# Higlue 272 Threadlocker

Technical Data Sheet
Jiangxi Gooz Adhesive Co.,Ltd

Product name:HiGlue 272 threadlocker
Producer:Jiangxi Gooz Adhesive Co.,Ltd
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**PRODUCT DESCRIPTION:**

Red, high strength, medium viscosity, methacrylate-based threadlocking adhesive with high temperature resistance.

Higlue 272 is a red, medium viscosity, methacrylate-based threadlocking adhesive with high strength. With a fixture time on steel of 10 min, brass 5 min and stainless steel 15 min, it is ideal for applications where any migration of the adhesive must be prevented. Can tolerate slight contaminations of industrial oils. Suitable for all metal fasteners. It has a breakaway torque on M10 bolts of 23 Nm

- Medium viscosity
- High temperature resistant
- Resists vibration
- Seals threads - allows through-hole tapping
- High strength

**PRODUCTION INFORMATION:**

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| Model | Higlue 272 |
| Color | Orange red |
| Fixture Time | 40.0 min. |
| Applications | Threadlocking |
| Key Characteristics | Strength:High Strength, High Temperature,Thixotropic |
| Operating Temperature | -54.0 - 230.0 °C |
| Substrates | Metal, Metal: Passive Metal |

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|---|---|
| Viscosity | 4,000~5,000 mPa·s (cP) |
| Capacity | 10ml 50ml 250ml |
| Cure Type | Anaerobic Cure |

**DIRECTIONS FOR USE:**

For Assembly
1.For best results, clean all surfaces (external and internal) with a cleaning solvent and allow to dry.
2.To accelerate cure speed or where large gaps are present, use activator and allow to dry.
3.For Slip Fitted Assemblies, apply adhesive around the leading edge of the pin and the inside of the collar and use a rotating motion during assembly to ensure good coverage.
4. For Press Fitted Assemblies, apply adhesive thoroughly to both bond surfaces and assemble at high press on rates.
5. For Shrink Fitted Assemblies, the adhesive should be coated onto the part to produce a smooth, even film of material. If heating the hub for assembly, coat the pin. If the pin is to be cooled for assembly, coat the hub. If both heating and cooling is to be done, apply material to cooled part. Avoid condensation on cooled parts.
6. Parts should not be disturbed until sufficient handling strength is achieved.

**For Disassembly**

1. Remove with standard hand tools.
2. If needed,apply localized heat to the assembly to approximately 250 °C. Disassemble while hot.
3. If this temperature is not possible, heat as much as possible and use mechanical aids.

Clean-up

1. Cured product can be removed with a combination of soaking in a solvent and mechanical abrasion such as a wire brush.

**Storage**
Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.
Optimal Storage: 8°C to 21°C. Storage below 8°C or greater than 28°C can adversely affect product properties.
Material removed from containers may be contaminated during use. Do not return product to the original container.