

## Product Description

Vibra-TITE 140 is a high strength, anaerobic thread locking compound. Vibra-TITE 140 is designed for the permanent locking of threaded fasteners. The product performs on aluminum, steel, plated fasteners, stainless steel, and special alloy parts. Vibra-TITE 140 exhibits good temperature stability and is solvent resistant.

## Typical Applications

Vibra-TITE 140 will lock and seal large fasteners. Vibra-TITE 140 is used in applications where shock and vibration may cause the fastener to loosen.

## Properties of Uncured Material

<b>Chemical Type</b>	Methacrylic Ester
<b>Cure Type</b>	Anaerobic
<b>Secondary Cure</b>	Activator
<b>Percent Solids</b>	100
<b>Color</b>	Red
<b>UV Fluorescent</b>	Yes
<b>Viscosity @25°C<sup>1</sup></b>	400 – 600 cP
<b>Specific Gravity</b>	1.1
<b>Application</b>	Threadlocking

1. Brookfield RVT Spindle 3, 20rpm

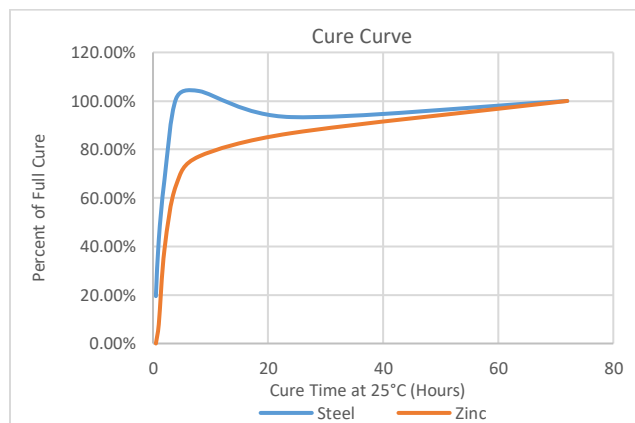
## Performance of Cured Material

Typical Values (M10-1.5 Steel test bolt)

<b>Strength</b>	High
<b>Operating Range</b>	-51°C to 150°C (-60°F-300°F)
<b>Fixture Time @ 25°C</b>	15 minutes
<b>Breakaway Torque</b>	39 – 50 Nm (350 – 450 in*lbs)
<b>Prevailing Off Torque</b>	28 – 34 Nm (250 – 300 in*lbs)
<b>Breakloose Torque</b>	34 – 45 Nm (300 – 400 in*lbs)

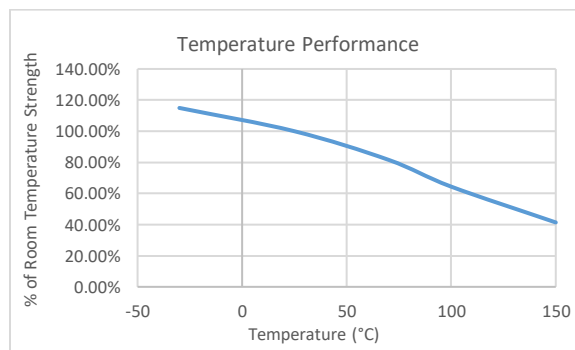
## Cure Speed

The cure speed is dependent on temperature and substrate. The graph below shows the Breakaway Strength on various common bolt and nut finishes. Testing was conducted on M10-1.5 bolts with Style 2 test nuts.



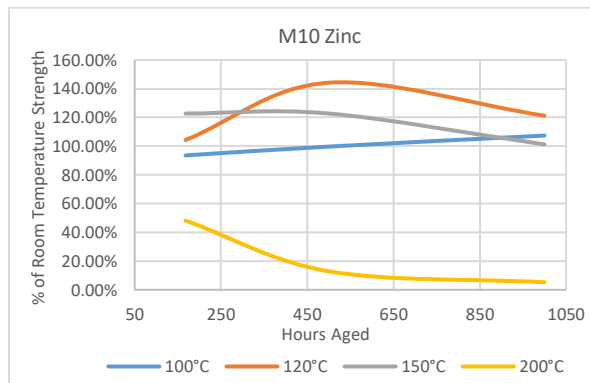
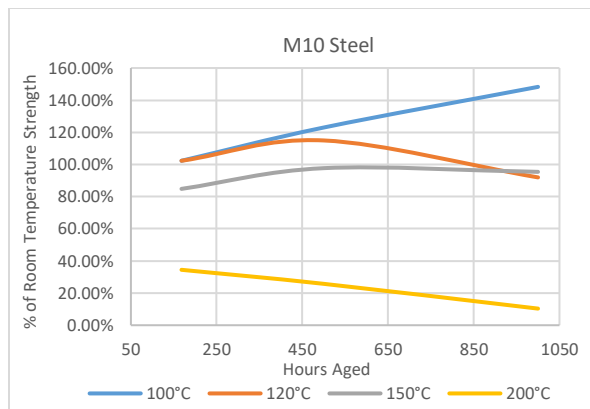
## Temperature Performance

Parts were cured for 24 hours then held at temperature for two hours. Breakaway torque values were recorded for parts at temperature. Testing was conducted on M-10x1.5 plain steel bolts with a style 2 plain steel test nut



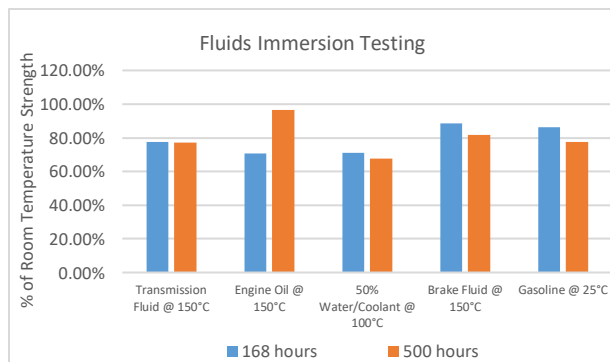
## Heat Aging

Parts were allowed to cure for 24 hours then were aged at the reported temperatures. Breakaway torque values were recorded at room temperature. Testing was performed on M10-1.5 bolts and style 2 nuts.



## Fluids Testing

Parts were allowed to cure for 24 hours then were submerged in the listed fluid(s) at the reported temperatures. Breakaway values for the M-10x1.5 plain test bolts with style 2 nuts were recorded at room temperature.



## Instructions for Use

For best results, ensure parts are clean, dry and free from oil and grease. Anaerobic adhesives cure in the presence of metal and the absence of oxygen. Residual adhesive outside of the bond area will remain liquid and is not indicative of product failure. For optimal performance, allow the material to cure for at least 24 hours prior to use when possible.

## Compatible Primers

Primers such as Vibra-Tite Excel 611 (Primer N) or Excel 612 (Primer T) can be used to speed the fixture time of the adhesive. Fixture times can improve by as much as 50%. The use of primers can result in lower strength and performance should be tested after full cure.

## 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). Storing above this temperature will result in a lower shelf life.

Shelf life of this product is 6 months when storing in quantities ≥ 2 liters. Refrigerate the material or download the material into smaller containers to extend the shelf life.

### Note

Vibra-Tite 140 is recommended for threaded components under 1" in diameter. Components can be disassembled using conventional hand tools. It is color coded red and once cured, seals and vibration proofs the assembly giving controlled breakaway and prevailing torques.

Product conforms to MIL-S-46163A, ASTM D-5363, NSF.

## Health & Safety in use

**IRRITANT:** Contains Methacrylate Esters which may irritate eyes, respiratory organs and skin. In case of contact with the skin, wash immediately with plenty of water.