



## **Product Description**

Vibra-Tite 146 Large Diameter High Strength Threadlocker is a red general purpose adhesive for permanent threaded assemblies. Vibra-Tite 146 locks fasteners 1" and larger in diameter, sealing against leakage and corrosion. It resists attack from lubricants and most industrial liquids and gases.

## **Typical Applications**

Eliminates double nutting and/or welding of critical assemblies. Using Vibra-TITE 146 permits reduced casting thickness, and eliminates cracked castings due to interference fit stresses. It is recommended for larger diameter studs with coarse threads and is used to reclaim worn stud holes. Primers are recommended for large gaps and poor fitting parts.

## **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.

## **Technical Features**

Resin:.....Dimethylacrylate  
Color:.....Red  
Fixture Speed w/Primer.....<10 seconds  
Fixture Speed w/out Primer 60 min. @ 77°F  
Viscosity.....7000 cps  
Gap Fill.....0.010"  
Max. Operating Temp..... -65°F to +300°F

## **Cured Performance**

Full Cure Time.....24 hours @ 68°F  
Typical Breakaway Strength..250-350 in.lbs.  
Typical Prevailing Strength...250-350 in.lbs.

## **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**

Vibra-TITE 146 is easy to apply and color coded red to assist in selection. Because of its chemical resistance it is ideal for applications such as sealing for refrigeration environments, air conditioning applications and plant and processing equipment using corrosive chemicals. 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.