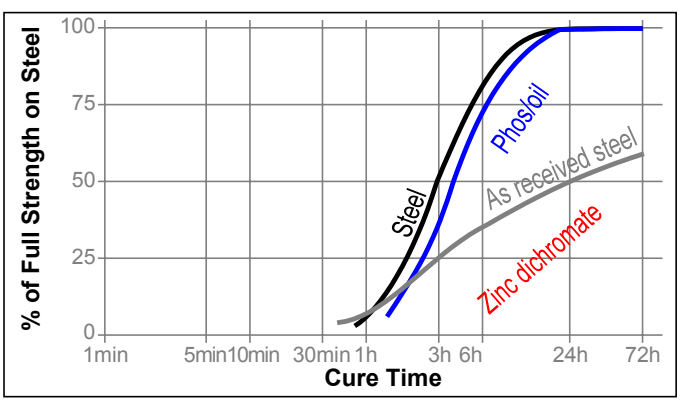
TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	1.11
Flash Point - See SDS	
Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP):	
Spindle 4, speed 20 rpm	4,000 to 15,000

TYPICAL CURING PERFORMANCE

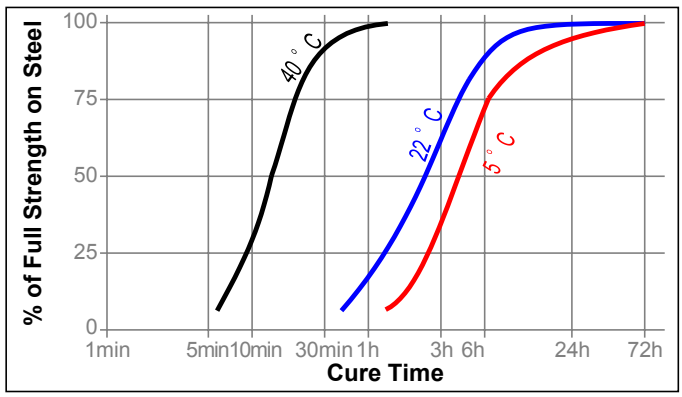
Cure Speed vs. Substrate

The rate of cure will depend on the substrate used. The graph below shows the breakaway strength developed with time on M10 steel nuts and bolts compared to different materials and tested according to ISO 10964.



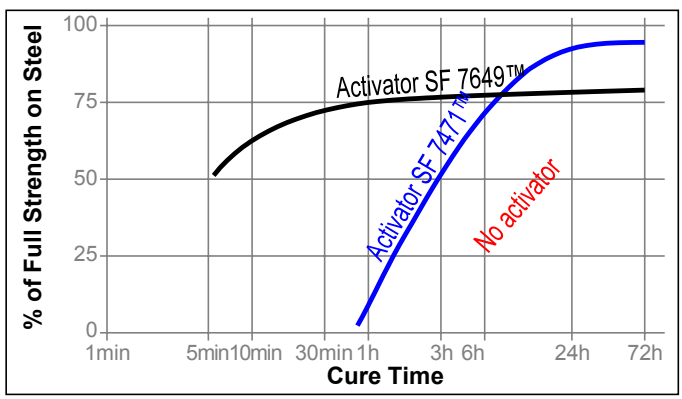
Cure Speed vs. Temperature

The rate of cure will depend on the temperature. The graph below shows the breakaway strength developed with time at different temperatures on M10 steel nuts and bolts and tested according to ISO 10964.



Cure Speed vs. Activator

Where cure speed is unacceptably long, or large gaps are present, applying activator to the surface will improve cure speed. The graph below shows the breakaway strength developed with time on M10 zinc dichromate steel nuts and bolts using Activator SF 7471™ or SF 7649™ and tested according to ISO 10964.



TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties:

Coefficient of Thermal Expansion, ISO 11359-2, K^{-1}	80×10^{-6}
Coefficient of Thermal Conductivity, ISO 8302, W/(m·K)	0.1
Specific Heat, kJ/(kg·K)	0.3

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

After 24 hours @ 22 °C

Breakaway Torque, ISO 10964:		
M10 steel nuts and bolts	N·m	23
	(lb.in)	(200)
3/8 x 16 steel nuts (grade	N·m	≥18

2) and bolts (grade 5)	(lb.in)	(≥159)
Prevail Torque, ISO 10964:		
M10 steel nuts and bolts	N·m	25
	(lb.in)	(220)
3/8 x 16 steel nuts (grade 2) and bolts (grade 5)	N·m	≥18
	(lb.in)	(≥159)
Compressive Shear Strength, ISO 10123:		
Steel pins and collars	N/mm²	≥14.5
	(psi)	(≥2,102)

Cured for 24 hours @ 22 °C followed by 72 hours @ 200 °C, tested @ 200 °C

Compressive Shear Strength, ISO 10123:		
Steel pins and collars	N/mm²	≥20
	(psi)	(≥2,900)

TYPICAL ENVIRONMENTAL RESISTANCE

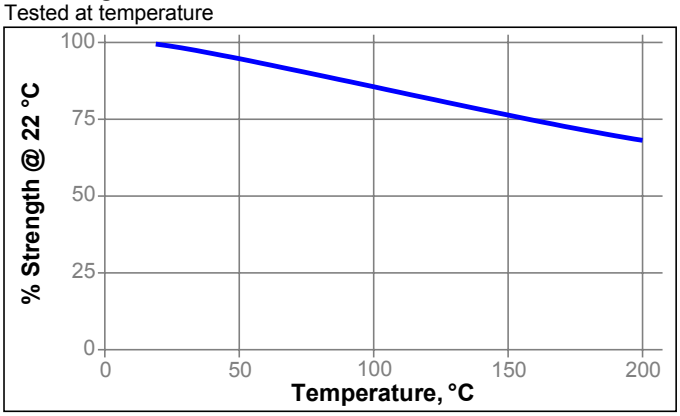
Cured for 24 hours @ 22 °C

Breakaway Torque, ISO 10964:

M10 steel nuts and bolts

Hot Strength

Tested at temperature



Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 22°C.

		% of initial strength
Environment	**°C**	**720 h**
Air reference	87	100
Motor oil (MIL-L-46152)	87	62
Gasoline	87	62
Water	87	58
Processing Temperature	87	87
Toluene	87	80
Phosphate ester	87	70

GENERAL INFORMATION

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

For safe handling information on this product, consult the Safety Data Sheet (SDS).

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some cases these aqueous washes can affect the cure and performance of the adhesive.

This product is not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). Users are recommended to confirm compatibility of the product with such substrates.