

ADHESIVE R&D’s anaerobic adhesive’s and sealants represent the latest generation in anaerobic chemistry. Anaerobic threadlockers remain liquid when they are exposed to the oxygen in air, but in the lack of air, (or anaerobic environment) these products quickly polymerize and fill the inner space between the surfaces. In a continuous quest to improve the performance of anaerobic adhesive’s and sealants, **ADHESIVE R&D** works with leading edge engineers to push the chemistry forward, to increase cure speeds and bond strengths, and to design products that are able to cure on contaminated or inert surfaces and yet remain stable without special handling.

77 RED™ is a very high viscosity high strength threadlocker. It should be used on large fasteners, where a high break away torque is desired. Because it is high in viscosity, **77 RED™** will not run out of the joint before it cures and can be used in applications requiring good gap filling abilities.

PHYSICAL PROPERTIES

Composition	Anaerobic Methacrylates
Color	Red
Fluorescence	Under Blue Light
Viscosity	7000 cps
Specific Weight	1.05
Flash Point	>100°F
Solvent Content	None
Shelf Life @ 72°F	2 years

CURING PROPERTIES

Handling	5 minutes
Functional Cure Time	1-2 hours
Full Cure	8-10 hours
Locking Torque*	
Breakaway	250-350 inch lb’s
Prevailing	200-300 inch lb’s
Temperature Range	150°C

* Per ASTM D5363 Specification.
3/8-16 plain finish cap screws and nuts.
Larger fasteners will increase surface area and breakaway torque.
77 Red™ meets ASTM D5363 AN0211 and Mil-S-46163 TYPE I Grade L.

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